EC Conformity Declaration

As prescribed by EC Machine Guidelines 89/392/EEC, Appendix II A

We declare herewith that the machine described in the following complies with the respective basic safety and health requirements of the EC Machine Guidelines due to its conception and type of construction as well as the model issued by us.
In case of any changes in the machine not authorized by us this declaration loses its validity.

Description of the machine : Drawer assembly unit for manually processing the InnoTech drawer system

Machine type: **01329**

Machine No.: 13984.0 / _____

CE

Relevant
EC Guidelines: **EC- Machine Guideline (89/392/EEC; 91/368/EEC; 73/23/EEC)**

Applied
harmonized
standards, mainly: **EN 292-1/2; EN 292-2/Al; prEN 614-1; EN 349; EN 983**

Applied
national standards and
technical specifications
mainly: **DIN 24420 T1 and T2; VDI-Guideline 4500**

Date: 30 September 2003

Huttenholscher
Masch A1U'ih b
Postfach
Grasweg 5
Tel. 05246/9269-0 Fax -10

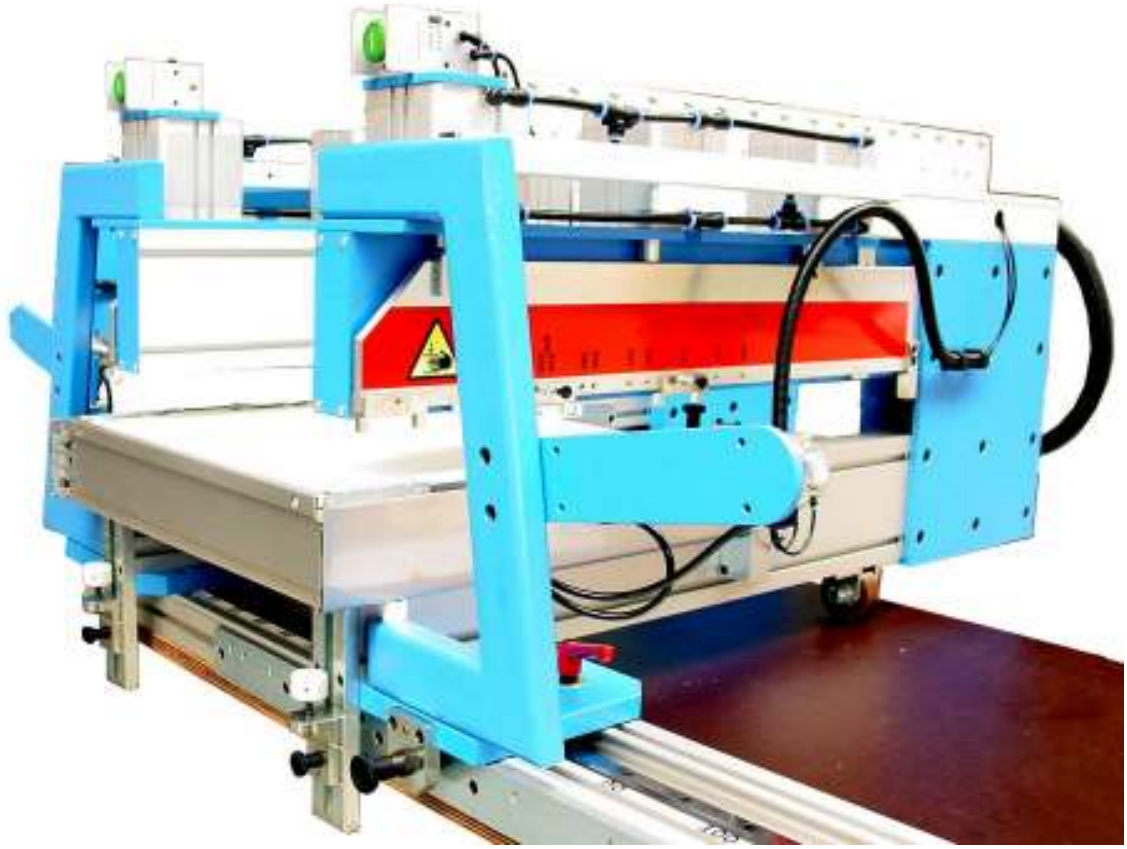
Form requirements:
Print letters or typescript
– Official language of country of use
– legally binding signature (s) of producer at least by proxy-
Original document to customer, copy in machine file

InnoTech Drawer Assembly Unit

Art. No. 901 974 300

Operating Instructions

Drawer Assembly Unit
for manually processing the InnoTech drawer systems



Advantages

- No electric power
- Little space needed, about 140 x 200 cm
- Short setup times due to preset fixed stops
- Different rear panel heights
- Any drawer width from
  300 – 1200 mm can be processed
- Installation time about 45 seconds

Technical Documentation.

Drawer Assembly Unit
for
manually processing
the
InnoTech Drawer Systems

Machine type: 01329
Machine No.: 13984.0 / ____
Documentation No.: 00347

Customer

MACHINE OWNER / END-CONSUMER

To be filled in by the customer

Inventory No.: .....

Control No.: .....

Place of installation .....

Table of Contents

1. Introduction

Paul Hettich GmbH & Co.
Vahrenkampstr. 12-16
32269 Kirchlengern

1. Introduction

1.1 General Information

For the customer of Paul Hettich GmbH & Co. it has been mutually agreed upon that the order of the InnoFit N unit for processing the InnoTech drawer system has been jointly established.
Order No.: 13903.0
On the basis of said order, the delivery had the following scope:

Machine No.: 013984/__
The current documentation describes the drawer assembly unit for manually processing the InnoTech drawer system
Machine No.: 013984/__
The documentation was written with the intention of instructing all those responsible about smooth machine operation without disturbance. One copy of the documentation ought to be kept near the machine at all times. Particularly important details for using the machine will be pointed out in this documentation.
It is absolutely necessary to read through the documentation before starting the machine, as we assume no liability for damage or disturbances caused by not observing this documentation. It is very important for operators to know chapter 2 "Safety"!

1.1.0 Intended Use

The drawer assembly unit for manually processing the InnoTech drawer system is intended for the InnoTech drawer system.

It can be set for any size between largest and smallest size! The measurements named are emphasized measurements that can be set with fixed stops.
If there is ever any difficulty with this then consult to the producer.

1.1.1 Who is this document intended for?

This machine is a robust and high performance system but it is technically sophisticated and requires careful servicing and maintenance. So this document is intended for: Qualified operators of the machine owner who perform the following tasks:

- Running the machine or system,
- The regular service work,
- Repairs and installation work,
- Ordering and installing the individual parts or wear and tear items and
- It is intended for the customer's operators, suppliers and producers.

1.1.2 What is this documentation for?

This documentation gives the machine owner's qualified operators, customers, suppliers and producers all the information needed for running, maintenance and repair of the machine.

1.1.3 Subject to Alteration

We reserve the right to make technical changes as opposed to the presentation in this documentation if this is necessary to improve the machine.

1.2 Application Area

This drawer assembly unit for manually processing the InnoTech drawer system is for joining individual elements of the InnoTech drawer system to make a drawer. Furthermore, the application area is determined by the „Technical Data" (chapter 1.1.0, chapter 3).

