



SM446-650-HD

NASTRATRICE AUTOMATICA

AUTOMATIC CASE SEALING MACHINE

MACHINE ENRUBANNEUSE AUTOMATIQUE

AUTOMATISCHE KARTONVERSCHLISSMASCHINE

PRECINTADORA AUTOMATICA

MANUALE DI ISTRUZIONI E PARTI DI RICAMBIO

INSTRUCTIONS MANUAL AND SPARE PARTS LIST

MANUAL D'INSTRUCTIONS ET PIECES DETACHEES

BEDIENUNGSANLEITUNG UND ERSTAZTEILLISTE

MANUAL DE INSTRUCCIONES Y RECAMBIOS



Instruction manual for the use, maintenance, safety, shipment, storage, unpacking, set-up, repairing, trouble shooting, spare parts and disposal concerning the case sealing machine model SM446 HS.

This publication is property of SIAT S.P.A.
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Publication n.
Version 0



SM446-650-HD

AUTOMATIC CASE SEALING MACHINE WITH DRIVE SIDE BELTS

- Maximum box size: h. 650 mm x w. 650 mm x l 800 mm
- Minimum box size: h. 150 mm x w. 160 mm x l 300 mm
- Adhesive tape: w. 50/70 mm
- Belt speed: 30 m/min.
- Production: 5 boxes/minute
- Average air consumption: 260 NI/min approximately

INDEX

ABBREVIATIONS AND ACRONYMS

| | Section | LIST OF ABBREVIATIONS, ACRONYMS AND UNUSUAL TERMS TO BE FOUND IN THIS MANUAL | |
|------------------------------|--------------|--|---|
| Manufacturing specifications | 1.1 | | |
| Manual, how to use the | 1.2 | | |
| Safety | 3 | Dwg. | = drawing |
| Serial Number | 2.1 | Encl. | = enclosure |
| After-sale service | 2.2 | Ex. | = example |
| Warranty | 2.3 | Fig. | = figure showing spare parts |
| Operators' skill levels | 3.6 | Max. | = maximum |
| Technical specifications | 4.2 | Min. | = minimum |
| Dimensions | 4.6 | Mod. | = machine model |
| Transportation | 5 | N. | = number |
| Unpacking | 6 | N/A | = not applicable |
| Installation | 7 | OFF | = machine stopped |
| Controls | 8 | ON | = machine running |
| Operation | 9 | OPP | = oriented polypropylene adhesive tape |
| Safety devices | 10 | Pict. | = picture |
| Set-up and adjustments | 11 | PLC | = Programmable Logic Control |
| Machine use | 12 | PP | = polypropylene |
| Tape replacement | 12.3 | PTFE | = Polytetrafluorethylene |
| Cleaning | 12.4 | PVC | = Polyvinylchloride |
| Trouble shooting | 12.7 | Ref. | = reference mark |
| Maintenance | 13 | SIAT SPA | = Società Internazionale Applicazioni Tecniche (Società per Azioni) |
| Lubrication | 13.5 | | |
| Blade replacement | 13.9 | Tav. | = Illustration |
| Belt replacement | 13.10 | | |
| Adjustment of belt tension | 13.11 | | |
| Additional Instructions | 14 | | |
| Enclosures | 15 | w | = width |
| | | h | = height |
| Spare parts | last section | l | = length |
| | | ol | = overall length |
| | | cbh | = conveyor bed height |

1-INTRODUCTION

1.1 MANUFACTURING SPECIFICATIONS

The automatic case sealing machine Mod. SM44 HS has been designed and manufactured complying with the legal requirements in force at the date of its manufacture.

THE REFERENCE DOCUMENTS ARE:

Machines guidelines **2006/42/CE**

Standards applied

UNI EN 415-7

EN 415-9:2009

Guidelines **EMC 2004/108/CE**

Standards applied

CEI EN 60204-1:2006

EN 61000-6-2:2005

EN 61000-6-4:2007

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÷16**
- spare parts: last section.

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-GENERAL INFORMATION

2.1 SERIAL NUMBER OF THE MACHINE AND NAME OF THE MANUFACTURER

| | | | | | | | | | |
|---|--|---|--|------|--|--------|--|-------|--|
|  | | SIATs.p.a. Via G.Puecher N°22 Turate (CO) ITALY | | | | | | | |
| Model | | Part Number | | Year | | Ampere | | Watt | |
| Type | | Serial Number | | Volt | | Hertz | | Phase | |

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

| | |
|---|---------------|
|  | |
| 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: |
|---|

2-GENERAL INFORMATION

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.

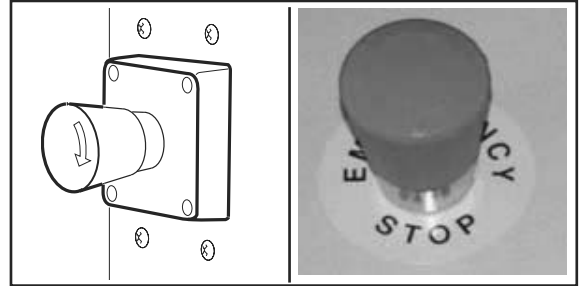
3-SAFETY

3.1 GENERAL SAFETY INFORMATION

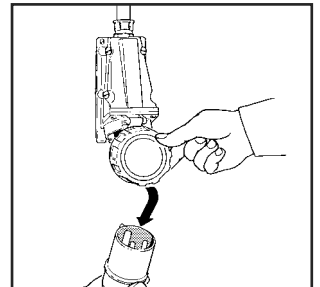
Read all the instructions carefully before starting the work with the machine; please pay particular attention to sections marked by the symbol



The machine is provided with a complete safety protection and with a two LOCKABLE EMERGENCY STOP BUTTON placed on the same protection and 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-SAFETY

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

3-SAFETY

3.7 RESIDUAL HAZARDS

The case sealer SM44 HD has been designed following the EC directives, and incorporates various safety protections which should never be removed or disabled.

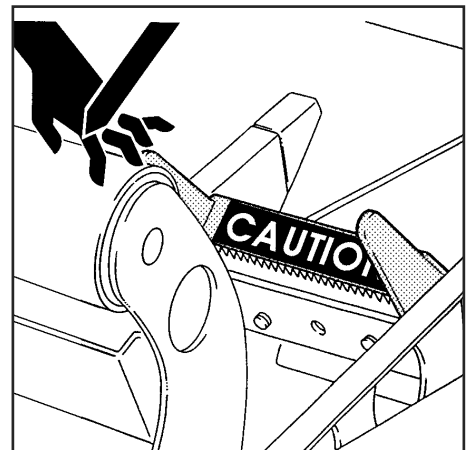
Notwithstanding the safety precautions conceived by the designers of the machine, it is essential that the operator and service personnel be warned that the following uneliminable residual hazards exist



WARNING! Tape cutting blades.

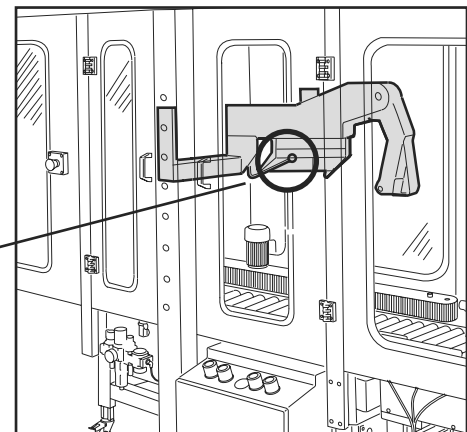
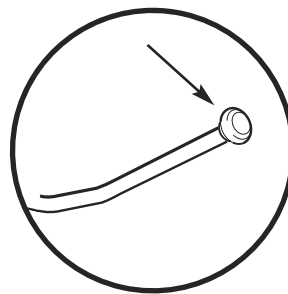
Never remove the safety device which covers the blade on the top and bottom taping units.

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



WARNING!: Side flaps fold device guard knobs

Don't remove the orange plastic guard knobs on the side flaps fold device ends.



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-SAFETY


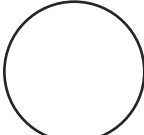

3.10 PREDICTABLE ACTIONS THAT ARE INCORRECT AND NOT ALLOWED

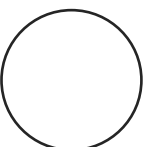
- Never try to stop or hold the box while it is being driven by the belts. Use only the EMERGENCY STOP BUTTON.
- Never work without the safety protections.
- Never remove or disable the safety devices.
- Only authorised personnel should be allowed to carry out the adjustments, repairs or maintenance 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.

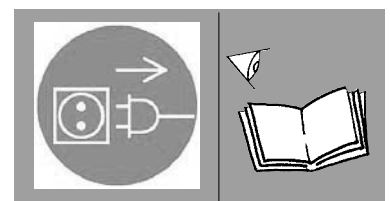


- The cleaning and maintenance operations must be performed after disconnecting the electric power.
 - Clean the machine using only dry cloths or light detergents. Do not use solvents, petrochemicals etc.
 - Do not modify the machine or any part of it. The manufacturer will not be responsible for any 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.


3.11 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  Before starting any maintenance operations the electrical power must be disconnected.




Label code: 3.0.01097.96A

b  Show the sharp knife on the taping head.



Label code: 3.0.01028.96A

c  Tape threading path for bottom taping unit and position 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



Show the earth wire connection point on the machine frame.



Label code: 3.0.01039.96A

f



Caution!: High voltage



Label code: 3.0.01100.96A

g

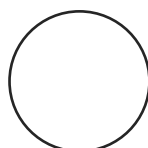


Tape threading path for upper taping unit.



