



F44

FORMATORE AUTOMATICO PER CASSE IN CARTONE

AUTOMATIC CASE FORMER

MACHINE AUTOMATIQUE A FORMER DES BOITES EN CARTON

AUTOMATISCHER KARTONFORMER

MOLDEADORA AUTOMATICA PARA CAJAS DE CARTON

MANUALE DI ISTRUZIONI E PARTI DI RICAMBIO

INSTRUCTIONS MANUAL AND SPARE PARTS LIST

MANUAL D'INSTRUCTIONS ET PIECES DETACHEES

BEDIENUNGSANLEITUNG UND ERSATZTEILLISTE

MANUAL DE INSTRUCCIONES Y RECAMBIOS

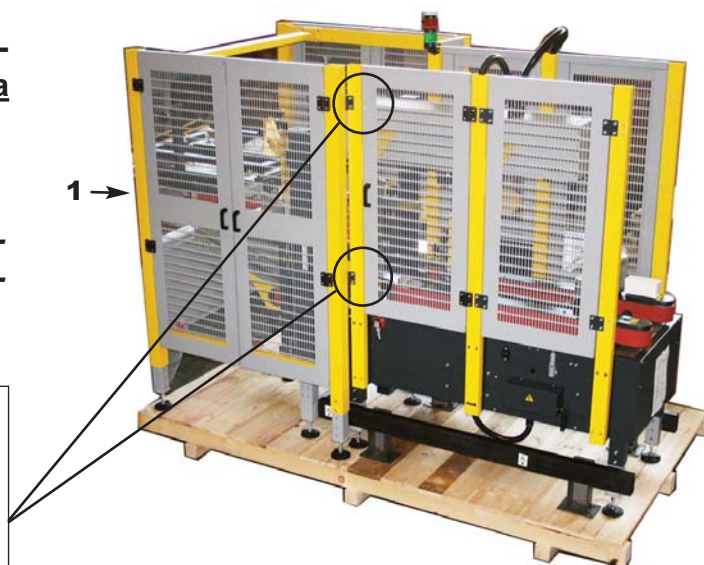


ATTENZIONE:

Prima di sollevare la macchina è necessario rimuovere la protezione perimetrale completa (1) del magazzino cartoni.

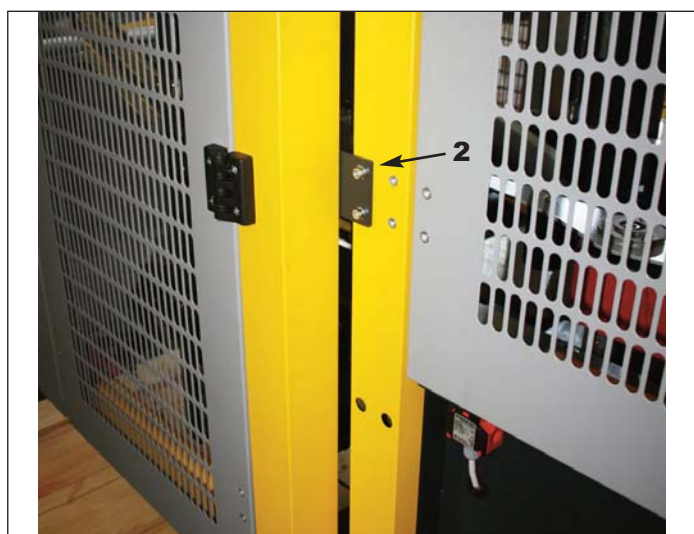
ATTENTION :

Before lifting the machine it's necessary to remove the complete perimetric safety protection (1) of the cartons storage.



Rimuovere le viti delle quattro piastrine di fissaggio (2) della protezione.
Rimuovere la protezione (1).

*Remove the screws of the four fixing plates (2) of the safety protection.
Remove the safety protection.*



Sollevare la macchina con un carrello elevatore inserendo le forche sotto la traversa inferiore avvitata alle gambe del bancale unicamente in corrispondenza dei punti indicati (etichette con il simbolo del carrello elevatore).



Lift the machine by a forklift inserting the pitchforks under the lower cross member, that are screwed to the pallet legs, only in correspondence of the suitable points (labels with forklift symbol).





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Instruction manual for the use, safety, maintenance and spare parts concerning the automatic case former machine
Model F44

This publication is property of SIAT S.P.A.
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The manufacturer reserves the right to modify the product at any time without notice.

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Release 0



F44

AUTOMATIC CASE FORMER

- Minimum box size: **h. 150 mm x w. 150 mm x l 200 mm**
- Maximum box size: **h. 400 mm x w. 350 mm x l 450 mm**
- Adhesive tape 50 mm
- Belt speed 21 m per minute
- Production 18 boxes per minute

		LIST OF ABBREVIATIONS, ACRONYMS AND UNSUAL TERMS TO BE FOUND IN THIS MANUAL	
	Section		
Manufacturing specifications	1.1		
Manual, how to use the	1.2	Dwg.	= drawing
Serial Number	2.1	Encl.	= enclosure
After-sale service	2.2	Ex.	= example
Warranty	2.3	Fig.	= figure showing spare parts
Safety	3	Max.	= maximum
Operators' skill levels	3.6	Min.	= minimum
Technical specifications	4	Mod.	= machine model
Dimensions and weight	4.2.-4.6	N.	= number
Noise measurement	4.10	N/A	= not applicable
Transportation	5	OFF	= machine stopped
Unpacking	6	ON	= machine running
Installation	7	OPP	= oriented polypropylene adhesive tape
Theory of operation	8	Pict.	= picture
Controls	9	PLC	= Programmable Logic Control
Safety devices	10	PP	= polypropylene
Set-up and adjustments	11	PTFE	= Polytetrafluorethylene
Operation		PVC	= Polyvinylchloride
		Ref.	= reference mark
Cledaning	12.4	SIAT SPA	= Società Internazionale Applicazioni Tecniche (Società per Azioni)
Maintenance	13		
Lubrication	13.4-13.5	Tav.	= Illustration
Blades replacement	13.7		
Belts tension adjustment	13.8	w	= width
Belts replacement	13.9	h	= height
Fire emergency	14.2	l	= length
Enlosures	15	ol	= overall length
		cbh	= conveyor bed height

1-INTRODUCTION

1.1 MANUFACTURING SPECIFICATIONS

The automatic case FORMER machine Mod. F44-has been designed and manufactured complying with the legal requirements in force at the date of its manufacture.

THE REFERENCE DOCUMENTS ARE:

Direttive 98/37/CE, 2006/95 CE, 89/336 CEE, 108/04 CE, 2002/96/CE, 2003/108/CE.

1.2 HOW TO READ AND USE THE INSTRUCTION MANUAL

1.2.1 IMPORTANCE OF THE MANUAL

The manual is an important part of the machine; all information contained herein is intended to enable the equipment to be maintained in perfect condition and operated safely. Ensure that the manual is available to all operators of this equipment and is kept up to date with all subsequent amendments. Should the equipment be sold or disposed of, please ensure that the manual is passed on. Electrical and pneumatic diagrams are included in the manual. Equipment using PLC controls and/or electronic components will include relevant schematics or programmes in the enclosure, and in addition the relevant documentation will be delivered separately.

1.2.2 MANUAL MAINTENANCE

Keep the manual in a clean and dry place near the machine. Do not remove, tear or rewrite parts of the manual for any reason.

Use the manual without damaging it.

In case the manual has been lost or damaged, ask your after sale service for a new copy, quoting the code number of the document.


1.2.3 CONSULTING THE MANUAL

The manual is composed of:

- pages which identify the document and the machine;
- index of the subjects:
- instructions and notes on the machine: sections **2÷14**
- enclosures, drawings and diagrams: sections **15**

All pages and diagrams are numbered. The spare parts lists are identified by the figure identification number. All the notes on safety measures or possible dangers are identified by the symbol:



All the important warning notes related to the operation of the machine are identified by the symbol:  The parts typed in **bold** refer to technical data or technical notes on a specific subject.

1.2.4 HOW TO UPDATE THE MANUAL IN CASE OF MODIFICATIONS TO THE MACHINE


Modifications to the machine are subject to manufacturer's internal procedures.

The user receives a complete and up-to-date copy of the manual together with the machine.

Afterwards the user may receive pages or parts of the manual which contain amendments or improvements made after its first publication.

The user must use them to update this manual.

2.1 SERIAL NUMBER OF THE MACHINE AND NAME OF THE MANUFACTURER

SIAT ■ M. J. MAILLIS GROUP	Part Number <input type="text"/>		SIAT s.p.a.Via G.Puecher N°22 Turate (CO) ITALY		
Model <input type="text"/>	Serial Number <input type="text"/>	Year <input type="text"/>	Ampere <input type="text"/>	Watt <input type="text"/>	
Type <input type="text"/>		Volt <input type="text"/>	Hertz <input type="text"/>	Phase <input type="text"/>	

2.2 FOR AFTER-SALE SERVICE AND SPARE PARTS PLEASE APPLY:

SIAT
M. J. MAILLIS GROUP

Via Puecher, 22
22078 TURATE (CO) - ITALY

Tel. 02-964951
Fax. 02-9682239
E-mail siat@siat.com

AGENT/DISTRIBUTOR OR LOCAL AFTER SALE SERVICE:

WARRANTY

Within the limits of what is set forth below, Seller agrees to repair or replace without cost to Buyer any defective goods when such defect occurs within a period of twelve (12) months from the date in which Seller's goods have been put into use, but in no event beyond thirteen (13) months from the date of shipment.

Expressly excluded from this warranty are those parts subject to normal wear and tear (by way of illustration, but not limitation, such parts as belts, rubber rollers, gaskets, brushes, etc.) and electrical parts.

Buyer must immediately notify Seller of any defect, specifying the serial number of the machine.

Buyer shall send to Seller the defective item for repair or replacement. Seller will perform the repairs or provide a replacement within a reasonable period of time.

Upon effecting such repair or replacement, Seller shall have fulfilled its warranty obligations. In the event the repairs or replacement must be effected at the place where the machine is installed, all expenses for labor, travel and lodging of Seller's personnel shall be sustained by the Buyer. Buyer will be invoiced in conformity with Seller's standard charges for the services rendered.

Seller is not responsible for defects resulting from:

- Improper use of the machine
- Lack of proper maintenance
- Tampering with the machine or repairs effected by the Buyer.

Seller will not be liable for any injury to persons or things or for the failure of production. With respect to the materials not manufactured by Seller, such as motors and electrical equipment, Seller will grant to Buyer the same warranty Seller receives from its supplier of such materials. Seller does not warrant the compliance of its machines with the laws of non-EEC countries in which the machines may be installed, nor does it warrant compliance with laws or standards relating to the prevention of accidents or pollution.

Adaptation of Seller's machines to the aforesaid laws or standards shall be the responsibility of Buyer who assumes all liability therefore.

Buyer shall indemnify and hold Seller harmless against any claim by third parties resulting from failure to comply with the aforesaid laws and standards.

3-SAFETY

3.1 GENERAL SAFETY INFORMATION

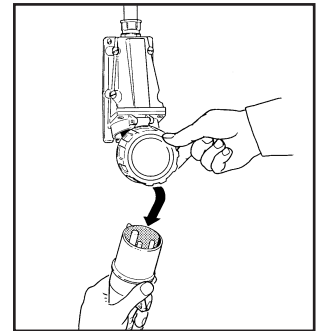
Read all the instructions carefully before starting the work with the machine; please pay particular attention to sections marked by the symbol



The machine is provided with a complete safety protection and with a two LOCKABLE EMERGENCY STOP BUTTON placed on the control panel; when one button is pressed, **it stops the machine at any point in the working cycle.**



Disconnect the machine from the mains before any maintenance operation.



Keep this manual in a handy place near the machine: its information will help you to maintain the machine in good and safe working condition.

3.2 DEFINITION OF THE OPERATORS' QUALIFICATIONS

- Machine operator
- Maintenance technician
- Electrician
- Manufacturer's technician

Only persons who have the skills described in the following page should be allowed to work on the machine. It is the responsibility of the user to appoint the operators having the appropriate skill level and the appropriate training for each category of job.

SKILL 1

MACHINE OPERATOR

This operator is trained to use the machine with the machine controls, to feed cases into the machine, make adjustments for different case sizes, to change the tape and to start, stop and restart production.

N.B.: the factory manager must ensure that the operator has been properly trained on all the machine functions before starting work.

3-SAFETY

SKILL 2

MECHANICAL MAINTENANCE TECHNICIAN

This operator is trained to use the machine as the MACHINE OPERATOR and in addition is able to work with the safety protection disconnected, to check and adjust mechanical parts, to carry out maintenance operations and repair the machine.

He is not allowed to work on live electrical components.

SKILL 2a

ELECTRICAL MAINTENANCE TECHNICIAN

This operator is trained to use the machine as the MACHINE OPERATOR and in addition is able to work with the safety protection disconnected, to make adjustments, to carry out maintenance operations and repair the electrical components of the machine.

He is allowed to work on live electrical panels, connector blocks, control equipment etc.

SKILL 3

SPECIALIST FROM THE MANUFACTURER

Skilled operator sent by the manufacturer or its agent to perform complex repairs or modifications, when agreed with the customer.

3.3 INSTRUCTIONS FOR A SAFE USE OF THE MACHINE

Only persons who have the skills described on the following paragraph **3.6** are allowed to work on the machine.

It is responsibility of the user to appoint the operators having the appropriate skill level and the appropriate training for each category of job.

3.4 STATE OF THE MACHINE

List of the modes which are possible with this machine:

- automatic running;
- running with safety protections removed or disabled;
- stopped by using the main switch;
- stopped by using the lockable emergency stop button;
- electric power disconnected;
- compressed air disconnected.

3-SICUREZZA

3.5 NUMBER OF THE OPERATORS

The operations described hereinafter have been analyzed by the manufacturer; the number of operators shown for each operation is suitable to perform it in the best way.
A smaller or larger number of operators could be unsafe.

3.6 OPERATORS' SKILL LEVELS

The table below shows the minimum operator's skill for each operation with the machine.

OPERATION	STATE OF THE MACHINE	OPERATOR'S SKILL	NUMBER OF OPERATORS
Installation and set up of the machine.	Running with safety protections disabled.	2 and 2a	2
Adjustment of the box size.	Stopped by pressing the EMERGENCY STOP button.	1	1
Tape replacement.	Stopped by pressing the EMERGENCY STOP button.	1	1
Replacement of blades.	Electric power disconnected.	2	1
Replacement of drive belts.	Electric and pneumatic power disconnected.	2	1
Ordinary maintenance (mechanical).	Electric and pneumatic power disconnected.	2	1
Ordinary maintenance (electrical).	Electric and pneumatic power disconnected.	2a	1
Extraordinary maintenance (mechanical).	Running with safety protections disabled.	3	1
Extraordinary maintenance (electrical).	Running with safety protections disabled.	3	1

3-SAFETY

3.7 RESIDUAL HAZARDS

The case former F44 has been designed with a safety protection which stops the machine when the operator opens it to access the moving parts. The safety protection should never be removed or disabled.

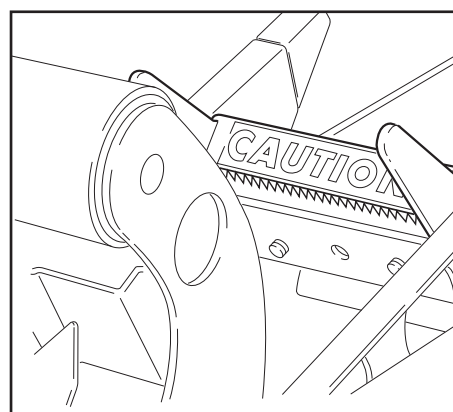
Notwithstanding the safety precautions conceived by the designers of the machine, it is essential that the operator and service personnel be warned that the following uneliminable residual hazards exists.



WARNING! Tape cutting blades.

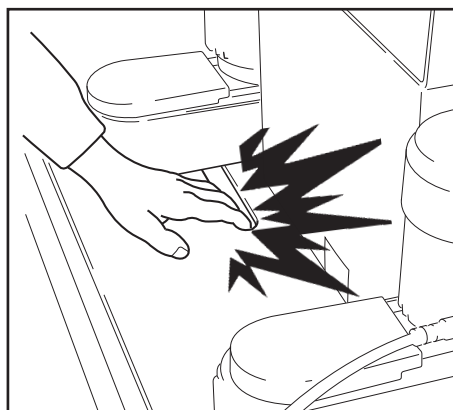
Never remove the safety device which covers the blade on the top and bottom taping units.

Blades are extremely sharp. Any error may cause serious injuries.



WARNING! Cavity in the conveyor bed.

Never put your hands inside any part of the machine while it is working. Serious injury may occur.



Correct position for the operator's hands during the filling of the box storage.



3-SAFETY

3.8 RECOMMENDATIONS AND MEASURES TO PREVENT OTHER HAZARDS WHICH CANNOT BE ELIMINATED

The operator must stay on the working position shown on paragraph 12.1. He must never touch the running driving belts or put his hands inside any cavity.

The box must be fed by keeping the hands in the right position.

The operator must pay attention to the blades during the tape replacement.

3.9 PERSONAL SAFETY MEASURES

(Safety glasses, safety gloves, safety helmet, safety shoes, air filters, ear muffs).

None is required, except when recommended by the user.

3.10 PREDICTABLE ACTIONS WHICH ARE INCORRECT AND NOT ALLOWED

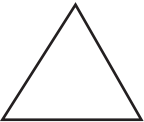
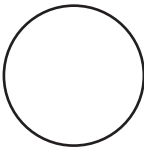
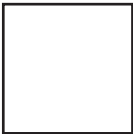
- Never try to stop or hold the box while it is being driven by the belts.
Use only the EMERGENCY STOP BUTTON.
- Never work without the safety protections.
- Never remove or disable the safety devices.
- Only authorised personnel should be allowed to carry out the adjustments, repairs or maintenance which require operation with reduced safety protections. During such operations, access to the machine must be restricted. When the work is finished, the safety protections must immediately be reactivated.



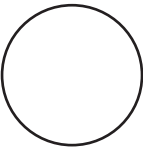
- The cleaning and maintenance operations must be performed after disconnecting the electric power.
- Clean the machine using only dry clothes or light detergents. Do not use solvents, petrols etc.
- Do not modify the machine or any part of it. The manufacturer will not be responsible for any modifications.
- We advise to apply directly to Siat for modifications.
- Follow carefully the installation instructions of this manual. The manufacturer will not be responsible for damages caused by improper installation.

3-SICUREZZA3-SAFETY

3.11 TABLE OF WARNINGS, LABELS, PLATES AND DRAWINGS TO BE FOUND ON THE MACHINE

	SYMBOLS	COLOURS
	DANGER AND PARTS IN MOVEMENT	YELLOW COLOUR
	COMPULSORY ACTIONS/PROHIBITION	RED COLOUR
	CONTROLS AND INFORMATION	LIGHT BLUE COLOUR

a

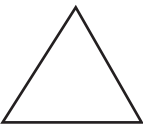


Compulsory position to lift the machine with for-
ktrucks or other suitable raising equipment.



Label code: SBC0010337

b

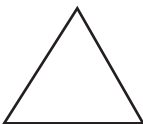


Shows the sharp knife on the taping head.

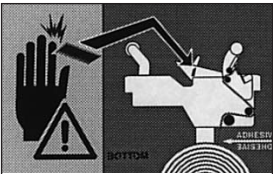


Label code: 3.0.01028.96A

c



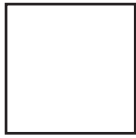
Tape threading path for bottom taping unit and po-
sition of the sharp knife.



Label code: 3.0.01024.96A

3-SAFETY

d

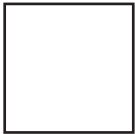


Shows the running direction of the belts.

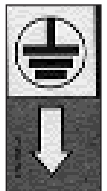


Label code:: 3.0.01040.96A

e



Shows the point for earth wire connection on the machine frame.



Label code: 3.0.01039.96A

f

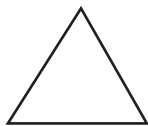


Caution!: High voltage

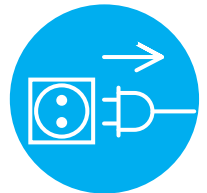


Label code: 3.0.01100.96A

g

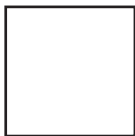


Caution! Disconnect the electric plug from the mains before any cleaning/servicing operation and before opening the electrical panel.



Label code: 3.0.01099.96A

h



Caution! Turn off the compressed air before each maintenance operation.



Label code: 3.0.01166.97A

i



Identification data of the machine model, serial number and manufacturer.



Label code:S340277700A

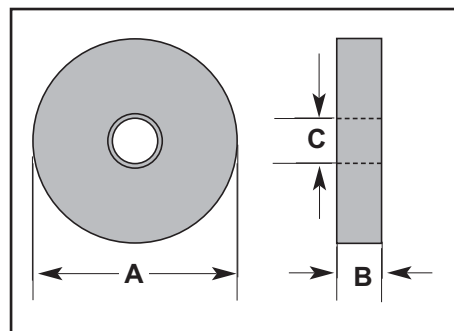
4-PRELIMINARY INFORMATION ON THE MACHINE

4.1 GENERAL DESCRIPTION OF THE MACHINE

Automatic case former with side dragging and manual sizing with sealing of the lower part of the box with self-adhesive tape.

4.2 TECHNICAL SPECIFICATIONS

- Production= 8÷10 boxes per min.
- Standard power supply= see data plate
- Installed power= 0,36 kW
- Taping unitsi K11 , tape width 50 mm
- Weight= 0000 kg
- Bdlts pseed= 21 m per min.
- Compressed air= max. 6 bar; 5 NI per min.



4.3 TAPE DIMENSIONS

Suitable adhesive tapes:

PVC

OPP

ADHESIVE PAPER

A = 410 mm max

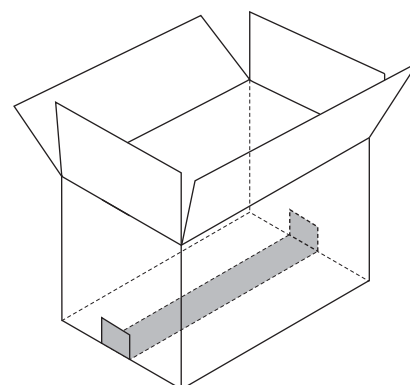
B = 50 mm

C = 76 mm

4.4 PURPOSE OF THE MACHINE

The machine is designed to seal with adhesive tape cases having the dimensions (in millimeters) shown in section 4.5, by applying two tape stripes on their top and bottom flaps simultaneously.

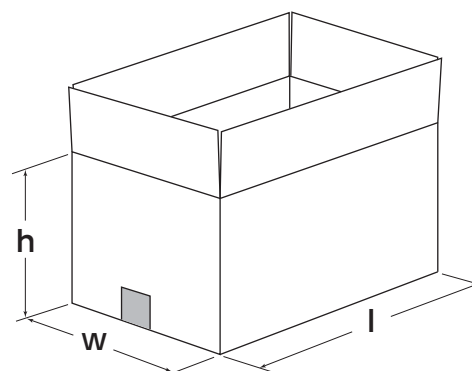
The machine supplied with the standard electric system is not designed for use in atmosphere with risk of deflagration. In such conditions the machine must be equipped with anti-deflagration components and/or air motors.



4.5 BOX-SIZE RANGE

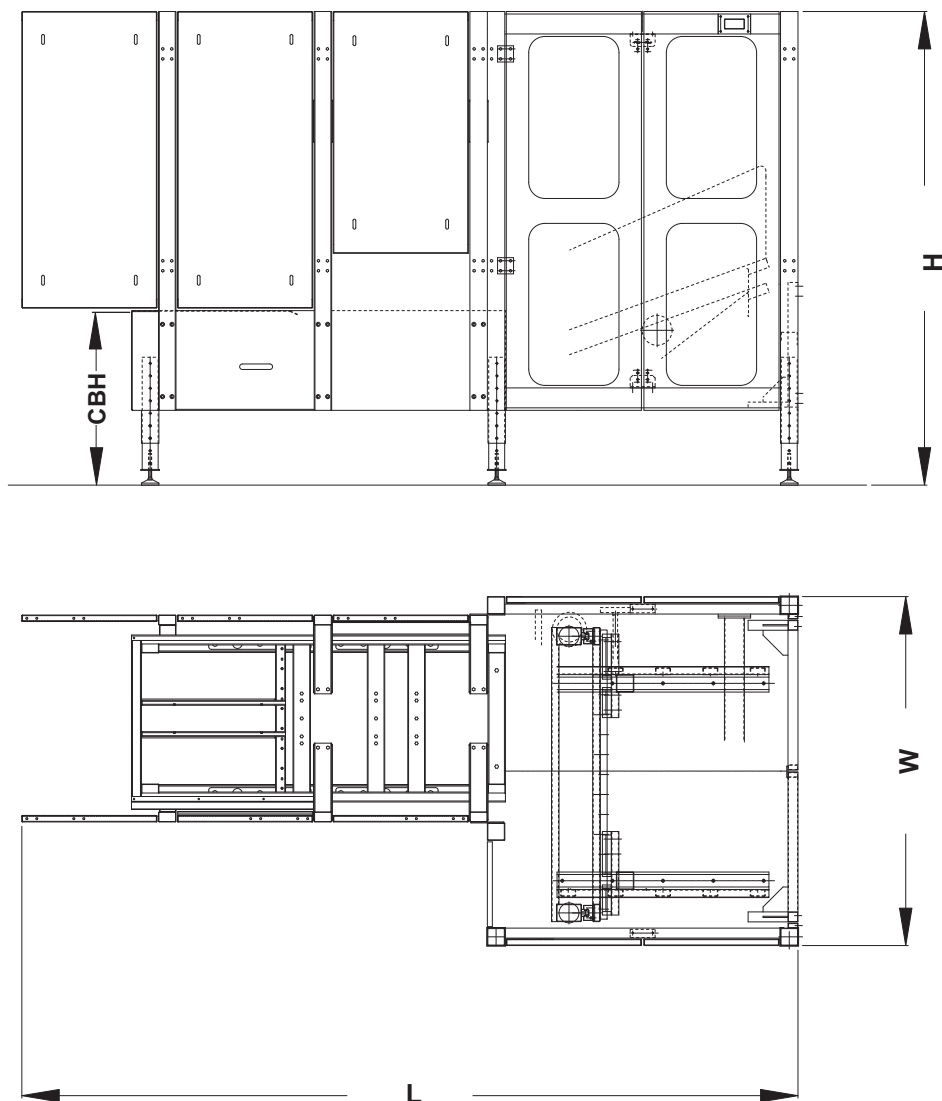
The former is manually adjustable for the forming and sealing of the lower part of the boxes whose dimension are included in the following range.
(Dimensions are in mm)

F44	w	h	l
Min.	150	150	200
Max.	350	400	450



4-PRELIMINARY INFORMATION ON THE MACHINE

4.6 DIMENSIONS



MACHINE OVERALL DIMENSIONS

- Length (L) : 3113 mm
- Width (W) : 1400 mm
- Height (H) : min. 1800 mm; max. 2150 mm

WEIGHT

- 0000 kg

4.7 CONVEYOR BED HEIGHT

The case former allows for a wide range of conveyor bed height.

