

... the roof and wall range of



Operating Instructions

Coil Trolleys / Decoilers

- **K1-CW** (decoiler only)
- **K1-CW/AQ** (with roll-off and cross-cut-device)
- **K1-CW/AQ-LSE** (with roll-off, cross-cut-, and slitting device)



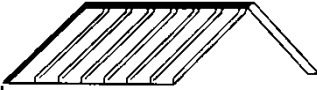
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General Notes

Observe the safety instructions listed for your own protection and for the protection of others in your working environment. The safety instructions warn you of possible danger conditions and give you instructions on how to avoid them by your own behavior.

Legend

In the operating instructions, the safety instructions are listed chapter-specifically again. They are indicated by the pictograms:



Tip



Attention



Danger in general



Danger specific



Specific bid signs



Prohibition signs

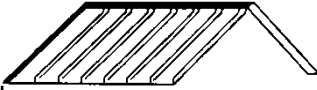
Appropriate use

The K1-CW* series coil wagons may only be used for storing and unrolling coil material in accordance with the technical specifications and the procedure described in this manual.

Obligation of the operator

The operator must ensure that only trained personnel are used to operate the coil wagon and the transport and cutting unit.

The operating instructions must always be kept with the machine.



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Safety Instructions for operators and operating personnel



All work on the roof and wall must comply with the relevant occupational safety guidelines and safety regulations!

Before connecting to the power grid and commissioning electrical accessories and supplied special accessories, check the power cord for damage! If damage, or e.g. hair cracks, the coil cart must be sent to the manufacturer for repair!



Work on sheet metal roofs in **rain** and **snow** is prohibited according to DIN 18339, accident prevention regulations !



Accident!



The maximum load must not be exceeded



Coil trolleys and accessories such as e.g. electrical or battery-operated scissors are **splash-proof according to IP20**. **Working in case of rain** is therefore **not permitted**.



Electrical accessories and special accessories supplied may only be connected to grounded protective contact sockets!
Danger of electric shock!



Always wear protecting gloves. High risk of accidents.



During adjustment and assembly work, remove the mains plug from the protective contact socket!
Injury!



Coil wagons must **not** be transported as a **floating load**.



The coil trolley may only be put into operation with original reels and wheels.



Work overhead is not permitted. Do not lay under the spindle or coil trolley.



Before commissioning, all parts such as .B shafts/spindle, reel brake and **rollers** must be checked for correct fit **and proper installation**.



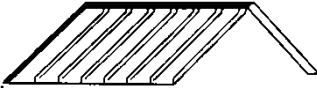
Sitting, driving, or standing on the coil cart is forbidden! **Risk of accident!**



The **machine operator** must be protected against a **crash** during work on the roof!
Accident!



When working on **steep** slopes, the coil trolley **must** be secured with additional **rollers and crash with ropes**. **Risk of accidents!**




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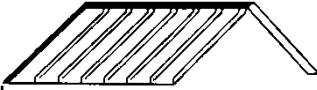


Scope of delivery

	K1-CW	K1-CW/AQ	K1-CW/AQ-LSE
Coil trolley	X	X	X
Cross-cutting device AQ		X	X
Longitudinal cutting device LSE			X




