



141-AF32

Power Feeder

Operationg instructions



Distributor:

IGM nástroje a stroje s.r.o.
Ke Kopanině 560, 252 67, Tuchoměřice
Czech Republic, EU
Phone: +420 220 950 910
E-mail: sales@igmttools.com
Website: www.igmttools.com

2022-07-11

141-AF32 IGM Power Feeder Manual EN v2.4.00 A4ob



Operating instructions EN

PLEASE READ THIS MANUAL THOROUGHLY AND FOLLOW THE SAFETY INSTRUCTIONS IN IT! TECHNICAL CHANGES AND PRINTING ERRORS RESERVED!

Dear customer,

This manual contains important instructions and information for the installation and proper use of the AF32 Power Feeder.

This manual is part of the machine and therefore it should not be kept elsewhere than in the vicinity of the machine so that you can be consulted at any time by you or other persons operating the machine.

Please read and follow the safety instructions!



Carefully read these instructions before using the machine. Operation of the machine will be simpler and you will also lower the risk of injury while eliminating the probability of incorrect operation and possible damage to the machine.

Because of our policy of constant improvement, the design, construction or pictures may differ slightly. Should you discover any mistakes, please contact us at podpora@igm.cz.

TABLE OF CONTENTS	OLD		
1. DECLARATION OF CONFORMITY	2	5.2.1 Fastening to a machine	4
2. WARRANTY SERVICE	3	5.2.2 Assembly of the feeder	5
3. SAFETY INSTRUCTIONS	3	5.3 Electrical connection	5
3.1 Notice	3	6. SET-UP AND ADJUSTMENT	6
3.2 General safety instructions	3	6.1 Basic movements of the feeder	6
3.3 Risks	3	6.1.1 Feeding from the side	6
3.4 Important safety notifications	3	6.2 Speed change	7
3.5 Safety rules	4	7. OPERATING THE MACHINE	7
4. SPECIFICATIONS OF THE MACHINE	4	8. MAINTENANCE AND CONTROL	7
4.1 Machine description	4	8.1 Replacing rollers	7
4.2 Technical data	4	8.2 Lubrication	7
4.3 The package includes	4	8.3 Transmission fluid replacement	7
5. TRANSPORT, UNPACKING AND ASSEMBLY	4	9. MALFUNCTION ASSISTANCE	8
5.1 Transport and unpacking	4	10. PROTECTION OF THE ENVIRONMENT	8
5.2 Assembly	4	11. ACCESSORIES (SPARE PARTS)	8

1. DECLARATION OF CONFORMITY

The undersigned: IGM nástroje a stroje s.r.o.

Address: Ke Kopanině 560

Tuchoměřice, Praha-západ, PSČ 252 67

Czech Republic, EU

Phone no.: +420 220 950 910

Certifies the

Product: Power Feeder

Type: **AF32**

Manufacturer: CO-MATIC Machinery Co., Ltd., No.

473-16,

San Feng Road, Houli District, Taichung

City, Taiwan, R.O.C. 42156

We declare under our sole responsibility that the product described in this manual is in conformity with the following standards: EN ISO 12100, EN ISO 13857, EN 349, EN 953, EN 60204-1, EN ISO 11202,

EN 55014-1, EN 55014-2 podle s ustanovení směrnice
2006/42/EC, 2004/108/EC, 2006/95/EC, 2002/95/EC.

Signed: Ivo Mlej
Director



2. WARRANTY SERVICE

The warranty is subject to Terms and Conditions and Warranty Conditions of IGM nástroje a stroje s.r.o., the current version of which are available at www.igmtools.com.

3. SAFETY INSTRUCTIONS

3.1 Notice

Warning: failure to comply with these rules can result in the risk of serious injury.

This machine is intended for feeding wood to be cut. Working with other materials is not permitted but can be allowed after consultation with the manufacturer. Comply with the minimum age limits specified by law. The machine may only be used when in perfect technical condition.