Label code: 3.0.01023.96A

h



Compulsory position to lift the machine with forklifts or other suitable raising equipment.



Label code: SBC0010337

i



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



Label code: S340277700A

4 - PRELIMINARY INFORMATION

4.1 GENERAL DESCRIPTION OF THE MACHINE

The SM446 HD case sealer with side drive belts is designed to seal boxes by applying two tape strips on the top and bottom flaps simultaneously. No operator is required. The introduction of the cases into the machine is performed by the indexing system AS26-HD. All the operations are managed by a PLC located in the controls board.

4.2 TECHNICAL SPECIFICATIONS

- Production = 300 boxes/hour (average)
- Standard power supply = see plate
- Installed power: 2,388 kW + 0,370 kW
- Taping units K11 or K12, tape width 50/75 mm
- Machine+control board+AS26HD weight=700+70+500 kg
- Compressed air = 6 BAR; feeding pipe diameter 10 mm
- Belts speed = 30 m/min.
- Infeed conveyor speed: 30 m/min.
- Air consumption: 260 NI/min

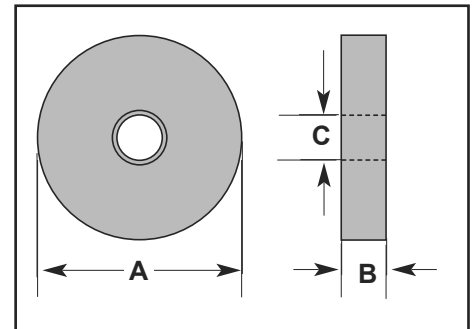
TAPE DIMENSIONS

Suitable adhesive tapes:

PVC

OPP

ADHESIVE PAPER



A = 410 mm max

B = 50/75 mm

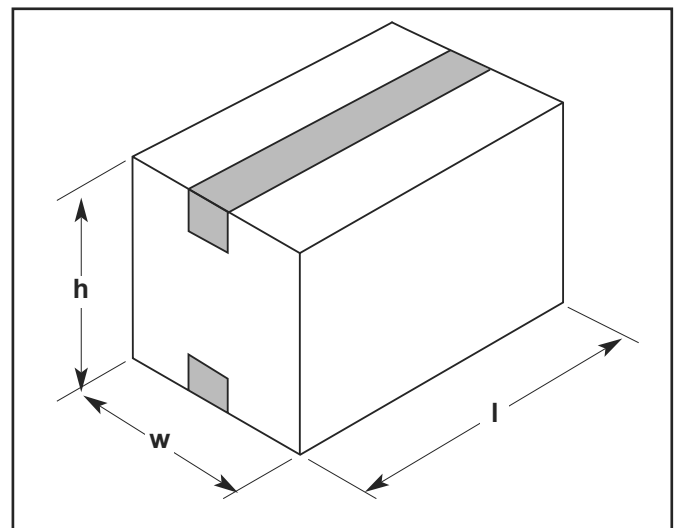
C = 76 mm

4.3 PURPOSE OF THE MACHINE

The purpose of this machine is the sealing with adhesive tape of boxes having the dimensions (in millimeters) shown in the table below:

BOXES DIMENSIONS

| SM44 HS | w | h | l |
|---------|-----|-----|-----|
| min. | 160 | 150 | 300 |
| max. | 650 | 650 | 800 |



CASE WEIGHTS

min.: 2 kg

max.: 30 kg

Warning: 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-PRELIMINARY INFORMATION

4.4 MAIN COMPONENTS

The machine is composed of:

- n. 1 frame
- n. 4 adjustable legs
- n. 2 columns
- n. 2 taping units
- n. 1 top head
- n. 2 side drive belts
- n. 2 electric motors
- n. 1 safety guard
- n. 2 emergency stop button
- n. 1 controls board

The infeed conveyor is composed of:

- n. 1 frame
- n. 4 adjustable legs
- n. 1 electric motor
- n. 1 motorized belt

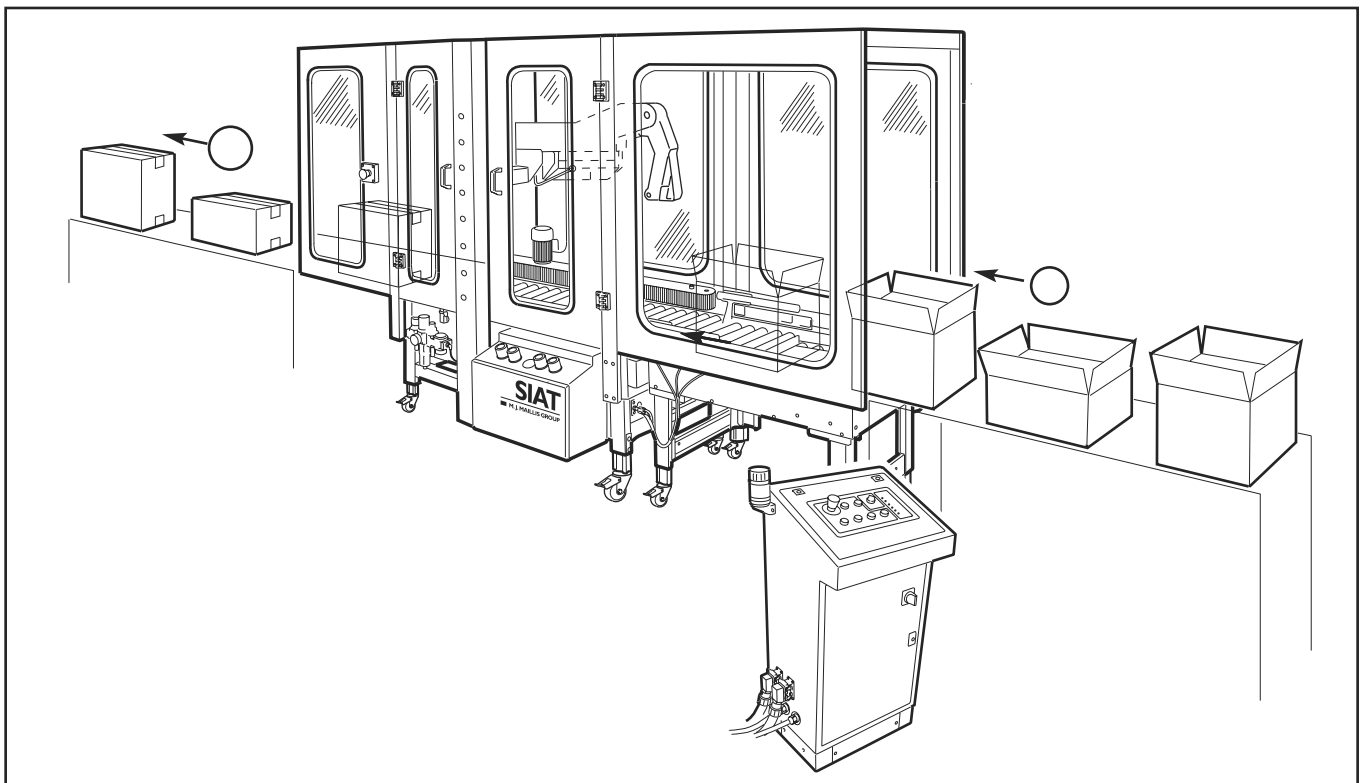
For the technical features of the electric parts refer to section **15-ENCLOSURES**

4.5 OPERATIVE FLOW

The boxes, coming from the filling stations, are centred, gated and fed to the machine by the indexing unit AS26 HD.

The same indexing unit is equipped with a reading head for the identification of the format of the introduced box and the position of the following upper forming group correctly by appropriate electro-pneumatic interface devices.

The driving belts transport the box during the different phases, from flaps folding to the following sealing, to the exit of the same box.