1.3 Copyright

Paul Hettich GmbH & Co.
Vahrenkampstr. 12-16
32269 Kirchlengern

1.4 Laws, Regulations and Standards

Guidelines:

EC Machine Guideline 89/392/EEC in the version of 14th June 93 (93/44), VDI Guideline 4500: User Information Technical Documentation.

Standards:

DIN 24420 T1 & T2 Remarks for Orders
DIN 418 EM-Stop
DIN 294 Safety Zones
DIN 349 Minimum Distance from Crushing Dangers
DIN 983 Technical Safety Requirements for Pneumatics

Instructions:

Machines for Processing Wood and similar Materials.

Laws:

GSG. Equipment Safety Law §3 paragraph 1 and §2 paragraph 5 sentence 1 a. 2

Regulations:

Regulations for GSG dated 12th march 1993

1.5 Abbreviations

OI	= Operating Instructions
GC	= Group of Components
DIN	= Deutsches Institut für Normung e.V. (German Institute for Standardization registered association)
EC	= European Community
EN	= European Standard
EEC	= European Economic Community
Prod.	= Product
GSG	= Equipment Safety Law
Qty.	= Quantity
No.	= Number
UVV	= accident prevention regulation (Accident Prevention Regulation)
VBG	= Verwaltungs-Berufsgenossenschaft (Administrational and Employers Mutual Insurance Association)
VDI	= Verein Deutscher Ingenieure (Union of German Engineers)

1.6 Concept Definitions

Producer

The producer of a product, vendor parts or a basic material. Producers in the legal sense are businesses that produce by labelling with name, brand, signs of recognition on items made by third parties and delivered by them as producer and are liable according to the product liability law.

Commissioning

Making a functional visible unit available for use.

Inspection

Measures for determining and judging the actual status of the technical means of a system.

Inspection Instructions
Inspection instructions include instructions for carrying out the inspection of a technical product as well as information about the product and technical service.

Maintenance
Measures for maintaining and restoring the operational status as well as determining and judging the actual status of the technical means of a system.

Customer
Natural or legal persons as a contractual partner of a producer, supplier, dealer or service supplier with whom a sales or service agreement is closed by two declarations covering each other having been made.

Machine
An aggregate of parts or devices connected to each other of which at least one is movable. (Regulations for GSG.)

Machine Owner
A person applying or using machines and systems.

Operator
The person (or persons) assigned for the installation, operation, setting up, maintenance, cleaning, repair or transport of the machine.

Product Liability
The obligation to compensate damage resulting from defective products.

Safety
The absence of danger or impairment for users or third parties when applying or using industrial products. (DIN 31000 part 1; DIN EN 292)

Planned status
The characteristic values set for the entirety for the respective case.

System
The entire technical, organizational and other means for independently fulfilling a task complex.

Contract
An oral or written agreement as an expression of two declarations covering each other has been made by natural and legal persons.

Servicing
Measures for maintaining the planned status of the technical means of a system.

Servicing Instructions
Inspection instructions include instructions for carrying out the inspection of a technical product as well as information about the product and technical service.

Paul Hettich GmbH & Co.
Vahrenkampstr. 12-16
32269 Kirchlengern

1.7 Warranty

Paul Hettich GmbH & Co. warrants that their products are free of material and production defects. Guarantee services may only be claimed by the customer if the damage occurring is reported to Paul Hettich GmbH & Co. without delay. Claims made later cannot be recognized. The period for making warranty claims is within **6 months** in single shift operation after the delivery of the machine.

Warranty Exclusions

There are no warranty claims for damage caused by the following:

- Intentional damage or gross negligence
- Improper installation or deinstallation by the customer
- Insufficient or improper servicing by the customer
- Unjustified change or unauthorized use
- Failure to observe the surrounding conditions prescribed for the product
- Using unsuitable means
- Overloading
- Insufficient or unsuitable place of use

Constructional Changes in the Machine

- Do not make any changes, additions or reconstruction on the machine without the producers authorization. This also applies for welding on the supporting parts.
- All constructional measures require the written approval of **Paul Hettich GmbH & Co.**
- Replace any machine parts in unsatisfactory condition immediately.

Use only original spare parts and wear and tear parts.

There is no warranty in case of parts from third parties that they are constructed and produced to meet safety and load standards.

Owner Obligations

The owner is obligated to allow only such persons to work on the machine

- who have thoroughly familiarized themselves with the instructions on work safety and accident prevention and have been shown how to use the machine
- who have read and understood the safety chapter and warnings of this documentation and certified this with their signature.
- the safety consciousness of the personnel's work is checked at regular intervals.

Personnel Obligations

All persons authorized to work with the machine are obligated before beginning work

- to observe the general regulations for work safety and accident prevention
- to have read the safety chapter and warnings and certified with their signature that they have understood it.

Dangers Using the Machine

This machine has been built according to the state of technology and recognized safety rules. However, while using it there can be dangers for life and limb of the operator or third parties or of damaging the machine or other property. The machine may only be used

- for the purpose it was intended for
- in a state with flawless safety technology.

Disturbances that can affect safety are to be eliminated immediately.

Liability

Changes and supplements of the warranty require written agreement and reference on it involves a change of this agreement. Any further claims against Hüttenhölscher, their assistants or helpers by the customer in particular for damage compensation above all for subsequent damage or lost profit are excluded unless intentionally caused or by gross negligence or for lack of guaranteed characteristics.

2. Safety

2. Safety

2.1 Danger Analysis

A danger analysis helps you understand what dangers there can be while **delivering, setting up, assembling, installing, commissioning, running, cleaning, maintaining, servicing, retooling, adjusting, repairing, disposing of** and **decommissioning** the machine.
A danger analysis of the drawer assembly unit for manually processing the InnoTech drawer system reveals the following dangers:

- **Transport:**

Bumping the transport unit,
Transport slipping on the loading area,
Being hit by falling loads,
Getting stuck and crushed by the transport tools

- **Delivery and unpacking:**

Bumping the transport unit,
Machine slipping on the loading area,

- **Setting up and installing:**

Being hit by falling loads,
Getting stuck and crushed by the transport tools
Getting stuck and crushed by the transport tools

- **Commissioning**

Compressed air escaping from leaky connections,

- **Normal operation:**

Crushing and bumping by moving machine parts and opened safety covers, compressed air escaping from leaky connections,

- **Cleaning:**

Crushing and bumping

- **Repairing:**

Bumping and crushing by opened machine parts

- **Disposing:**

Crushing and bumping while disposing of waste,

2. Safety

2.2 General Safety Tips

This operating instructions is to make operating, servicing and maintenance of the system easier for the respective operator. It is supposed to help keep the drawer assembly unit for manual processing at a high production level over a long period of use and prevent accidents. The following guidelines and safety regulations in particular are to be observed in all work, delivering, setting up, installing, commissioning, operating, cleaning, maintenance, servicing, reequipping, adjusting, repairing, disposal, and decommissioning work.

- EC Guideline Machine 89/392/EEC in the version 91/368 EEC
- Equipment Safety Law (Gerätesicherheitsgesetz, GSG) 9th Regulation for GSG (9. GSGV)
- DIN EN 292 T1 & T2, DIN EN 294, DIN EN 349
- the safety regulations according to

VBG 1	General Safety Tips
§ 2	General requirements
§ 7	Interpretation of safety regulations, training insured
§ 8	Fostering co-operation among the insured in accident prevention
§ 36	Dangerous jobs
§ 37	Prohibiting access and presence
§ 39	Tests
§ 41	Equipping and maintenance jobs
§ 42	Testing facilities
§ 3	General principles
§ 5	Tests
§ 6	Work on active parts
VBG 5	Power tools
§ 1	Application areas
§ 3	General requirements
§ 4	Dangerous places

- the local safety and accident prevention regulations and laws
- Warning signs according to DIN 4844.