K1-CW	K1-CW/AQ	K1-CW/AQ-LSE
<ol style="list-style-type: none"> Coil trolley K1-CW, mobile, mobile with reel incl. 2 buck and 2 steering wheels Load capacity: K1-CW125+150:1.5 t K1-CW100: 2.0 t. Reel 5-arm, thus no pressure points for clamping and coiling. Weight: 100 kg. Max coil outer diameter: 1100 mm. The coil trolley can be used for profiling systems and bending benches for siging. Type designation and coil working width: K1-CW 100 800 mm # 91201 K1-CW 125 1000 mm # 91202 K2-CW 150 1250 mm # 91205 	<ol style="list-style-type: none"> Coil trolley K1-CW/AQ, mobile with reel incl. 2 buck and 2 steering wheels Coil holder inside K1-CW/100 x 230-510 mm Coil holder Inside K1-CW/125 x 250-515 mm Coil holder Inside K1-CW/150 x 390-535 mm. Reel 5-arm, thus no pressure points for clamping and coiling. Load capacity: K1-CW125+150:1.5 t / K1-CW100: 2.0t. Max roll-off power: approx.750 kg Coil outer diameter max.: 800 mm Weight complete with roll-off and cross-cutting device: approx. 130 kg. <p>Type designation and coil working width:</p> <p>K1-CW/100 AQ 800 mm # 91241-2 K1-CW/125 AQ 1000 mm # 91242-2 K1-CW/150 AQ 1250 mm # 91245-2</p>	<ol style="list-style-type: none"> Coil trolley K1-CW/AQ, mobile with reel incl. 2 buck and 2 steering wheels Coil holder inside K1-CW/100 x 230-510 mm Coil holder Inside K1-CW/125 x 250-515 mm Coil holder Inside K1-CW/150 x 390-535 mm. Reel 5-arm, thus no pressure points for clamping and coiling. Load capacity: K1-CW125+150:1.5 t / K1-CW100: 2.0t. Max roll-off power: approx.750 kg Coil outer diameter max.: 800 mm Weight complete with roll-off, transverse and longitudinal cutting device: approx. 150 kg. <p>Type designation and coil working width:</p> <p>K1-CW/100AQ-LSE 800 mm K1-CW/125AQ-LSE 1000 mm K1-CW/150AQ-LSE 1250 mm</p>
<p>Reel to coil trolley - individually -</p>  <p>K1 - CWz / 100 # 91221 K1 - CWz / 125 # 91222 K1 - CWz / 150 # 91225</p>		



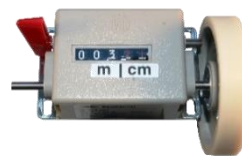
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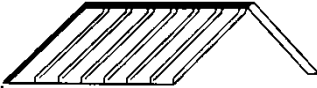
specifications

K1-CW	K1-CW/AQ	K1-CW/AQ-LSE
<p>Capacity: K1-CW100, 2,0 t K1-CW125: 1,5 t K1-CW150: 1,5 t.</p> <p>Weight: K1-CW100, 100 kg K1-CW125: 115 kg K1-CW150: 130 kg</p> <p>Coil inner diameter variable: K1-CW/100: Ø 230-510 mm K1-CW/125: Ø 250-515 mm K1-CW/150: Ø 390-535 mm.</p> <p>Max coil outer diameter: 1100 mm.</p>	<p>Capacity: K1-CW100/AQ, 2,0 t K1-CW125/AQ: 1,5 t K1-CW150/AQ: 1,5 t.</p> <p>Weight: K1-CW100/AQ, 130 kg K1-CW125/AQ: 145 kg K1-CW150/AQ: 155 kg</p> <p>Coil inner diameter variable: K1-CW/100: Ø 230-510 mm K1-CW/125: Ø 250-515 mm K1-CW/150: Ø 390-535 mm.</p> <p>Max rolling power AQ: ca.750 kg</p> <p>Max Coil outer diameter: 800 mm</p>	<p>Capacity: K1-CW100/AQ-LSE, 2,0 t K1-CW125/AQ-LSE: 1,5 t K1-CW150/AQ-LSE: 1,5 t.</p> <p>Weight: K1-CW100/AQ-LSE: 140 kg K1-CW125/AQ-LSE: 155 kg K1-CW150/AQ-LSE: 165 kg</p> <p>Coil inner diameter variable: K1-CW/100: Ø 230-510 mm K1-CW/125: Ø 250-515 mm K1-CW/150: Ø 390-535 mm.</p> <p>Max rolling power AQ: ca.750 kg</p> <p>Max Coil Outer Diameter: 800 mm</p> <p>Max cutting width: K1-CW100/AQ-LSE: 800 mm K1-CW125/AQ-LSE: 1000 mm K1-CW150/AQ-LSE: 1250 mm</p> <p>Cutting performance Aluminum, zinc, copper: 1.0 mm Iron plate: 0.7 mm Stainless steel V2A: 0.5 mm</p> <p>Slitter attachment LSE: Variable infinitely variable width adjustment</p>
<p style="text-align: center;">Reel to coil trolley - individually -</p>  <p style="text-align: center;">Spindellänge: K1-CWz/100: K1-CWz/125: K1-CWz/150:</p>		

Available as optional accessories:



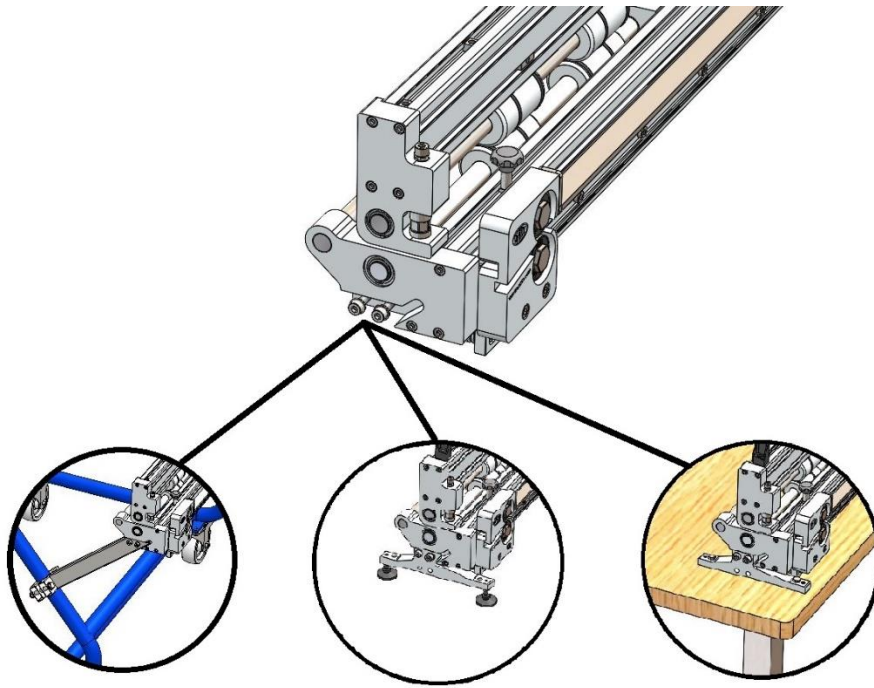
Mechanical length measurement device K1-LAQ # 91260-1



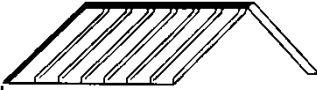
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Installation and assembly options of the K1-AQ rolling and cross-cutting device



1. **Mounting on the coil trolley by means of supports**
2. **Setting up on table by means of support feet**
3. **Fixed assembly by means of screw connection**



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Operating instructions for the coil trolley with roll-off and cross-cutting device K1-CW/AQ and K1-CW/AQ-LSE


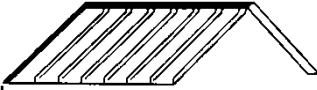
1. Insert the reel into the coil material and clamp it by means of a clamping cross (on the threaded spindle). Position the coil as centrally as possible on the reel.
2. Lift coil material with reel onto the coil trolley by means of cranes or lifting trolleys. (Observe video instructions if necessary.)
3. Depending on the weight of the coil, tighten both brakes on the star handle,  so that it does not roll itself off.
4. Insert material between aluminum transport rollers. (see illus. 2, next page)
5. Set, apply and tighten tape entry stops on both sides on the material width. (illus. 2, see next page) After the coil material has arrived on the outlet side, the outlet stops should also be set to the coil width (illus.4, see next page)
6. Using a handwheel (illus. 5, see next page) or ratchet, insert the coil material about 3-6 mm over the roller scissors. Cut off material overhang (s.c. zero cut) so that the next cut is true to size and right angled.
7. If the cross-cutting device is equipped with an optional k1-LAQ length measuring device, it should be reset to zero after each cut if it is to be measured again.
8. With the handwheel, only small coils up to approx. 300 kg can be turned forward. If the weight is above, it may be possible to turn forward with a ratchet.
9. When turning forward, the material slips through with the handwheel or ratchet, increasing the pressure on the transport rollers: loosen both nuts and turn screws until the material is held or transported. (illus. 4, see next page) In case of coils that are too heavy, strain relief may have to be produced by turning the coil along.
10. At the height of the handwheel (illus. 5, see next page) (or ratchet) there is a locking lever, which prevents the material from running back, therefore necessarily tighten after insertion of the material before the first cut takes place.
If the return blocking is in operation, the material can only be transported forward. It is then no longer possible to turn the material back. For this purpose, the locking lever of the return block must be loosened again.
11. The front support foot on the coil trolley is adjustable in height to compensate for ground unevenness if necessary.
The steering wheels are fitted with a brake and should also be detected to ensure a safe stand during rolling and cutting.



illustration 1

The knives of the roller scissors can be sharpened and replaced if necessary.
All bearings are maintenance-free.