- (CBH) : min. 485 mm; max. 825 mm

4-PRELIMINARY OPERATION ON THE MACHINE

4.4.8 MAIN COMPONENTS

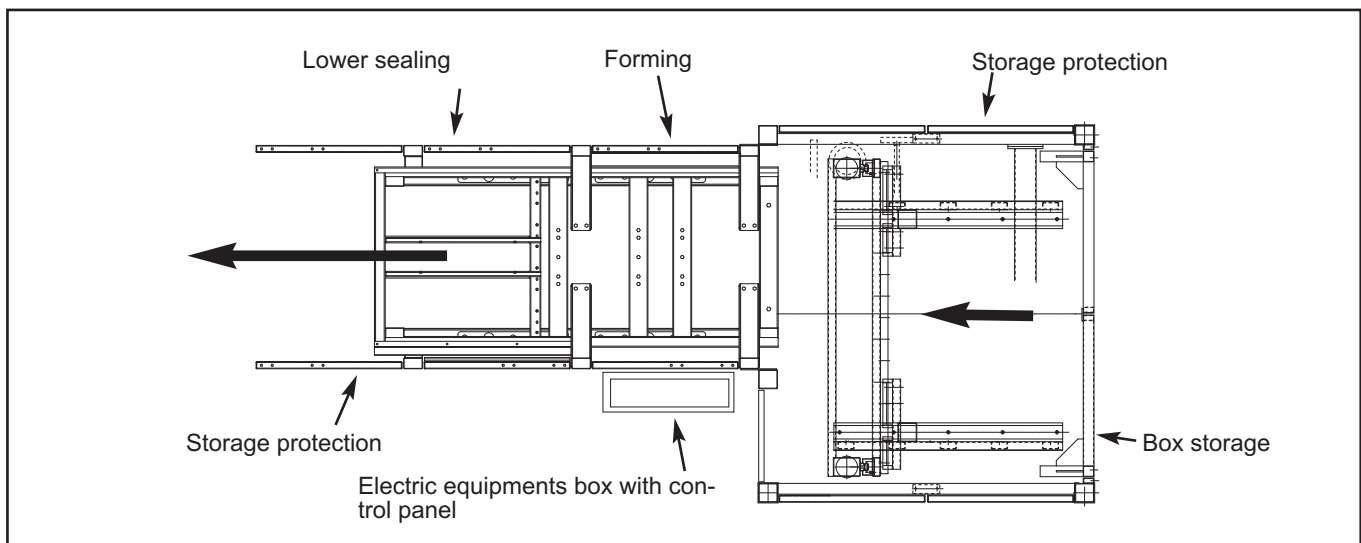
The machine is composed of:

- N. 2 frames
- N. 10 adjustable legs
- N. 1 taping unit
- N. 2 side drive belts assembly
- N. 2 electric motors
- N. 1 emergency stop button
- N. 2 anti-accident protection (storage-former)
- N. 1 control panel

4.4.9 OPERATIVE FLOW

The operator, after having filled the box storage with boxes and adjusted the machine, presses the Start Cycle button.

The machine automatically picks up a box from the box storage and pushes it through the driving belts where it is taped and expelled on idle or motor-driven rollers at the exit.



4.10 MACHINE NOISE MEASUREMENT

Acoustic pressure at 1 meter distance from the machine with the tape roll inserted: 78 dB. Acoustic pressure at a height of 1,6 meter above the machine with the tape roll inserted: 78 dB.

The measurement has been performed by a SPYRI-MINOPHON phonometer.

5-SHIPMENT-HANDLING-STORAGE

5.1 SHIPMENT AND HANDLING OF THE PACKED MACHINE

The machine is fixed on the pallet with four bolts and can be uplifted by using a forkluck.

The packaging is suitable to travel by land and by air. Optional sea-freight packaging available.

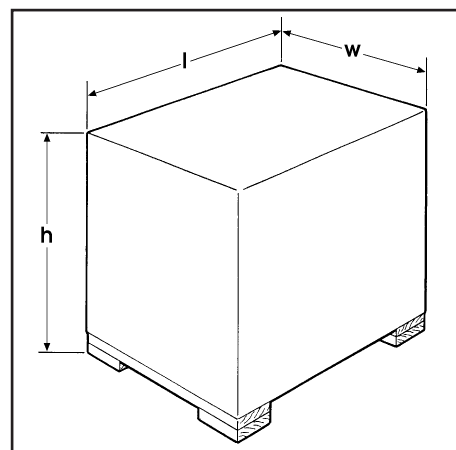
PACKAGING OVERALL DIMENSIONS

l = length 2700 mm

w = width 1400 mm

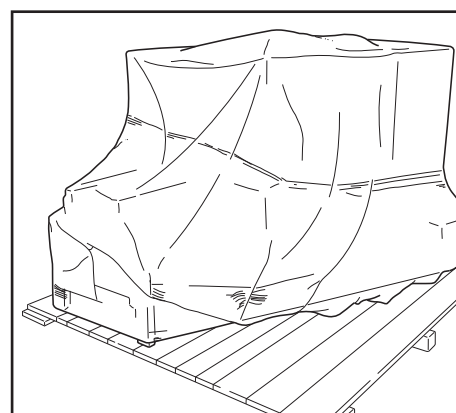
h = height 2100 mm

Weight 000 kg.



5.2 PACKAGING FOR OVERSEAS SHIPMENT (OPTIONAL)

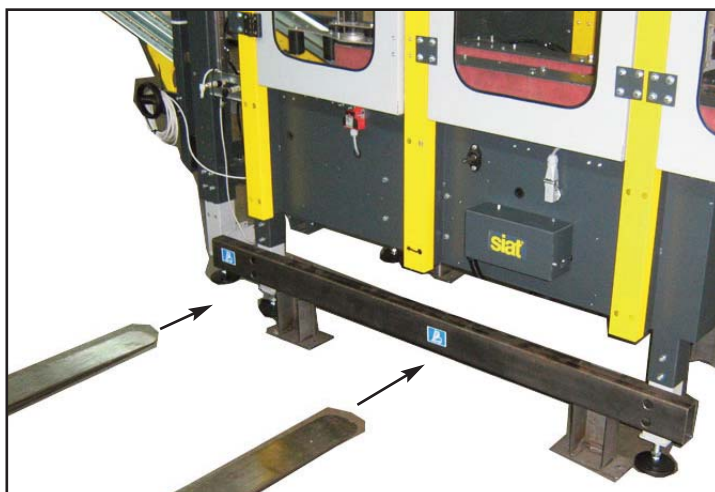
The machines shipped by sea freight are covered by an aluminum/polyester/ polythene bag which contains dehydrating salts.



5.3 SHIPMENT AND HANDLING OF THE UNPACKED MACHINE

The unpacked machine can only be moved short distances and indoors only.

The transportation of the machine without packaging may cause damage and accidents. If it is necessary to move it, lift it by a forklift inserting the pitchforks under the lower cross member, that are screwed to the pallet legs, only in correspondence of the suitable points (labels with forklift symbol)



MACHINE DIMENSIONS

length: mm 3113

width: 1400 mm

height: min. 1800 max. 2150 mm.

weight: 000 kg

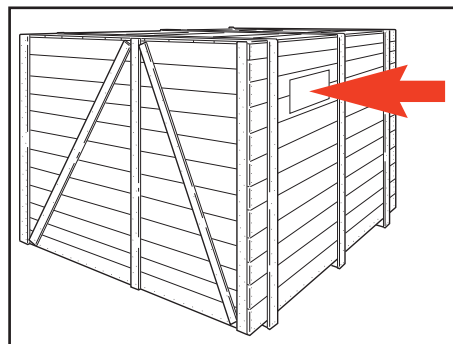
5.4 STORAGE OF THE PACKED OR UNPACKED MACHINE

If the machine is left inactive for a long period, please take the following precautions:

- store the machine in a dry and clean place;
- if the machine is unpacked it is necessary to protect it from the dust and do not stack anything over the machine.

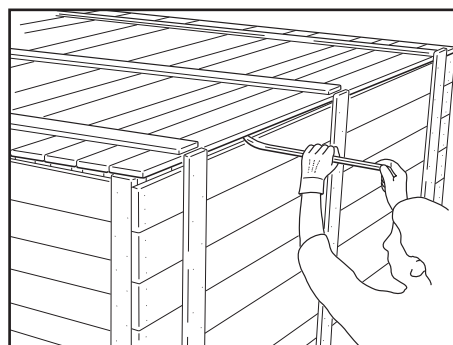
6-UNPACKING

- 6.1** The envelope attached to the external side of the packing case contains the instructions concerning the unpacking of the machine.



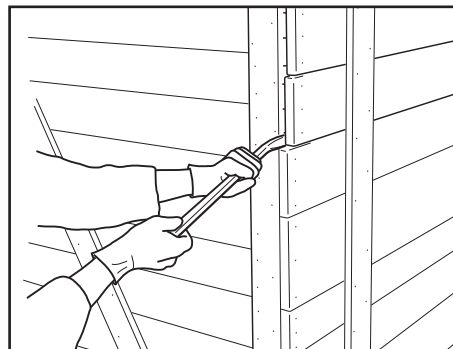
Unnail the top cover and using the proper tools and gloves, take the studs away.

Pay attention to the studs and the wood splinters



Unnail and remove the four side walls of the case.

Take care to hold each wall to avoid that it may fall to the floor causing damages or injuries (minimum 2 persons).



MACHINE PROTECTION

Remove the plastic protection, without using a cutter or others tools.

Use a forktruck to carry the machine to its working location.

Unscrew the nuts and remove the brackets which fix the machine to the pallet.

Uplift the machine by using a forktruck; see paragraph 5.3.

6.2 PACKAGING DISPOSAL

The packaging of the machine is composed of:

- wooden pallet
- wooden box
- steel fixing brackets
- polythene foam protection
- plastic straps (PP)
- clay dehydrating pouches (only for seafreight shipments)
- aluminum/polyester/polythene bag (only for seafreight shipments)

For the disposal of these materials please follow the provisions of the law in your country..

7-INSTALLATION

7.0. SAFETY

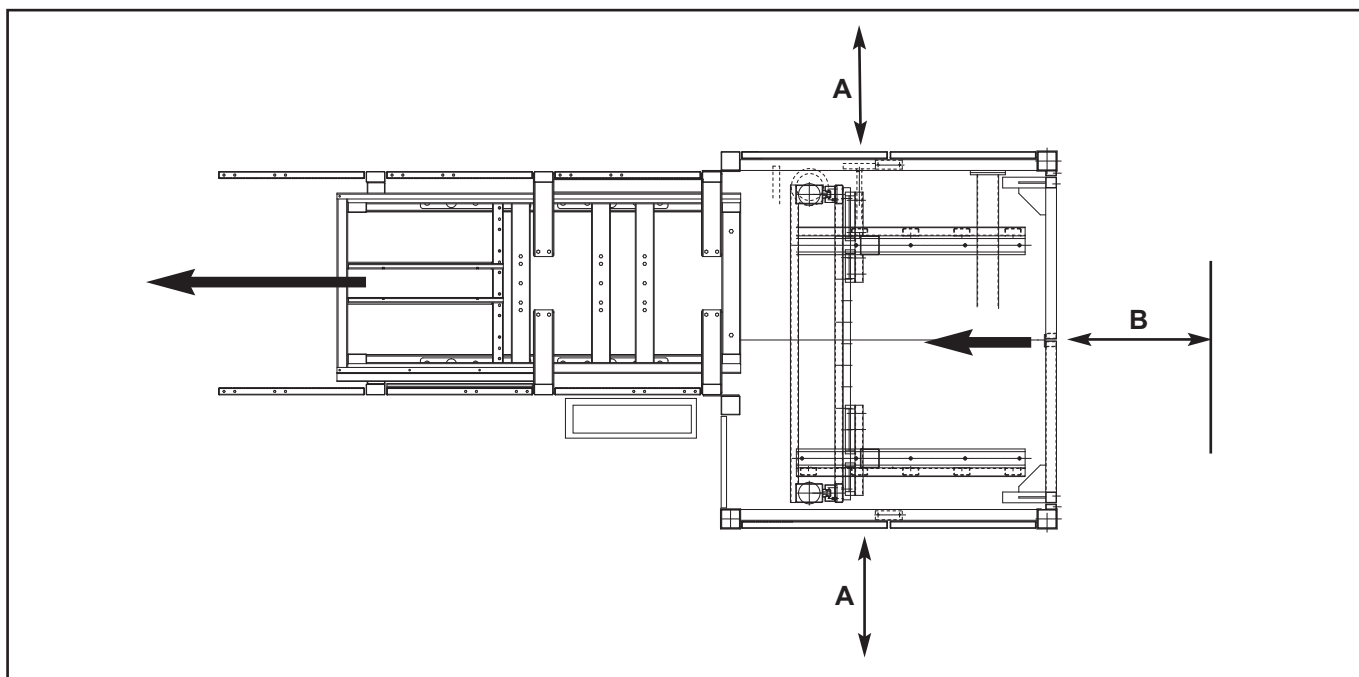
(Read Section 3 carefully).

7.1. ENVIRONMENTAL CONDITIONS REQUIRED

- Min. temperature. = 5 °C; max. 40 °C
- Min. humidity 30%; max. 80%
- Dust free environment.

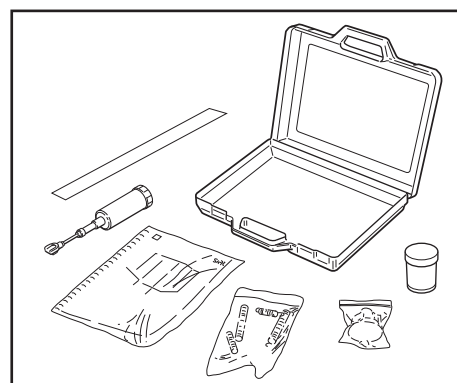
7.2. SPACE REQUIRED FOR OPERATION AND MAINTENANCE

Min. distance from the wall: **A = 1000 mm**; **B = 1500 mm**; Min. height= **2500 mm**



7.3 SPARE PARTS AND THREADING TOOL FOR TAPING HEADS SUPPLIED WITH THE MACHINE

For a detailed description see section 13.1.

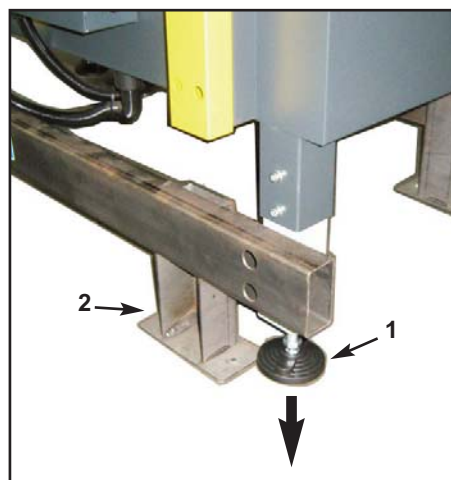


7-INSTALLATION

Lift the machine by a forklift, see parag. 5-3



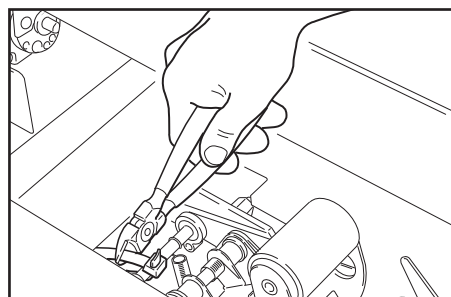
Lower the support legs (1) how much enough to overcome the flasks of the cross members (2).



Reach the foreseen place of installation, place the machine onto the floor and remove the cross members (2).
Act opportunely on the adjustable legs (1) to level the machine.

7.4 CLAMPS REMOVAL

Cut the plastic clamps that lock the protection doors, the forming carriage in the upper group, the storage box pushers, the taping head, etc.



7.5 PROTECTIONS ASSEMBLY

Assemble the safety protections on the box storage side, positioning opportunely the fixing squares and the stiffening angles.

7.6 PNEUMATIC CONNECTION

Connect a 10 mm diameter hose to the plug and fix it by the supplied clamp.



7-INSTALLATION

7.10 PRELIMINARY ELECTRIC CHECK-OUT

Before connecting the machine to the mains please carry out the following operations:

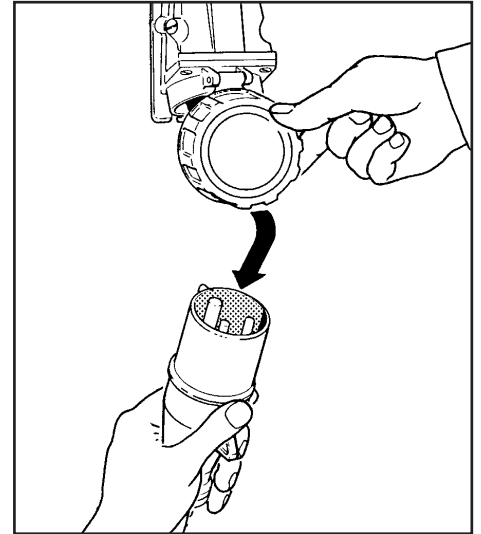
7.10.1 Make sure that the socket is provided with a ground protection circuit and that both the mains voltage and the frequency match the specifications on the machine plate.

7.10.2 Check that the connection of the machine to the mains meets the safety regulations in your country.

7.11 MACHINE CONNECTION TO THE MAINS AND CHECK-OUT

Power supply = 0,36 kW

Connect the cable supplied with the machine to a plug which complies with the safety regulations of your country.



8-OPERATION

8.1 OPERATION DESCRIPTION

The operator presses the starting cycle button after having filled the box storage with cartons and after having adjusted the machine.

After having pressed the starting cycle button, the suction caps holder arm of the upper carriage lowers and it approaches the box storage.



The suction caps take the first box.

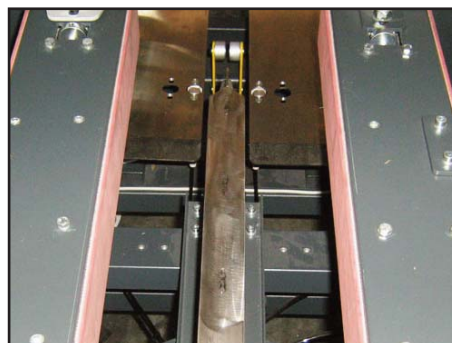
During the carriage return the suction caps holder arm drags the carton with itself; the same carton is opened automatically by the box opening springs.



Two lower pneumatic cylinders start the sealing operation of the front flap.

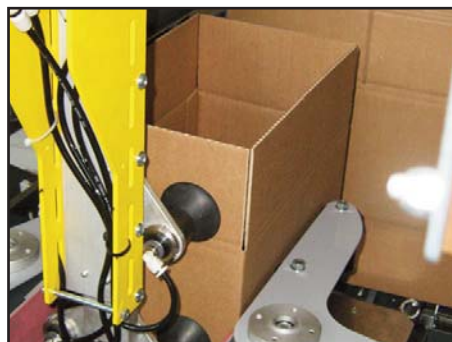
The box is inserted between the driving belts and at the same time the little forming arm is closed.

The front flap folder between the driving belts completes the sealing operation of the corresponding flap.



The rear flap folder is closed by the respective pneumatic flap folder arm (in case of big boxes the cycle is slow down automatically to allow the correct closing of the above mentioned flap).

The suction caps holder arm releases the box and comes back to its original position; the driving belts speed is decreased and a correction of the squaring of the box is done, as necessary, by a stop and a re-start of the same driving belts in short times.



The normal driving belts speed is reactivated and then the lateral flaps folder is activated.

The so formed box is sent to the sealing group that provides for the sealing of the lower part with self adhesive tape.

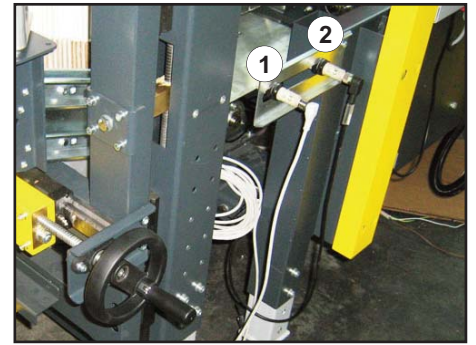


8-OPERATION

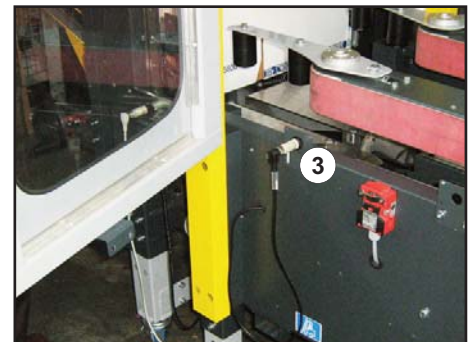
MAGIC EYES

1. Control of the box squaring arm on motorisation.

2. Control of the rear flap folder.

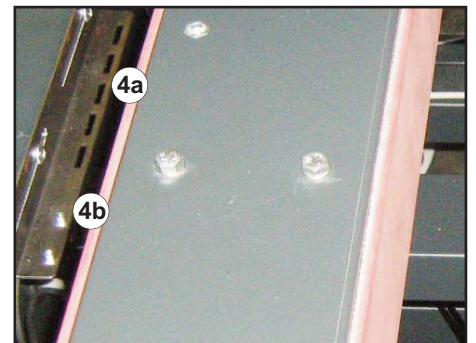


3. Control of the suction caps activation time.



4a. Control of the motorizations' deceleration.

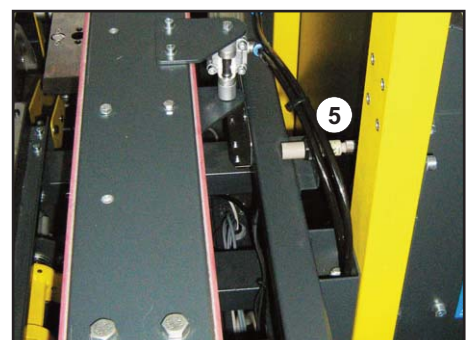
4b. Control of the right motorisation stop time for correction of the box squaring and reset of the normal operation speed.



4c. Control of the left motorisation stop time for correction of the box squaring and reset of the normal operation speed.



5. Control of the side flap folders.



8-OPERATION

8.2 DESCRIPTION OF OPERATIONS MODES

The case former can work in « manual » or « automatic » :

- EMERGENCY STOP button not pressed;
- safety protection doors (case former and box storage) surely closed.
- auxiliary circuits and pneumatic plant activated.
- starting cycle button activated.

In “manual” the case former performs a cycle at every activation of the corresponding starting button; if the motorisations are not activated, the cycle is only simulated (the box is not taken from the box storage)

In « automatic » it's not necessary to activate the motorizations before pressing the starting cycle button.

8.3 STOP WAYS DESCRIPTION – RE-START

8.3.1 NORMAL STOP

Machine stop is immediate in every cycle point pressing the cycle stop button.

At stop, the suction caps holder arm and the upper translation carriage (if still in movement) are brought in the original position of starting cycle.

8.3.2 STOP WITH ALARM SIGNAL ON CONTROL PANEL

As in previous paragraph 8.3.1.

To re-start press reset button and then cycle start.

8.3.3 EMERGENCY STOP

Emergency stop button.

Machine stop is immediate in every cycle point pressing the button on the control panel; all movements are stopped in the reached position.

To re-start press in sequence the auxiliary button (obtaining in this way the re-placement of the upper translation carriage with suction caps holder arm as necessary) and then the reset and cycle starting buttons.

8.3.4 STOP DUE TO SAFETY PROTECTION DOOR OPENING

As in previous paragraph 8.3.3.

8.3.5 STOP DUE TO INTERRUPTION OF POWER SUPPLY AND/OR PNEUMATIC FEEDING

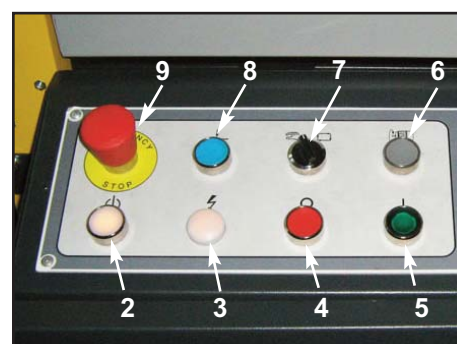
As in previous paragraph 8.3.3.

9-CONTROLS IN BRIEF

9.1 CONTROL PANEL ON ELECTRIC EQUIPMENTS BOX

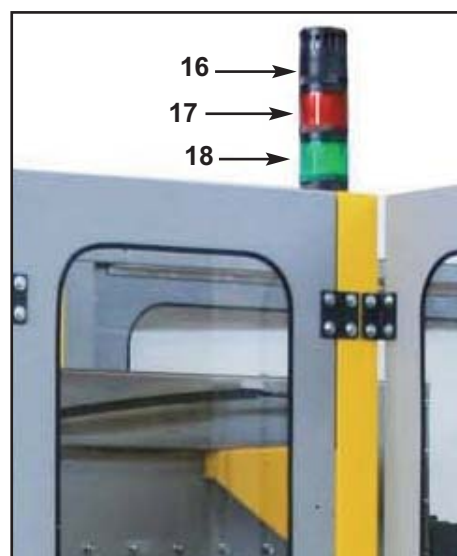
Electric equipments box

1. Main switch
2. Auxiliary circuits insertion button
3. Bright signaller for tension presence
4. Cycle stop button « 0 » - « OFF »
5. Cycle start button « I » - « ON »
6. Motorizations start button
7. Selector of « manual » - « automatic » operation ways
8. Reset button (alarm signal zero setting)
9. Emergency stop button
10. Bright signal of alarm activation « emergency »
11. Bright signal of alarm activation « low air pressure »
12. Bright signal of alarm activation « max. cycle time »
It's active after around 13 seconds from start if lower forming and sealing is not finished
13. Bright signal of alarm « tape end or breakage » (option)
Flashing light : tape next to the end
Fixed light : tape end or breakage
14. Bright signal of alarm activation « forming mistake »
15. Bright signal of alarm activation « overload »
Consult the attached technical documentation related to the group converter of frequency that is installed in the electric equipments box.



Multi-functions flash light

16. Acoustic signal
It's active in case of alarm signals 11, 12, 13, 14 and 15.
17. Red bright signal
Fixed light for every operation anomaly
18. Green bright signal
Fixed light: during normal machine operation
Flashing light :in case of signal of « full line » (consult the attached electric schemes, wishing to activate the optional signal of "full line").



9-CONTROLS IN BRIEF

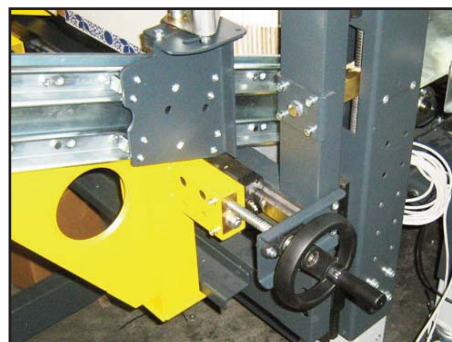
9.2 HANDLE FOR SIDE MOTORIZATIONS ADJUSTMENT

It adjusts the driving belts width according to width of the box to be sealed.



9.3 HANDLE FOR CARTONS STORAGE WIDTH ADJUSTMENT

It adjusts the cartons box position according to the width of the box to be sealed (the ruler in millimetres of reference reports the box width values in mm).



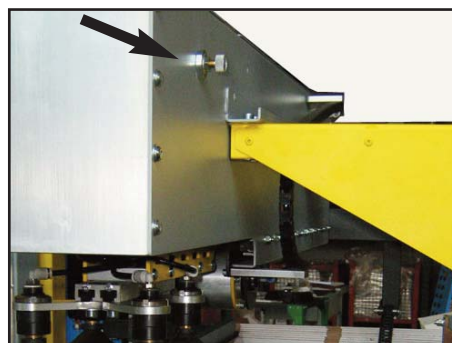
9.4 HANDLE FOR CARTONS STORAGE HEIGHT ADJUSTMENT

It adjusts the cartons box position according to the height of the box to be sealed (the ruler in millimetres of reference reports the box width values in mm).



9.5 FLOW REGULATOR OF THE SUCTION CAPS HOLDER ARM CYLINDER

It's placed on the upper carriage carter, externally; it allows to adjust the suction caps holder arm speed during the return stroke.



9.6 PNEUMATIC PLANT CONTROLS

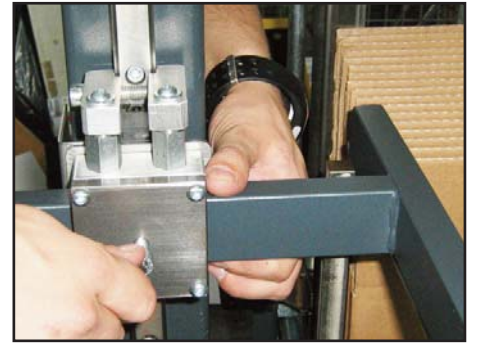
Cutoff cock.
Pressure regulator.
Solenoid valve.
Progressive starter.



9-CONTROLS IN BRIEF

9.7 CHUTE OF THE UPPER PRESSER

It keeps the box in the right position from cartons storage extraction till a complete forming.