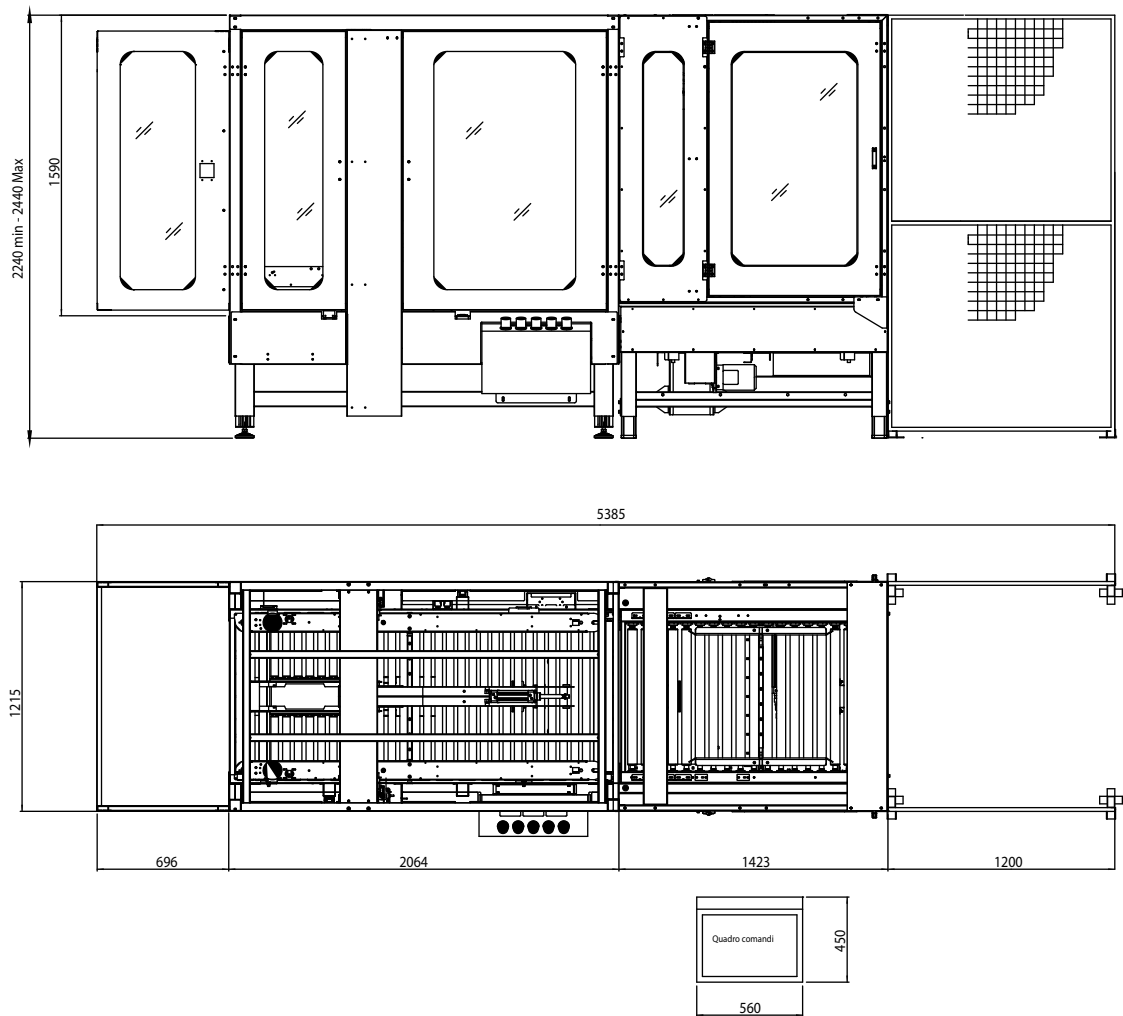
4.6 MACHINE NOISE MEASUREMENT

Acoustic pressure at 1 meter distance from the machine with the tape roll inserted: 73 dB. Acoustic pressure at a height of 1,6 meter above the machine with the tape roll inserted: 73 dB.

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

4-PRELIMINARY INFORMATION

4.7 OVERALL DIMENSIONS



5-SHIPMENT - HANDLING - STORAGE

5.1 MACHINE TRANSPORTATION AND HANDLING

The machine and the infeed conveyor are shipped in 2 separate packings, fixed on a wooden pallet. They can be lifted with a normal fork lift. The standard packing is suitable for surface and air transportation. Oversea packing on request.

Packing dimensions

SM446HD

l= length: 2600 mm

w= width: 2250 mm

h= height: 1500 mm

Weight: 800 kg

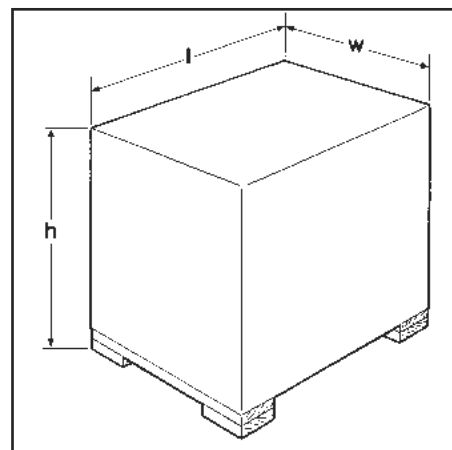
AS26HD

l: length: 2600 mm

w= width: 2250 mm

h= height: 1500 mm

Weight: 600 kg

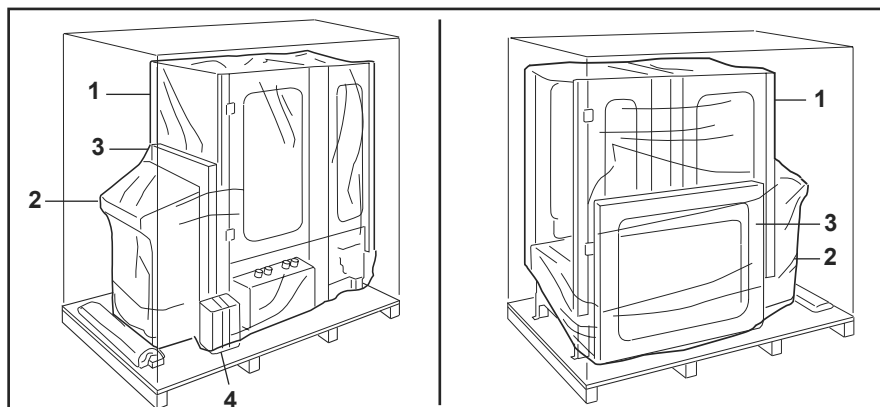


5.2 PACKING FOR OVERSEAS SHIPMENT (OPTIONAL)

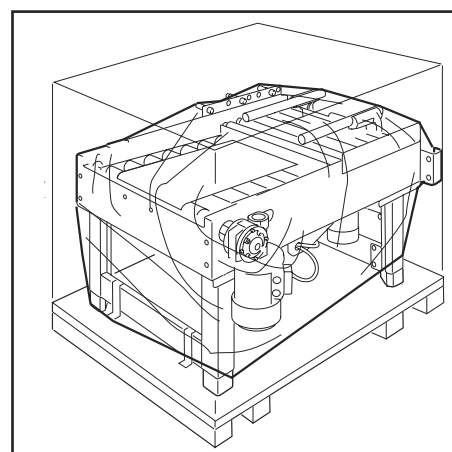
The machines shipped by sea freight are covered by an aluminium/polyester (Vacupol) bag which contains dhydrating salts.

Machine packing

- machine 1
- control board 2
- guards 3
- accessories 4.



Indexing unit packaging.



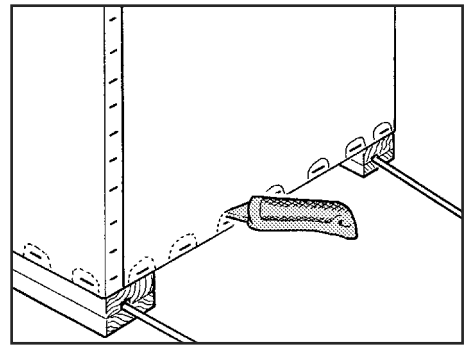
5.3 STORAGE OF THE PACKED OR UNPACKED MACHINE

In case the machine must stay inactive for a long period, please take the following precautions:

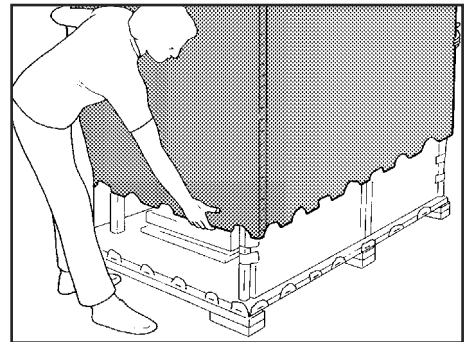
- store the machine in a dry and clean place;
- if the machine is unpacked it is necessary to protect it from the dust;
- do not stack anything on top of the machine;

6-UNPACKING

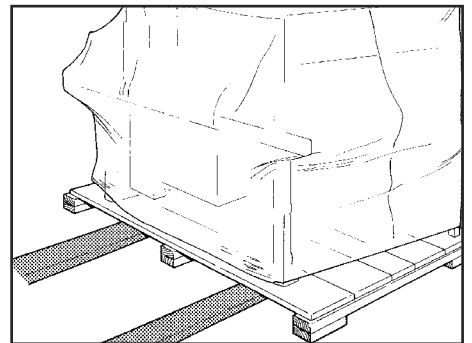
- 6.1** Cut the polypropylene straps.
Use a cutter to remove the part of the carton fixed by the staples along the entire perimeter of the packing. (Otherwise remove the staples by using a suitable tool)



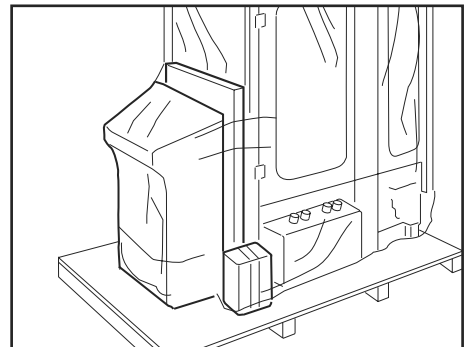
After having cut the carton or removed the staples, lift the packing up in order to free the machine. (2 persons)



Move the machine and the infeed conveyor to where they will be located.



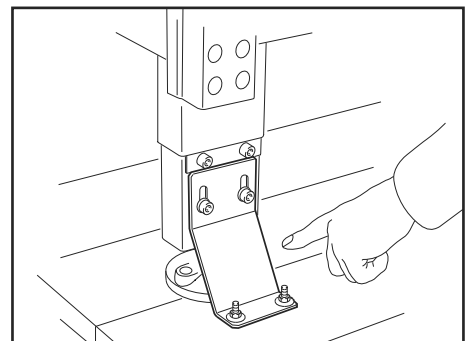
Cut the stretch film and remove the control board, the guard panels and the accessories box.



Sealing machine brackets removal

Caution: the operations must be accomplished on all the four legs one at a time.