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Decoiling & cross cut attachment K1-AQ



Weight of the rolling and cross-cutting device:
Depending on the version 30 - 39 kg (without coil trolley and reel)

The roll-off and cross-cutting device with Roller shears are available as an addition for **each DRACO decoiler**, or for screwing on available to the **workbench**.

Type designation and coil working width

K1 - 100 AQ	800 mm	# 91251-2
K1 - 125 AQ	1000 mm	# 91252-2
K1 - 150 AQ	1250 mm	# 91255-2

Cutting performance

Aluminum, zinc, copper:	1,0 mm
sheet iron:	0,8 mm
Stainless steel V2A:	0,5 mm

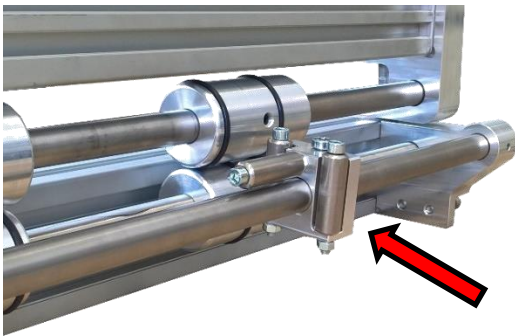
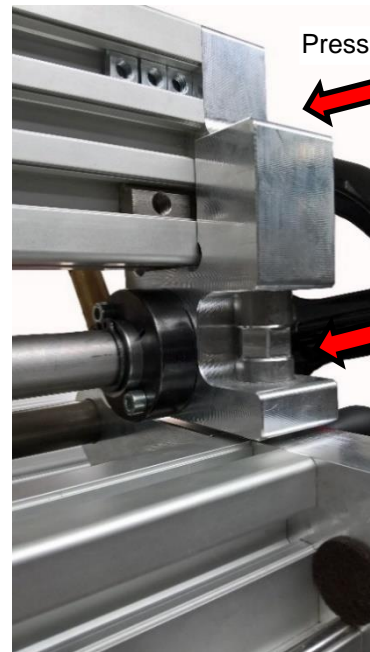
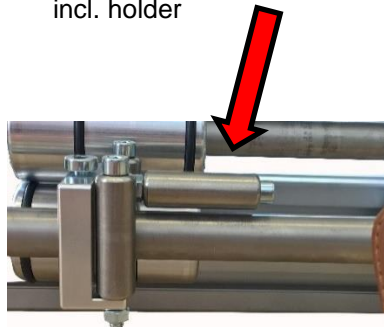


illustration 2

Guides Material Feed
incl. holder



illustration 3
Guide standard



Pressure setting for feed

Pressure setting for
feed rollers

illustration 4

Loosen nuts to adjust.
For higher pressure: Screw screws in
For lower pressure: unscrew

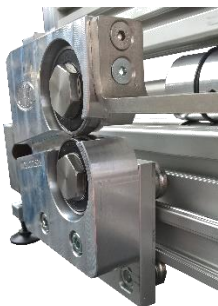
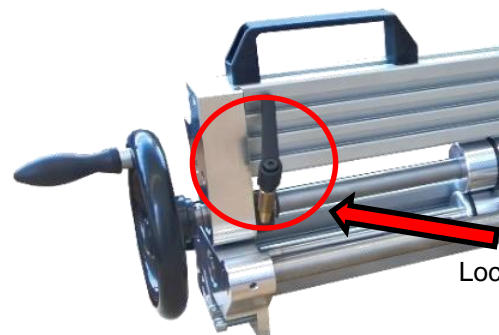


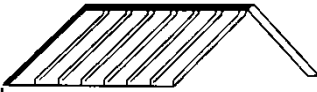
illustration 6, Roller shear for pulling,
regrindable.