In addition to the operating instructions read the safety instructions and also comply with any and all special regulations of your country. You should adhere to the generally recognized technical and safety rules concerning the operation of woodworking and metalworking machinery. The manufacturer or the supplier is not responsible for any damage resulting from improper use. Every user is responsible for their own actions.

3.2 General safety instructions

The machine can pose danger when improperly operated.

Completely read the operating instructions before working with the machines and follow all the instructions in this manual.

Keep this user manual clean and protect it from dirt and moisture; in case of re-selling, pass the manual onto the new owner.

Any alterations or changes to the machine are prohibited.

Daily try out if the machine runs smoothly and check the function of protective covers before operating the machine. Remove any malfunctions or deficiencies found on the machine as well as

damaged protective cover.

The machine may only be used when in perfect technical condition.

Use a hairnet or a hat to protect long hair. Wear tight-fitting clothes, remove all bracelets, rings, necklaces or ties. Wear work boots only, do not wear casual shoes or sandals during work. Abide by the regulations for personal protection.

Always wear safety eyewear. Always use hearing protection. The tools are sharp and can cause severe injury, use them with care.

Keep in mind the necessary space for operation when installing and positioning the machine. The machine must stand on a stable surface and must be adequately lit.

Always use respiratory protection when working in a dusty environment.

Make sure you have good lighting.

Make sure the power cord is not in your way when working. Keep your work area clean. Never touch the machine when it's running.

Make sure you are concentrating and paying attention. Use caution. Never work under the influence of drugs and/or alcohol.

Make sure there are no children around when working with the machine.

Never leave the machine unattended

. Always switch the machine off when leaving the workspace.

Watch your fingers and other body parts when working. Never walk away from a machine without protective guards.

Do not place anything on the machine.

Electrical connection malfunctions can be repaired by an electrician only.

Damaged electric cord must be replaced immediately.

Any adjustments

and maintenance may be carried out when the machine is disconnected from the power source.

3.3 Risks

Risks may arise even during proper and prescribed use of the machine.

Danger of a workpiece flying off. Beware of noise and dust.

Wear eye, ear and dust protection. Use a suitable dust extraction device!

Watch out for damaged electrical cords.

3.4 Important safety notifications

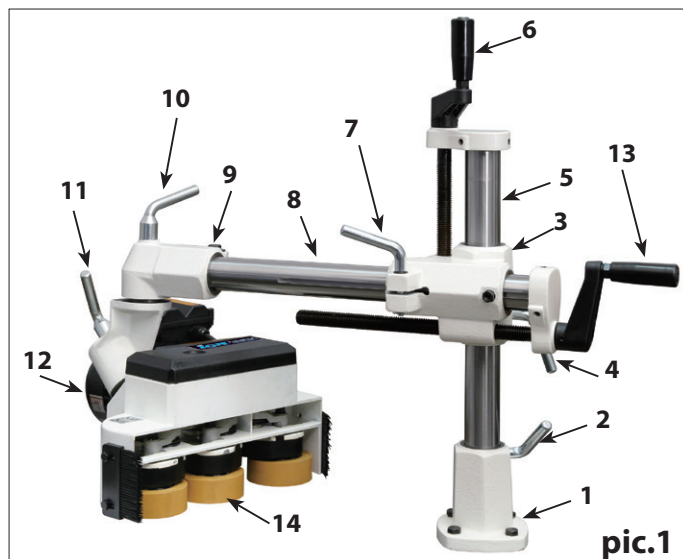
Do not use the feeder in a dangerous environment.

Operating instructions EN

Keep your workspace well ventilated and lighted, avoid wet or damp environments. Only operate the machines under temperatures ranging from +5° to +40°C.

3.5 Safety rules

The tool must reach working speed before feeding. Do not overload the machine by feeding material too quickly. ALWAYS keep your hands away from rotating parts. Provide additional support and stability for larger workpieces. Always switch off the feeder first, only



then switch off the machine that is being fed material. Always disconnect the power cord before any repairs or adjustments.