2. Safety

2.2.1 Symbols for Work Safety

These symbols for job safety according to DIN 4844 part 1 are stuck to the parts of the system near areas where there is danger for people. The safety symbols according to DIN 4844 in this operating instructions mean:

Prohibition sign

Danger! Do not start the machine!

Warning sign

Danger! Danger for life and limb!

Danger! Do not step under suspended load!

Danger! Warning of crushing danger!

Danger of hand injury!

2. Safety

Improper use could damage the machine!

Order signs

Warning!
Wear protective gloves against mechanical risks!

Danger! Disconnect before working!

2.2.2 Warning Sign

Attention!
This „**Attention!**" is written in places in this operating instructions that are to be particularly well noted so that the guidelines, tips and the right work methods are observed and damage or destruction of the machine and/or parts of the system is avoided.

2. Safety

2.3 Basic Safety Tips

- This machine is built according to the state of technology and recognized safety rules. However, while using it there can be dangers for life and limb of the operator or third parties or of damaging the machine or other property.
- The system may only be used in technically flawless condition and only for the intended work in a manner oriented on safety with attention to the operating instructions. Disturbances that can affect safety are to be eliminated immediately.
- This drawer assembly unit for manually processing the InnoTech drawer system is for joining individual elements of the InnoTech drawer system to make a drawer. No use going beyond this like using other materials with other measurements may be deemed as the intended use.

Attention! For damage resulting from this the producer/supplier shall not be liable. The risk shall be born by the user alone.

- The intended use includes observing the operating instructions and fulfilling the inspection and servicing conditions set out in chapter "**6. Servicing and Maintenance**".

2. Safety

2.3.1 Organizational Measures

- An operating instructions is always to be kept available at the place where the machine is in use.
- In addition to the operating instructions the general safety and ecology protection laws and regulations are to be observed and passed on as orders! (See chapter „2.2 General Safety Tips") Such obligations can be seen in handling dangerous materials for example or making personal protective equipment available and wearing it.
- Amending the operating instructions with respect to orders, including supervision and reporting duties to take consideration of operational peculiarities like work organization, work processes, personnel deployed.
- The personnel assigned to activities on the machine (operators) must have read the operating instructions and particularly the chapter "2. Safety" before beginning work on the machine. It is too late while working on the machine. This applies in particular for personnel that only work on the machine occasionally such as for equipping, servicing.
- Occasionally control the safety and danger consciousness of the work of personnel under observation of the operating instructions!
- The personnel should not wear long hair open or loose clothing or rings and jewelry. There is the danger of injury from being pulled in!
- Use personal safety equipment as far as necessary or prescribed by regulations! Wear protective gloves!
- Observe all safety and danger signs on the machine!
- Keep all safety and danger signs on the system complete and in legible condition!
- Should any change in machine operation occur affecting safety or its action immediately stop the machine and report the disturbance to the office or person in charge!

2. Safety

- Do not make any changes, additions or alterations to the machine/system that could affect the safety without the supplier's approval! This also applies for the installation or adjustment of safety equipment and valves.
- Spare parts must meet the technical requirements established by the producer. This is always the case for original spare parts.
- The intervals prescribed or shown in the operating instructions for regular checks/inspections must be observed! (Chapter "6. Servicing and Maintenance")
- For performing maintenance measures, a workshop reasonably well equipped for the work is necessary.
- Post the places and use of fire extinguishers!
- Take notice of the fire alarm and fire fighting equipment!

2.3.2 Personnel Selection and Qualification; Basic Obligations

- Work on/with the machine/system may only be performed by reliable personnel. Obey the law for the allowable minimum age!
- Only assign trained or instructed personnel and establish clear competencies for operating, equipping, servicing, maintenance!
- Make sure that only the competent personnel works with the machine!
- Establish machine operator responsibility – also with respect to traffic regulations – and assure their right to contradict unsafe orders from third parties!
- Personnel being trained, introduced or instructed or being within the scope of general apprenticeship should only be allowed to work on or with the machine or system under constant supervision of an experienced person.
- Work on technical gas equipment (gas consuming devices) may only be performed by personnel trained for this.
- Only personnel with special knowledge and experience with pneumatics may work on the pneumatic equipment!

2.3.3 Safety Tips for certain phases of operation

Normal operation:

- Omit any unsafe way of working!
- Take measures to assure that the machine is only operated in safe and functional condition! Only run the system when all safety equipment and devices installed for safety like emergency stop devices are in place and functioning!
- Check the machine/system for externally visibly recognizable damage and defects at least once per shift. Report any changes occurring (including that of running behavior) immediately to the office/person in charge! Immediately stop and secure the machine in such a case!
- In case of functional disturbances immediately stop and secure the machine/system. Have the disturbances corrected without delay!
- Observe the procedures for switching on and off according to the operating instructions.
- Before starting the system make sure that nobody is endangered by the starting machine/system.

Special jobs within the scope of using the machine/system and maintenance work as well as eliminating disturbances in work procedures; disposal

- Observe the settings, servicing and inspection work and intervals prescribed in the operating instructions including the information on replacing parts and components! Only specialist may perform these activities.
- Inform operation personnel before beginning to perform special and maintenance jobs! Appoint a supervisor!
- For all work having to do with operation, changing production, re-equipping or setting the machine/system and its safety equipment as well as inspection, servicing and repair obey the procedures for switching on and off and tips for maintenance work according to the operating instructions!

2. Safety

- Secure the maintenance area as broadly as necessary!
- If the machine/system is completely switched off for servicing and repair work it has to be secured against unexpected switching on:
- Individual parts and larger groups of components are to be carefully held by lifting equipment while being replaced so that they present no danger. Only suitable and technically flawless lifting equipment as well as load support means with sufficient load capacity should be used! Do not work or stand under suspended loads!
- Only entrust experienced personnel with giving directions to crane operators when placing loads! The person giving directions must be within sight of or in speaking contact with the operator!
- For installation work over head level use the climbing aids and work platform provided or other safe aids! Do not use machine parts as climbing aids!
- Clean the machine and particularly the connections and screw couplings of oil, fuel or other substances when beginning servicing/repairs! Do not use aggressive cleaning materials! Use a cloth that does not shed fibers!
- Always tighten screwed connections loosened during servicing and maintenance work.
- If safety equipment has to be removed for retooling, servicing and repair work it has to be reinstalled and checked immediately afterwards.
- Make sure of safe and non-polluting disposal of process materials as well as old parts!

2.3.4 Tips for gas, dust, steam and smoke

- Only do welding, burning and grinding work when this has been expressly authorized, since there is the risk of fire or explosion!
- Before welding, burning and grinding work remove all dust and flammable materials from the machine/system and the surrounding area and be sure there is good ventilation (risk of explosion)!

2.3.5 Tips for pneumatics

- Only personnel with special knowledge and experience with pneumatics may work on the pneumatic equipment!
- Regularly check all pipes, hoses and screw couplings for leakage! Eliminate damage without delay! Pressure drop.
- Depressurize any of the sections of the system and pressure pipes to be opened before beginning repairs according to the component descriptions!
- Lay out and install the compressed air pipes properly! Do not get the connections mixed up! The valves, lengths and quality of the hoses have to meet specifications.