Locking levers

illustration 5

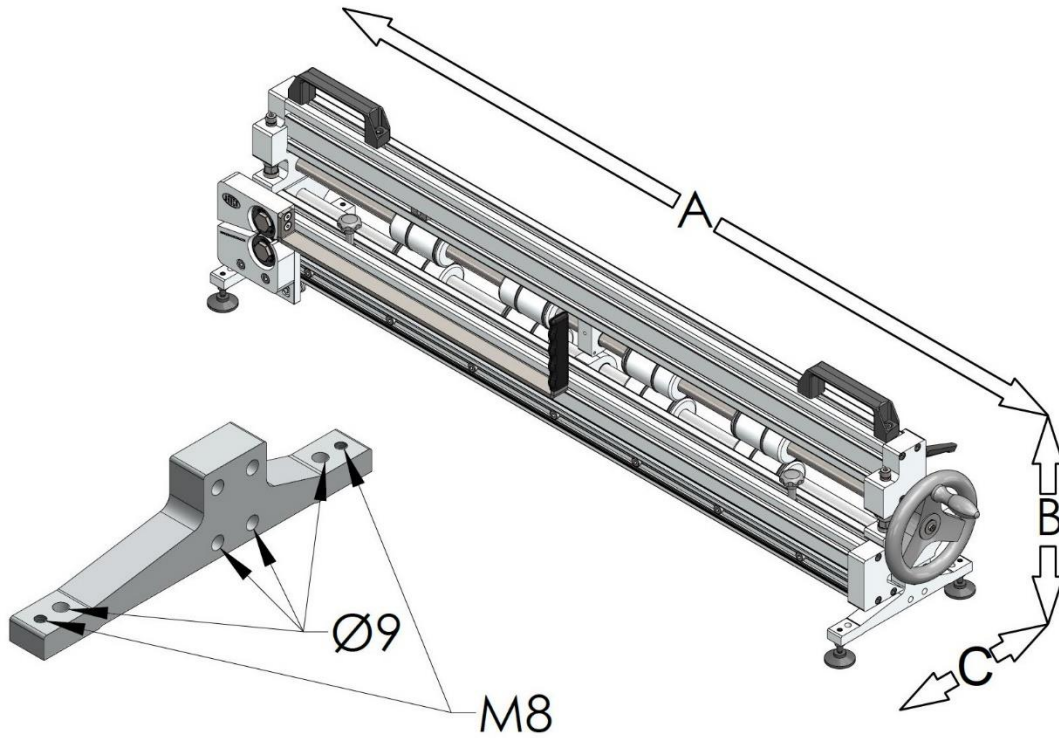
Handwheel for forward and return.
Return blocking by means of locking levers for
avoidance of return (e.g. for heavy coils).



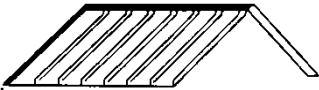
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Dimensions of the roll-off and cross-cutting device K1-AQ