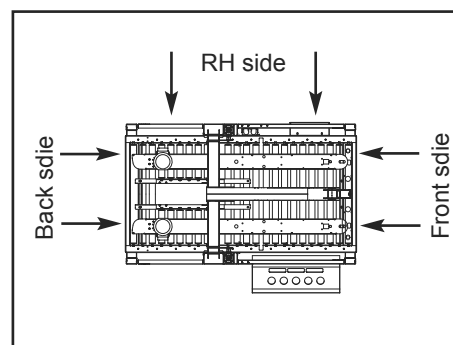
Remove the screws **1**;
Unscrew the nut **2** and remove the bracket;
Replace and tighten the screws **1**;
Acting in similar way on the other legs, in sequence.



6-UNPACKING

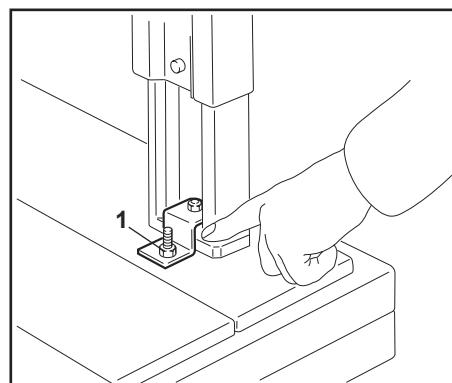
To lift the machine up, position the lift forks where there are the labels on right hand side or front-back sides and remove the pallet.

Machine weight + control board: 480 + 100 kg.



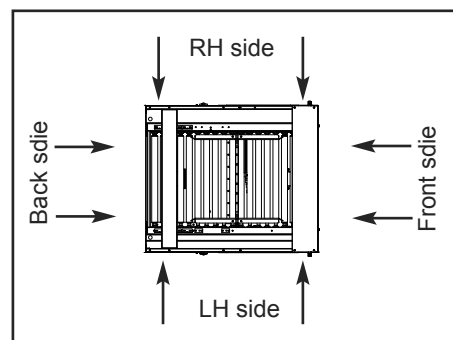
Conveyor brackets removal

Loosen the nuts **1** and remove the brackets.



To lift the conveyor, position the lift forks where there are the labels on front or back side and remove the pallet.

Conveyor weight: 600 kg



6.4 PACKING DISPOSAL

The packing of the machine Mod. SM44 HS is composed of:

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

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

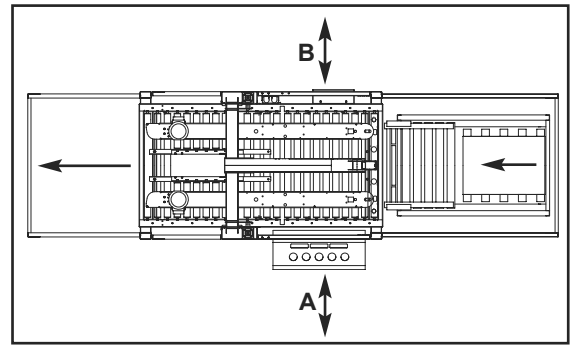
7-INSTALLATION

7.1. SAFETY MEASURES

Read carefully chapter 3.

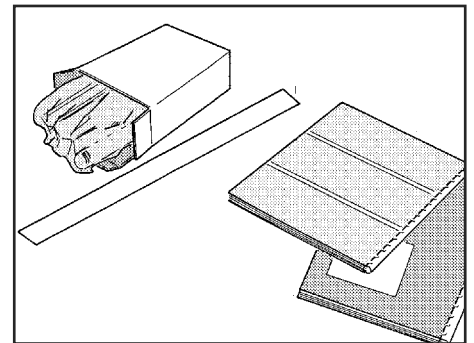
7.2. SPACE REQUIRED FOR MACHINE OPERATION AND MAINTENANCE

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



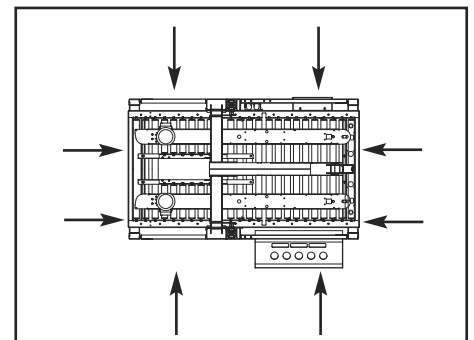
7.3 SPARE PARTS AND THREADING TOOL FOR TAPING HEADS

For a detailed description of the tools kit see section 3.5.



7.4 MACHINE POSITIONING

Raise the machine with a fork lift positioning the lift forks under the points where there are the labels.

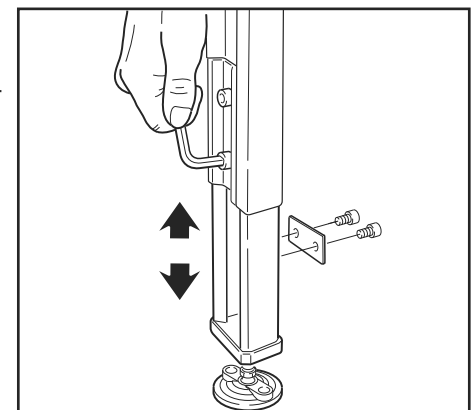


7.4.1 WORK HEIGHT ADJUSTMENT

Lift the machine as shown in picture.

Unlock the screws and take the legs out looking for the desired conveyor bed height on the graduated label.

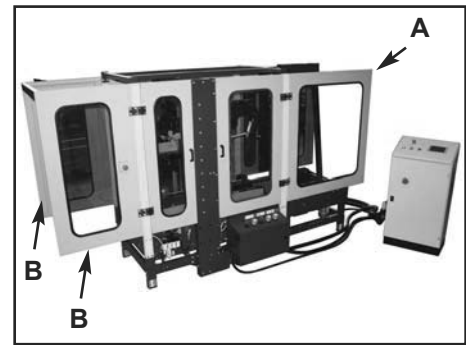
Then lock the screws again.



7-INSTALLATION

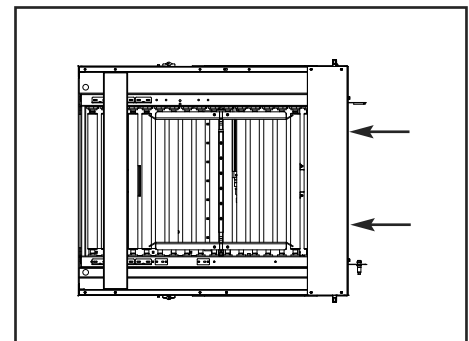
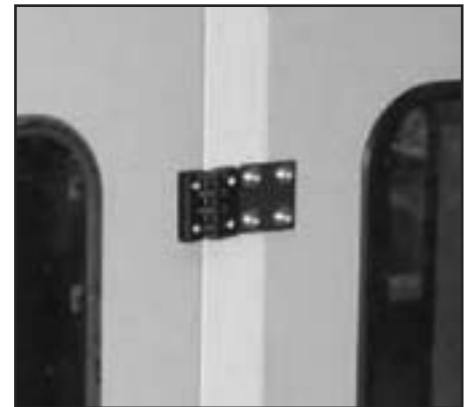
7.5 SAFETY GUARDS: INSIDE AND OUTSIDE MACHINE EMERGENCY STOP PUSH-BUTTON

Position and assemble the inside (A) and outside (B) guard panels with the upper and bottom brackets and stiffening profile plates as shown in the pictures.

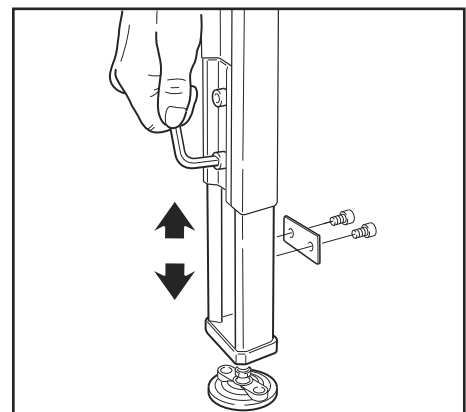


7.5.1. INSIDE SAFETY GUARDS

Support brackets (upper and bottom); 4+4 socket head screws each bracket.



7.6.1 Move the indexing unit to the machine and fix it using the screws previously removed.

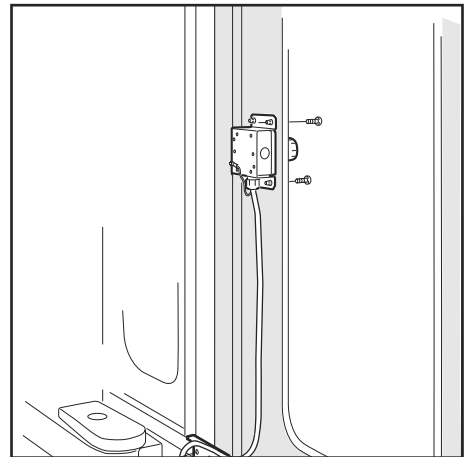


7.6.2 Unlock the screws of the legs, move the legs down to the floor and lock the screws.

7-INSTALLATION

7.7 EMERGENCY STOP BUTTON

Furthermore mount the complete bracket with emergency stop button.



7.8 PNEUMATIC CONNECTION

Connect air pipes from the sealing machine to the conveyor centring guides cylinder connectors and to infeed conveyor cylinders.

Fitting acronyms shown in the picture identify the pipes number coming from the machine.