9.8 BOX OPENER CONTRAST SPRINGS OR BRUSHES (UPPER AND LOWER)

Opposing the box extraction from the storage they allow a correct forming of the same box during the return stroke of the carriage with suction caps holder arm.



9.9 CARTONS HOLDER ROTATING ACTUATOR

It keeps in seat the cartons in the storage correctly; turning the cams of $\frac{1}{4}$ of a turn every cycle, it allows the extraction of a box at a time.



10-SAFETY DEVICES OF THE MACHINE

10.1 ANTI-ACCIDENT GUARD

The automatic former is equipped with a total anti-accident guard..

When one of the doors of the anti-accident guard is opened, the machine stops. The microswitch mounted on the door automatically cuts the power supply and the compressed air.

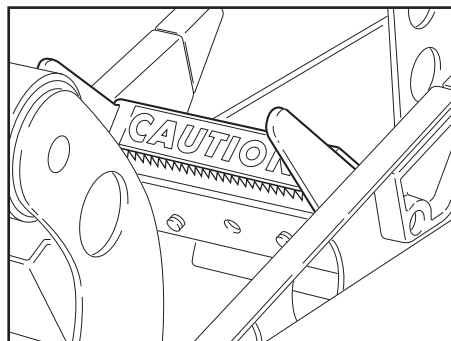
If this interruption takes place during the work cycle, interrupting the machine program half-way, before resuming the cycle the following operations are necessary:

- 1) Remove the box inside the machine;
- 2) Close the protection door;
- 3) Press the auxiliary circuits button;
- 4) Press the 'reset' button;
- 5) Press the START button.



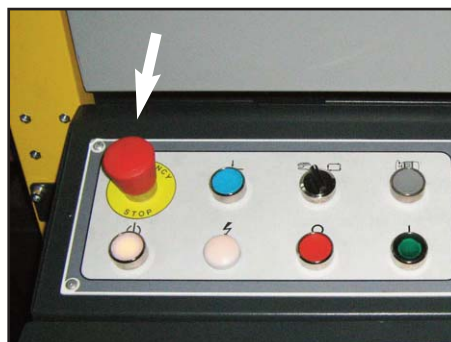
10.2 BLADE GUARDS

Both the top and bottom taping units have a blade guard.



10.3 EMERGENCY STOP BUTTON

The lockable emergency stop button is placed in handy position.



10.4 ELECTRIC SYSTEM

The electric system is protected by a ground wire whose continuity has been factory- tested during the electrical test.

11-SET-UP AND ADJUSTMENTS

11.0 SAFETY

All the set-up operations and adjustments must be carried out when the machine is stopped and the EMERGENCY STOP BUTTON is locked.

11.1 TAPE LOADING ON THE BOTTOM UNIT

Remove the bottom taping unit from its housing and put it on a working bench.

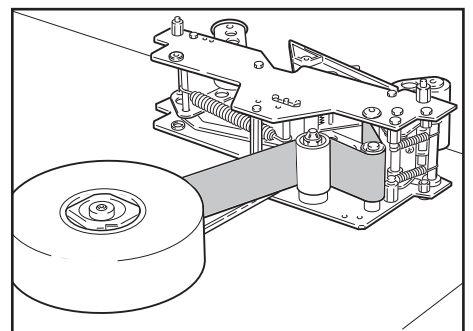
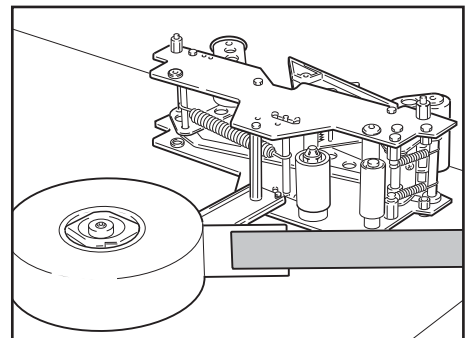
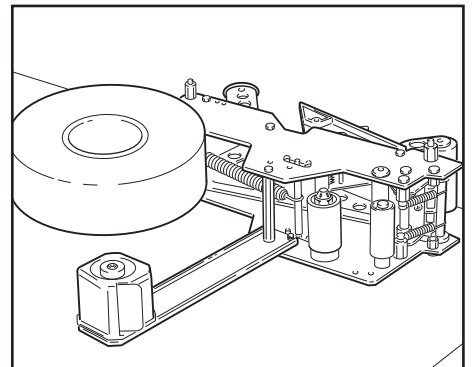
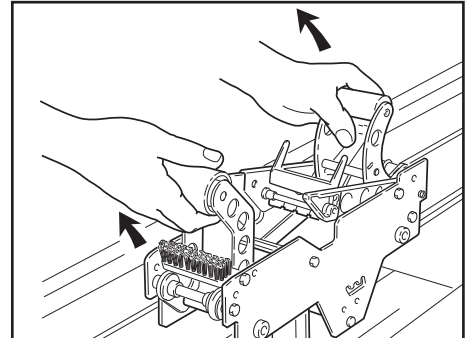
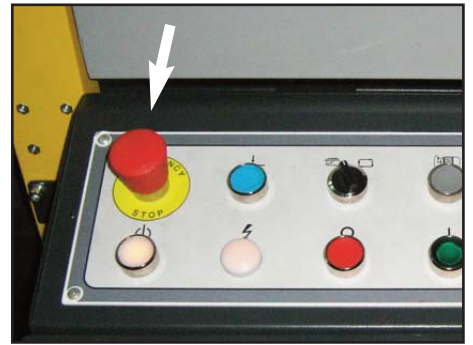
Put a tape roll on the drum.

WARNING! Very sharp blade. It may cause serious injuries.



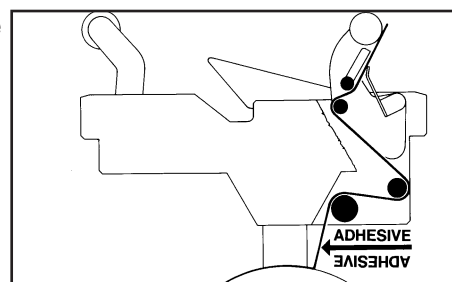
Attach the tape leg to the threading tool (supplied with the tools kit)

Insert the plastic threading leader through the taping unit. Take care to keep hands away from the tape cutting blades. (see section 3.11-c).



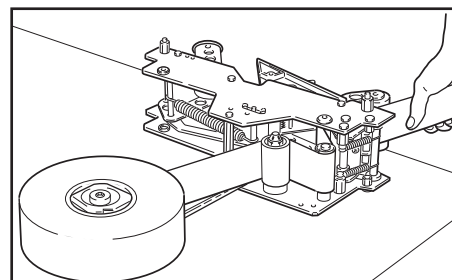
11-SET-UP AND ADJUSTMENTS

Follow the path through the unit as shown on Picture and make sure that the adhesive side is placed on the correct side.



Pull and cut off the excess tape.

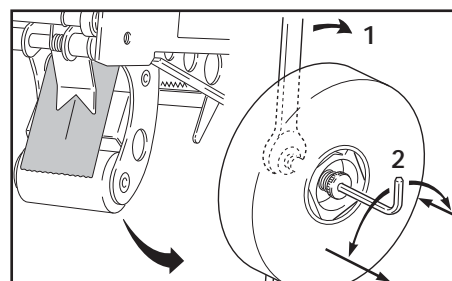
Put again the taping head into its seat..



11.2 TAPE DRUM ALIGNMENT



Check the centering of the tape on the rollers of the taping unit.
If needed, unlock bolt 1 and adjust screw 2.

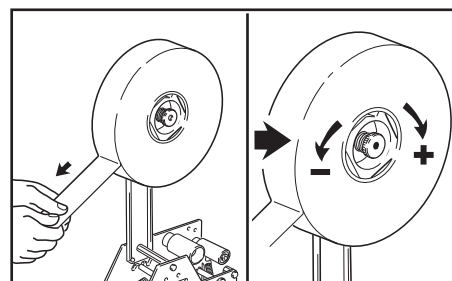


11.3 TAPE DRUM FRICTION BRAKE ADJUSTMENT



Check the tape tension:

- with PVC tape the drum must be free
- with OPP tape the drum must be slightly frictioned

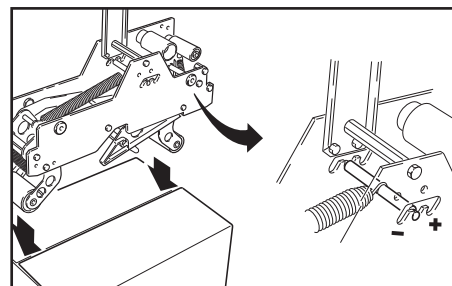


11.4 ADJUSTMENT OF TAPING UNITS ACCORDING TO THE TYPE OF BOXES



Adjust the main spring:

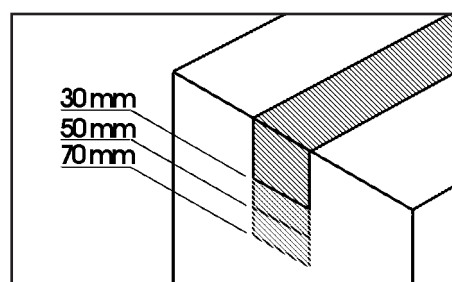
- decrease the spring load for light cardboard cases;
- increase the spring load for robust cardboard cases.



SPECIAL ADJUSTMENTS

11.5 CHANGE OF THE TAPE LEG LENGTH

The tape leg length can vary from 70 to 50 to 30 mm. To adjust the tape leg length refer to the manual of the K11 taping unit, supplied with the machine.



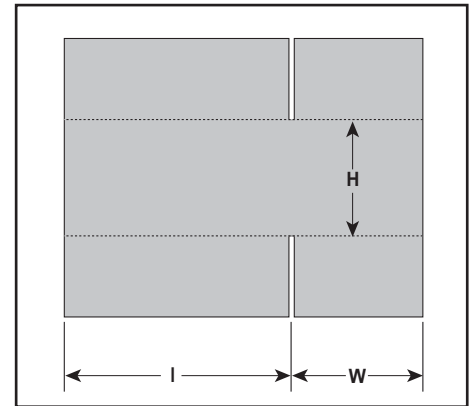
11-SET-UP AND ADJUSTMENTS

11.6 TYPES OF BOX, BOX STORAGE LOADING AND MACHINE ADJUSTMENTS

11.6.1 Squared box (l=W) or standard without writings :

The box can be squared in every machine (with right or left cartons storage).

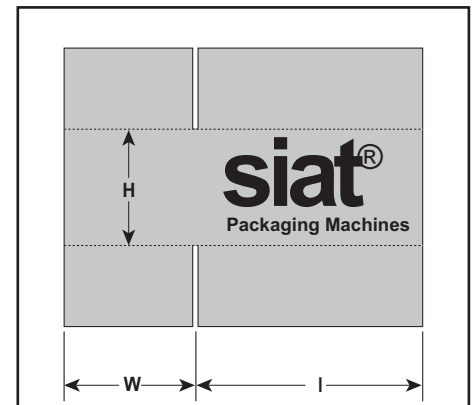
It's better to place the same one in the cartons storage with the glued side visible from the loading side.



11.6.2 Box with writings on side « l » (length) on the right for forming in the machine with right cartons storage.

Wishing to use boxes with personalized printings and/or various wordings, to avoid that these boxes go out from the case former with the inverted writings, it's necessary to print them as shown in the picture (side l on the right).

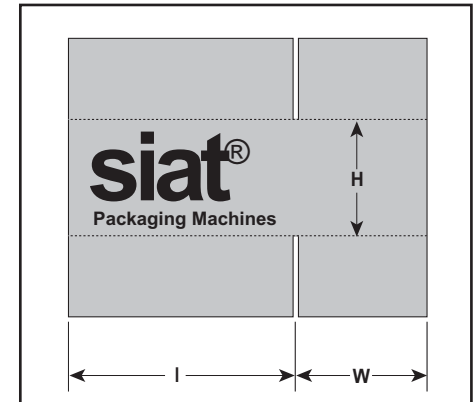
ATTENTION : sight of the box in the cartons storage from loading side



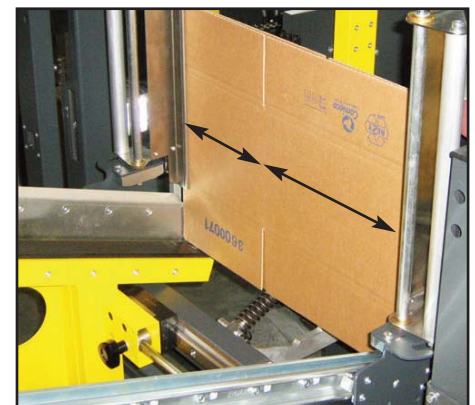
11.6.3 Box with writings on side « l » (length) on the left for forming in the machine with left cartons storage.

Wishing to use boxes with personalized printings and/or various wordings, to avoid that these boxes go out from the case former with the inverted writings, it's necessary to print them as shown in the picture (side l on the left).

ATTENTION : sight of the box in the cartons storage from loading side



Sight of the box in the cartons storage from loading side



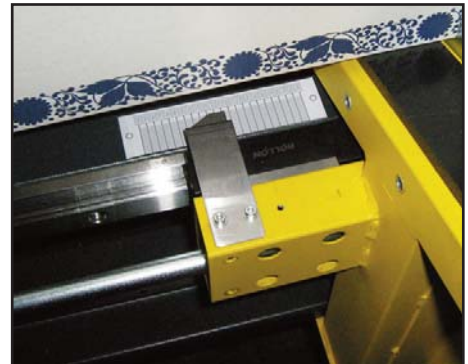
11-SET-UP AND ADJUSTMENTS

11.6.4 CARTONS STORAGE ADJUSTMENT

Place one carton on the guides correctly (see previous paragraphs).

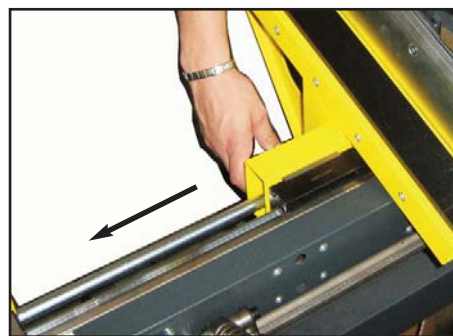
Adjust the cartons storage width by the corresponding handle, that is placed sideways in the same storage.

Take the value of the box width as reference and let coincide the above mentioned value on the ruler in millimetres fixed on the cartons storage with the index mounted on the guide sliding support.



For a more accurate set up, see through or verify with the help of a fillet with proper length that the side wall of the boxes storage slide is correctly lined up with the belt of the motorization; if necessary, use the handle again to set the width.

Keeping the box in position, approach the side guide on the opposite side to the carton and block with the corresponding knob.



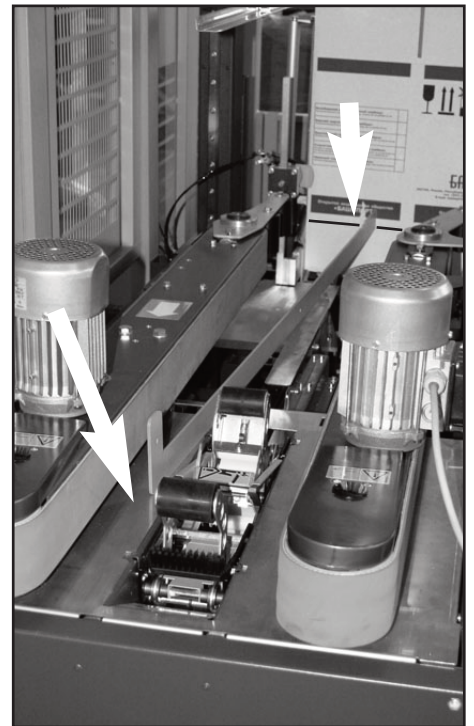
Adjust the cartons storage working plan height by the handle, always taking the box width value as reference; let coincide the above mentioned value on the ruler in millimetres fixed on the cartons storage with the index mounted on the guide sliding support.



11-SET-UP AND ADJUSTMENTS

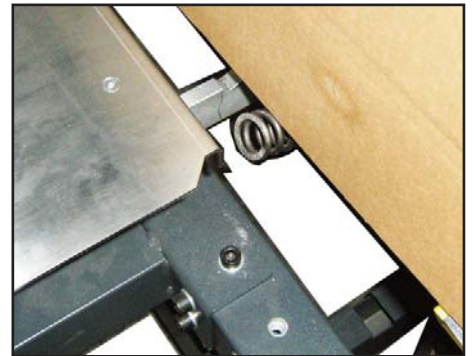
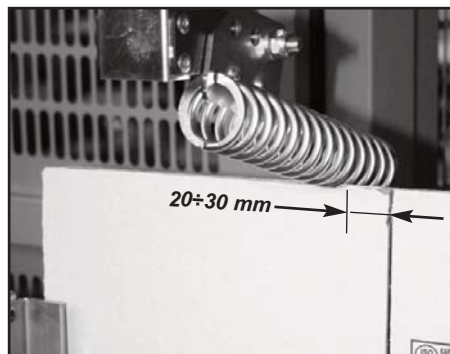
For a more accurate set up, see through or verify with the help of a fillet with proper length that the exit plan is correctly lined up with the box folds in correspondence of the lower flaps; if necessary, use the handle again to set the right height up.

Insert the cartons package and place the two side cartons pushers correctly.



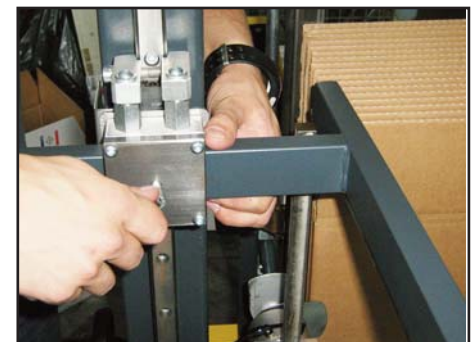
11.6.6 UPPER CONTRAST SPRING OR BRUSH

Set the upper contrast spring position up; 20-30 mm from the box cut on the width side as in picture (sight of loading side)



11.6.5 LOWER CONTRAST SPRING

Set the upper contrast spring in the same way.



11.6.7 PRESSER CHUTE

Adjust the upper presser chute position.

11.6.8 CARTONS HOLDER ROTATING ACTUATOR

Adjust the cartons holder rotating actuator position.



11-SET-UP AND ADJUSTMENTS

11.6.9 DRIVING BELTS WIDTH ADJUSTMENT

Insert a formed box and approach the driving belts by the handle.



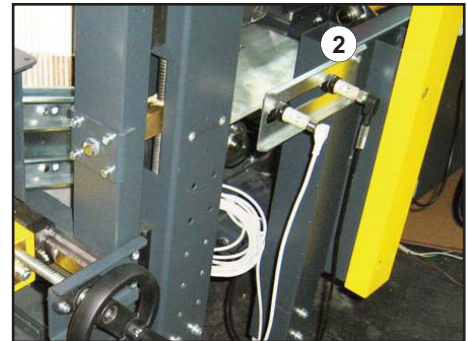
11.6.10 SUCTION CAPS ADJUSTMENT

Adjust, as necessary, the suction caps positions on the corresponding suction caps holder arm according to the box width.



11.6.11 REAR FLAP FOLDER PHOTOCELL ADJUSTMENT (2)

Delay the magic eye intervention moving it forward as necessary in case of forming of boxes with length (l) over 200 mm.

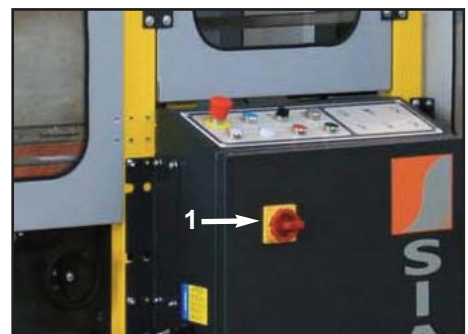
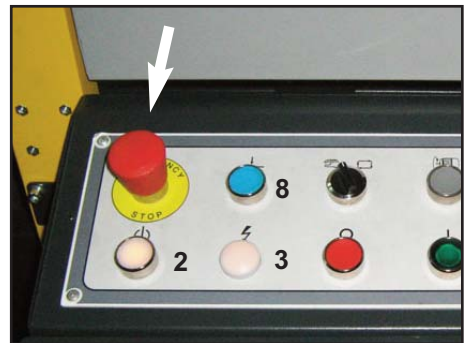


11.7 CONTROL PANEL: PRELIMINARY OPERATIONS

Verify that the safety protections are closed;
Verify that the emergency stop button is not activated (pressed), in case turn it clockwise.

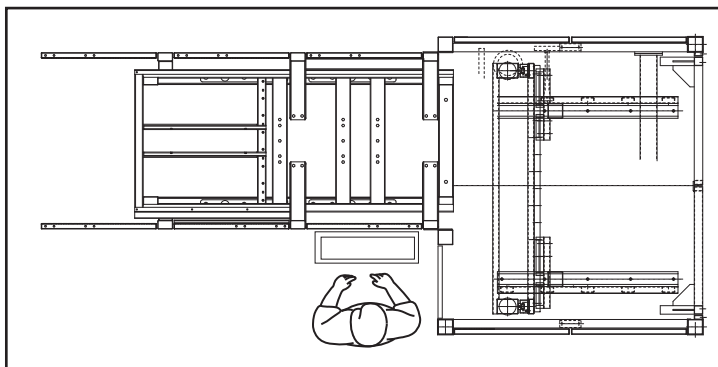
Turn main switch on position « I » - « ON » and verify the lighting of the bright signaller for tension presence 3; press auxiliary button 2.

In presence of possible alarm signals see paragraph 9.1 ; reset pressing button 8.



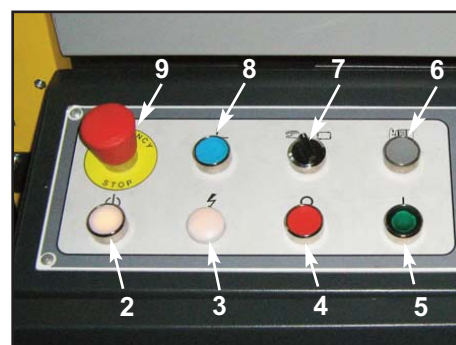
12-OPERATION

12.1 OPERATOR'S CORRECT WORK POSITION



12.2 START

- Select the desired operation way 7.
- Start motorizations 6 as necessary.
- Start production pressing button 5.



12.3 TAPE REPLACEMENT

Each time it is necessary to replace the tape roll, do as follows:

- Press the E-stop;
- Set the main switch in OFF position;
- Open the safety guard;
- Do all the operations under points 11.1 and 11.2

Pay attention to the cutting blades.



12.4 CLEANING

Before carrying out any cleaning or maintenance operation stop the machine by turning the main switch on position **O**.

Disconnect the electric power and disconnect pneumatic circuit.

Use dry clothes or light detergents.

Do not use solvents or water jets.

12.7 SAFETY DEVICES CHECKOUT

- 1 Taping units blade guard;
- 2 Lockable emergency stop button;
- 3 Safety guards;

13-MAINTENANCE AND REPAIRS

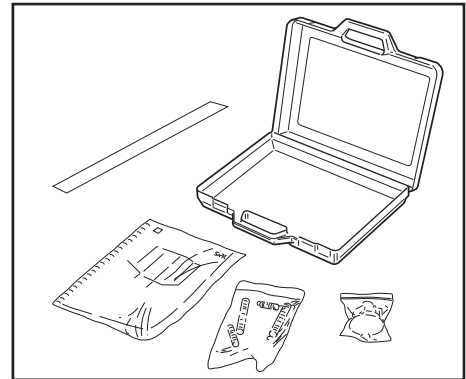
13.0 SAFETY MEASURES

(see section 3)

Carrying out maintenance and repairs may imply the necessity to work in dangerous situations. This machine has been designed making reference to the standards EN292, 1.2 and EN292/2.

13.1 SPARE PARTS SUPPLIED WITH THE MACHINE

- N.1 Instructions and spare parts manual
- N. 2 Suckers
- N. 1 2" spare blade
- N. 1 K11 main spring
- N. 2 Blade-holder spring
- N. 1 Plastic threading leader



13.2 RECOMMENDED FREQUENCY OF CHECK-OUTS AND MAINTENANCE OPERATIONS

OPERATIONS	FREQUENCY	OPERATOR'S SKILL	SECTION
Lubrication	Quarterly	2	13.5-6-7
Blade cleaning	Weekly	2	13.8
Machine cleaning	Weekly	1	12.5
Checkout of safety devices	Daily	1	13.4
Blade replacement	//	2	13.9
Side drive belts replacement	//	-	-

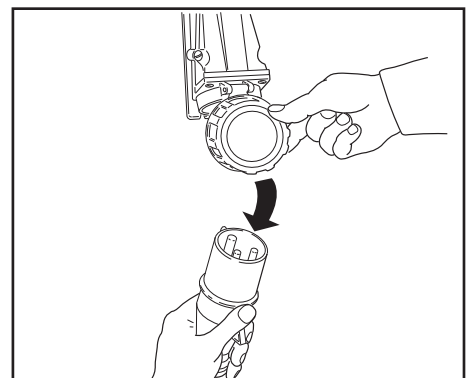
13.3 CHECK-OUT TO BE PERFORMED BEFORE AND AFTER EVERY MAINTENANCE OPERATION

Before every maintenance operation turn the main switch on position **O**.



During the maintenance operation only the operator responsible of this duty must work on the machine.

At the end of every maintenance operation check the safety devices.



13-MAINTENANCE AND REPAIRS

13.4 SUGGESTED PRODUCTS FOR LUBRICATION

GREASE TYPE:

METAL/METAL: B.C.190 HEAVY DUTY (otherwise grease for chains and bearings)

METAL/PLASTIC: PLATE MASTER M+L

(molybdenum grease and PTFE for plastic and metallic materials)

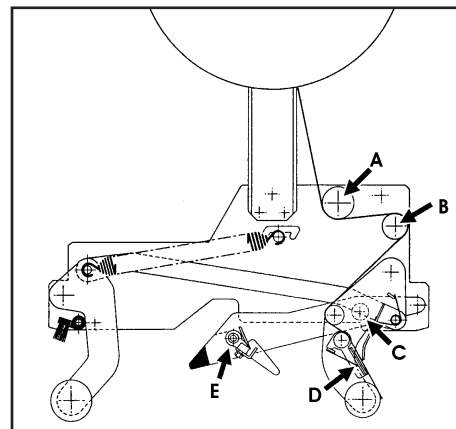
OIL TYPE:

regular lubricating oil or general purpose spray lubricant.

13.5 LUBRICATION OF THE TAPING UNIT

Lubricate monthly with oil the points shown on Picture.

- A spring holder pin
- B spring tension pin
- C roller shaft
- D cutter hinge
- E blade guard pin

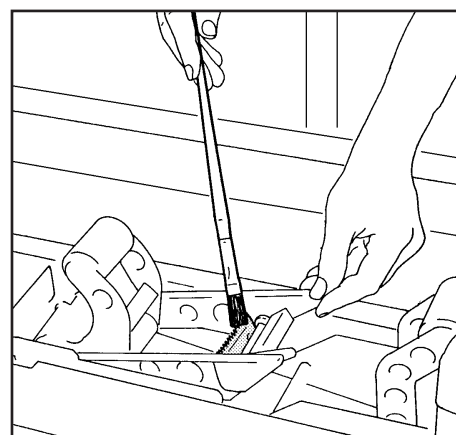


13.6 BLADE CLEANING



Skill 2 operator

Lift the blade guard and clean the blade by using a brush (with a long handle) and some oil. The oil prevents the adhesive clotting.



13.7 BLADE REPLACEMENT

Skill 2 operator

- Lift the blade guard as shown in Picture
- Release the screws.
- Remove the blade.