2.3.6 Oils, grease and other chemical substances

- Obey the safety regulations for oils, grease and other chemical substances when using them!

2.3.7 Transport and installation

- When loading only use lifting equipment and supports with sufficient load capacity!
- Select an experienced person for giving directions during lifting.
- Only lift machines with proper lifting equipment according to the operating instructions (support points for taking the load etc.)!
- Use only a suitable transport vehicle with sufficient load capacity!
- Secure the load properly. Use suitable support points!
- Secure the machine/system against accidental change of position before and immediately after moving with the recommended/supplied equipment. Put up the corresponding warning signs! Properly remove the temporary equipment before re-commissioning!
- Carefully install and fasten the parts removed for transport purposes before re-commissioning.
- Disconnect the machine or system from any external energy supply before even the slightest moving! Properly reconnect the machine to the mains again before re-commissioning!
- Proceed according to the operating instructions when re-commissioning!

2.4 Protective equipment

In order to avoid the dangers recognized in chapter "2.1 Danger analysis".

2.4 Remaining dangers

Despite all precautions there is always some danger that is not obvious but only of a potential nature:

- Tools wrongly positioned,
- The danger of being cut by the sharp edges of the sides,
- Hand injuries at the operator's place of work,
- Danger from relaxing compressed air from bursting pneumatic pipes,

2.5 Improper or misuse

On this drawer assembly unit for manually processing the InnoTech drawer system, drawers and front closing systems in various lengths and widths are joined. The numerous different system elements have to be put on manually.

Any other use like using other drawer systems with other measurements and materials shall be deemed improper use.

Attention! For damage resulting from this the producer/supplier shall not be liable. The risk shall be born by the user alone.

Improper use could damage the machine!

Alterations of the drawer assembly unit for manually processing the InnoTech drawer system not authorized by the producer shall be deemed misuse!

Attention! The producer assumes no liability for alterations of the drawer assembly unit for manually processing the InnoTech drawer system not authorized by him!

3. Technical Data

3. Technical Data

Producer : **Hüttenhölscher Maschinenbau GmbH**

Description : Drawer assembly unit for manually processing the InnoTech drawer system

Machine No.: : **01329 / ____**

Construction year : **200__ / __**

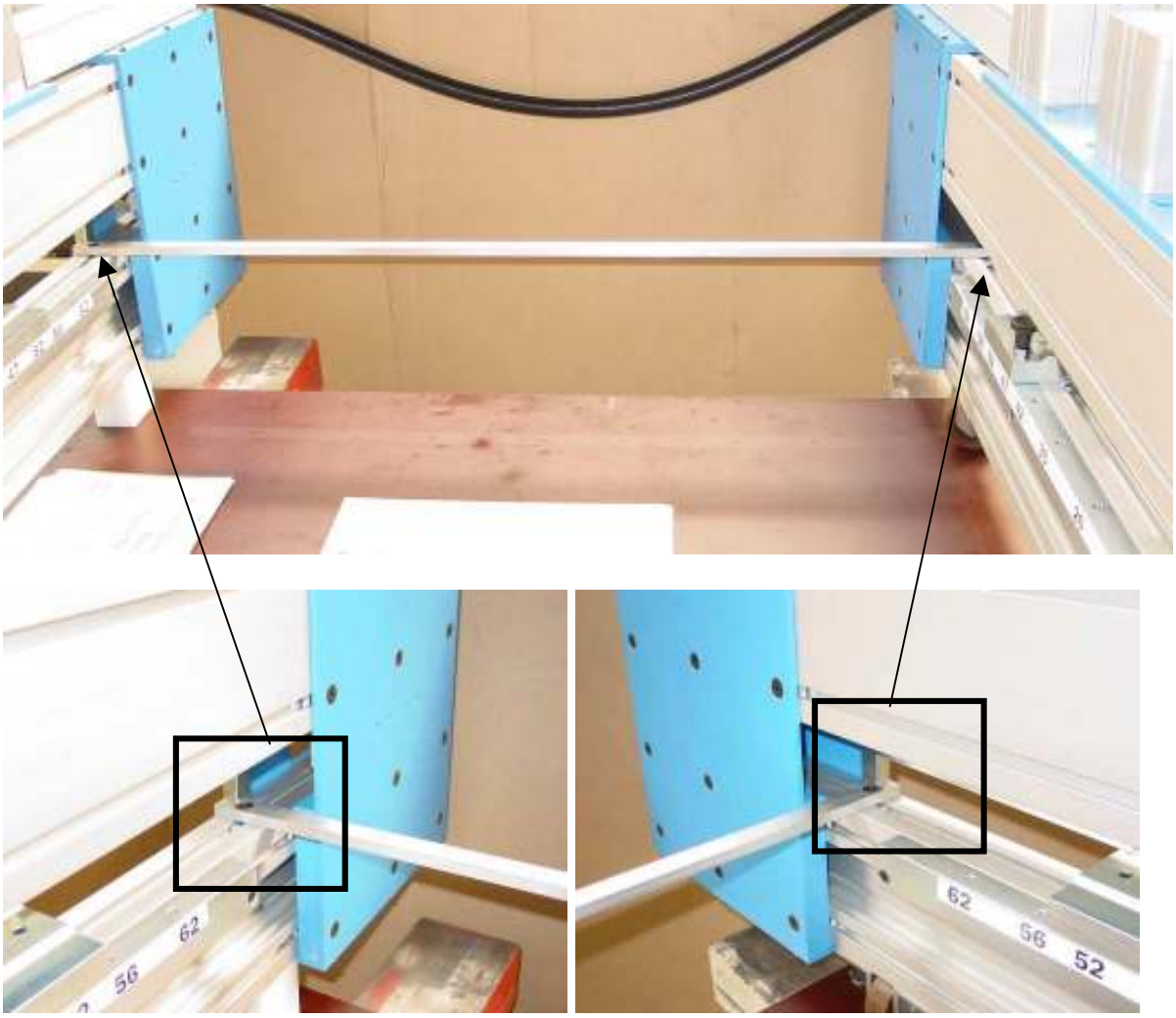
Compressed air : **6 bar**

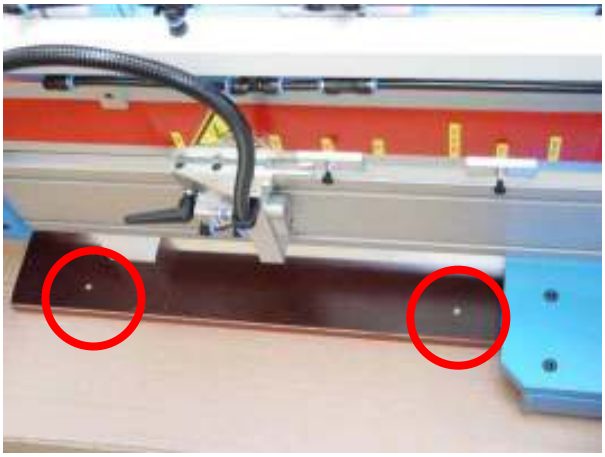
Paul Hettich GmbH & Co.
Vahrenkampstr. 12-16
32269 Kirchlengern