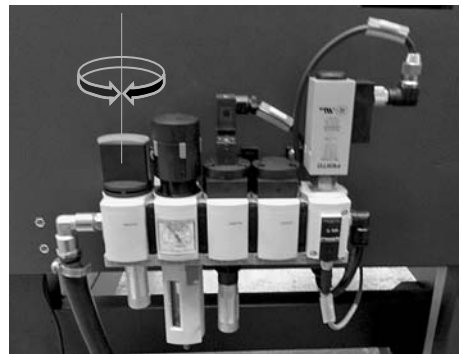
C1A-C1B-11A-11B-12A-12B



7.9 MAIN PNEUMATIC CONNECTION

Connect an air pipe to the ON-OFF valve and fix it with a strap.
Min. inside diameter of the pipe 10mm.
Air pressure 6÷7 BAR

Give air to the machine by the ON-OFF valve.



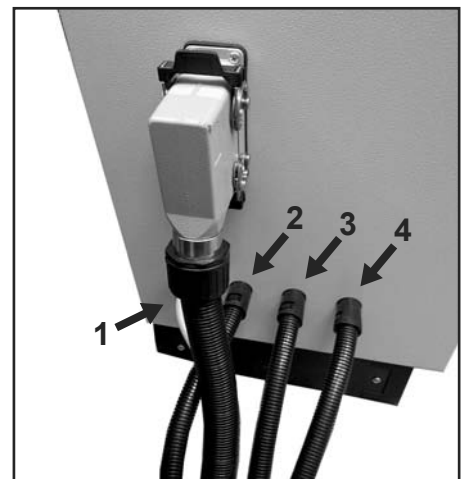
7.10 CONTROL BOARD CONNECTION

Place the control board near the machine.

Feeding cables:

Connect the two cables with multipolar connectors from the machine and from the indexing unit to the control board.

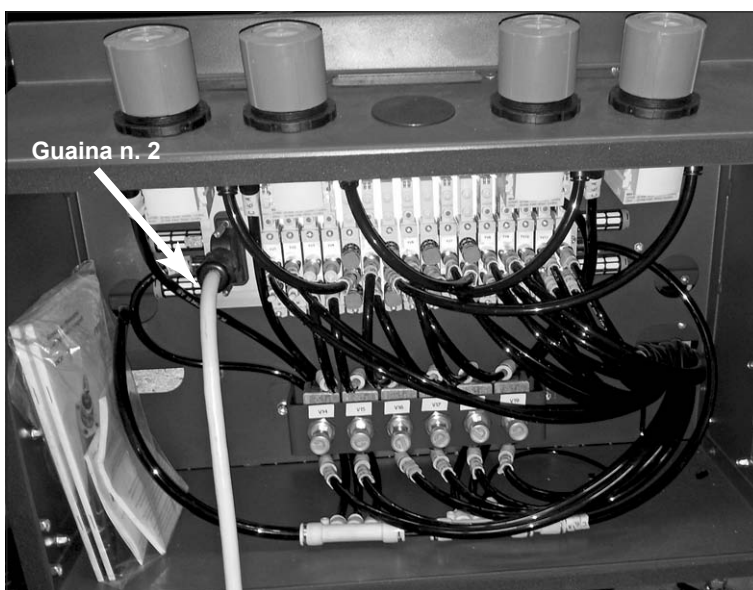
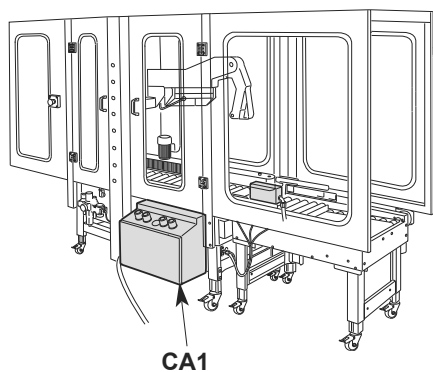
1. Feeding cable (net)
2. Carton sealer front box (CA1)
3. Carton sealer rear box
5. Indexing unit box and vertical electrical axis motors.



7-INSTALLATION

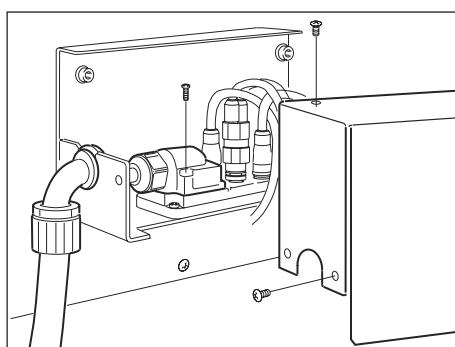
7.11 Carton sealer front box

Box **CA1**
Cables n.2



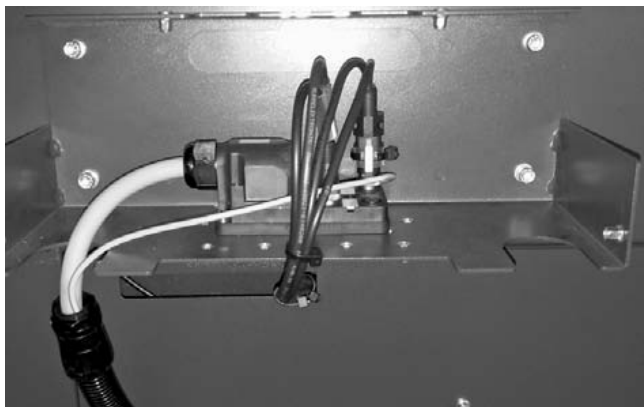
7-INSTALLATION

7.12 Carton sealer rear box Cable n. 3



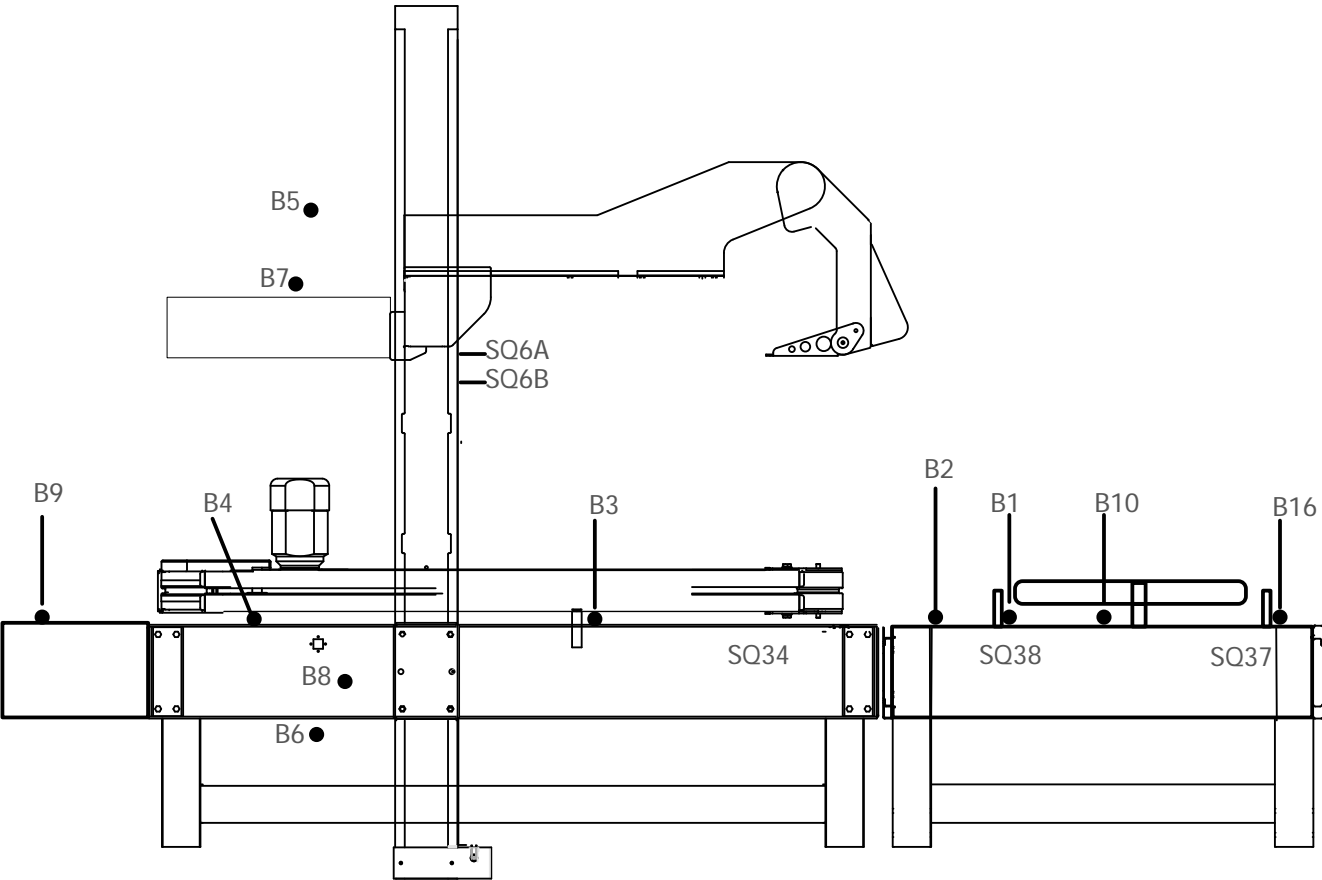
Indexing unit box and vertical axes motors