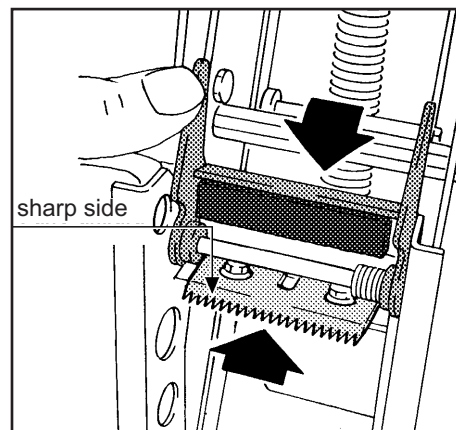
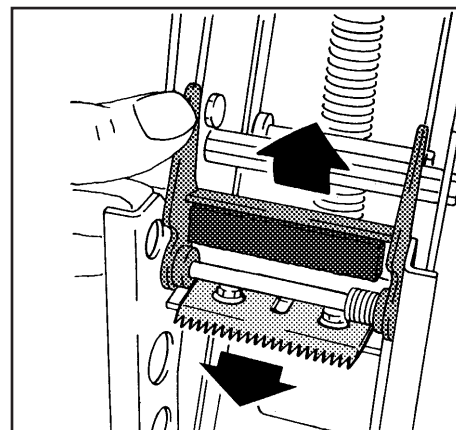
WARNING!

Very sharp blade.

Any error may lead to bad injuries.



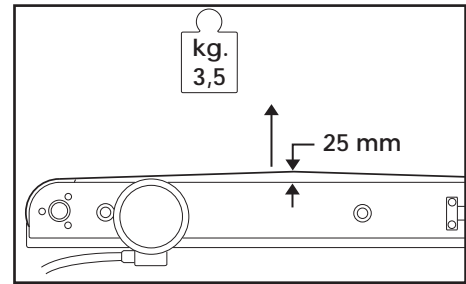
- Insert the new blade paying attention to the position of its sharp side.
- Fix the screws.
- Release the guard..



13-MANUTENZIONE E RIPARAZIONE

13.8 ADJUSTMENT OF THE BELTS TENSION

Check the tension of the belt by pulling it outwards in the middle.
A force of 3,5 kg should produce a gap of 25 mm (1 inch) between the belt and the frame

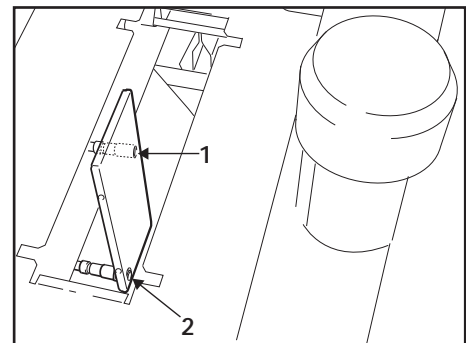


13.9 DRIVE BELTS REPLACEMENT

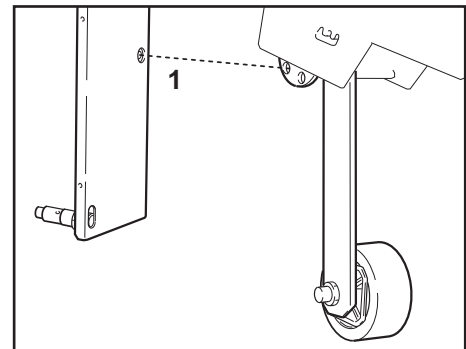
Contact **SPECIALIST FROM THE MANUFACTURER.**

13.10 PHOTOCELL FOR THE CONTROL OF THE TAPE END/BREAKAGE

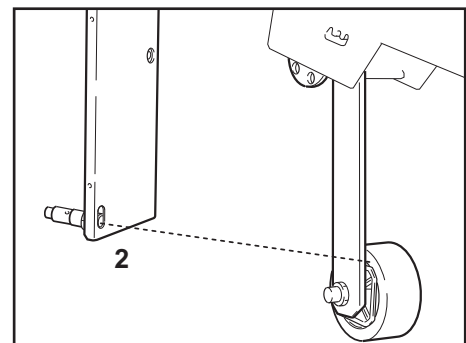
If during the automatic operation, the machine, after the forming and the sealing of the box, stops at each cycle, it is necessary to check the position of photocell n.1.



Without removing the taping unit, make sure that photocell n. 1 is in line with the wheel located under the unit. Otherwise, adjust the position of the photocell in the vertical sense.



Photocell n. 2 checks and signals by means of the switch board the end of the adhesive tape. Adjust the position of the photocell according to the minimum diameter of the tape drum.



13-MAINTENANCE AND REPAIRS

LIST OF THE MAINTENANCE OPERATIONS CARRIED OUT ON THE MACHINE

[illegible]

14-ADDITIONAL INSTRUCTIONS

14.1 INSTRUCTIONS FOR SCRAPPING AND DISPOSAL OF THE MACHINE

The machine is made of the following materials:

- steel frame
- nylon conveyor rollers
- PVC drive belts
- nylon pulleys

In order to dispose of the machine materials please comply with the law in force in your country.
Follow the RAEE Directive for the disposal of electric-electronic type components.

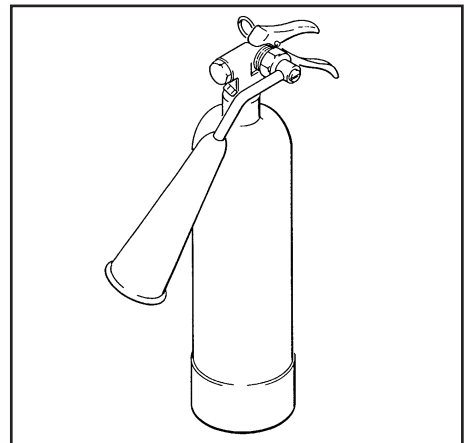
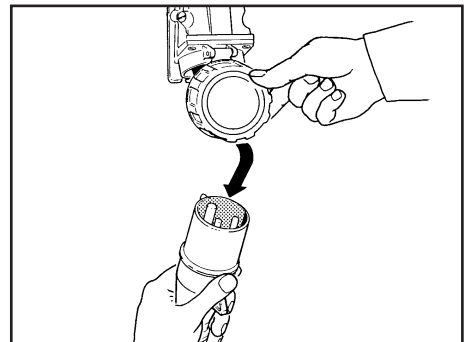
14.2 INSTRUCTIONS ON EMERGENCY SITUATIONS

In case of danger/fire:
disconnect the electric power.

FIRE

In case of fire use an extinguisher containing CO₂.

DO NOT use water.



15-ENCLOSURES

15.1 STATEMENT OF CONFORMITY

to the Directives on Machinery 98/37/CE, 2006/95 CE, 89/336 CEE, 108/04 CE, 2002/96/CE, 2003/108/CE.

15.2 SAFETY LABELS

The safety labels are important for the correct use of the machine.

In case any label is damaged or removed, it is responsibility of the user to replace it immediately.

15.3 EMISSIONS OF RADIATIONS, GAS, VAPOURS AND DUST

Nothing to report

15.4 ELECTRIC TESTS

Electric tests:

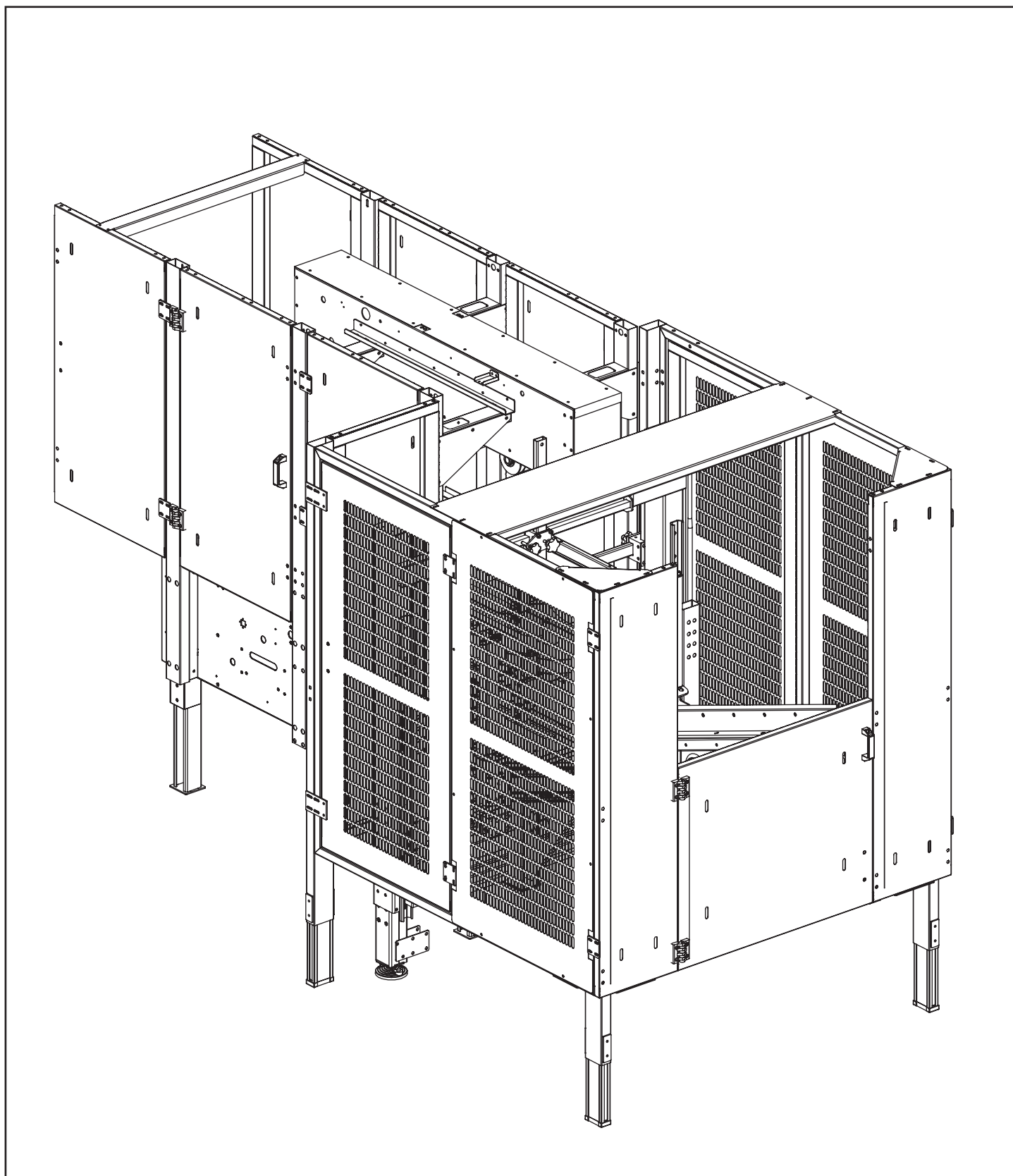
1 - Continuity of the ground circuit

2 - Insulation resistance

3 - High voltage insulation

Reference: EN 60204-1 Section 20.2, 20.3, 20.4

SIAT S.p.A. - Via Puecher, 22 - 22078 TURATE (CO) ITALY - P.O. BOX 1
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<http://www.siat.com> - E-Mail: siat@siat.com



F44 - DX

CATALOGO PARTI DI RICAMBIO

MAG. 2011

Fig. 15478
ass. gruppo prot. macchina

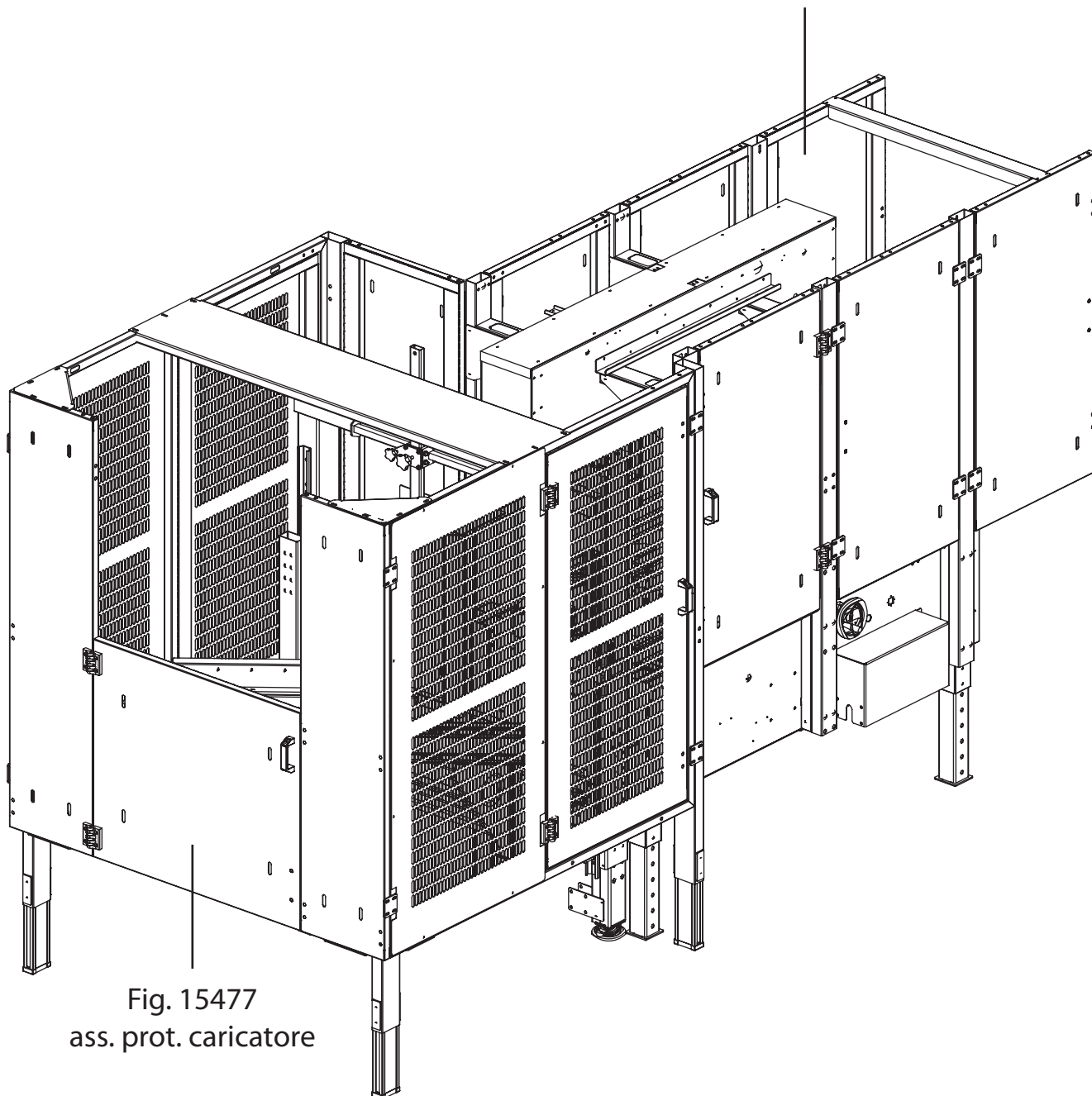
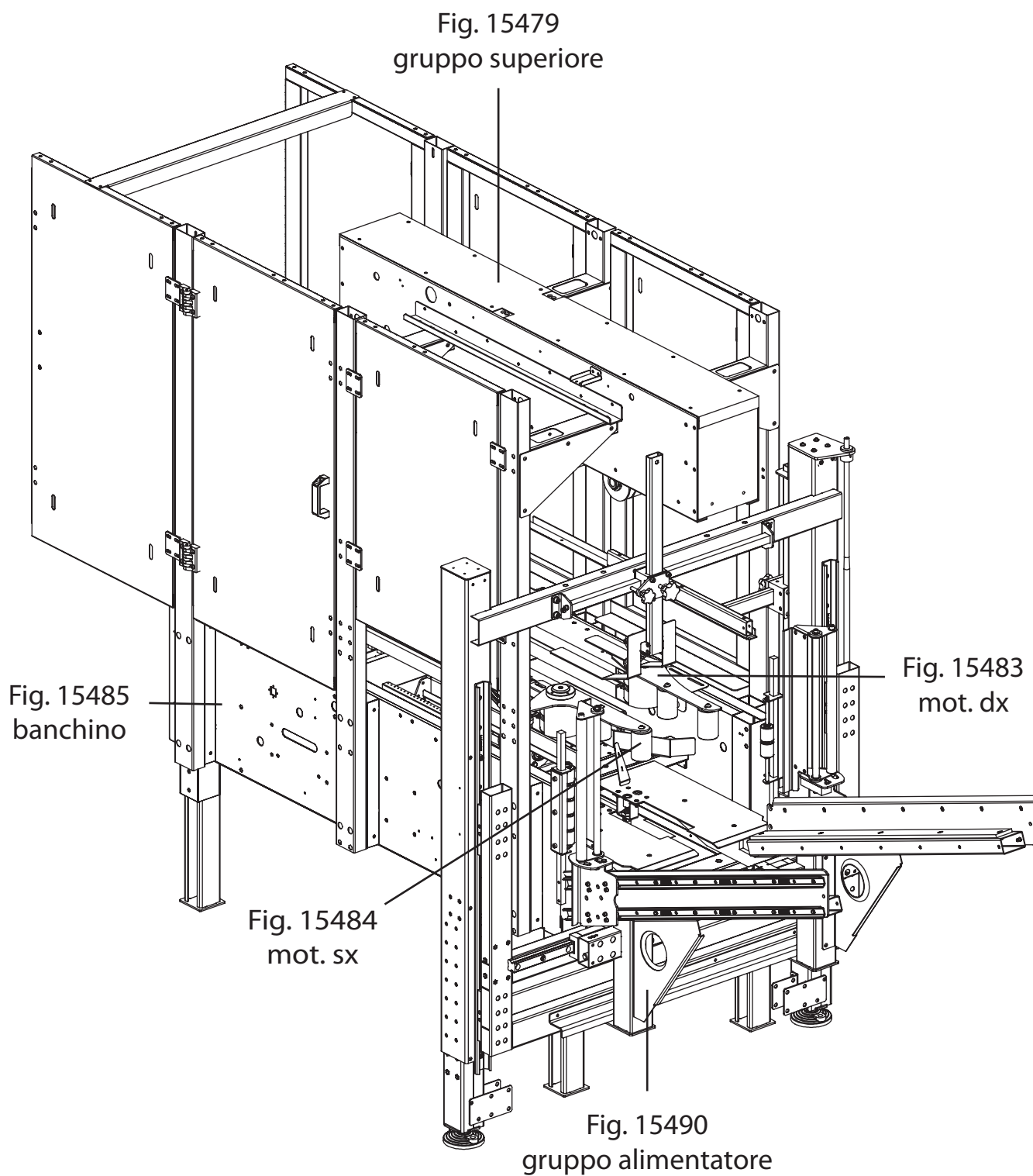


Fig. 15477
ass. prot. caricatore

F44 - DX
VISTA LATO DX
MAG. 2011



F44 - DX
VISTA LATO SX
MAG. 2011

Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15477	Assieme prot. Caricatore		F44	Formatore

Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBA0009916V	Assieme pannello ant. Sx	1	pz
2	SBA0009915V	Assieme pannello ant. Dx	1	pz
3	SBC0016790V	Pannello apertura protezioni	1	pz
4	SBC0016773V	Staffa supporto micro	1	pz
5	SBC0016767	Traversa superiore	1	pz
6	SBA0009898V	Assieme pannello lat. Dx	1	pz
7	SBA0010308	Assieme telaio fisso dx	1	pz
8	SBA0009906	Gamba scorrevole prot. Compl.	4	pz
9	SBC0016538V	Pannello protezioni caricatore	1	pz
10	SBC0016803V	Piantana post. Prot.	2	pz
11	SBC0016806V	Squadra angolo prot.	2	pz
12	S3801095ZZZ	Maniglia m443/110	2	pz
13	S340398000A	Cerniera elesa cfa.65 ch-6	4	pz
14	S3401601ZZZ	Blocco a scatto	2	pz
15	S3401707ZZZ	Aggancio x blocco a scatto	2	pz
16	SBC0016808V	Piastr. Ant. Giunz. Prot.	6	pz
17	SBC0016810V	Piastr. Post. Giunz. Prot.	2	pz
18	SBC0016811V	Piastr. Lat. Giunz. Prot.	2	pz
19	SBC0017337V	Squadra inferiore prot.	2	pz
20	SBC0017340V	Squadra sup. prot.	2	pz
21	SBC0017343V	Pannello laterale caricatore	2	pz
22	SBC0015159V	Piastrina fissaggio struttura	2	pz
23	SBC0019466V	Squadretta supp. Blocco a scatto	2	pz

Data mag-11

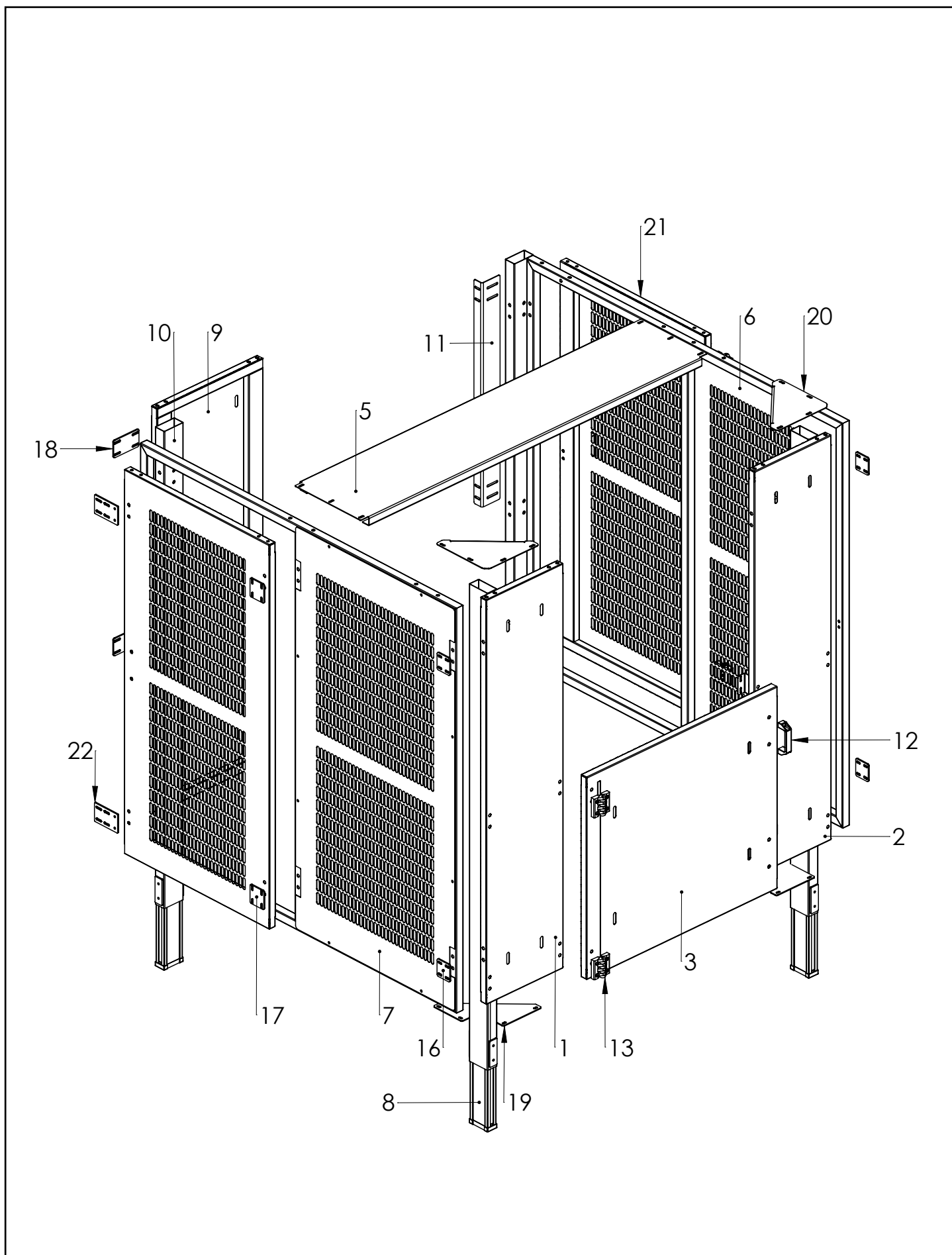


Fig. 15477

Maggio 2011

F44

Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15478	Ass. gruppo protez. Macchina		F44	Formatore

Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBA0009817	Protezione esterna c/ins.	5	pz
2	SBA0009818	Protezione esterna Q.E. c/ins.	1	pz
3	SBC0016635V	Lamiera chiusura prot. Esterna	2	pz
4	SBC0015902V	Traversa protezione est.	1	pz
5	SBC0015018V	Squadretta micro	2	pz
6	S3401601ZZZ	Blocco a scatto spec.	2	pz
7	S3401707ZZZ	Aggancio x blocco a scatto	2	pz
8	S340398000A	Cern. Eleso cfa.65 ch-6	4	pz
9	S3801095ZZZ	Maniglia m 443/110	2	pz
10	S340057793Z	Vite tcei m6x16 zinc.	52	pz
11	S340003393Z	Rondella tripla x vite m6 zinc.	48	pz
12	S340011293Z	Vite tcei m5x16 zinc.	28	pz
13	S340046893Z	Rondella tripla x vite m5 zinc.	12	pz
14	S340051693Z	Vite tsvei m5x12 zinc.	8	pz
15	S340040393Z	Vite tsvei m5x16	4	pz
16	S340006193Z	Rondella piana x vite m5 zinc.	8	pz
17	S340025993Z	Dado autoblocc. M5 zinc.	8	pz
18	SBC0017355V	Lamiera chiusura prot. Est.	1	pz
19	SBC0019466V	Squadretta supp. Blocco a scatto	2	pz
20	SBC0016820V	Piastrina	12	pz
21	SBC0016158V	Montante esterno	2	pz
22	SBA0009539V	Ass. montante gruppo ventose	4	pz

Data mag-11

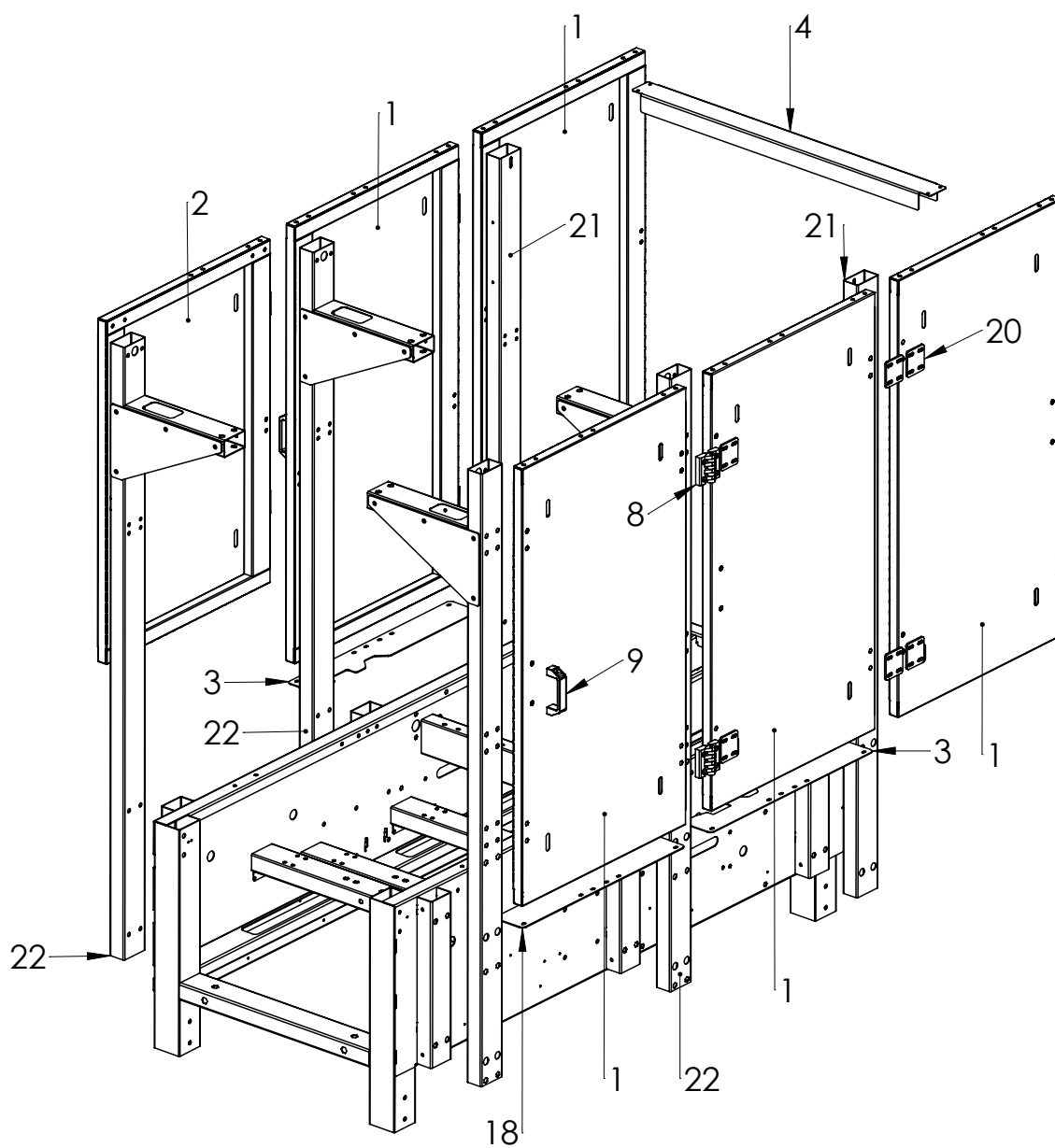


Fig. 15478

Maggio 2011

Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15479	Gruppo superiore	SBA0009887	F44	Formatore
15480	Gruppo ventose	SBA0009040	F44	Formatore
15481	Braccio portaventose	SBA0009030	F44	Formatore
15482	Gruppo movimento ventose	SBA0009891	F44	Formatore