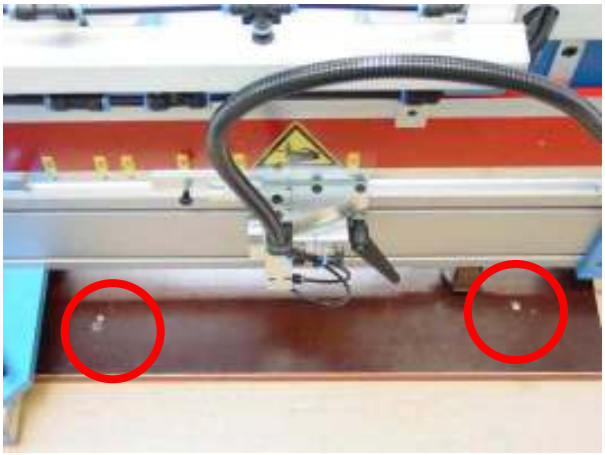
InnoTech Drawer Assembly Unit

4. Commissioning

Before commissioning remove the transport support with an Allen key

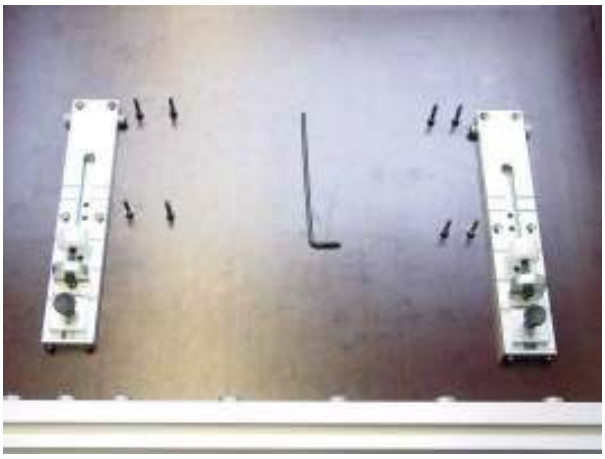






The assembly unit is fastened on the base plate to the transport palette with screws
(see pictures).

The screws have to be removed.



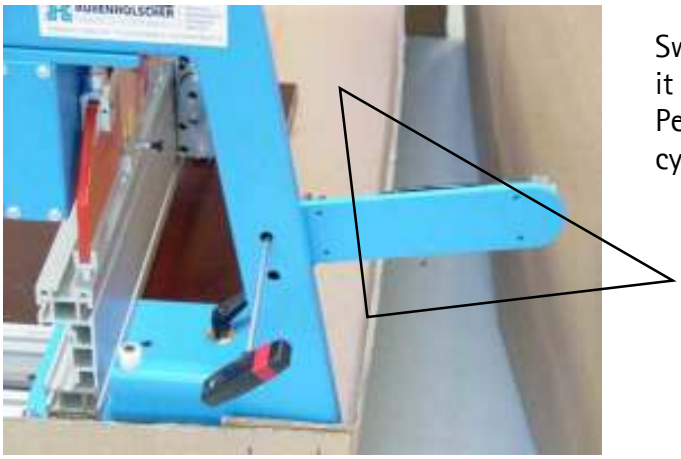
Mounting of the rear panel holders

Put one rear panel holder up against the front of the profiles and fix it with the 4 screws supplied.
Perform the procedure for both front surfaces.

Attention:

The plastic thrust piece must be mounted in the direction of the side panel cylinder.

Mounting of the side panel cylinder
Loosen the bottom screw

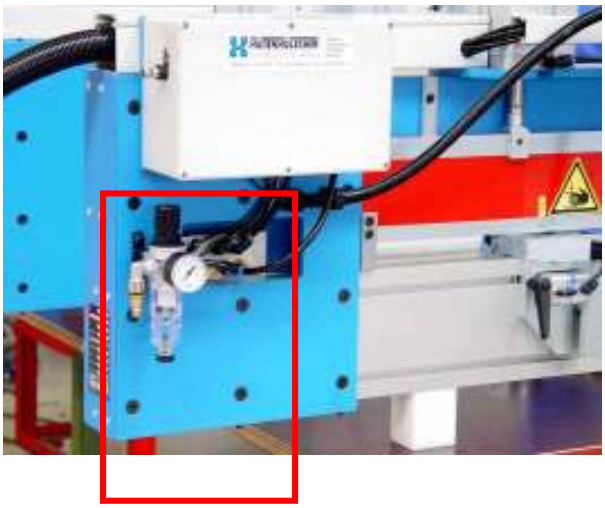


Swing in the side panel cylinder 90° and mount it with the screws supplied.
Perform the procedure for both side panel cylinders.

4. Commissioning

Important!

The pneumatic connection is to be installed only by trained specialists.

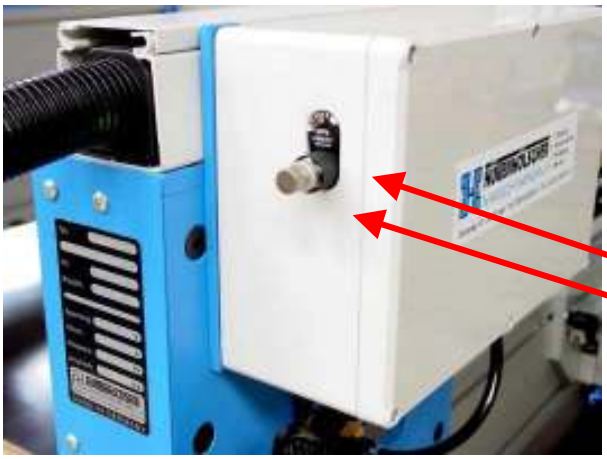


Connect compressed-air

Factory setting: 6 bar

Compressed-air supply

Setting of the counter pressure of the side panel stop



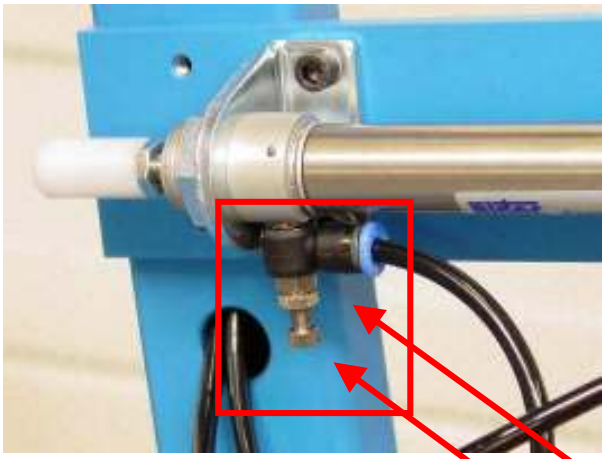
Factory setting
(0.15 – 0.20 bar) for the counter pressure of the side panels.

Loosen the knurled thumb nuts and adjust the pressure with the knurled thumb screw.