Cable n.4



7-INSTALLATION

Infeed conveyor photocell connection

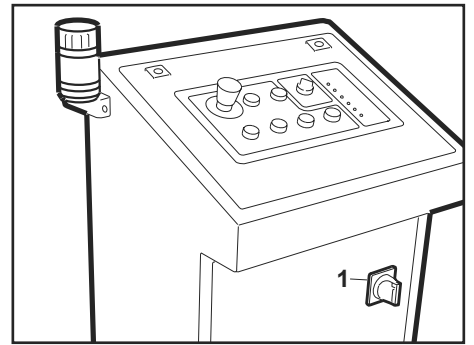


7-INSTALLATION

7.11. CHECK-OUT OF PHASES (FOR THREE-PHASES ONLY)

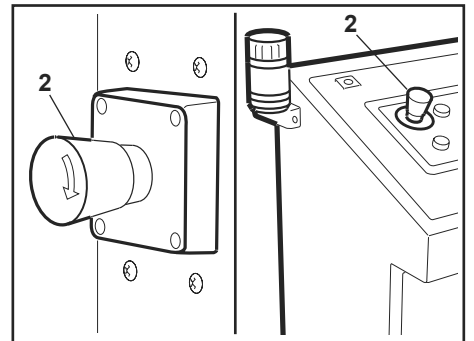
Procedure to be followed in order to connect correctly the position of the phases:

-Set the main switch **1** in ON position;



-Check that safety guard panels are clearly shut;

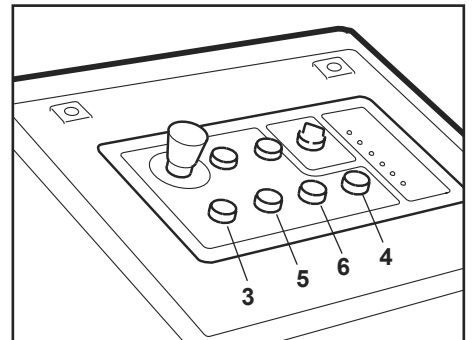
-Release the emergency stop push buttons rotating them clockwise;



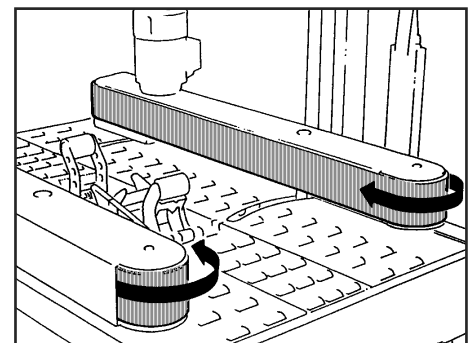
-Push the AUXILIARIES button **3**;

-Push the RESET button **4**;

-Push the START button **6**;



Check the rotation direction of the side drive belts.

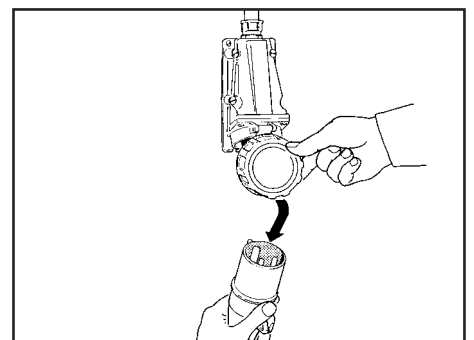


In case of wrong direction of rotation operate as follows::

-Push the STOP button **6** and disconnect the plug;

-Invert two phases on the terminals of the plug;

-Repeat the above mentioned procedure.



8-CONTROLS

8.1. CONTROLS BOARD

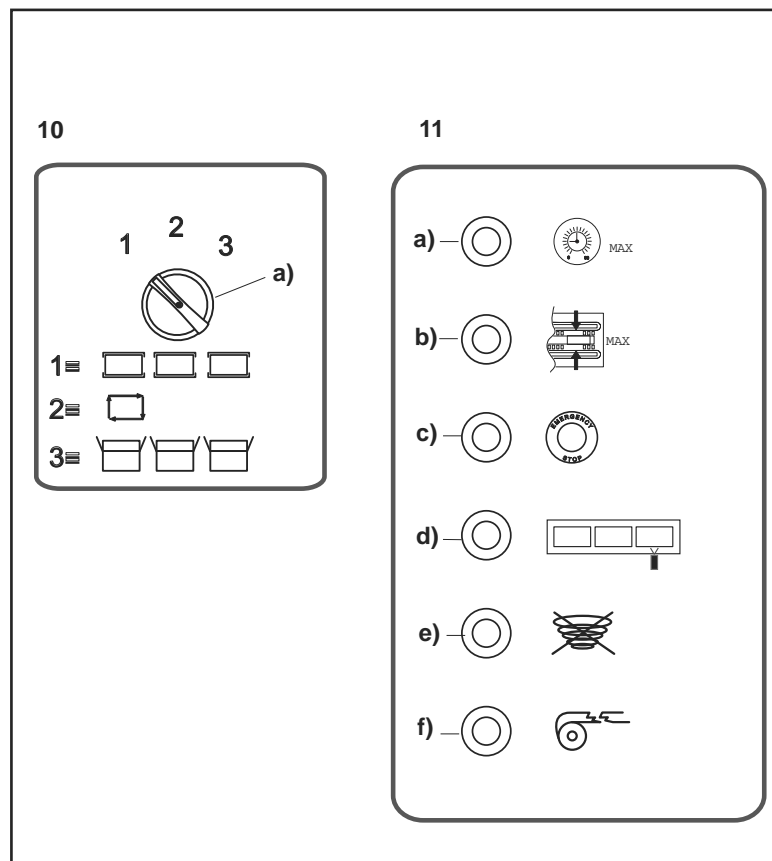
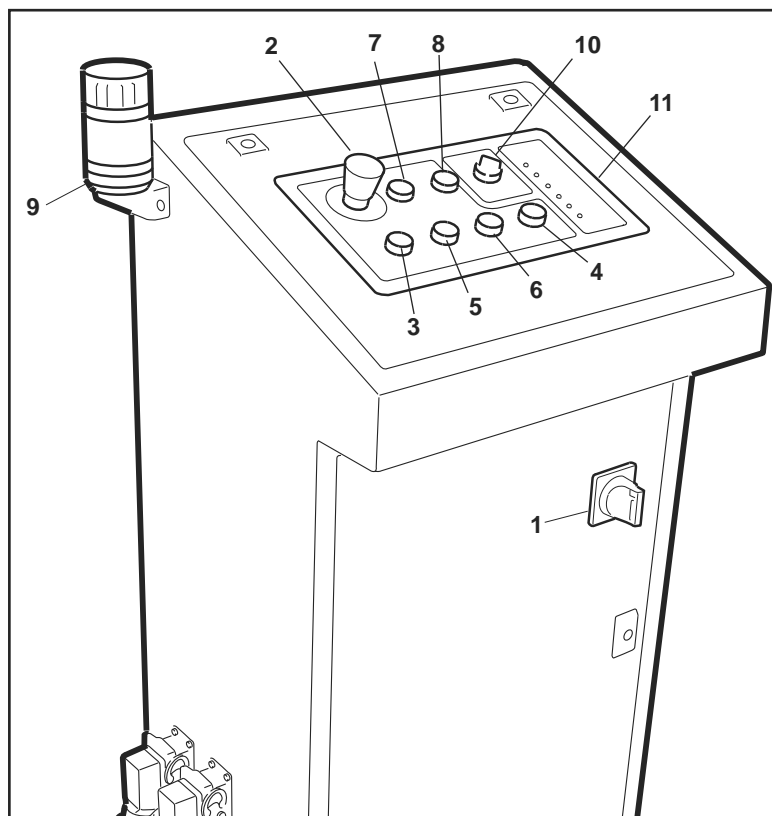
1. **Main switch**
2. **Emergency stop push button**
(lockable)
3. **Auxiliaries push button**
(control board electrical components habilitation)
4. **Reset push button**
(new work cycle predisposition)
5. **Start push button**
6. **Stop push button**
7. **Voltage warning light**
8. **Thermal switch warning light**
9. **Warning (flashing light + buzzer)**

10. Operating mode panel (See paragraph 9)

- a) Selector swit
- 1) Operating mod
'unchanging box size'
- 2) Operating mod
'automatic'
- 3) Operating mod
'transit only'

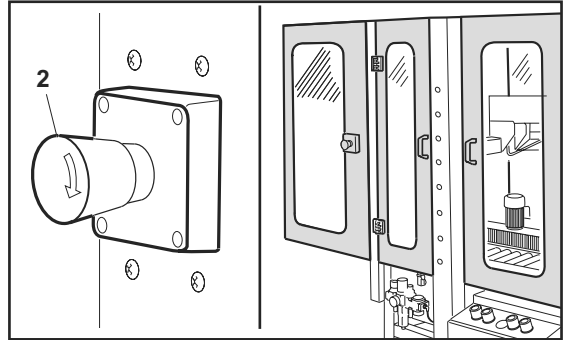
11. Warning lights panel (See paragraph 9)

- a) Max cycle time
- b) Minimum gap between side belts
- c) Emergency (emergency push button pressed or safety guard opened)
- d) Full sealing line
- e) Low air pressure or insufficient brake of the cylinders controlling the top taping head frame
- f) Tape end/breakage



9-OPERATION

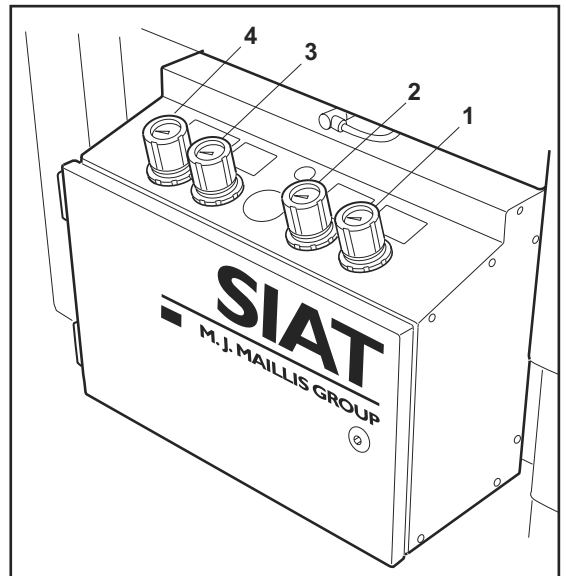
2. Lockable emergency stop push button on outside safety guards