Posizione	Ricambio	Descrizione	Q.tà	U.M.
1	SBA0009887	Ass. fiancata sx testata	1	pz
2	SBA0009889	Ass. fiancata dx testata	1	pz
3	SBC0015263	Piastra anteriore testata	1	pz
4	SBC0015264	Piastra posteriore testata	1	pz
5	SBA0009018V	Piastra unione cilindro lineare ass.	2	pz
6	SBC0015274V	Piastra cuscinetto cilindro lineare	1	pz
7	SBC0015275V	Spessore piastra porta cuscinetto	1	pz
8	SBC0015377T	Blocchetto di fermo	2	pz
9	SBC0015218V	Squadretta fiss. Catena portacavi	1	pz
10	SCA0001324	Guida tipo ULV 43-800	1	pz
11	SCA0001327	Guida tipo TLV 43-800	1	pz
12	SBA0009040	Gruppo ventose	1	pz
13	SBA0009030	Braccio portaventose	1	pz
14	SBA0009891	Spalla gr. Movimento ventose	1	pz
15	SBC0017254V	Copertura unità centrale	1	pz
16	SBC0000584	Attuatore lineare	1	pz
17	S3400073ZZZ	Cuscinetto 6003-2rs ntn skf	1	pz
18	S3802401ZZZ	Festo KQH08	1	pz
19	S3802400ZZZ	Festo KQH04	1	pz
20	SBC0000463	Profilo piegato 7225-3T	1	pz
21	SCA0001356	Catenaia Kabelschlepp	1	pz

Data mag-11

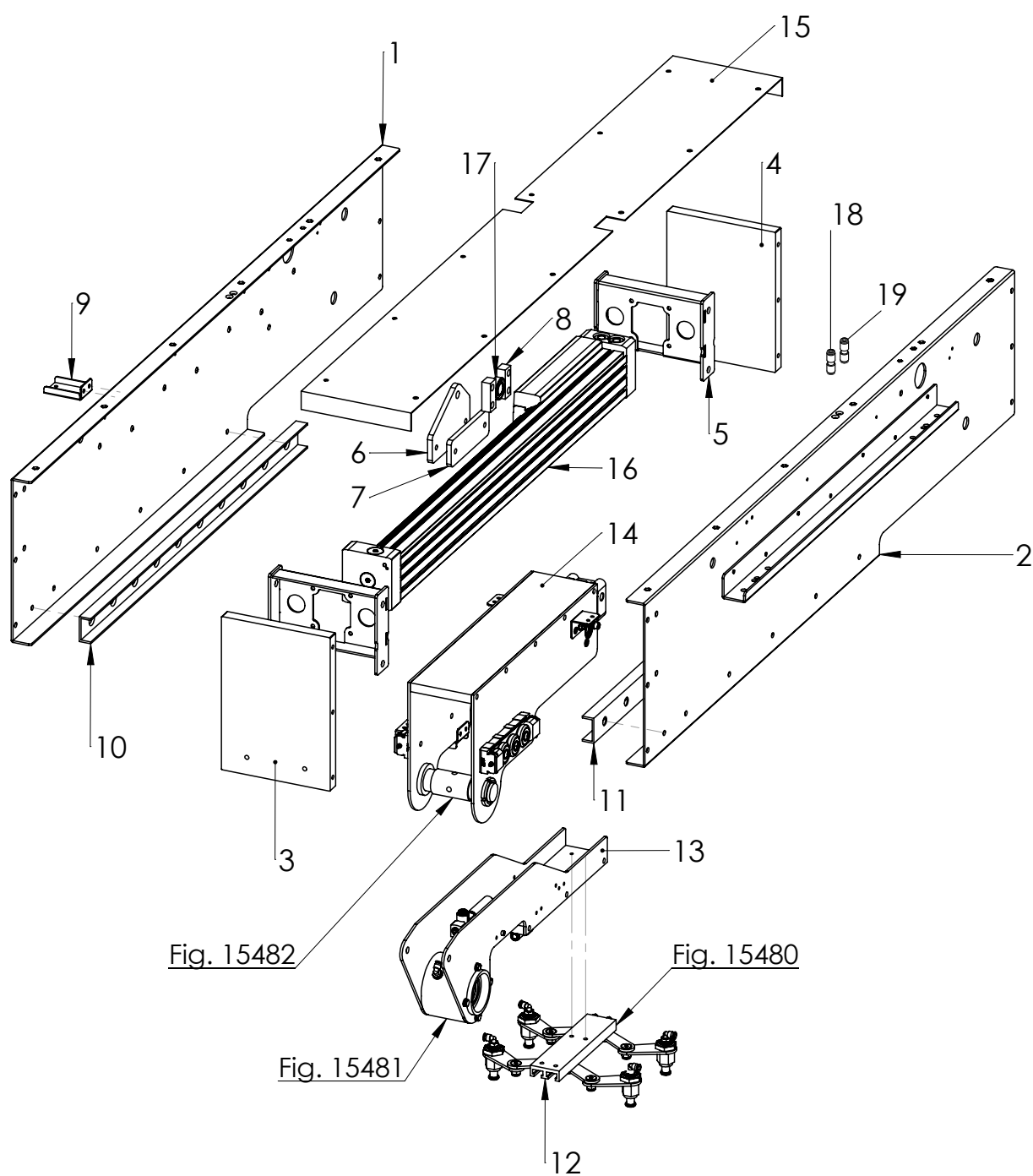


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15480	Gruppo ventose		F44	Formatore
Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBC0015272T	Dado fiss. Guida ventose	4	pz
2	SBC0015269	Guida ventose	1	pz
3	SBC0015291V	Lam. di attacco al braccio portavent.	4	pz
4	S340028393Z	Dado autoblocc. M8 basso zinc.	4	pz
5	S340012493Z	Vite tsvei m8x20 zinc.	4	pz
6	SBC0015297T	Perno attacco ventosa	4	pz
7	S340220592Z	Ranella di safety "s" (schnorr)/8	4	pz
8	S340058493Z	Vite tcei m8x16 zinc.	4	pz
9	S340012393Z	Rondella piana x vite m8 zinc.	4	pz
10	SBC0015294Z	Lamiera x attacco ventose	4	pz
11	S340017693Z	Vite te m4x12 zinc.	2	pz
12	S340004393Z	Rondella piana x vite m4 zinc.	2	pz
13	S350051593Z	Dado spec. Autoblocc. M20x1 zinc.	4	pz
14	SCB0000724	Racc. a "L" girevole QSML-G1/8"	4	pz
Data	mag-11			

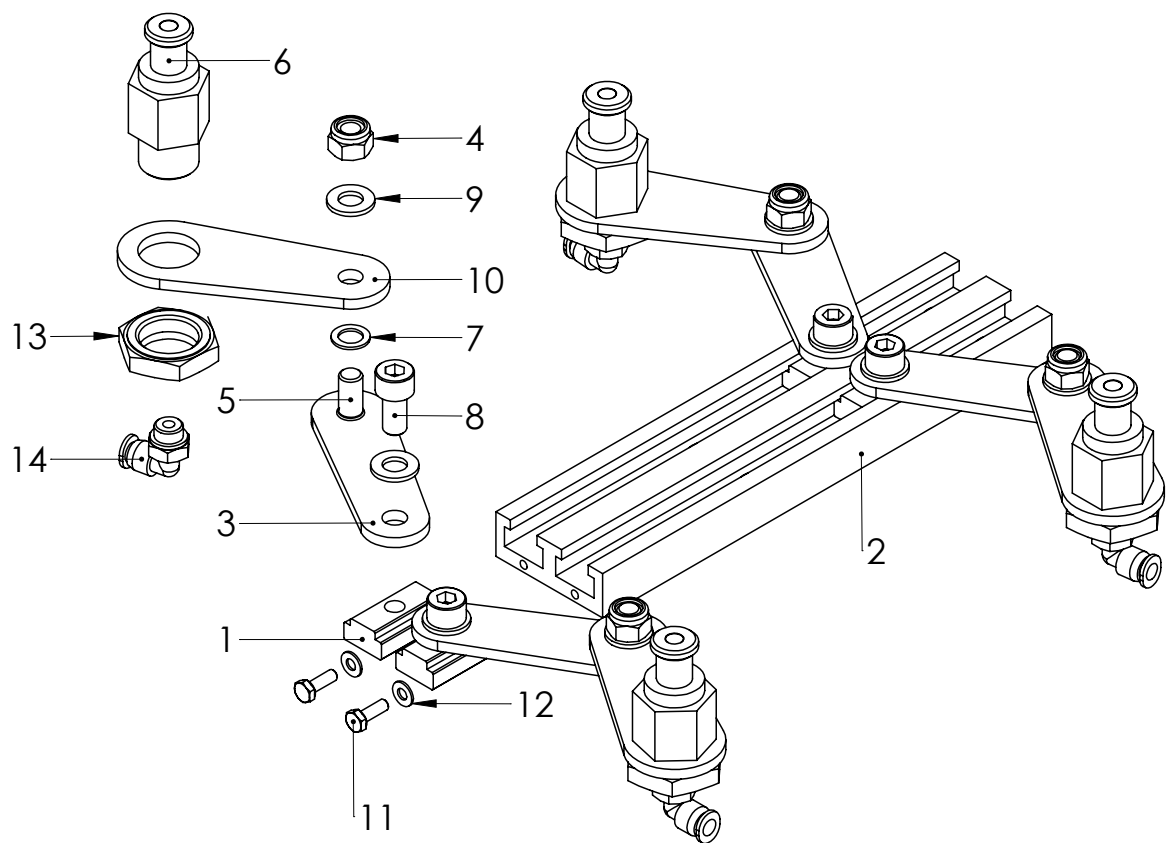


Fig. 15480

Maggio 2011

Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15481	Braccio portaventose		F44	Formatore
Posizione	Ricambio	Descrizione	Quantità	U.M.
1	S340017593Z	Rond. Piana x vite m6 zinc.	8	pz
2	SBC0015249V	Spalla gruppo estr. cartoni	2	pz
3	SBA0009022	Cilindro incern. Braccio estr. compl.	1	pz
4	SBC0015262T	Perno incern. Gr. Portavent.	1	pz
5	S340002193Z	Vite te m6x12 zinc.	8	pz
6	S340022993Z	Vite tcei m4x30 zinc.	6	pz
7	S340507793A	Vite tbei m8x20 zinc.	6	pz
8	S340029893Z	Dado autoblocc. M4 zinc.	8	pz
9	S340004393Z	Rondella piana x vite m4 zinc.	2	pz
10	S340272793Z	Vite tcei m3x35 zinc.	2	pz
11	SBC0015270	Piastra sostegno guida ventosa	1	pz
12	S340055893Z	Rondella piana x vite m3 zinc.	2	pz
13	S340101493Z	Dado autoblocc. M3 zinc.	2	pz
14	SCB0000724	Raccordo ad "I" girevole qsml-g1/8"	2	pz
15	SCB0000722	Ugello aspiraz. Vn-14-l-t4-pq2-vq3	2	pz
16	SCB0000725	Racc. ad "y" con uscite ridotte qsy	2	pz
17	SCB0000148	Pressostato sde5-d10-0-q6-p-m8	1	pz
18	SBC0000742	Piastra 7506-3T	1	pz
Data	mag-11			

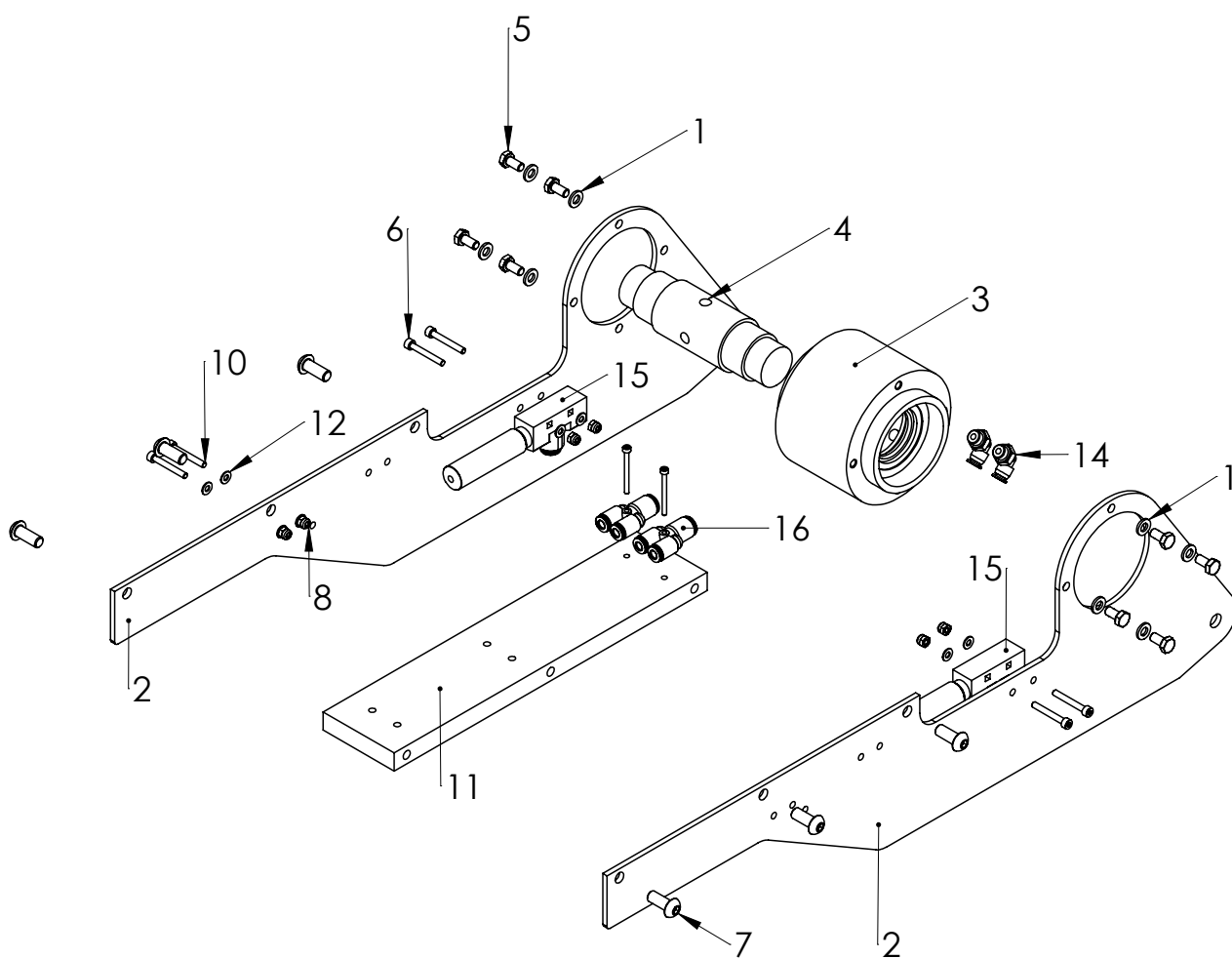


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15482	Gruppo movimento ventose		F44	Formatore
Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBA0009891	Spalla gr. Movimento ventose compl.	2	pz
2	S340017593Z	Rondella piana x vite m6 zinc.	3	pz
3	S340072993Z	Vite tcei m6x14 zinc.	3	pz
4	S3400780ZZZ	Bronzina ferro	2	pz
5	SBC0015283T	Flangia movimento ventose	2	pz
6	SBC0015281V	Spalla gr. Movimento ventose	2	pz
7	S340011293Z	Vite tcei m5x16 zinc.	4	pz
8	S340006193Z	Rondella piana x vite m5 zinc.	4	pz
9	SBC0015251V	Squadretta catena portacavi	1	pz
10	S380629400A	Cerniera interm zncm-50 festo	1	pz
11	SBC0015266	Piastra sostegno spalle	1	pz
12	SBC0015863T	Cilindro festo dncb 50 20 ppv-a	1	pz
13	SBC0015255V	Squadra fiss. Catena portacavi	1	pz
14	SBC0016056T	Dist. Gr. braccio portaventose	2	pz
15	S3400101ZZZ	Ghiera	2	pz
16	SCA0001324	Guida ULV43-800	1	pz
17	SCA0001327	Guida TLV43-800	1	pz
18	SBC0000463	Profilo piegato 7225-3T	1	pz
19	SCB0000584	Festo GRXA-H6	1	pz
Data	mag-11			

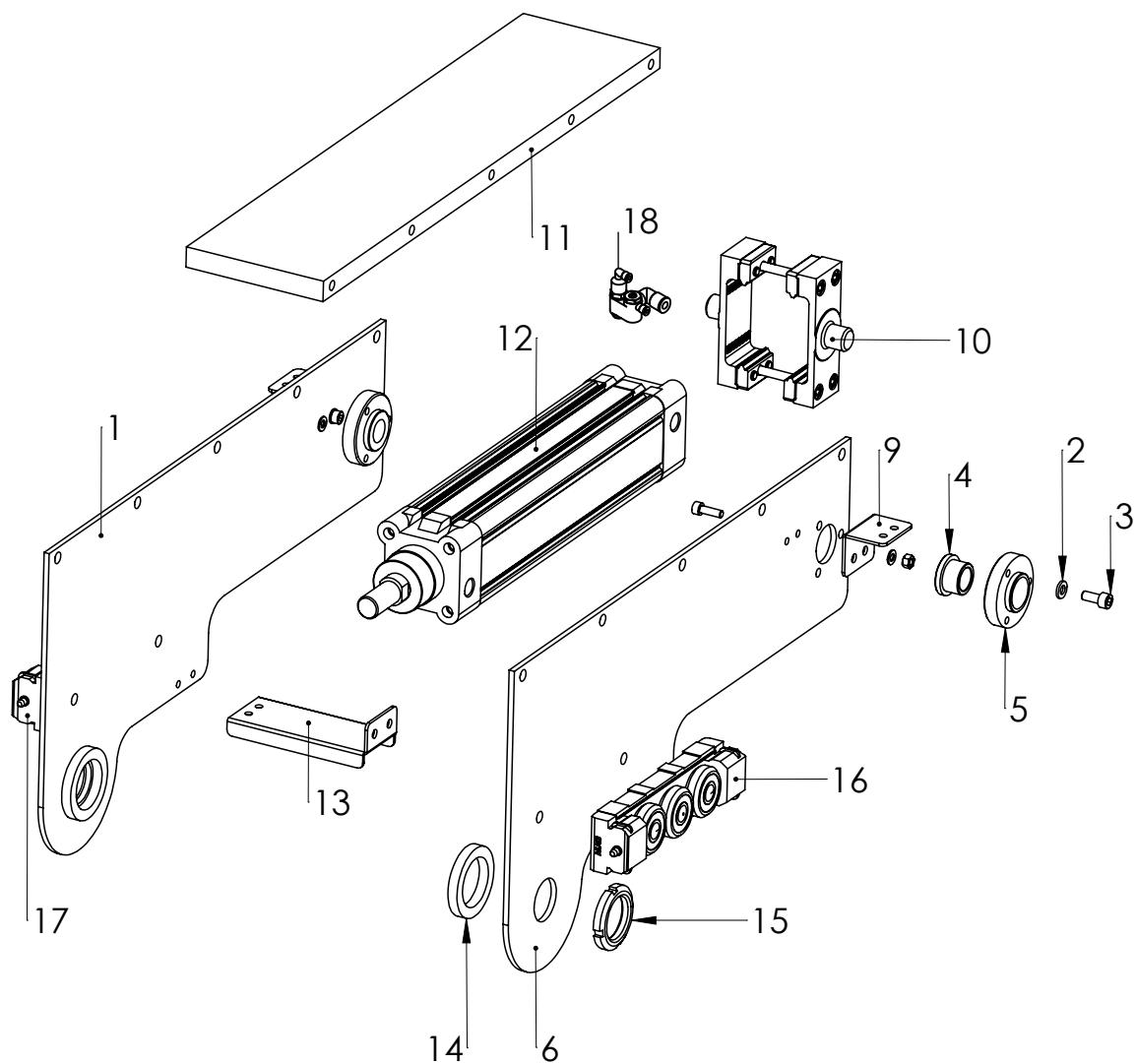


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
	Gruppo alimentatore completo	SBA0009895	F44	Formatore
15460	Gruppo molla superiore compl.	SBA0009077		
15461	Gruppo supp. asta porta molla	SBA0009865		
15462	Gruppo bloccaggio molla inf.	SBA0009060		
15463	Gruppo appoggio cartoni dx	SBA0009870		
15464	Gruppo appoggio cartoni sx	SBA0009871		
15465	Ass. telaio caricatore con guide	SBA0009881		
15466	Gruppo premi cartoni dx compl.	SBA0009885		
15467	Gruppo vite sollevamento compl.	SBA0008944		
15468	Gruppo scivolo pressatore	SBA0009815		
15469	Gruppo premi cartoni sx compl.	SBA0009884		
15470	Telaio mobile alim. Con guide	SBA0009890		
15471	Gruppo sx passaggio cartoni	SBA0010143		
15472	Gruppo dx passaggio cartoni	SBA0010140		
15473	Gruppo vite spost. Orizz.	SBA0009894		
15474	Gruppo rulli arresto cartoni	SBA0009389		
15475	Gruppo rulli ferma cartoni	SBA0009822		
15476	Assieme guida pressatore	SBA0009822		
Data	mag-11			

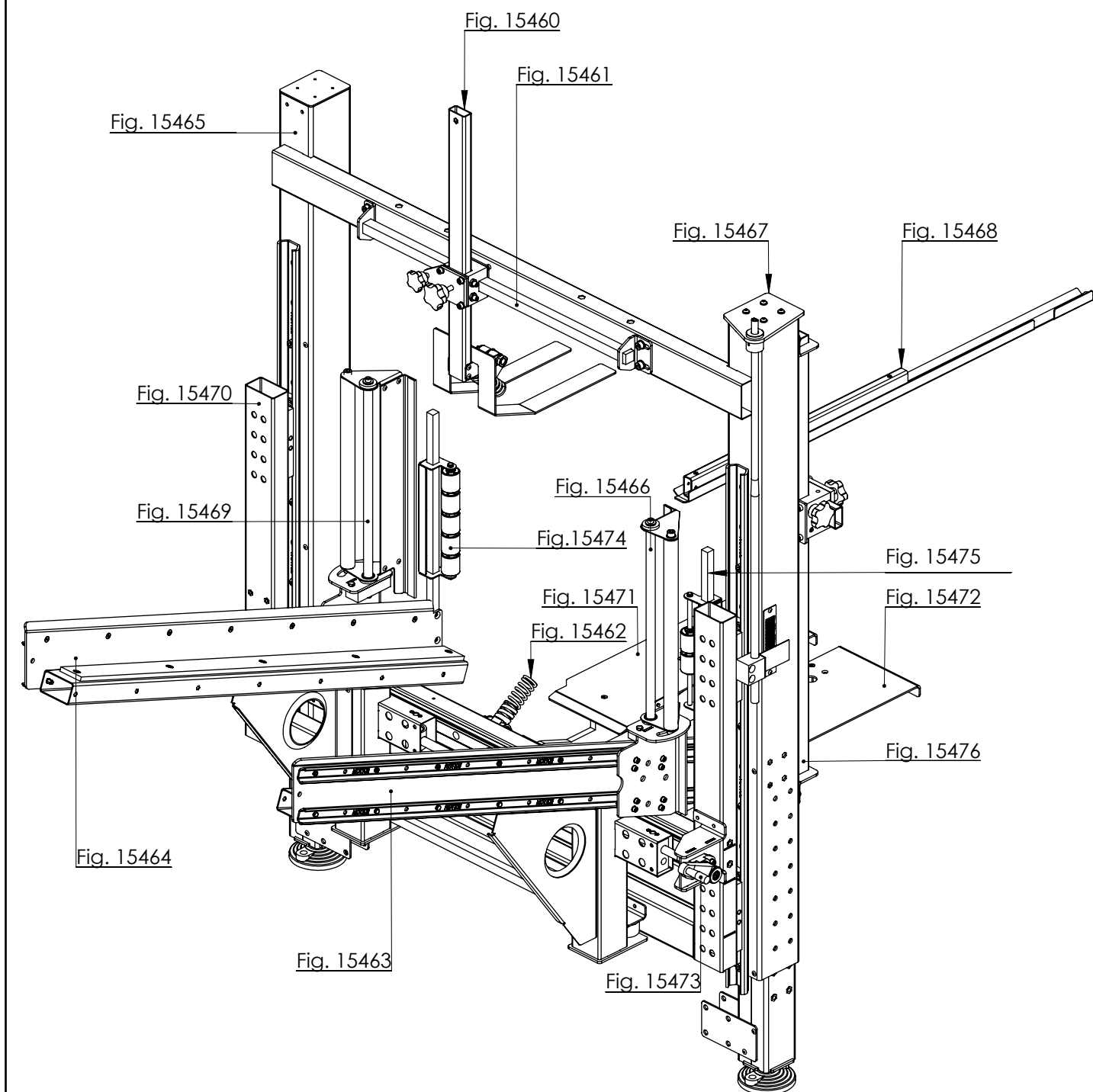


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15460/15461	Gruppo molla/gruppo supporto		F44	Formatore

Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBC0015981T	Distanziale supp. Molla sup.	2	pz
2	SBA0009076	Gruppo supporto molla superiore	1	pz
3	SBA0004241T	Piastrina con molla apriscatole ass.	1	pz
4	S340012393Z	Rondella piana x vite m8 zinc.	2	pz
5	S340040693Z	Vite te m8x60 zinc.	1	pz
6	S340028393Z	Dado autoblocc. M8 basso zinc.	1	pz
7	S340011293Z	Vite tcei m5x16 zinc.	2	pz
8	S340006193Z	Rondella piana x vite m5 zinc.	2	pz
9	SBC0017302	Scivolo pressatore	1	pz
10	S340058493Z	Vite tcei m8x16 zinc.	3	pz
11	S340012393Z	Rondella piana x vite m8 zinc.	6	pz
12	S340001593Z	Vite tcei m6x25 zinc.	1	pz
13	SCA0001391	Pressore filett. a molla GN 616-M8-K	2	pz
14	S340246293Z	Vite tcei m5x14 zinc.	4	pz
15	S340006193Z	Rondella piana x vite m5 zinc.	4	pz
16	S340017593Z	Rondella piana x vite m6 zinc.	6	pz
17	SBC0014947	Supporto regolazione molla sup.	1	pz
18	SBC0014948T	Spessore supp. Regolaz. Molla sup.	1	pz
19	SBC0014939T	Disco di pressione	1	pz
20	SBC0016720T	Piastra fiss. Portamolla	1	pz
21	SBC0015320T	Piastra per disco bloccaggio tubo	1	pz
22	S340051593Z	Vite tcei m8x35 zinc.	4	pz
23	S340012393Z	Rondella piana x vite m8 zinc.	4	pz
24	S340268205Z	Volant. elesa vc.192-50-m8x25	1	pz
25	SCA0001404	Volantino a lobi vc. 192 p m8x45	1	pz
26	S340011693Z	Dado basso m8 zinc.	2	pz
27	S340057793Z	Vite tcei m6x16 zinc.	2	pz
28	SBC0017055T	Squadretta dx gr. Molla	1	pz
29	SBA0010062T	Ass. barra traslazione molla	1	pz
30	S330895593Z	Dist./6,25x10x15,5 zinc.	2	pz
31	S340020693Z	Vite tcei m10x20 zinc.	1	pz
32	SBC0015878V	Squadra con unione	1	pz