InnoTech Drawer Assembly Unit

4. Commissioning

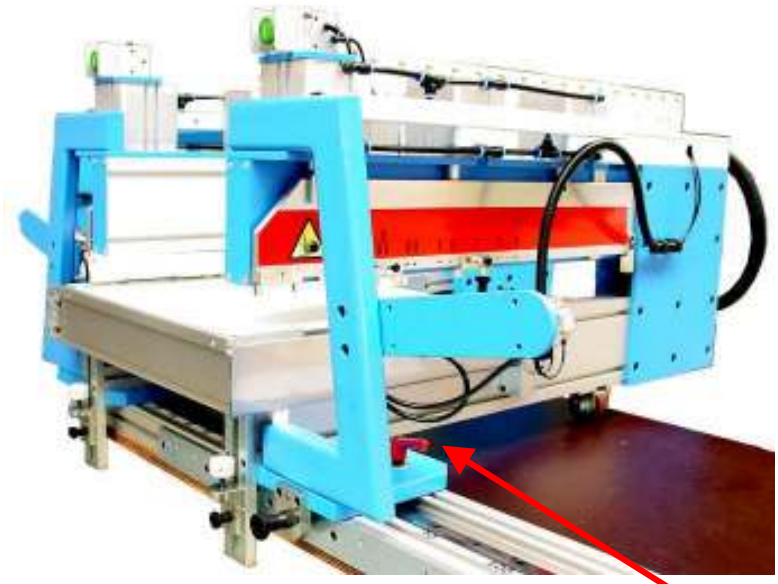
Setting of the side panel cylinder

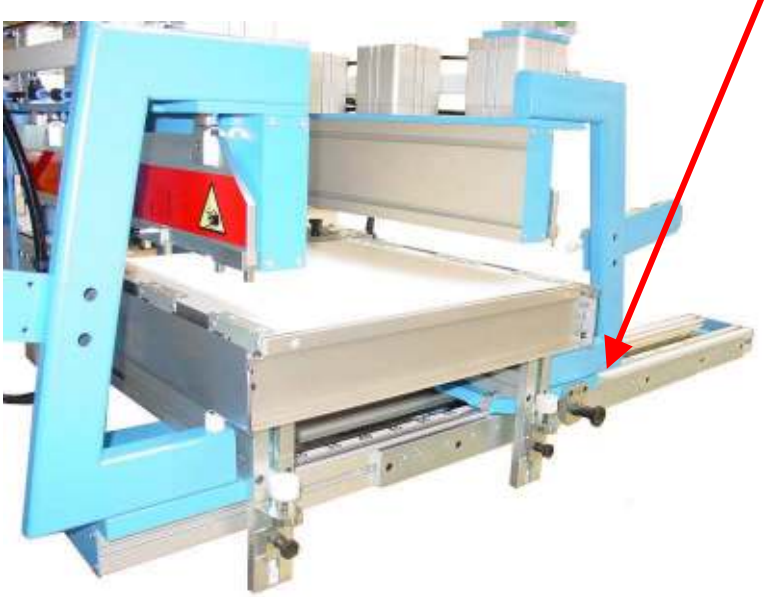


In order to assure smooth operation of the drawer assembly the side panel cylinders have to put up the side panels against the bottom of the drawer at the same time. The adjustment for simultaneous extension of the cylinders can be done with a throttle.

Attention!
Uneven positioning of the panels onto the bottom by the side panel cylinders can lead to slipping of the parts of the drawer.

Loosen the knurled thumb nuts, adjust the speed with the knurled thumb screws.