4. SPECIFICATIONS OF THE MACHINE

4.1 Machine description

- 1 base
- 2 locking lever (turning)
- 3 height-adjustable arm 4 locking lever (height adjustment)
- 5 stand
- 6 height control (turning alters height) 7 locking lever (protrusion)
- 8 feeder arm
- 9 screws (positioning joint) 10 locking lever (turning)
- 11 locking lever (angle of the feeder)
- 12 motor
- 13 control wheel of arm protrusion (turning moves the arm)
- 14 roller

4.2 Technical data

Motor power (230/400V)	240 W
Motro power (230/400V)	188 W
Arm reach	260 mm
Max. workpiece height	150 mm
No. of rollers	3
Size of rollers	80 x 30 mm
Feed speed	5 - 6,5 - 8 - 11 m/min
Weight with stand	33 kg

4.3 The package includes

The AF32 Power Feeder, Feeder Arm, Feeder base quick adjustment joint, 1:1 mounting template

5. TRANSPORT, UNPACKING AND ASSEMBLY

5.1 Transport and unpacking

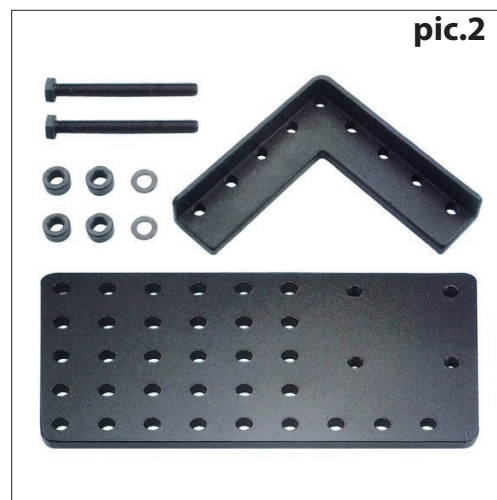
The machine is not assembled due to transport. Assemble before operating. Remove the feeder from the packaging and place on a flat surface. Check for any apparent transport damages, these could damage the machine or your health.

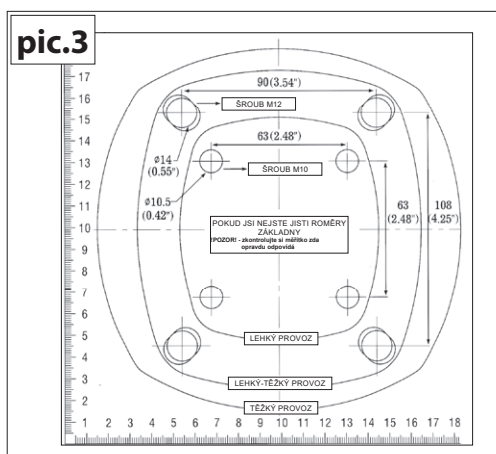
5.2 Assembly

We recommend greasing parts during assembly (the adjustment joint...)

5.2.1 Fastening to a machine

- A) using a quick fit universal plate
- you can fasten the feeder to the machine using a quick fit universal plate (not included).
- B) Mounting to the top of a workbench
The feeder is supplied with a 1:1 template that facilitates the mounting of the feeder onto a base (pic.3).





1. Unpack the feeder base and adjust it according to the mounting template.
2. Prepare 4 bolts and spring washers (not included). Bolt size - M12, length = feeder base (thickness) + table top (thickness)
3. Select position of the base to avoid ribbing on the bottom of the table.
4. Place the template on the table, use a tape to hold two sides of the template
5. Use something to mark out the holes and drill them out.