Data mag-11

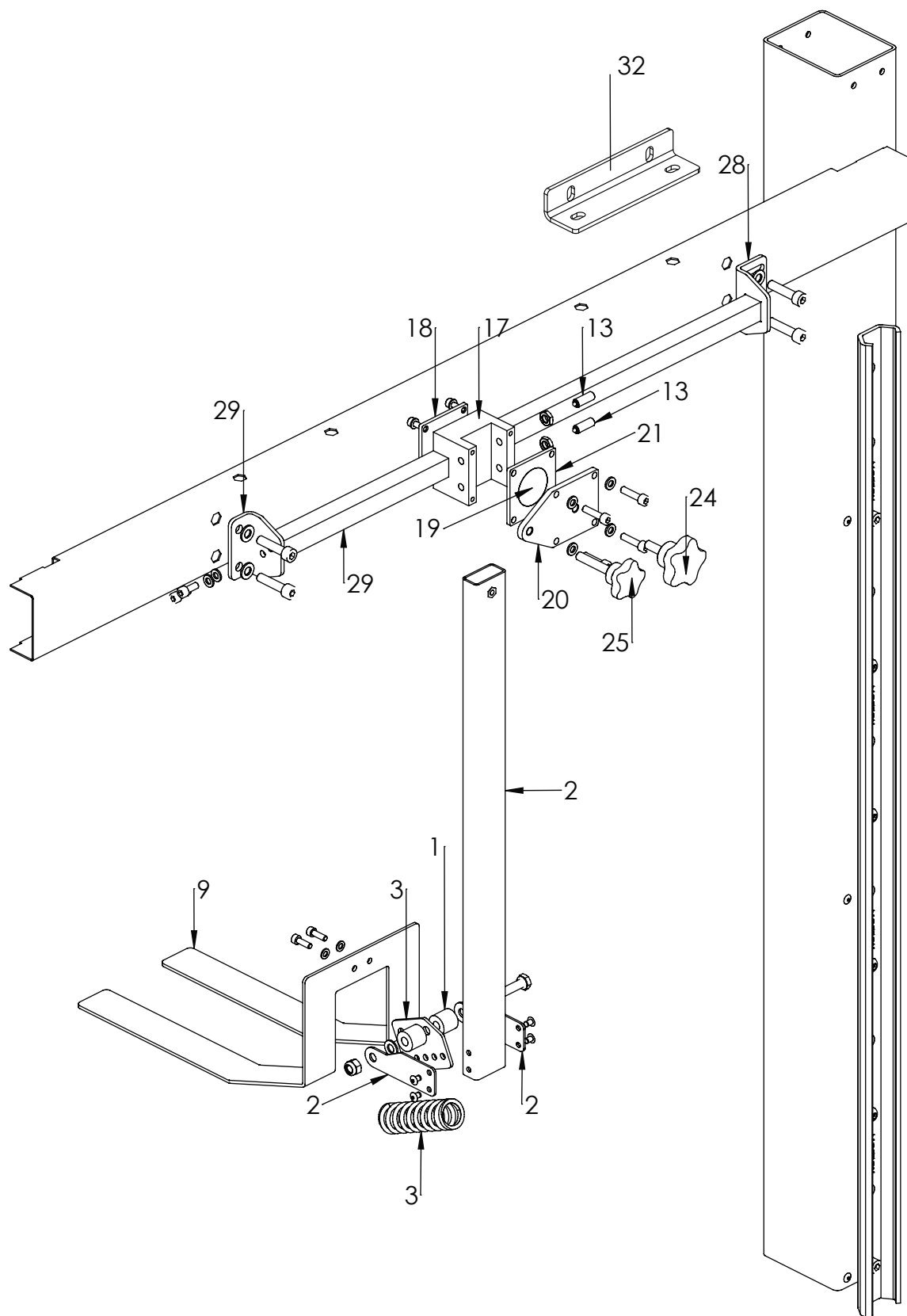


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15465/15470	Telaio caricatore/alimentatore		F44	Formatore

Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBA0009880	Ass. telaio principale	1	pz
2	SCA0001413	Guida TES45-rollon	2	pz
3	SBC0015915	Piastra grad. Serigr. Regolaz. Vert.	1	pz
4	S340058493Z	Vite tcei m8x16 zinc.	4	pz
5	S340344893Z	Vite tbei uni 7380 m8x16 zinc.	8	pz
6	SBC0014979T	Anello esterno morsetto	1	pz
7	S3400984ZZZ	Rivetto	2	pz
8	S340043893Z	Dado autoblocc. M10 basso	1	pz
9	S340021993Z	Rondella piana per vite m10 zinc.	1	pz
10	S340382600A	Piedino 312525 lv	2	pz
11	SBA0008919	Gamba scorrevole dx con ins.	1	pz
12	SBA0008921	Gamba scorrevole sx con ins.	1	pz
13	SBA0008862	Telaio mobile alimentatore con ins.	1	pz
14	S340048693Z	Vite tcei m8x25 zinc.	6	pz
15	SBC0014983	Dist. Attacco carrello	4	pz
16	SCA0001302	Cursore tipo ces45-150-2z	4	pz
17	SBC0014988	Blocc. Filettato vite sollevamento	1	pz
18	SCA0001301	Cursore tipo mrs30-w-h-k1	4	pz
19	SCA0001300	Guida mrr30-1060-h per trasl. Orizz.	1	pz
20	S3400984ZZZ	Rivetto	2	pz
21	SBC0014741	Piastrina serigrafata per spost. Orizz.	1	pz
22	SBC0015901	Indicatore posizione verticale	1	pz
23	S340004393Z	Rondella piana x vite m4 zinc.	2	pz
24	S340002993Z	Vite te m4x10 zinc.	2	pz
25	SBC0015890V	Staffa attacco catadiottro	1	pz

Data mag-11

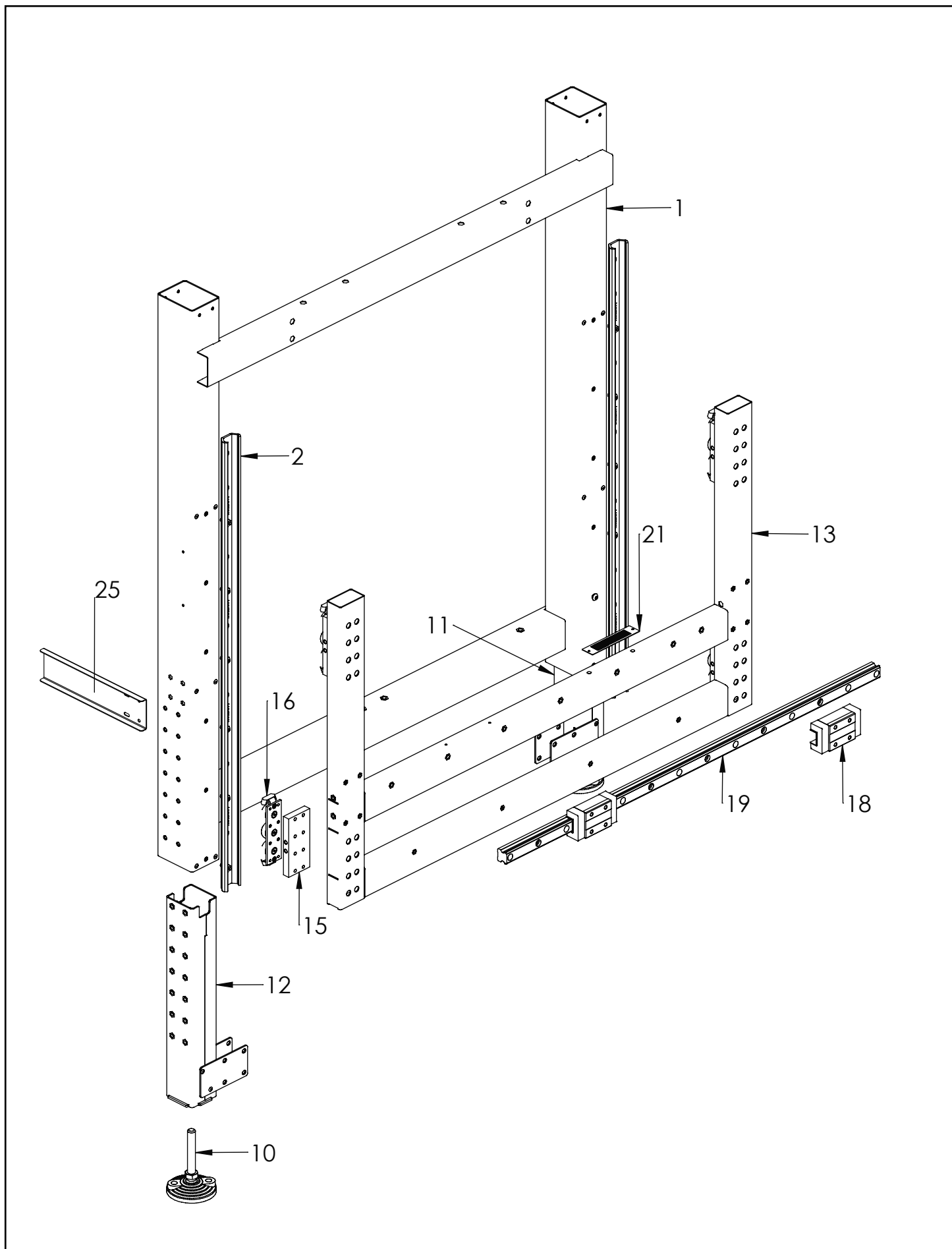


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15467/15473	Gruppo vite sollev./spostam.		F44	Formatore

Posizione	Ricambio	Descrizione	Quantità	U.M.
1	S340017593Z	Rondella piana x vite m6 zinc.	4	pz
2	SCA0000133	Vite tbei m6x20 iso 7380 zinc.	4	pz
3	SBA0008943	Piastra sup. chiusura tubo con ins.	1	pz
4	SBC0015108V	Piastra attacco vite sollevamento	1	pz
5	SBC0015112T	Vite sollevamento alimentatore	1	pz
6	S3100583ZZZ	Bussola	1	pz
7	S470534100A	Manovella	1	pz
8	S331200993Z	Bussola fissaggio vite sollevamento	1	pz
9	S340014293Z	Vite tcei m4x25 zinc.	1	pz
10	S340172896Z	Inserto esagonale rf41	8	pz
11	SBC0014988	Blocchetto filettato vite sollevamento	1	pz
12	SBC0015901	Indicatore posizione verticale	1	pz
13	S460424405A	Supporto con cuscinetto	1	pz
14	S340051693Z	Vite tsvei m5x12 zinc.	1	pz
15	SBA0008925	Gruppo attacco leva spost. Orizz. Ins.	1	pz
16	S350050693Z	Rondella fissaggio motori	1	pz
17	S3402700ZZZ	Manovella elesa mt. 80 as 10x10	1	pz
18	S340072993Z	Vite tcei m6x14 zinc.	1	pz
19	S340003393Z	Rondella tripla x vite m6 zinc.	1	pz
20	S340057793Z	Vite tcei m6x16 zinc.	2	pz
21	S340017593Z	Rondella piana x vite m6 zinc.	2	pz
22	S340013592Z	Anello arresto x albero br.	1	pz
23	S3310014900A	Distanziale manov. Motorizz.	1	pz
24	S332415192A	Bussola vite di centratura 130cf	1	pz
25	SBC0015096T	Asta scorrimento	1	pz
26	SBC0014774V	Piastra chiusura tubo sup.	1	pz
27	SBC0015962V	Piastra di fermo spost. Orizz. Carr.	1	pz
28	SBC0015165	Piastra di attacco	1	pz

Data mag-11

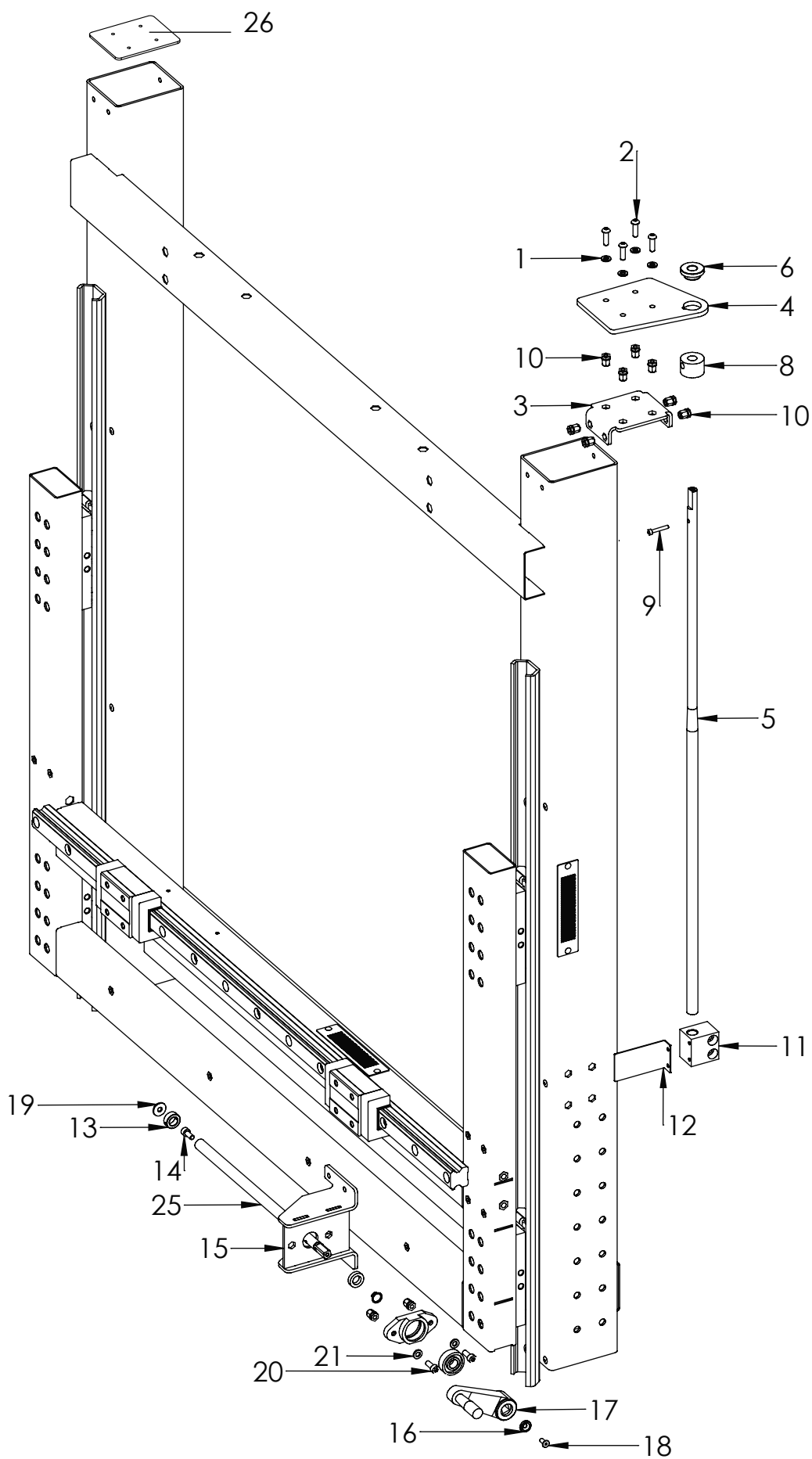


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15468/15476	Gruppo scivolo/guida pressatore		F44	Formatore
Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBC0016625T	Blocco sostegno pressatore	1	pz
2	S340016093Z	Vite tcei m6x20 zinc.	8	pz
3	SBC0015058	Lamiera scivolo pressatore	1	pz
4	SBA0009011	Tubo scivolo pressatore con ins.	1	pz
5	S340033093Z	Vite tsvei m4x12 zinc.	3	pz
6	SBC0014913T	Spessore blocchetto scivolo press.	1	pz
7	SBC0014911T	Piastra fissaggio scivolo press.	1	pz
8	SBC0014939T	Disco di pressione	1	pz
9	SCA0001391	Pressore filett. a molla GN 616-M8-K	3	pz
10	S340268205Z	Volantino elesa vc 192-50-m8x25	2	pz
11	S340017593Z	Rondella piana x vite m6 zinc.	4	pz
12	SBC0016648V	Staffa superiore guida	1	pz
13	S340011493Z	Vite tcei m6x15 zinc.	4	pz
14	SBA0010220T	Ass. tubo guida pressatore	1	pz
Data	mag-11			

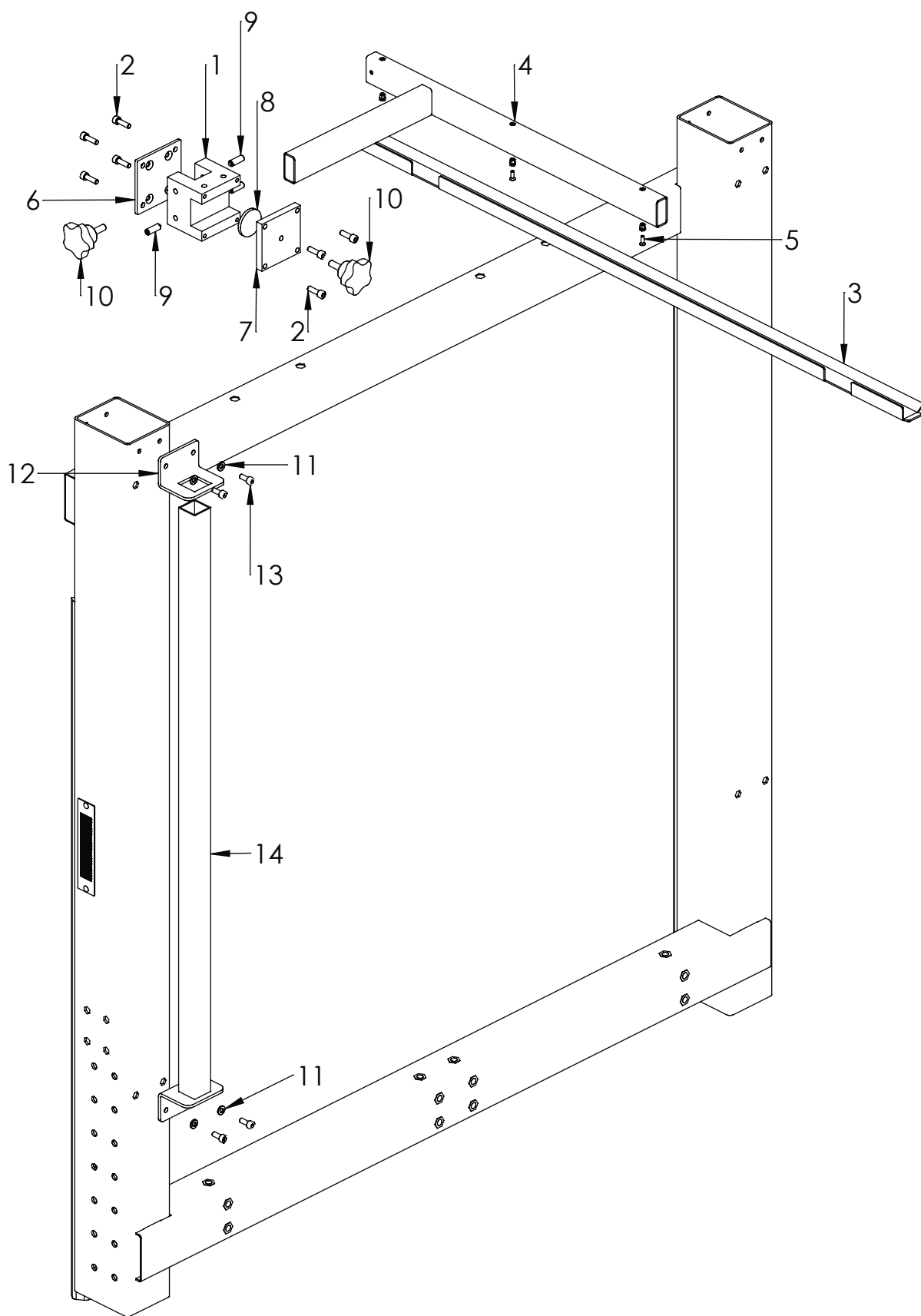


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15471/15472	Gruppi passaggio cartoni		F44	Formatore

Posizione	Ricambio	Descrizione	Quantità	U.M.
1	S340051693Z	Vite tsvei m5x12 zinc.	1	pz
2	SBC0017104	Piano dx passaggio cartoni	1	pz
3	SBC0015165	Piastra di attacco	1	pz
4	SBC0015164V	Piastra di att. Piani pass. Cartoni	2	pz
5	S340016093Z	Vite tcei m6x20 zinc.	2	pz
6	S340017593Z	Rondella piana x vite m6 zinc.	2	pz
7	SBA0010103	Ass. con ins. Staffa cilindro FESTO	1	pz
8	SBC0017096	Prolunga cilindro FESTO DSNU	1	pz
9	S340028493Z	Dado m6 basso zinc.	1	pz
10	SCB0000849	Cilindro DSNU D16 CORSA 25 P-A	1	pz
11	S340040393Z	Vite tsvei m5x16 zinc.	2	pz
12	S340028493Z	Dado m6 basso zinc.	1	pz
13	SBC0017096	Prolunga cilindro FESTO DSNU	1	pz
14	SCB0000849	Cilindro DSNU D16 CORSA 25 P-A	1	pz
15	S340040393Z	Vite tsvei m5x16 zinc.	2	pz
16	S340051693Z	Vite tsvei m5x12 zinc.	1	pz
17	SBC0017189	Piano Sx passaggio cartoni	1	pz
18	SBA0010103	Ass. con ins. Staffa cilindro FESTO	1	pz
19	S340016093Z	Vite tcei m6x20 zinc.	2	pz
20	S340017593Z	Rondella piana x vite m6 zinc.	2	pz
21	SBC0015165	Piastra di attacco	1	pz
22	SBC0015164V	Piastra di att. Piani pass. Cartoni	1	pz

Data mag-11

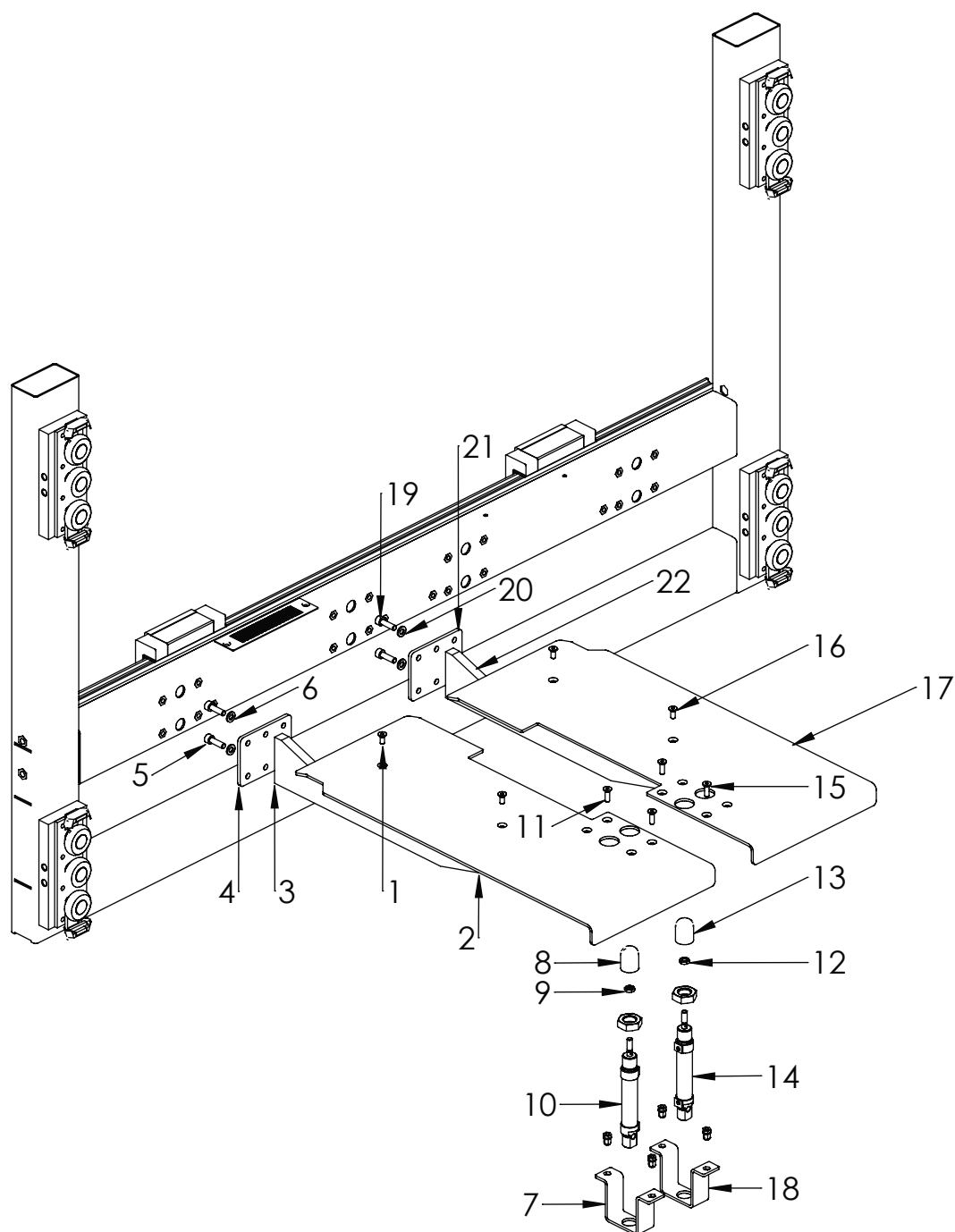


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15463/15464	Gruppo appoggio cartoni dx/sx		F44	Formatore

Posizione	Ricambio	Descrizione	Quantità	U.M.
1	S340005093Z	Vite tsvei m6x20 zinc.	5	pz
2	SBA0008906	Ruota completa traslaz. Orizz.	1	pz
3	SBC0015043T	Perno per ruota trasl. Orizz.	1	pz
4	SBC0015044T	Distanziale d25 foro17.5 h9	1	pz
5	SBC0016741	Piano appoggio cartoni	1	pz
6	SBA0009862	Gruppo app. cartoni dx con ins.	1	pz
7	SCA0001402	Guida TES30-1040 ROLLON	2	pz
8	SBC0016735T	Lamiera contenitrice cartoni dx	1	pz
9	SBC0015065	Supporto vite trasl. Orizz.	1	pz
10	S340000293Z	Dado m6 zinc.	1	pz
11	S340006293Z	Rondella piana x vite m12 zinc.	1	pz
12	S340001893Z	Dado m12 zinc.	1	pz
13	S340037093Z	Vite tsvei m5x10 zinc.	7	pz
14	S340004593Z	Vite te m5x20 zinc.	7	pz
15	S340002393Z	Dado m5 zinc.	7	pz
16	S340005093Z	Vite tsvei m6x20 zinc.	5	pz
17	S340001893Z	Dado m12 zinc.	1	pz
18	S340000293Z	Dado m6 zinc.	1	pz
19	S340006293Z	Rondella piana x vite m12 zinc.	1	pz
20	SBC0015044T	Distanziale d25 foro17.5 h9	1	pz
21	SBC0016741	Piano appoggio cartoni	1	pz
22	SBA0009863	Gruppo app. cartoni sx con ins.	1	pz
23	SCA0001402	Guida TES30-1040 ROLLON	2	pz
24	SBC0016736T	Lamiera contenitrice cartoni sx	1	pz
25	SBA0008906	Ruota completa trasl. Orizz.	1	pz
26	SBC0015043T	Perno per ruota trasl. Orizz.	1	pz
27	S340037093Z	Vite tsvei m5x10 zinc.	7	pz
28	S340004593Z	Vite te m5x20 zinc.	7	pz
29	SCA0001411	Dado m5 basso zinc.	7	pz
30	SBC0015096T	Asta scorrimento	1	pz
31	SBC0015959V	Indicatore x spost. Lat.	1	pz