FRONT JUNCTION BOX CONTROLS

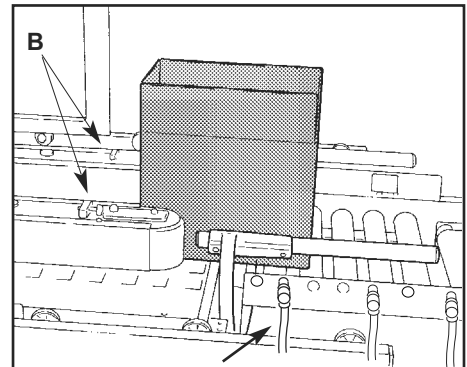
(See paragraph 11))

1. Centering guide pressure regulator
2. Side belts (motorizations) pressure regulator
3. Box height pick-up pressure regulator
4. Upper unit pressure regulator



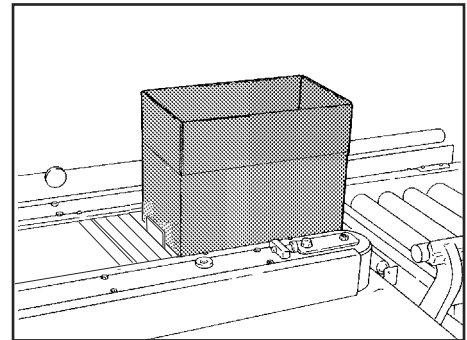
9-OPERATION

The side guides open and the box obscures the third photocell.
The side drive belts **B** go against the box and, if the box is longer than 500 mm, the rear flap folder is controlled.

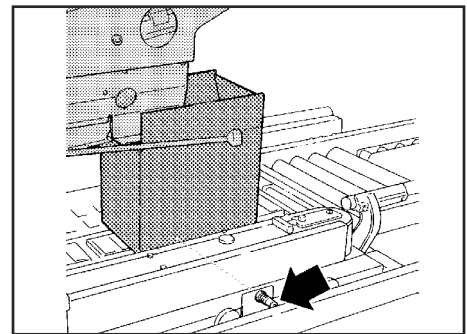


When the 4th photocell is obscured, the side drive belts stop.

The gate between the rollers, positions the box correctly.

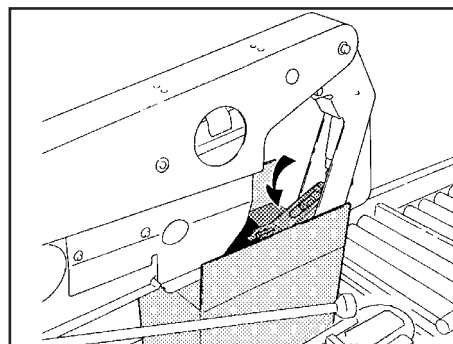


The upper group then comes down on the box after folded the front flap, the height pick-up device stops the upper group descent.

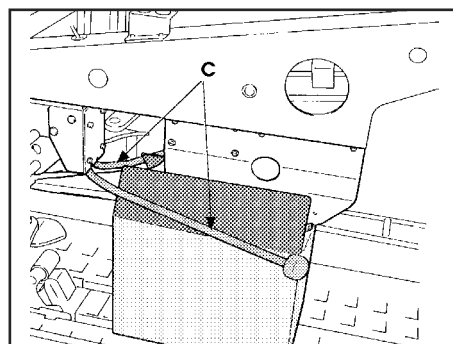


9-OPERATION

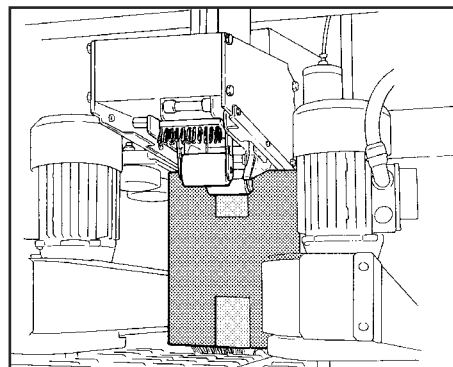
Simultaneously the rear flap is folded the fork goes down and the side belts restart to run.



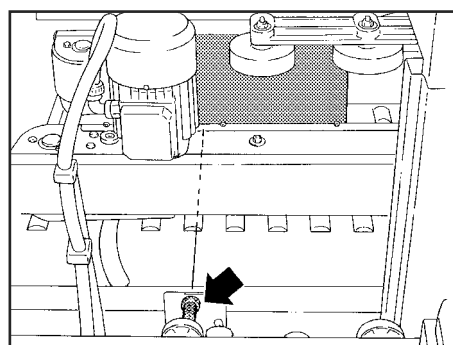
The side flaps are folded.



The two taping heads seal the box with adhesive tape.



When the box has passed the fifth photocell, the upper group goes up, the side drive belts open and the infeed conveyor belt (on which awaits the next box) comes up and restarts.
The sealing machine begins again with a new cycle.



9-OPERATION

IMPORTANT!

If, for any reason, the box should stop inside the machine after 10 seconds the machine stops.
To remove the box and restart operate as follows:

- press the E-stop,
- open the safety guard
- remove the box,
- close the safety guard and release the E-stops,
- press the AUXILIARIES push-button;
- press the RESET push-button,
- press the START button to start the cycle

9.3 OPERATION METHODS

The SM44-HD works only in automatic: safety guard closed, E-stop released, START button pressed, air circuit open.

9.3.1. AUTOMATIC OPERATING MODES

-Unchanging box size (selector switch **10** on **1** pos.): the machine acknowledges the size of the first box.

The upper unit maintains its position along whole production.

Introducing a box of different size with consequent machine jam the same stop after 10 seconds with activation of the "cycle time out" warning light on the control board.

-Automatic (selector switch **10** on **2** pos.): the machine acknowledges the box size whenever a new box are placed on the infeed conveyor belt.

-Transit only (selector switch **10** on **3** pos.): upper taping unit out of operation; the box is sealed only on the bottom side.

Removing the bottom taping unit the boxes can be simply moved inside-outside; a useful condition when the sealing machine is placed in a automatic packaging line.

9.4. STOP METHODS

9.4.1. NORMAL STOP

STOP push button **6** on control board panel: the push-button must be pressed at the working cycle end.

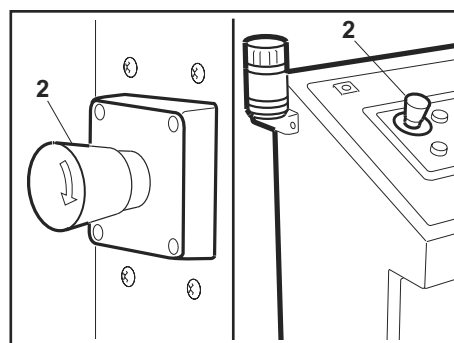
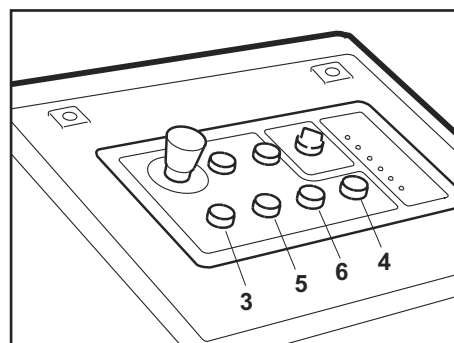
To restart press RESET **4** then START **5**.

9.4.2. EMERGENCY STOP

Lockable E-stops pressed or safety guard open. They stop the machine at any point of the cycle; also pneumatic circuit are disconnected.

To restart release the E-stops and close the safety guards as necessary and then:

- press AUXILIARIES **3** push-button
- press RESET **4** push-button,
- press START **5** push-button.

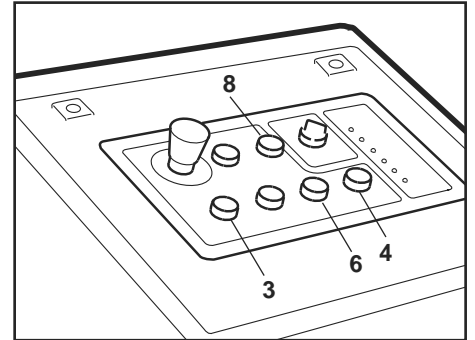


9-OPERATION

9.5 ALARMS

Warning light 8 : thermal switch activation (motor overload)

- The machine cannot be started; machine stops if its running
- To restart press **3**, after **4** , then **6** push-buttons.



Warning light 11a: time out cycle (the machine will stop when the cycle taping boxes is not done just in time as preselected; 10 seconds approximately).

- machine stop.
- to restart press **4**, **6** push-buttons; if has been necessary open a safety guard to eliminate a jam, press **3**, **4**, **6** push-buttons.

Warning light 11b: minimum gap between side belts (box size below allowed minimum dimensions or no box)

- machine stop.
- to restart press **4**, **6** push-buttons; if has been necessary open a safety guard to eliminate a jam, press **3**, **4**, **6** push-buttons.

Warning light 11c: emergency (emergency push button pressed or safety guard opened).