B.1) Fastening with a nut through the table

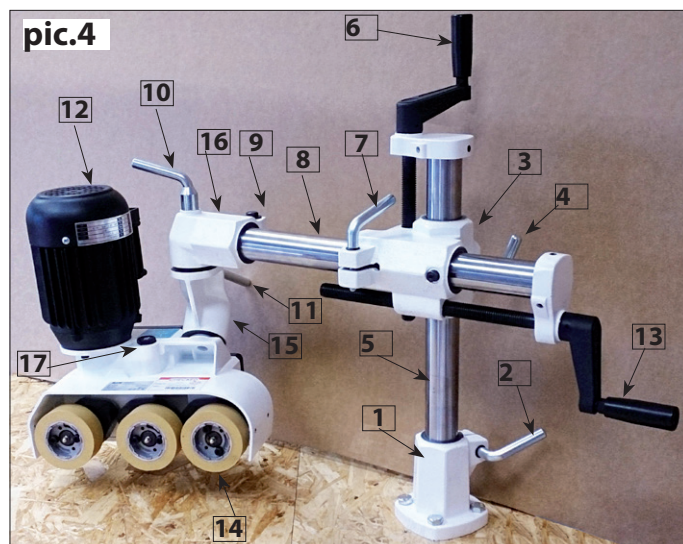
1. Insert the screws with washers through the base and the tabletop.
2. Tighten the nut to the table.

B.2) Fastening with a thread in the table

1. Use a screw cutter to drill out the holes.
2. Insert the screws with washers through the base and screw it them into the tabletop.

5.2.2 Assembly of the feeder

- Place the stand (5) into the base (1) fastened to the table
- Mount the height adjustable holder (3) with the jib onto the stand (5).
- Assemble adjustment levers (6) and (13).
- Attach the foot of the stand through which you will put the screw of the lever (6).
- Screw in the lever screw (6) into the height-adjustable holder (3).
- Insert the feeder arm (8) into the height-adjustable holder (3). Attach the lever (13).
- Rotate the lever (13) a couple of times. Tighten the lever (7.)
- Attach the end joint (16) to the feeder arm (8). WE RECOMMEND: Thoroughly grease up connecting



- surfaces during assembly. Gently tighten the screw (9).
- Screw a joint onto the feeder (15) and tighten the locking lever (11).
- Slide the arm with the end joint (16) down to the pin of the joint (15) and screw it in with a lever (10).
- Properly tighten all screws and levers.

5.3 Electrical connection

WARNING: Make sure the electrical connection corresponds to the motor specification (see engine cover.) **WARNING:** Make sure the switch is in the „OFF“ position.

A) Integrated power supply:

A power feeder is an auxiliary machine that cooperates with your spindle moulder, table saw or a planer.

It is necessary that the machine is connected in accordance with valid directives.

The electrical connection to your machine using the integrated power supply is controlled by the main switch and an emergency stop meaning you have full control over the machine. In addition, the integrated power supply provides protection against overload of the machine.

Current-carrying capacity

Type	32
Current	1,5A

The integrated power supply can be installed only by a qualified electrician.

B) Separate power supply:

You should use a separate electric socket with copper

Operating instructions EN

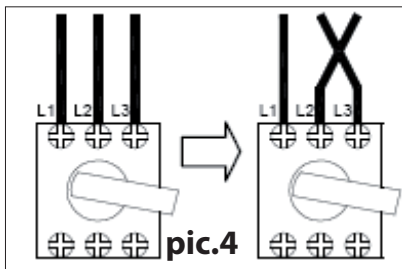
mains installed in accordance with valid directives and is protected with a 15 Amp fuse or a circuit breaker.

If you are using an extension cord, it must conform to valid guidelines. Regularly check that the cable is not damaged. Damaged electric cord must be replaced immediately.

The engine has its own grounding wire (green with yellow stripes).

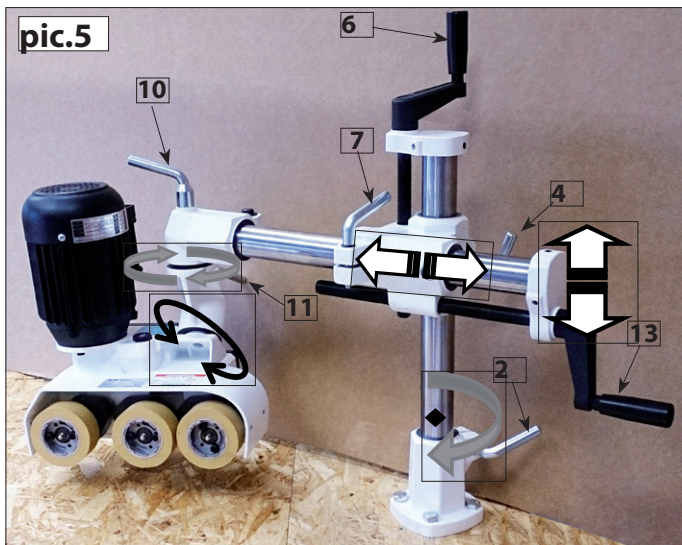
If you are unsure about the electrical connection, consult a qualified electrician.