Data mag-11

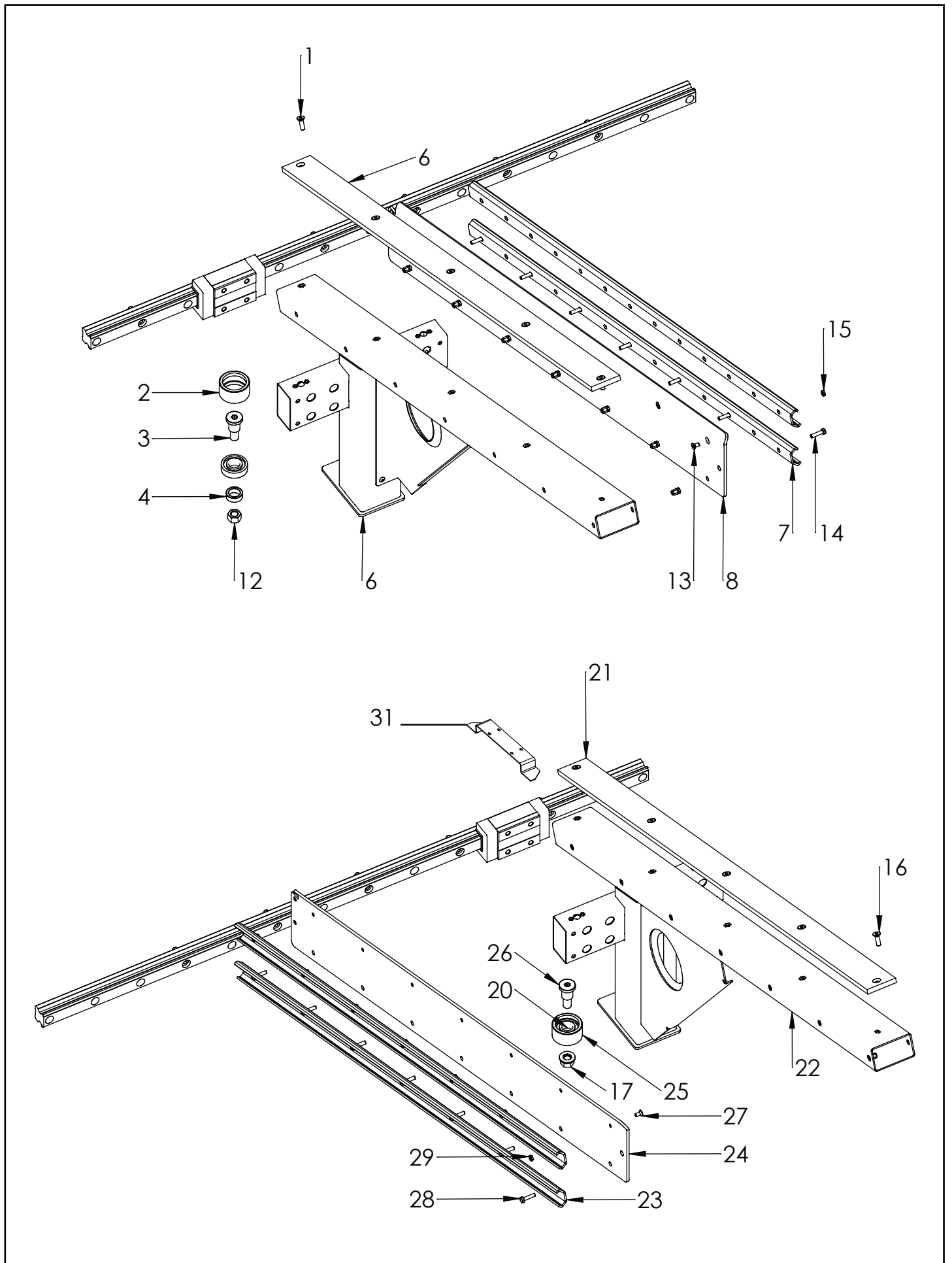


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15469/15474	Premi cartoni sx\Rulli arr. Sx		F44	Formatore

Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBA0008970V	Ass.sopp. Rulli ferma scatole	1	pz
2	S3100564ZZZ	Rullino/32x38	5	pz
3	S340012393Z	Rondella piana x vite m8 zinc.	18	pz
4	S340057793Z	Vite tcei m6x16 zinc.	3	pz
5	S340006193Z	Rondella piana x vite m5 zinc.	2	pz
6	S340037193Z	Vite te m5x12 zinc.	2	pz
7	SBC0014934T	Colonna supporto attuatore	1	pz
8	SBC0017402T	Perno arresto cartoni	1	pz
9	SBC0014996T	Distanziale asta pos. Molla	2	pz
11	S340003093Z	Vite tsvei m6x25 zinc.	2	pz
12	S340017593Z	Rondella piana x vite m6 zinc.	2	pz
13	S340057793Z	Vite tcei m6x16 zinc.	3	pz
14	S340003393Z	Rondella tripla x vite m6 zinc.	1	pz
15	SCA0001403	Cursore CES30-88-2Z ROLLON	2	pz
16	S340002193Z	Vite te m6x12 zinc.	2	pz
17	S340006193Z	Rondella piana x vite m5 zinc.	8	pz
18	SBA0008962	Lam. Premi cartoni sx ass.	1	pz
19	SBA0008858T	Incernieramento spintore cartoni	1	pz
20	SBC0015123V	Piastra attacco gr. Pos. Cartoni	1	pz
21	SBC0016751V	Lamiera sx attacco carrello	1	pz
22	S340058493Z	Vite tcei m8x16 zinc.	2	pz
23	S340012393Z	Rondella piana x vite m8 zinc.	2	pz
24	SBC0015135	Tondo d25 l381	1	pz
25	SBC0017401	Spessore pattino gr. Arresto cartoni	2	pz
26	S340010893Z	Vite tcei m5x20 zinc.	8	pz
27	SBC0014936	Dist. Colonna attuatore	1	pz

Data mag-11

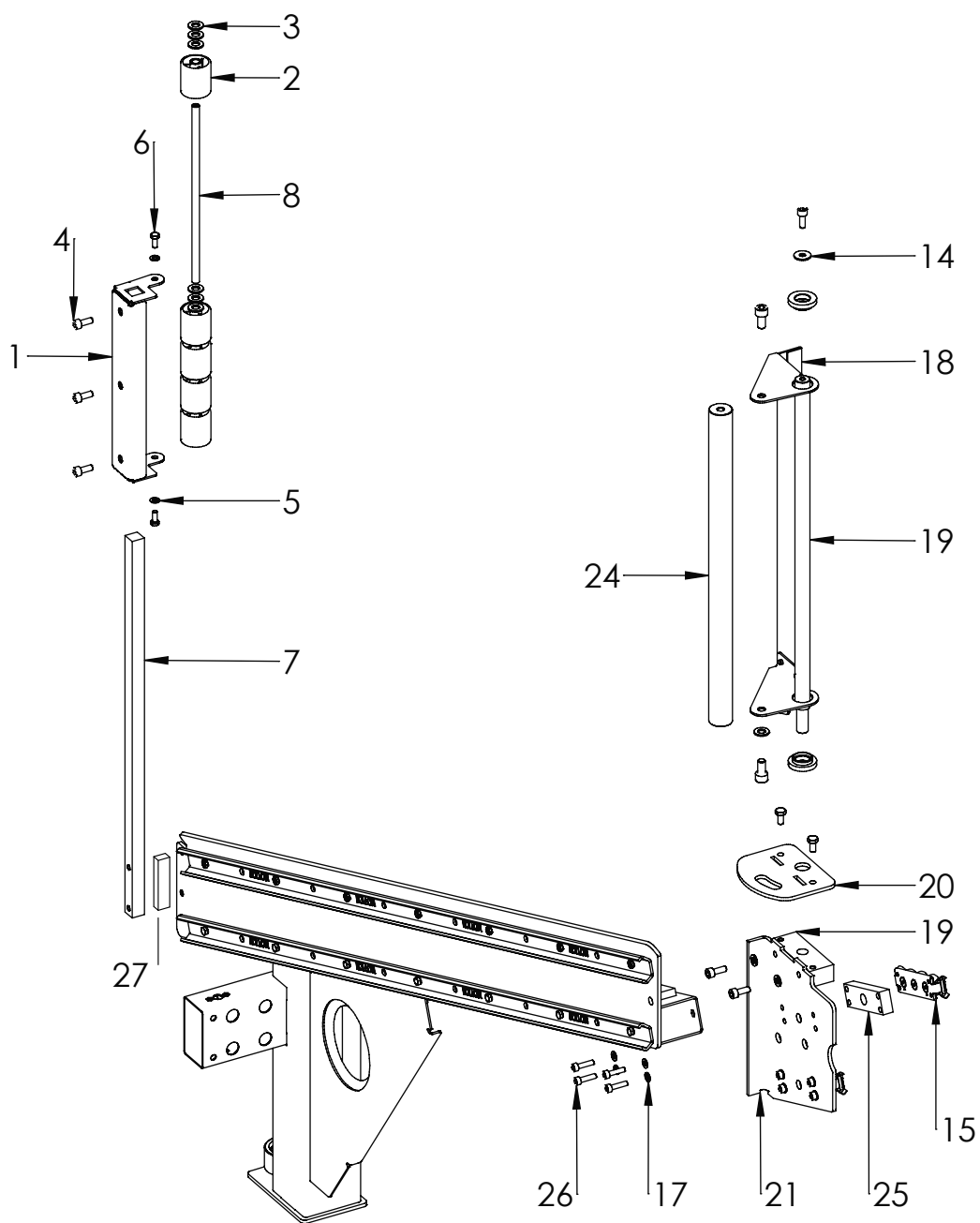


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15466/15475	Gruppo premi/ferma cartoni dx		F44	Formatore

Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBA0009885	Vite te m6x12 zinc.	2	pz
2	S340057793Z	Vite tcei m6x16 zinc.	3	pz
3	S340003393Z	Rondella tripla x vite m6 zinc.	1	pz
4	S340006193Z	Rondella piana x vite m5 zinc.	8	pz
5	S340012393Z	Rondella piana x vite m8 zinc.	2	pz
6	SBC0015135	Tondo d25 l381	1	pz
7	SBA0008950	Lam. Premi cartoni dx ass.	1	pz
8	SBA0008858T	Incernieramento spintore cartoni	1	pz
9	S340017593Z	Rondella piana x vite m6 zinc.	2	pz
10	S340058493Z	Vite tcei m8x16 zinc.	2	pz
11	SCA0001403	Cursore CES30 - 88 - 2Z ROLLON	2	pz
12	SBC0015123V	Piastra attacco gr. Pos. Cartoni	1	pz
13	SBC0016750V	Lamiera dx attacco carrello	1	pz
14	SBC0017401	Spessore pattino gr. Arresto cartoni	2	pz
15	S340010893Z	Vite tcei m5x20 zinc.	8	pz
16	S340012393Z	Rondella piana x vite m8 zinc.	9	pz
17	S340011493Z	Vite tcei m6x15 zinc.	3	pz
18	S340037193Z	Vite te m5x12 zinc.	2	pz
19	SBC0014934T	Colonna supporto attuatore	1	pz
20	SBA0008907V	Ass. sopp. Rulli ferma scatole	1	pz
21	S340006193Z	Rondella piana x vite m5 zinc.	2	pz
22	S3100564ZZZ	Rullino/32x38	2	pz
23	SBC0017402T	Perno arresto cartoni	1	pz
24	S340026392Z	Anello arresto x albero 8 br.	2	pz
25	S340076593Z	Vite tsvei m6x30 zinc.	2	pz
26	SBC0014936	Distanziale colonna attuatore	2	pz

Data mag-11

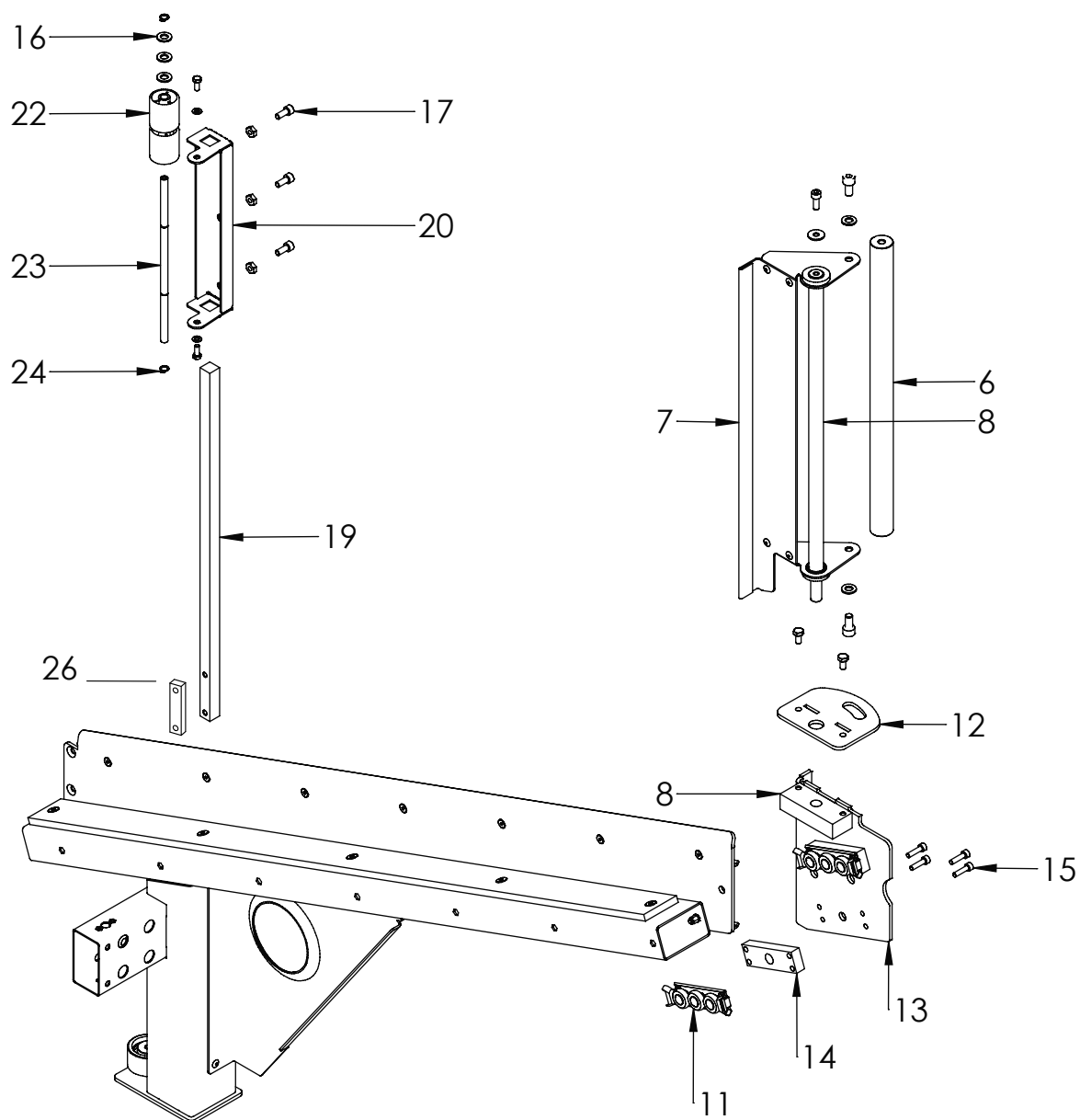


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15462	Gruppo bloccaggio molla inf.		F44	Formatore

Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBC0014993T	Asta posizionamento molla inf.	1	pz
2	SBC0014996T	Distanziale asta posiz. Molla	2	pz
3	SBC0015342T	Piatto bloccaggio molla inferiore	1	pz
4	SBC0015340V	Fianco x gruppo bloccaggio molla inf.	2	pz
5	S340006193Z	Rondella piana x vite m5 zinc.	4	pz
6	S340031893Z	Vite tcei m5x12 zinc.	4	pz
7	SBC0014995T	Distanziale supporto molla	2	pz
8	SBA0009067V	Gruppo molla apricartoni	1	pz
9	S340012393Z	Rondella piana x vite te m8 zinc.	2	pz
10	S340040693Z	Vite te m8x60 zinc.	1	pz
11	S340028393Z	Dado autoblocc. M8 basso zinc.	1	pz

Data **mag-11**

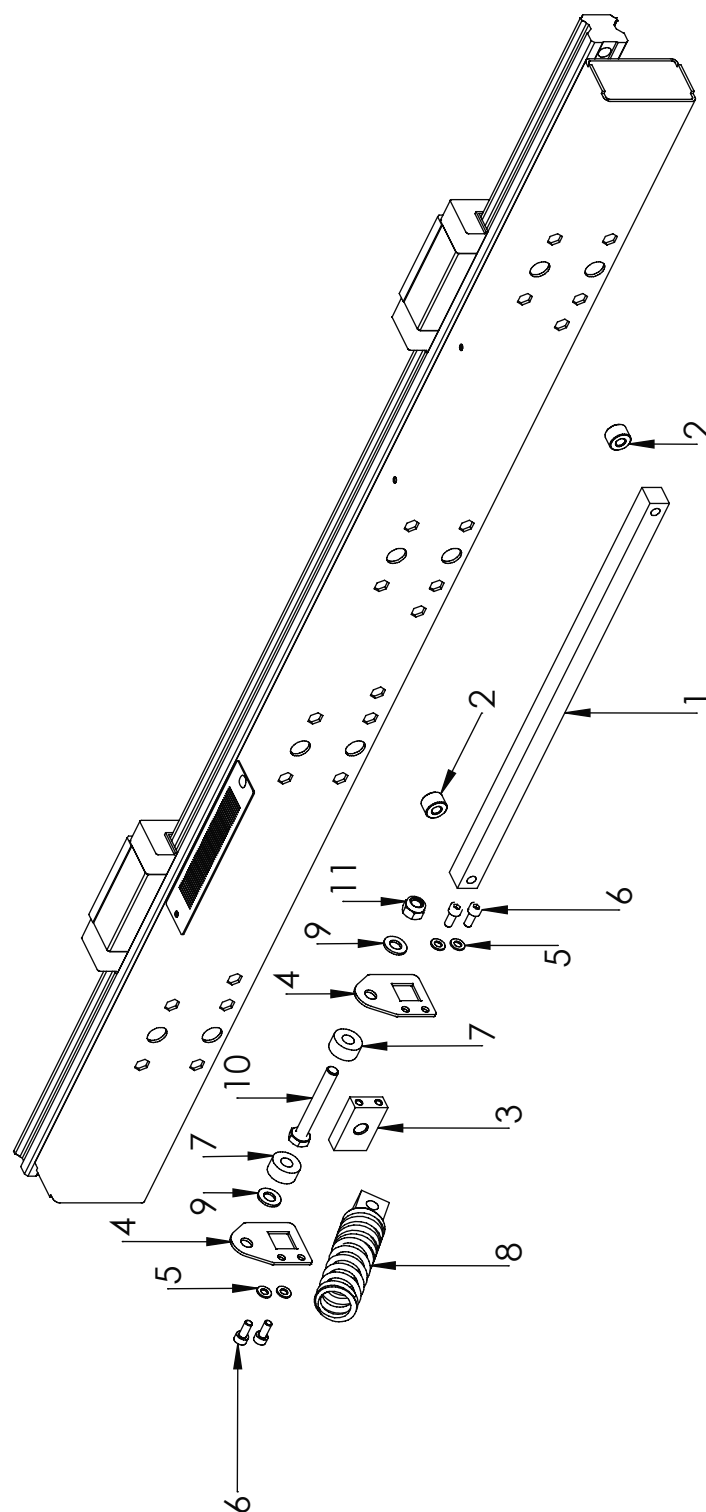


Fig. 15462

Aprile 2011

Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15483	Motorizzazione dx		F44	Formatore

Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBA0008928	Guida superiore dx motorizz. c/ins.	1	pz
2	SBA0008926	Guida inferiore dx motorizz. c/ins.	1	pz
4	S330596093Z	Distanziale es. 10x81 zinc.	4	pz
8	S470405100A	Galoppino ass.	1	pz
9	S470405200A	Puleggia doppia ass.	1	pz
14	S3311650ZZZ	Blocchetto x motorizz.	1	pz
16	S331163893Z	Vite spec. X tens.	1	pz
17	S3101491ZZZ	Distanz. X motori	1	pz
20	S340038892Z	Grano eipp m5x6 br.	1	pz
21	S3401593ZZZ	Cinghia dentata 160XL050	1	pz
22	S330655192Z	Pignone P=3\8" Z=28	1	pz
23	S3400094ZZZ	Ghiera km2	1	pz
25	S330627893Z	Vite spec. M6	2	pz
26	S3400913ZZZ	Rosette di sicurezza mb2	1	pz
27	S3801458ZZZ	Custodia vol. uscita vert. Pg11	1	pz
28	S3801455ZZZ	Inserto maschio 4 poli 3p+t	1	pz
29	S3803441ZZZ	Mot. H63a4 220V/240V 380/415V	1	pz
30	S3400281ZZZ	Linguetta 5x5x12	1	pz
31	S330970292Z	Pignone z=11 p=3\8	1	pz
35	S3310004693A	Distanziale fissaggio motorizz.	1	pz
36	SBC0015097T	Blocchetto fiss. Motorizz.	1	pz
37	SBC0015038	Blocchetto inf. Motorizz.	1	pz
39	SCA0001217	Cinghia trasc. Linatex sv2706x75	1	pz
40	S3402207ZZZ	Cinghia dentata 255 L075	1	pz
41	S330674292Z	Puleggia pd14 xl050	1	pz
42	S3401275ZZZ	Cat.an.chiuso 3/8" L=50 ps pr stir.	1	pz
43	S310112205Z	Carter x motorizz.	1	pz
44	S3402573ZZZ	Tappo dp 1250 (x foro/32)	1	pz
45	S3802139ZZZ	Bocchettone skintop	2	pz
46	S3800145ZZZ	Terminale a occhiello/4 rosso	4	pz
47	SCC0000518	Cavo olflex-classic 400p 4g1.5 mmq	0.7	m/l
48	SBA0001151	Puleggia motrice dentata ass.	1	pz
49	SBA0001152	Puleggia motrice post. Ass.	1	pz
50	S470405300A	Puleggia folle ass.	1	pz
51	S320132547Z	Piastra tendcinghia	1	pz
52	SBC0017258V	Squadratore fisso dx	1	pz
53	SBC0015110	Rullino x gruppo squadratore	2	pz
54	SBC0015111T	Perno fissaggio rullino squadr.	2	pz
55	S340344893Z	Vite tbei UNI 7380 m8x16 zinc.	2	pz

Data mag-11

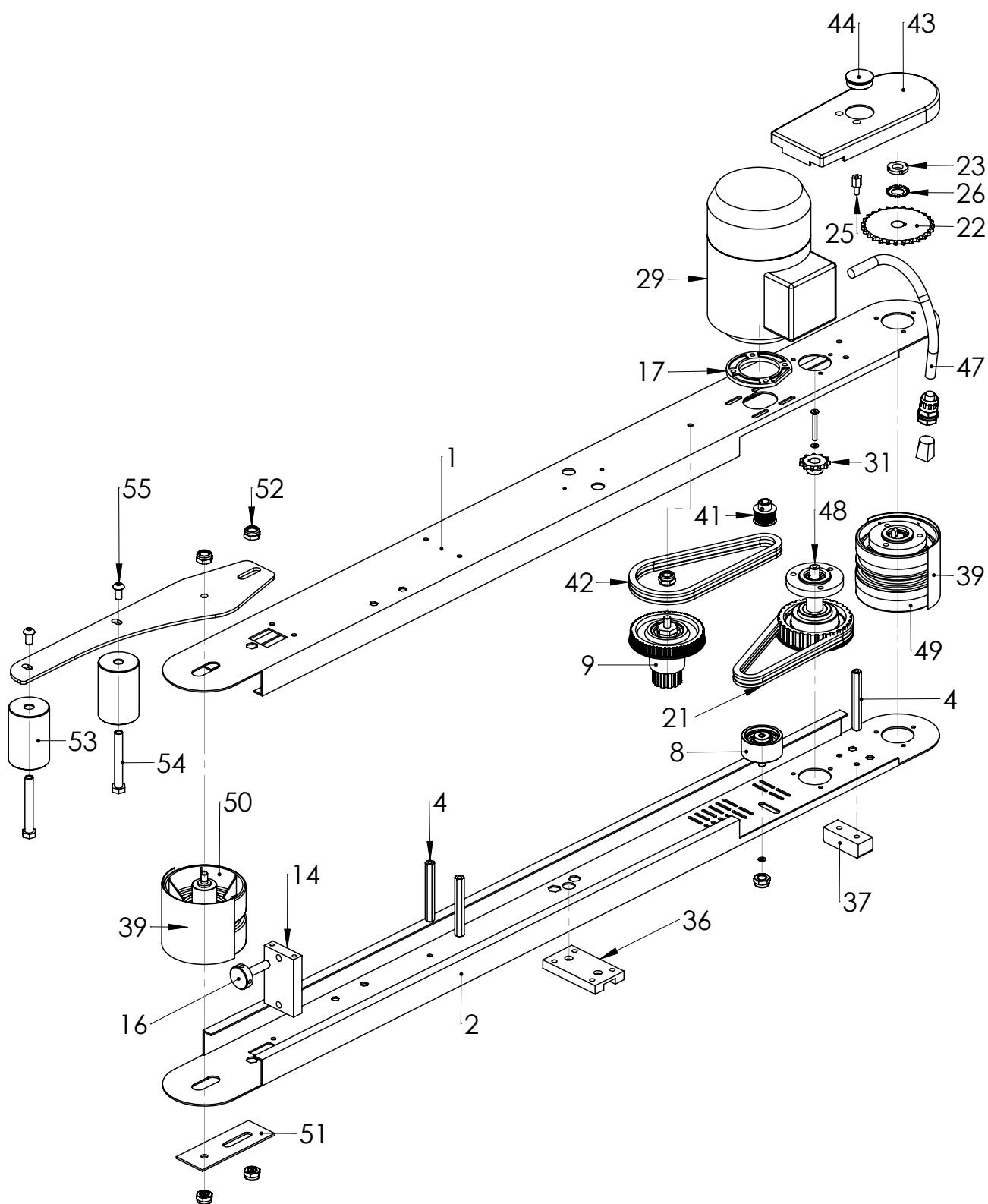
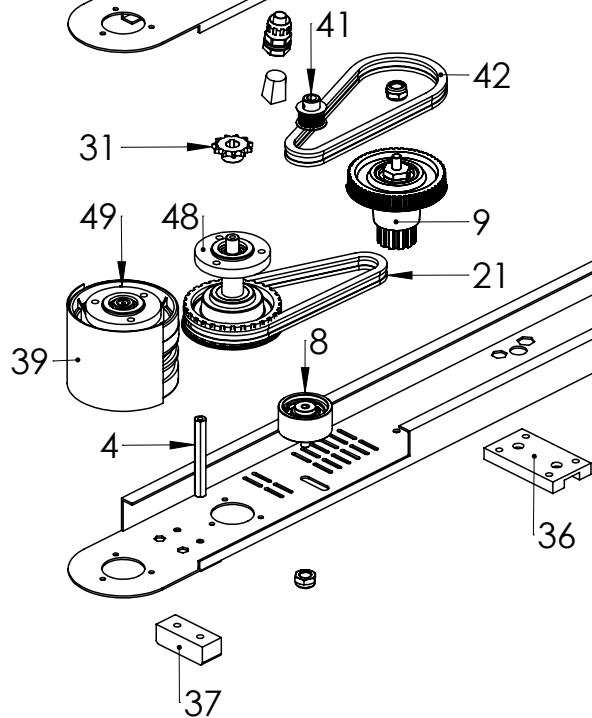