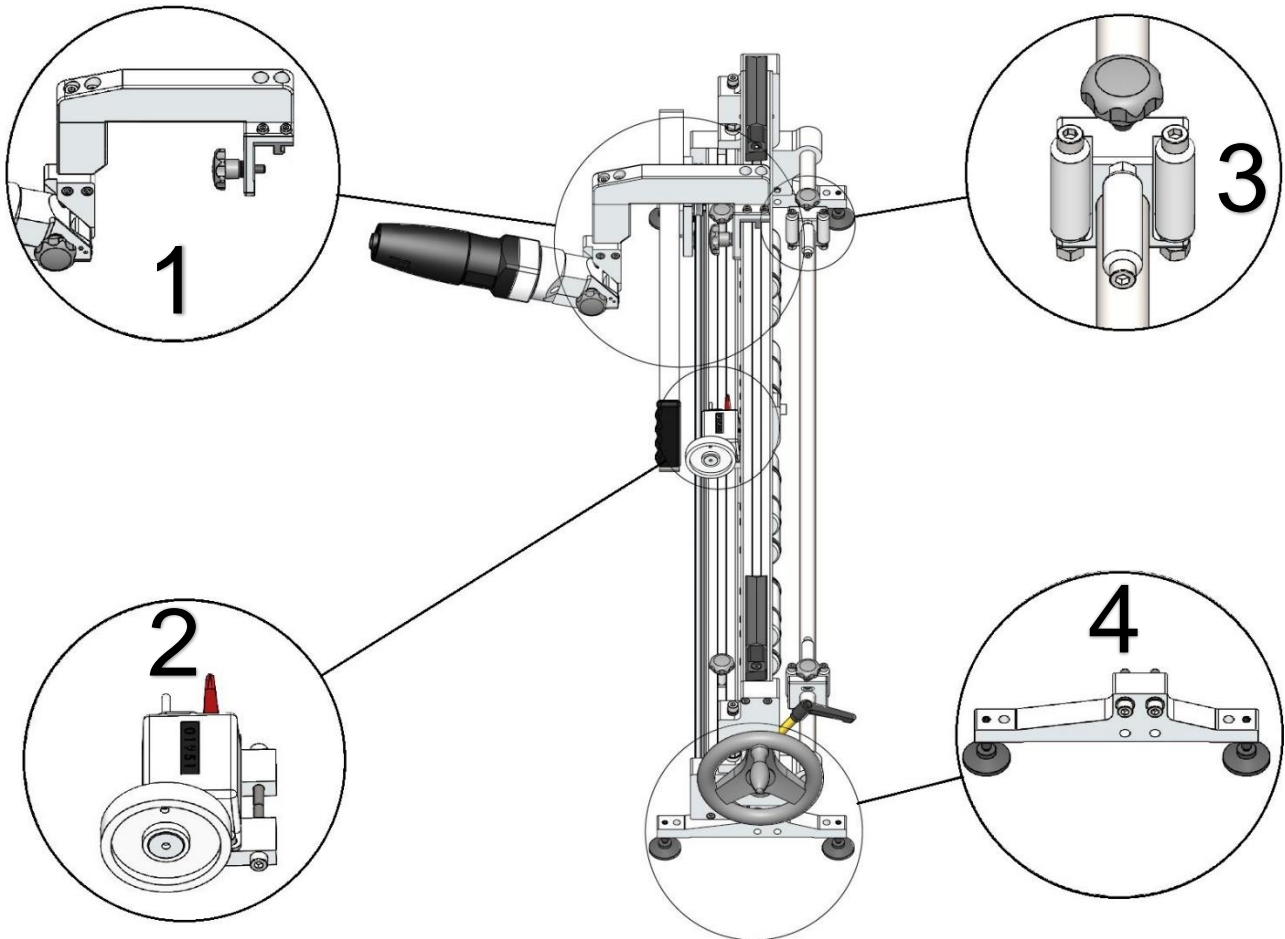
	A (mm)	B (mm)	C (mm)
K1-AQ 100	1204	333	274
K1-AQ 125	1525	333	274
K1-AQ 150	1754	333	274



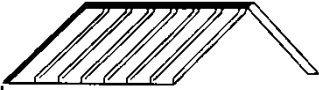
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Optional accessories



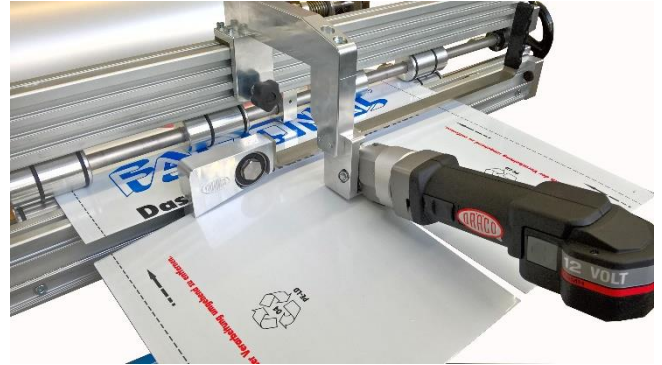
	Type	Designation	Item No.
1	K1-LSE	Longitudinal cutting device	91268-2
2	K1-LAQ	Length measuring device	91260-1
3	K1-AMN	Guides Material supply incl. holder	91263
4	K1-FT	Feet for table mounting	BGC300218



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Longitudinal cutting device K1-LSE



The longitudinal cutting device is used for the assembly of a DRACO sheet metal shear, in order to be able to cut lengthly at the transport and cross-cutting device K1-AQ.

For this purpose, the longitudinal cutting device is mounted on the transport and cross-cutting device K1-AQ. In the upper groove, the device is only inserted and fixed to one of the front grooves.

The longitudinal cutting device can then be adjusted to the left or right steplessly, or adjusted to the desired sheet width.



Optional professional battery set AK 3514-2 S1 with hole for strip cutter for mounting on the longitudinal cutting device K1-LSE.

(5-piece professional battery set AK3514-2 with 2 batteries, charger and transport case)