If the motor spins in an opposite way than you require, ask a qualified electrician to switch the L2 and L3 phases.



6. SET-UP AND ADJUSTMENT

- Release the screw (9, pic.4)
- Place a 3-4 mm high pad under the output roller and slowly run the feeder down until the input roller lies on the surface and the output roller is touching the pad.
- Tighten the screw again (9, pic.4), this grants more pressure on the outfeed roller.



6.1 Basic movements of the feeder

- For rotation around the axis of the base: release lever (2), and turn the feeder to the requested position.



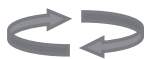
- To extend or compress the arm of the feeder: release the lever (7) and turn the lever (13).



- To alter the height: release the lever (4) and turn the handle (6).



- To rotate the feeder: release the lever (10) and turn the whole feeder.



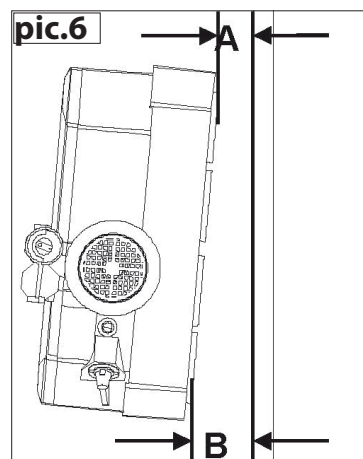
- To angle the feeder: release the lever (11) and turn the whole feeder.



Tighten all levers when finished.

6.1.1 Feeding from the side

- Release the locking lever (2) and turn the feeder off the workbench.
- Release the lever (11), turn the feeder to a vertical position. Turn it back on the workbench and tighten all the levers.
- The workpiece must be leaning on a guiding fence when feeding. The rollers must push the workpiece against the fence. The difference between the distance of the feeder and the fence should be greater on the infeed roller by 3-4 mm than on the



outfeed roller (pic. 6).

6.2 Control panel features

Main switch (pic.7)

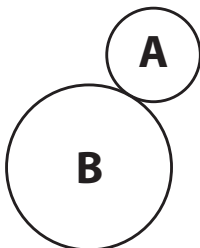
- switch positions:

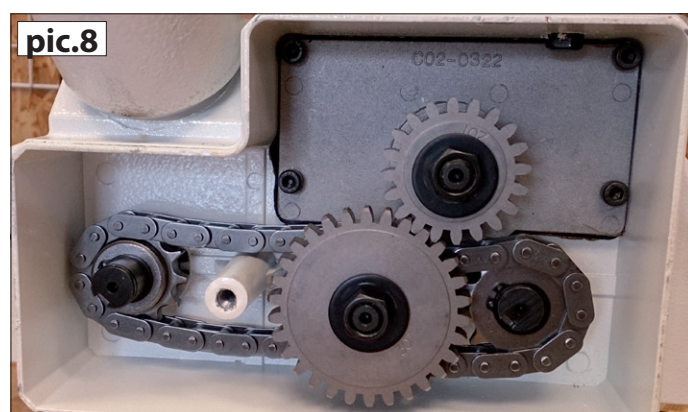
- **O** - turned off
- **REV** - reverse feed
- **FOR** - forward feed



6.2 Speed change

- Disconnect the feeder from the power supply to change speed.
- Loosen the Allen screw that holds the side cover of the gearbox.
- Alter speed by changing gears (pic.8) according to the following table on the inside of the gearbox cover.
- The package includes 4 wheels with no. of teeth: 20, 24, 26, 30. The no. of teeth is marked on the gear.