Fig. 15483

Maggio 2011

Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15484	Motorizzazione sx		F44	Formatore
Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBA0008927	Guida superiore sx motorizz. c/ins.	1	pz
2	SBA0008929	Guida inferiore sx motorizz. c/ins.	1	pz
4	S330596093Z	Distanziale es. 10x81 zinc.	4	pz
8	S470405100A	Galoppino ass.	1	pz
9	S470405200A	Puleggia doppia ass.	1	pz
14	S3311650ZZZ	Blocchetto x motorizz.	1	pz
16	S331163893Z	Vite spec. X tens.	1	pz
17	S3101491ZZZ	Distanz. X motori	1	pz
20	S340038892Z	Grano eipp m5x6 br.	1	pz
21	S3401593ZZZ	Cinghia dentata 160XL050	1	pz
22	S330655192Z	Pignone P=3\8" Z=28	1	pz
23	S3400094ZZZ	Ghiera km2	1	pz
25	S330627893Z	Vite spec. M6	2	pz
26	S3400913ZZZ	Rosette di sicurezza mb2	1	pz
27	S3801458ZZZ	Custodia vol. uscita vert. Pg11	1	pz
28	S3801455ZZZ	Inserto maschio 4 poli 3p+t	1	pz
29	S3803441ZZZ	Mot. H63a4 220V/240V 380/415V	1	pz
30	S3400281ZZZ	Linguetta 5x5x12	1	pz
31	S330970292Z	Pignone z=11 p=3\8	1	pz
35	S3310004693A	Distanziale fissaggio motorizz.	1	pz
36	SBC0015097T	Blocchetto fiss. Motorizz.	1	pz
37	SBC0015038	Blocchetto inf. Motorizz.	1	pz
39	SCA0001217	Cinghia trasc. Linatex sv2706x75	1	pz
40	S3402207ZZZ	Cinghia dentata 255 L075	1	pz
41	S330674292Z	Puleggia pd14 xl050	1	pz
42	S3401275ZZZ	Cat.an.chiuso 3/8" L=50 ps pr stir.	1	pz
43	S310112205Z	Carter x motorizz.	1	pz
44	S3402573ZZZ	Tappo dp 1250 (x foro/32)	1	pz
45	S3802139ZZZ	Bocchettone skintop	2	pz
46	S3800145ZZZ	Terminale a occhiello/4 rosso	4	pz
47	SCC0000518	Cavo olflex-classic 400p 4g1.5 mmq	0.7	m/l
48	SBA0001151	Puleggia motrice dentata ass.	1	pz
49	SBA0001152	Puleggia motrice post. Ass.	1	pz
50	SBA0008934	Puleggia fole ass.	1	pz
51	SBC0015115T	Supp. Post. Cilindro pneum.	1	pz
52	SBC0015063V	Piastra sostegno cilindro mot.	2	pz
53	SBC0015111T	Perno fissaggio rullino squad.	2	pz
54	SBC0015120V	Spalla squad. Mobile	1	pz
55	SBC0015109V	Distanziale ant. Cilindro pneum.	1	pz
56	SBC0015075	Supp. Cuscinetto squad.	1	pz
57	SBC0015110	Rullino x gruppo squad.	2	pz
58	SBC0015118T	Coperchio fix squad. Mobile	1	pz
59	S340101093Z	Testa a snodo m10x1,25 zinc.	1	pz
60	S3800223ZZZ	Fissaggio oscillante sn32	1	pz
61	S380616800A	Cilindro festo DNCB-32-40-PPV-A	1	pz
62	SBA0008916V	Piastra tendicinghia forata ass.	1	pz
63	SBA0008918V	Piastra tendicinghia filettata ass.	1	pz



F44

Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15485	Banchino		F44	Formatore
Posizione	Ricambio	Descrizione	Quantità	U.M.
1	Fig. 15486	Gruppo superiore banchino	1	pz
2	Fig. 15487	Gruppo piegafalda	1	pz
3	Fig. 15488	Gruppo chiudifalda inferiore prem.	1	pz
4	Fig. 15489	Gruppo chiudifalde lat. Ass.	1	pz
5	SBC0014972V	Squadretta supp. Fotocellula	2	pz
6	SBC0016177V	Deviatore falde	2	pz
7	SBA0009355V	Traversa chiudifalda anteriore	1	pz
8	SBC0016603V	Fondo chiusura bancale	1	pz
9	SBC0014975V	Squadretta supporto fotocellula	1	pz
10	S3210015300A	Supporto piastra connettori	1	pz
11	SBC0015397V	Protez. Batteria elettrovalv.	1	pz
12	S3210015100A	Carter protezione connettori	1	pz
13	SBC0015777V	Squadra supporto sensori	1	pz
Data	mag-11			

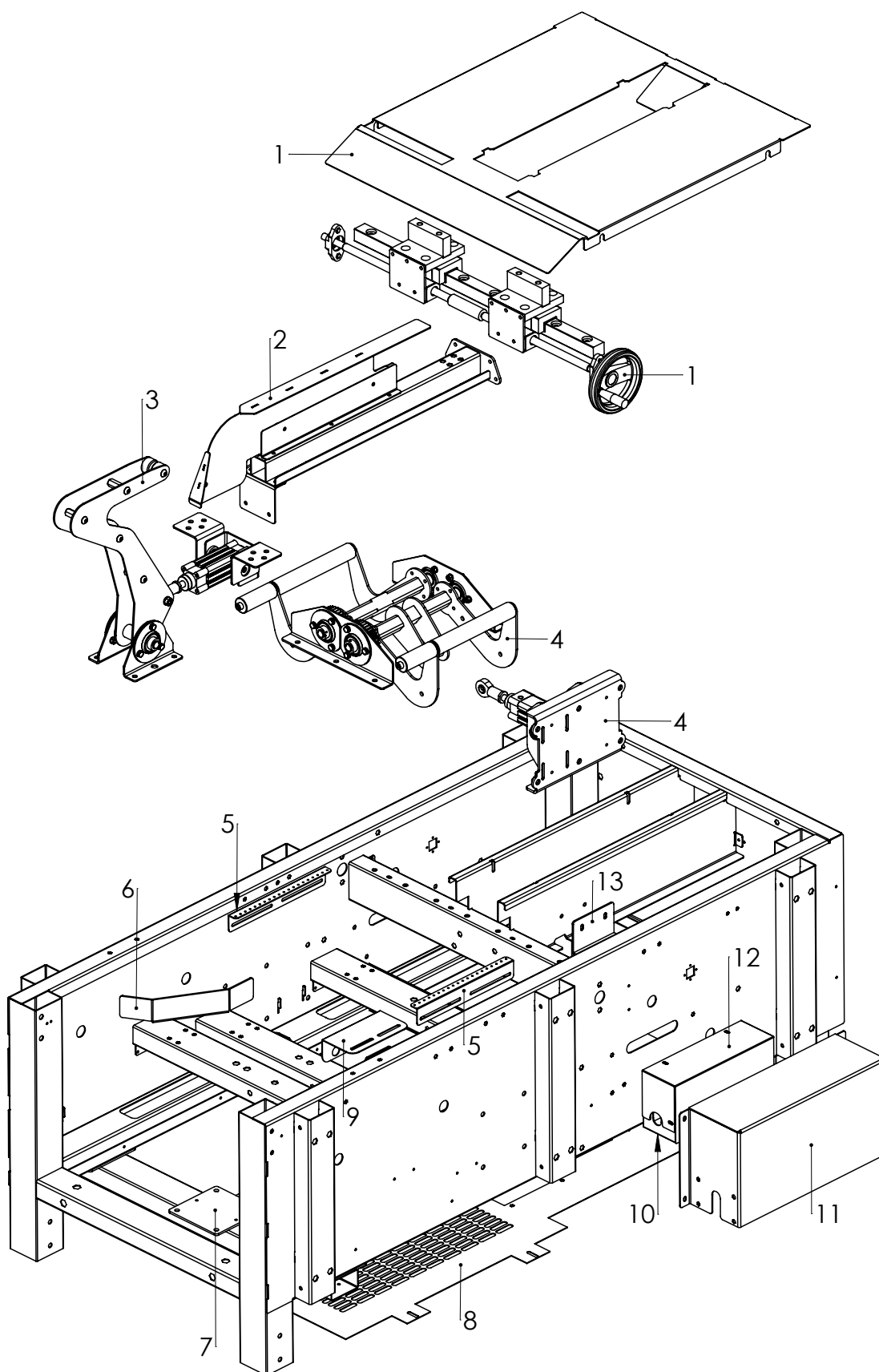


Fig. 15485

Maggio 2011

F44

Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15486	Gruppo sup. banchino		F44	Formatore
Posizione	Ricambio	Descrizione	Quantità	U.M.
1	S3214713ZZZ	volantino 78631 vrtp.125+ir	1	pz
2	S332415100A	bussola vite di centratura	2	pz
3	S340011192Z	Spina	2	pz
4	SBA0009086V	supporto chiocciola ass.	2	pz
5	SCA0001285	cursore rollon mrs30lnk0	2	pz
6	SBC0015381T	blocchetto inf. Supp. Motorizz.	2	pz
7	SBC0015382T	blocchetto vert. Motorizz.	1	pz
8	SBC0014815T	vite di centratura filetto dx	1	pz
9	S332314792A	manicotto giunz. Viti centr.	1	pz
10	SCA0001326	guida rollon mrr30620h	1	pz
11	SBC0015006	piano superiore bancale	1	pz
12	S460424405A	supp. Con cuscinetto trasp.	2	pz
13	SBC0014814T	vite di centratura filetto sx	1	pz
14	S310208400A	chiocciola x colonna s2 rossa (vite sx)	1	pz
15	S310157200A	chiocciola x colonna s2 (vite dx)	1	pz
16	S310233600A	bussola guida molla	2	pz
17	S370036493A	molla per supporto	2	pz
Data	mag-11			

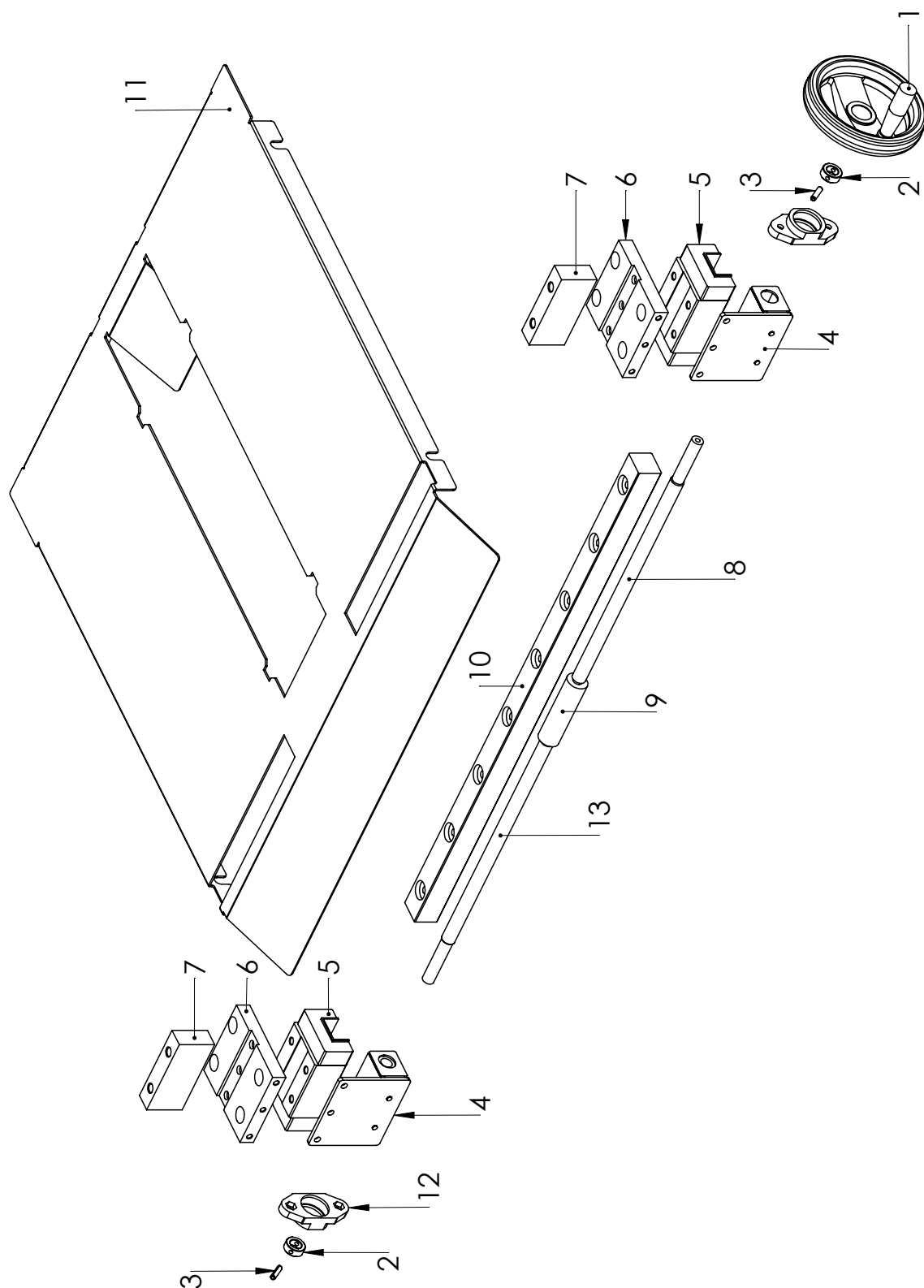


Fig. 15486

Maggio 2011

F44

Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15487	Gruppo piegafalde		F44	Formatore
Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBA0009075T	Piegafalda inferiore ass.	1	pz
2	SBC0015884V	Squadra supp. Chiudifalda	2	pz
3	SBA0009369V	Supp. Chiudifalda ant. Ass.	1	pz
4	SBC0015891V	Squadra fiss. Supp. Chiudifalda	1	pz
Data	mag-11			

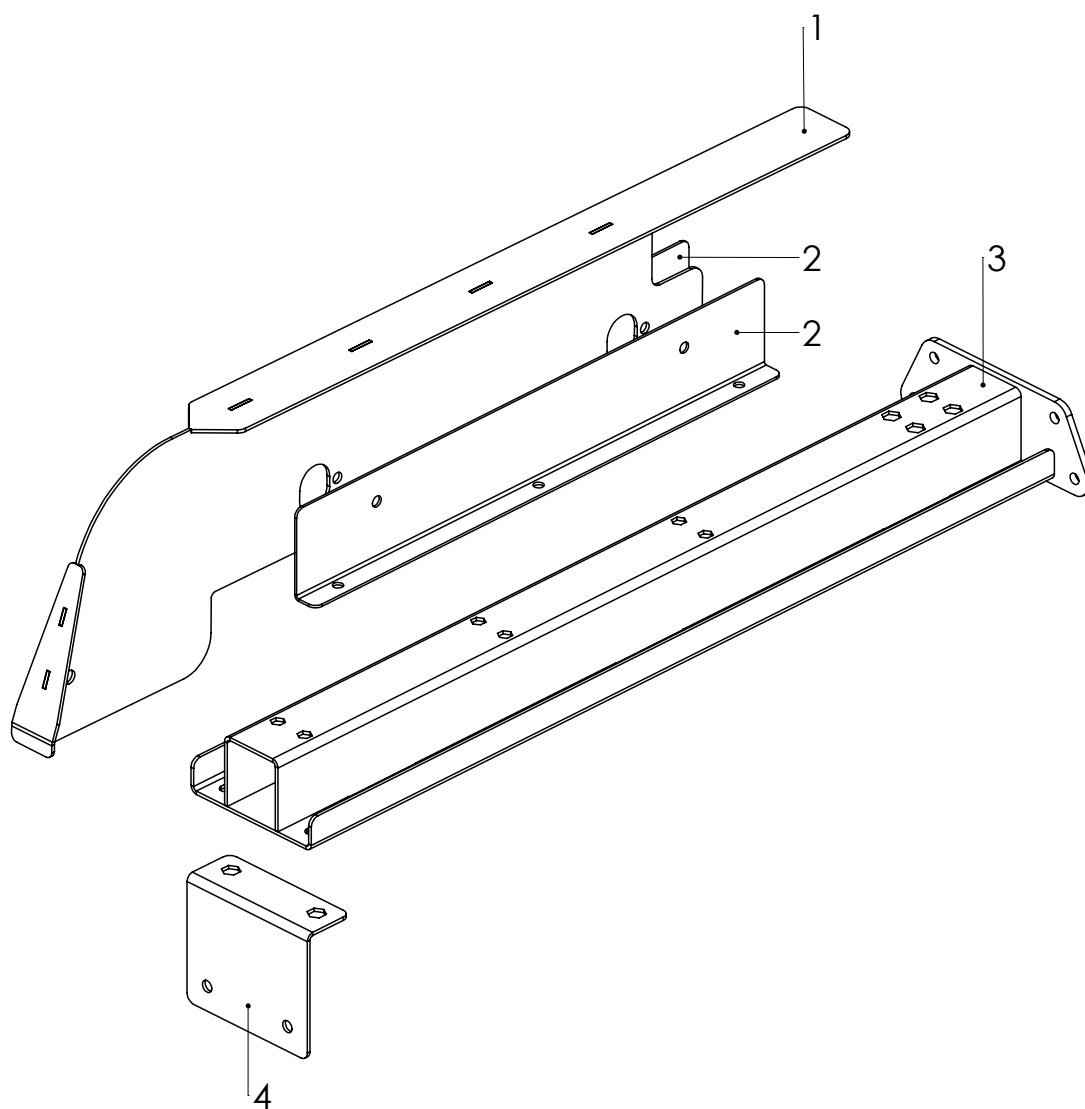


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15488	Gruppo chiudifalda inf. Prem.		F44	Formatore
Posizione	Ricambio	Descrizione	Quantità	U.M.
1	SBC0015293	Perno chiudifalda anteriore	1	pz
2	SBC0015315	Leva chiudifalda inferiore	2	pz
3	SBC0015296T	Distanz. Spalle chiudifalda	4	pz
4	SBC0015312	Bussola chiudifalda inf.	2	pz
5	S340403800A	Supporto nsk ubpf 202	2	pz
6	SBC0015313T	Bussola testa a snodo	2	pz
7	SBC0015008V	Squadra incern. Chiudifalda	2	pz
8	S340002693Z	Vite te m6x16 zinc.	6	pz
9	S340344893Z	Vite tbei uni 7380 m8x16 zinc.	6	pz
10	S340023593Z	Dado m6 zinc. A bassa resist.	6	pz
11	S340101693Z	Testa a snodo m12x1,25 zinc.	1	pz
12	S380616800A	Cil. Dncb 32 40 ppv festo 532725	1	pz
13	SBC0015009V	Staffa attacco cilindro	1	pz
14	S330595582Z	Bussola x motorizz. Ricotta	2	pz
15	SBC0015013V	Squadra supp. Cilindro chiudifalda	2	pz
16	S340000293Z	Dado m6 zinc.	3	pz
17	S340017593Z	Rondella piana x vite m6 zinc.	12	pz
Data	mag-11			

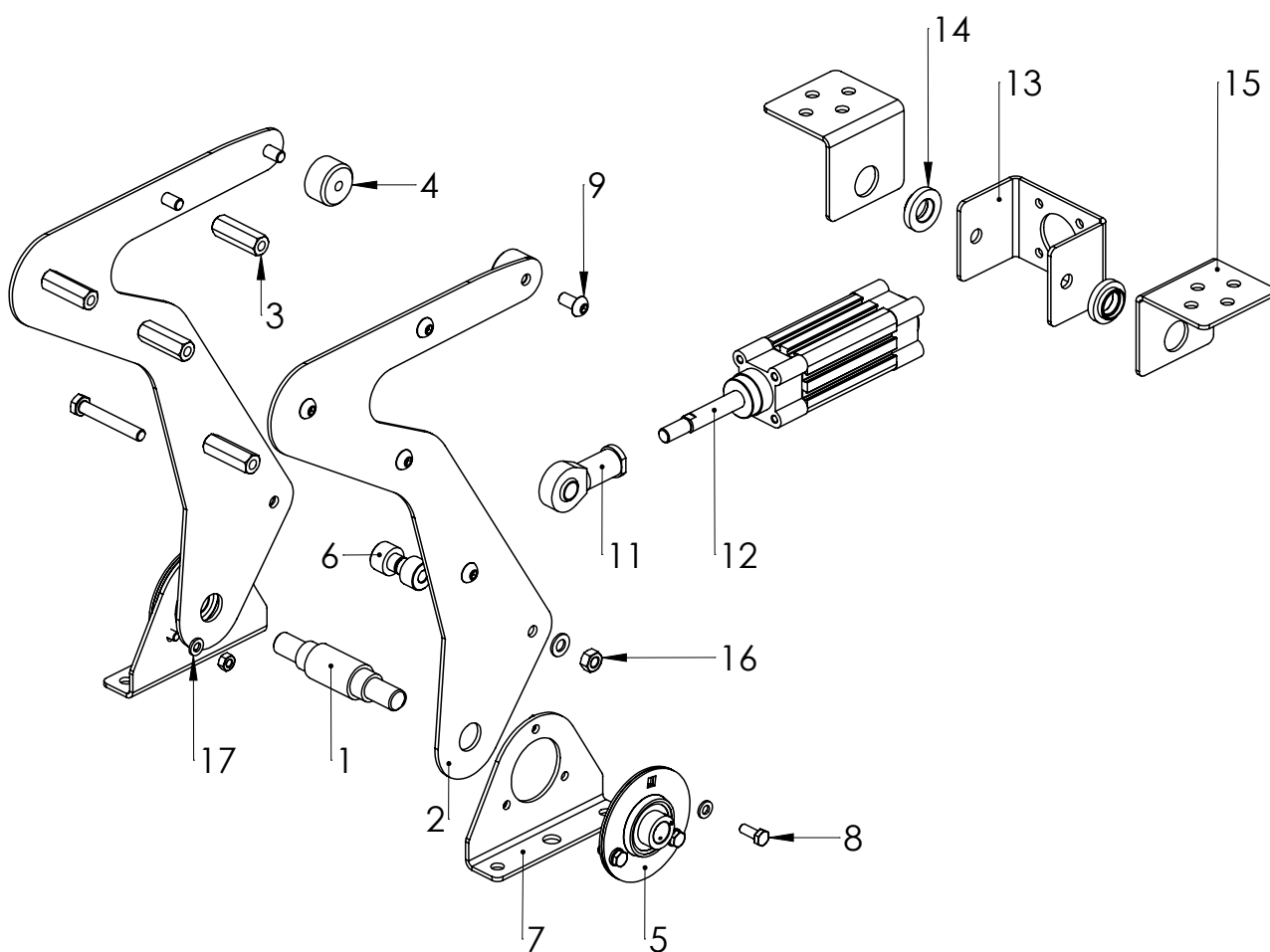


Figura	Descrizione figura	Magazzino	Prodotto	Descrizione
15489	Gruppo chiudifalda lat. Ass.		F44	Formatore
Posizione	Ricambio	Descrizione	Quantità	U.M.
1	S340057693Z	Vite te m6x14 zinc.	12	pz
2	S340017593Z	Ros. Piana x vite m6 zinc.	32	pz
3	SBC0015319	Supp. Pf 202 tagliata	4	pz
4	SBC0015007V	Squadra x supp. Inf.	2	pz
5	S340023593Z	Dado m6 zinc. Bassa res.	28	pz
6	S3400015937	Vite tcei m6x25 zinc.	8	pz
7	SBC0015309	Ingranaggio denti diritti z36 m2	2	pz
8	SBC0016250V	Rondella d est. 58 foro d 34 h4	2	pz
9	SBC0015305	Leva esterna chiudifalde lat.	4	pz
10	SCA0000108	Vite tcei m8x90 zinc.	2	pz
11	SBC0015311	Prolunga rullo chiudifalde lat.	2	pz
12	SBC0015310	Rullo chiudifalda inf.	2	pz
13	SBC0015287	Perno chiud. Lat.	2	pz
14	SBC0015303	Leva chiud. Lat.	2	pz
15	S340101693Z	Testa a snodo m10x1,25 zinc.	1	pz
16	S380616800A	Cil. Dncb 3240 ppv a festo 163306	1	pz
17	SBC0015338	Bussola inc. cil. Chiudifalda inf.	2	pz
18	SBC0015374	Squadra fiss. Cil. Chiud. Lat.	2	pz
19	SBC0015009V	Staffa attacco cilindro	1	pz
20	S330595582Z	Bussola x mot. Ricotta	2	pz
21		Dadi proiez.	6	pz
22	SBC0015372	Piastra fiss. Cil. Chiud. Lat.	1	pz
Data	mag-11			

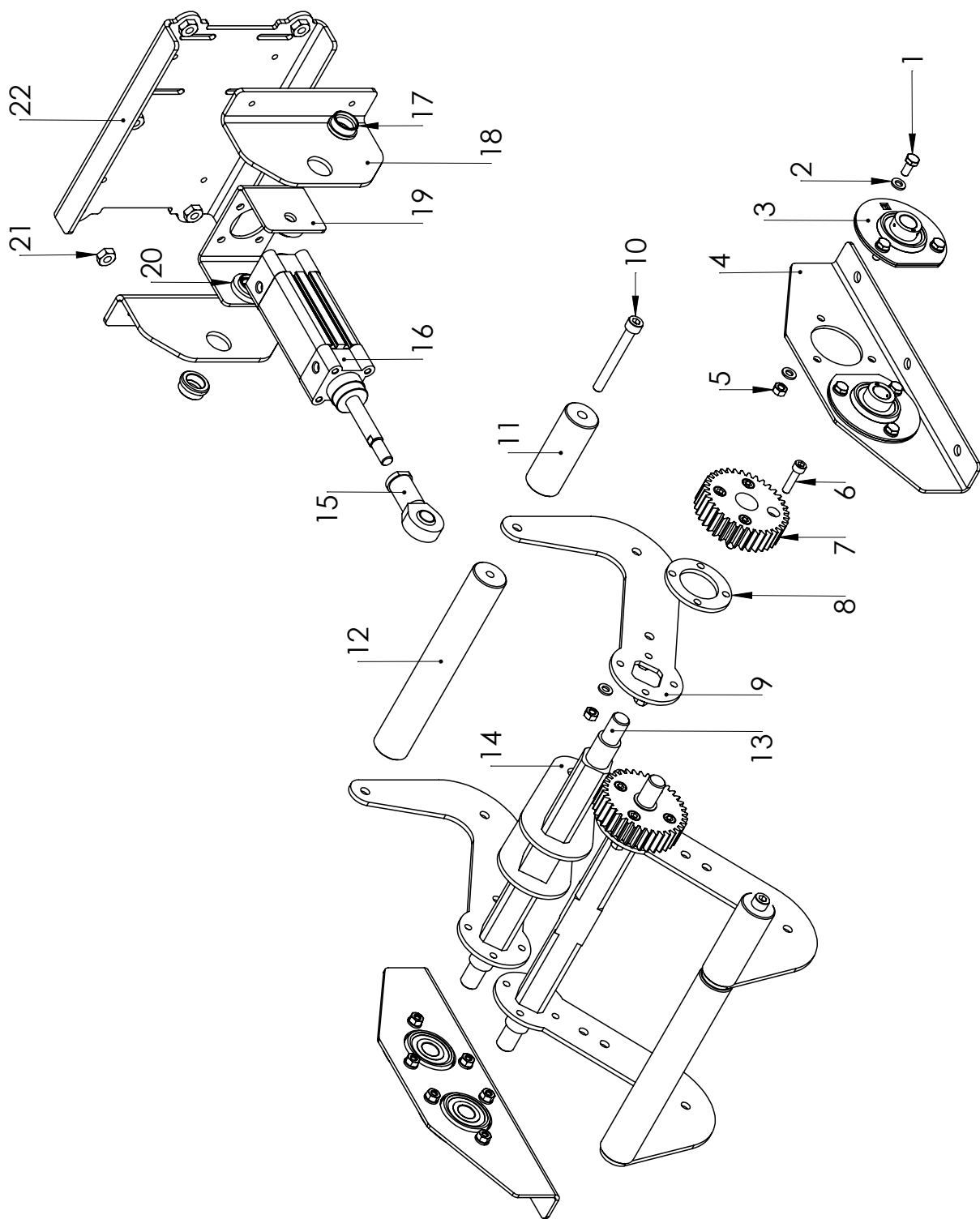


Fig. 15489

Maggio 2011