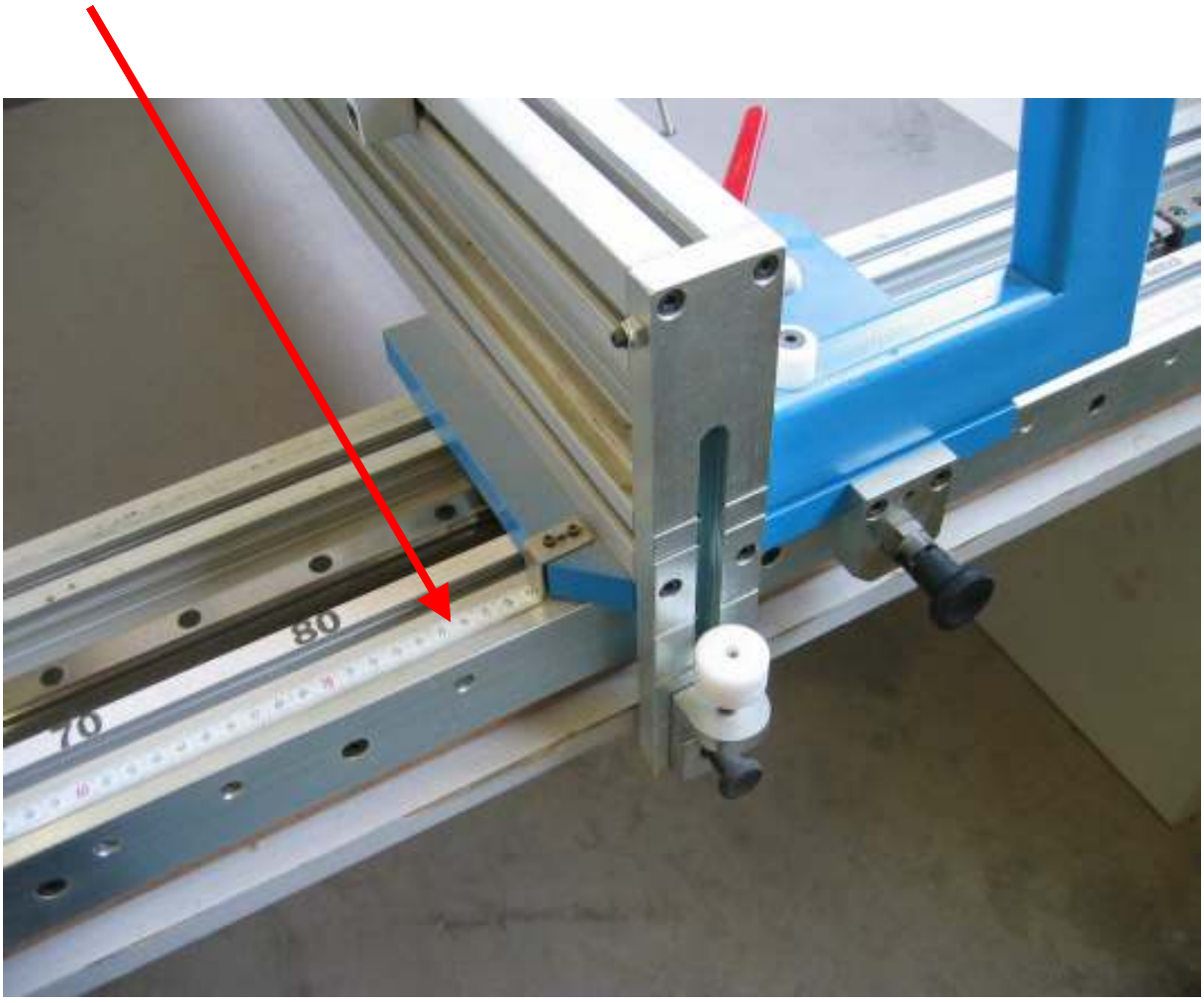


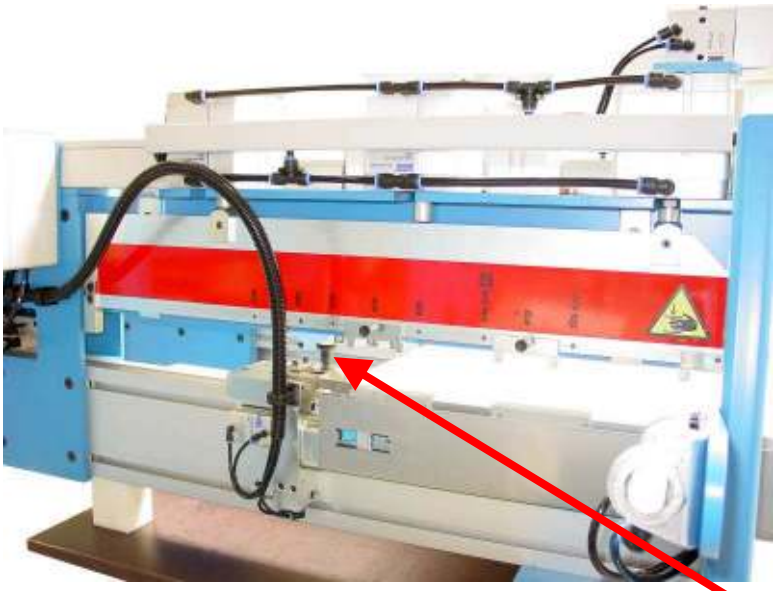
Drawer width setting
Loosen the clamping lever!
Pull up the indexing bolt, move to the required size and lock into place!
Tighten the clamping lever!

Setting of the size

With this setting required intermediate sizes or bottom widths can be adjusted.
Loosen the clamping lever! Free the stop and move it to the required size! Tighten the clamping lever!

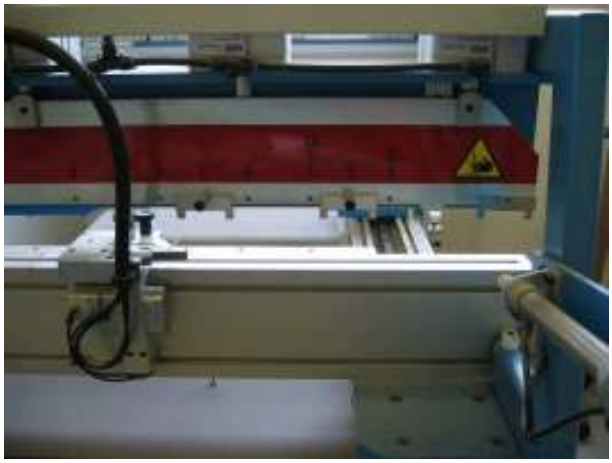
Scale = bottom blank measurement





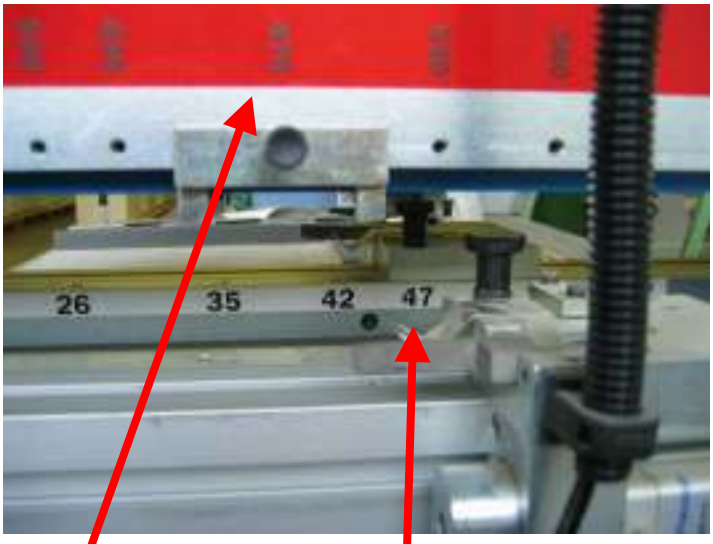
Setting of the drawer depth
Pull up the indexing bolt, adjust to the size wanted and lock into place!

Repeat this operation on the opposite side.



Set pressing plunger

Pull out the indexing bolt and adjust the pressing plunger to the required measurement. Repeat this operation on the opposite side.



470

470

For example:

470 to 470

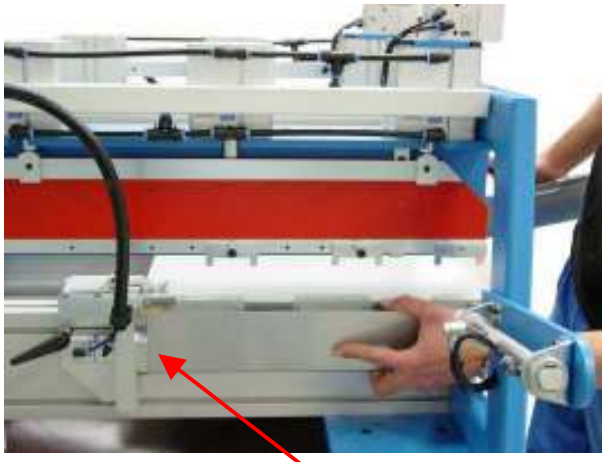
Setting of the rear panel height

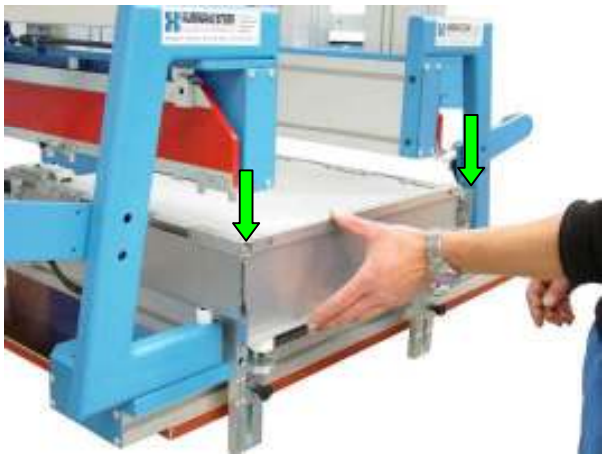
Pull out the indexing bolt and move the stop to the required rear panel height.

Repeat this operation on the opposite side.

Put in the drawer bottom and move up to the positive stop.

Put the side panels against the side of the drawer bottom and move them up to the panel stop.





Attach the rear panel of the drawer and press it with both hands laterally and from above respectively onto the adapter hooks till it locks into place.

Move the rear panel together with the side panels against the positive stop.

For the counter pressure of the side panel stops see item 1 Commissioning.

Press the two-hand control device and the drawer parts will be assembled.

Carefully withdraw the drawer after the assembly.

6. Maintenance

6.1 General Information

6.2 Inspection Instructions

6.3 Servicing Instructions

6.4 Lubrication Instructions

6.5 Spare Parts

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6. Maintenance

6.1 General Information

Operation disturbances caused by improper or insufficient servicing and inspection can lead to high cost of repairs and long down times for the drawer assembly unit for manually processing the InnoTech drawer system. Besides the surroundings of the installation, the proper operation and maintenance like care and servicing, inspection and lubrication of the system are decisive for the life expectancy and operation safety of the drawer assembly unit for manually processing the InnoTech drawer system. For carrying out servicing and repair work as well as operational disturbance by the customer's operators, the instructions for servicing, inspection and lubrication as well as installation and adjusting in accord with the intended use are to be obeyed.

Attention! **Observe chapter „2. Safety" for servicing and inspection work! Observe the suppliers' operating instructions.**

6.2 Inspection Instructions

For the intended use and warranty of the system availability it is necessary to observe the inspection intervals.