	Gear	Speed/min.	
		50 Hz	60 Hz
	A20 - B30	5m	6m
	A24 - B26	6,5m	8m
	A26 - B24	8m	10m
	A30 - B20	11m	13m



- going for maximum efficiency and quality of work. The feed speed is very much linked to the speed of your machine, quality of tools and thickness of the material you work with. We recommend testing the work conditions and making a visual control. The feed speeds listed in the table are informative only.

7. OPERATING THE MACHINE

After switching the machine on, let the feeder reach its full speed before feeding any material.

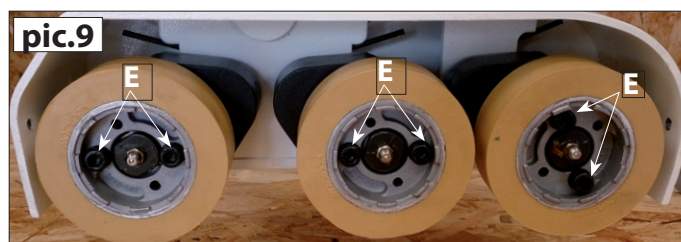
8. MAINTENANCE AND CONTROL

8.1 Replacing rollers

Any adjustments and maintenance may be carried out when the machine is disconnected from the power source.

Note:

The regular switch up of roller position grants longer life of the rollers.



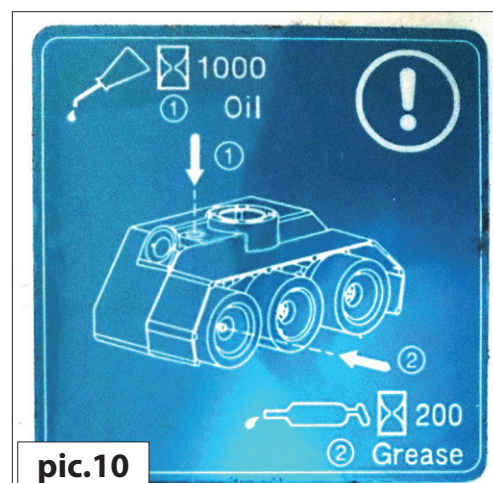
- To remove the roller, loosen the two screws (E, pic.9) and remove the wheel from the shaft.
- Use the D80x30 mm roller for the AF32 Power Feeder. (code: 141-R80)

8.2 Lubrication

- The wheels and chains should be greased every 200 hours or 30 days using a grease gun, see section 2, the location of grease on the displayed label (pic.10).
- Gears and chains: grease regularly.
- Recommended greases: (Shell – Alvania Grease R2, SHELL GADUS S2 V220 2, MOBILUX EP 2; FUCHS RENOLIT EP 2; BP ENERGREASE MM-EP 2 and other)

8.3 Transmission fluid replacement

- Oil change after 200 hours of operation (30 days) of a new machine. Afterwards, replace oil every 1000 hours (6 months).
- Rotate the feeder away from your bench. Unscrew the two Allen screws and pull the motor upwards. Turn the feeder upside down and let the oil drain. When the oil is drained, return the feeder to its previous position and pour the transmission fluid in, approximately 2,5 cm below the edge of the motor.
- Recommended gear oil: MOBIL Mobilgear 630, Shell/Omala 150 BP, Energol GR-XP 150, and other equivalents.
- Clean the machine after every use (dust, shavings etc.).



Operating instructions EN

9. MALFUNCTION ASSISTANCE

- If you are not sure why a problem occurred, please contact technical support.

10. PROTECTION OF THE ENVIRONMENT

Protect the environment.

Your machine contains materials that can be recycled. Please, let specialized institutions handle the machine.

11. ACCESSORIES (SPARE PARTS)

IGM Spare Roller D80x30 for Feeders AF32 **141-R80**

IGM Quick Fit Universal Plate for M3, AF32 Feeders

141-DP