Attention! **To keep the system working observe the inspection intervals!**

Attention! **Only allow trained operators to perform inspections in the danger zones!**

Attention!
Disconnect in danger zones before inspection of the drawer assembly unit for manually processing the InnoTech drawer system !

Danger of hand injury!

Paul Hettich GmbH & Co.
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6. Maintenance

Inspection List I

Check and control the function elements	Frequency Interval	Machine / Remarks
Base frame After setting up and during operation control the vertical alignment!	monthly	Before commissioning and during operation.
Protective device Drawer assembly unit for manually processing the InnoTech drawer system Has the protective device completely been installed?	weekly	Between shifts by trained service personnel
Quality control Observe dimension deviations! Are the tolerances met?	daily	Operation
Pneumatics Regularly check all pipes, hoses, screw couplings and valves for leakage or damage!	monthly	Operation

6. Maintenance

6.3 Servicing Instructions

The defects observed during inspection intervals are to be reported and corrected immediately if possible. Beside this the intervals of the servicing list are to be considered.

Attention! **Deploy only trained personnel for installing and removing wear and tear or spare parts**

Service list

Service measures Cleaning and installing:	Frequency Interval	Machine / Remarks
Tighten screw connections.	semi annually	Entire drawer assembly unit for manually processing the InnoTech drawer systems
Clean the unit of Oil, fat and dirt.	semi annually 	Entire drawer assembly unit for manually processing the InnoTech drawer systems **Attention!** **Depressurize and secure!** Hand injuries!
Installation work! Removing and installing parts subject to wear and tear! Removing and installing supplier machines! Approved modifications and add-ons	as needed	**Attention!** **Depressurize**

6. Maintenance

6.4 Lubrication Instructions

Careful lubrication is necessary besides the inspection and servicing intervals for smooth operation of the drawer assembly unit for manually processing the InnoTech drawer system. It avoids very costly repairs.

Attention! **The drawer assembly unit for manually processing the InnoTech drawer system has to be standing still for any lubrication or work involved with lubrication.**

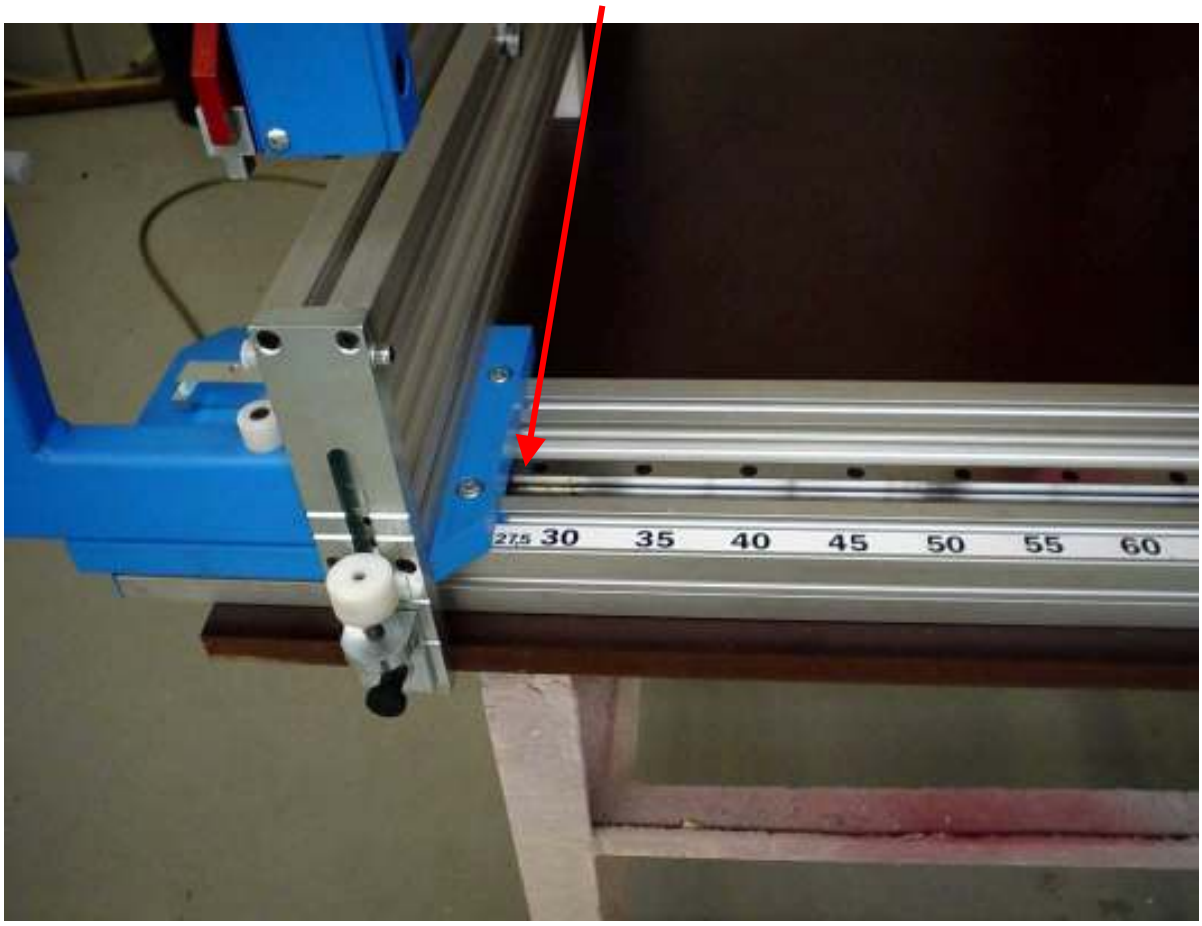
The lubrication has to be done at the intervals and with the corresponding lubricants and quantities shown in the lubrication points list.
The recommendations do not exclude the use of other brands of lubricants with the same characteristics.
Roller bearings are lubricated for their lifetime.

Attention! **The operating instructions of suppliers for lubrication are also to be observed.**

6. Maintenance

Lubrication Plan

Machine parts	Guide carriage of the unit
Contact points	All see photo 1
Graphic symbol of the contact DIN 249000	
Check	semi-annually
Clean or replace (h)	annually
Lubricant according to	



6. Maintenance

6.5 Spare Parts

Parts that ought to be replaced when servicing or doing maintenance have to be exactly described by the owner (the customer's and/or producer's operators). Consult chapter „**5. Construction and Function**" for this.
If the spare part can be found in the included lists, the item number in the parts list and the drawing number are known.
The item number in the assembly drawing corresponds to the item number in the parts list. The following data can be found in the parts list.

Attention! **The following data must be given when placing orders:**

Type of Machine:

Drawing No.: 01329

Item no. in the parts list : .....

Name: Drawer assembly unit for manually processing the InnoTech drawer system

Item No.:	Part name :		Amount
100	Pressure cylinder	NXD – 040 – 060 210	04
101	Exhaust throttle	GRAL IQS 186	04
102	Two hand control device	SZ – 14 –510	01
103	Sensor	St - 18 - 310	02
104	Filter controller (G ¼)	FRK - 14	02
106	Track roller	KSt 2702320102	01
108	Coupling socket	KDG 18 NW5	02
111	Guide carriage	LAH20GLZ - 90	01