- machine stop, pneumatic circuit disconnected.
- to restart press **3**, **4**, **6** push-buttons.

Warning light 11d: full taping line

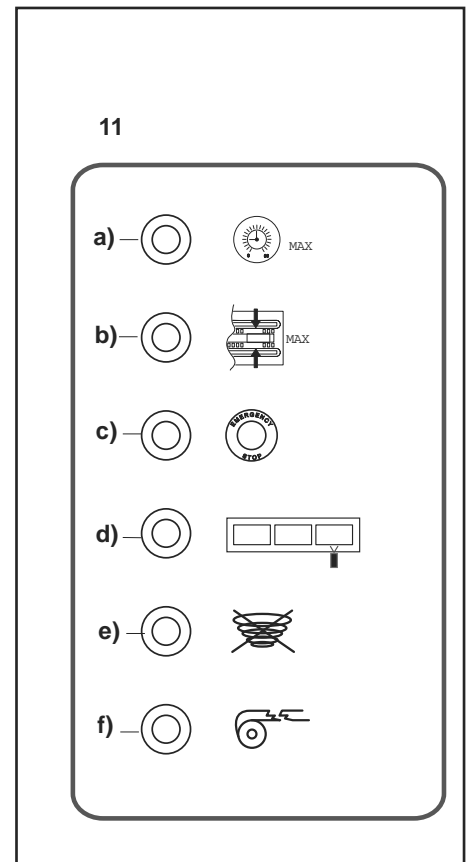
- Temporary stop of the machine, the outside line photocell is obscured; the cycle restart just when the box is removed and so the above mentioned photocell is reactivated.

Warning light 11e

- 1) low air pressure** -min. 6 bar or no air.
 - the machine cannot be started, machine stops if it is running;
 - to restarts press **4**, **6** push-buttons
- 2) Insufficient brake of the cylinders controlling the top taping head frame.**
 - start of the machine prohibited or stop if working;
 - proceed to adjust the braking system on the cylinders; see section 13 "Maintenance"
 - to start push subsequently buttons **4** and **6**

Warning light 11f: tape end/breakage

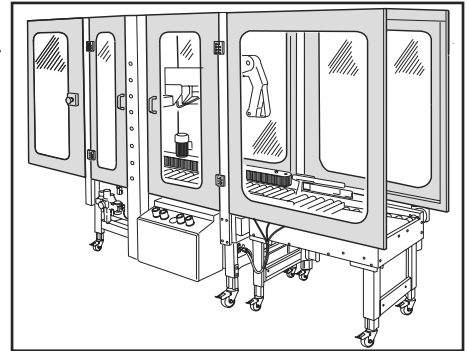
- the machine cannot be started, machine stops if it is running;
- to restarts press **3**, **4**, **6** push-buttons



10-SAFETY DEVICES OF THE MACHINE

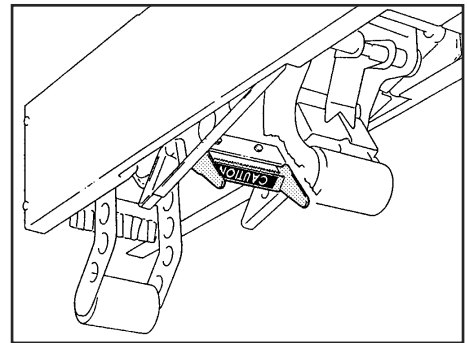
10.1 SAFETY GUARD

It limits the access to the machine, protecting the operator from the moving parts.



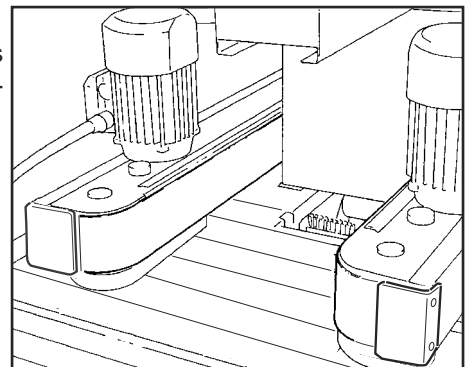
10.2 BLADE GUARDS

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



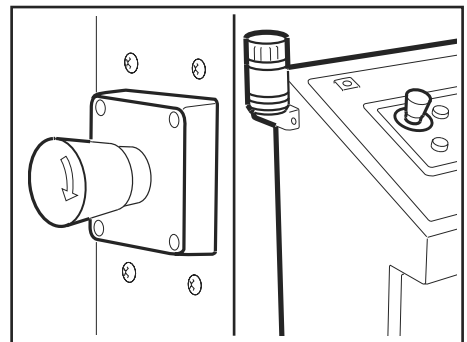
10.3 BELT GUARDS

The drive belts are protected by safety covers on their external sides and by rigid elements on the exit side. These protections must be immediately replaced if damaged.



10.4 EMERGENCY STOP BUTTONS

The lockable emergency stop buttons are placed in handy position, on control board and on the safety guards.



10.5 ELECTRIC SYSTEM

The electric system is protected by a ground wire whose continuity has been tested during the final inspection. The system is also subject to insulation and dielectric strength tests.

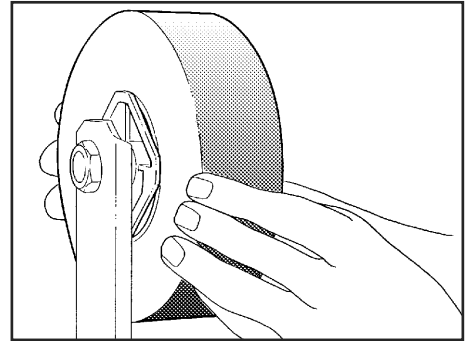
11-SET-UP AND ADJUSTMENTS

11.0 SECURITY

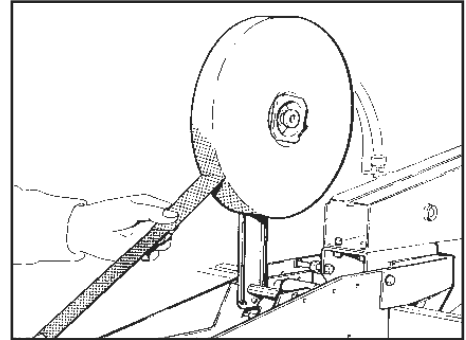
If the operations to prepare and adjust the machine must be made with the E-stop locked.

11.1. TAPE LOADING ON THE TOP UNIT

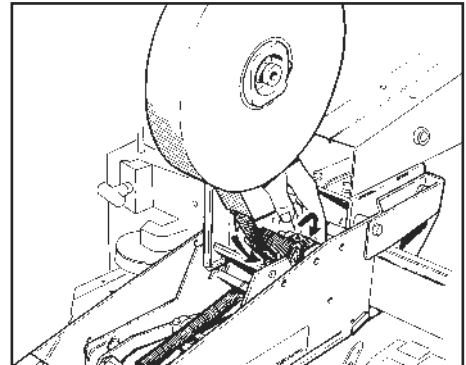
Insert a tape roll on the drum and push it fully forward.



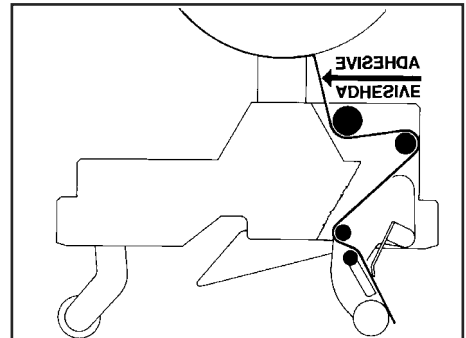
Attach the tape leg to the threading tool (supplied with the tools kit).



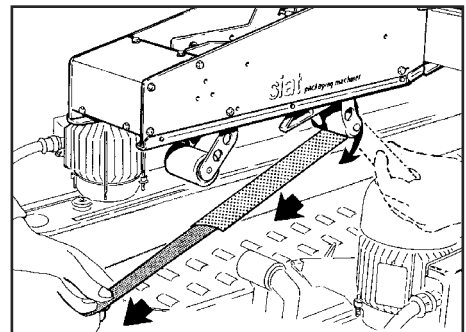
Insert the plastic threading leader through the taping unit. Take care to keep hands away from the tape cutting blades. (see section 3.11-b)



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



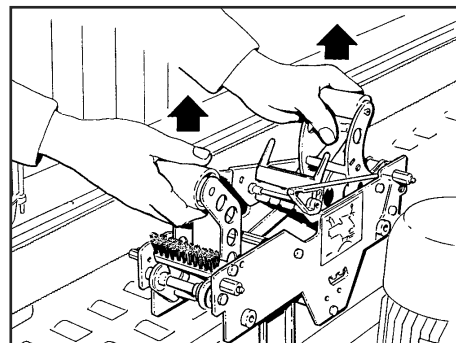
Pull and cut off the excess tape using a pair of scissors as shown.



11-SET-UP AND ADJUSTMENTS

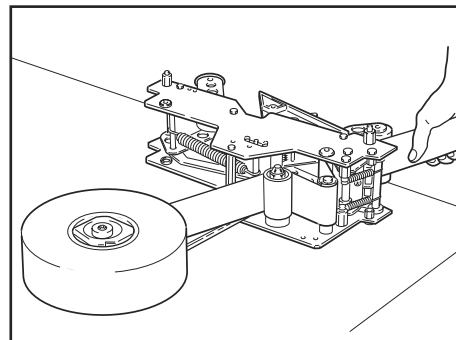
11.2 TAPE LOADING ON THE BOTTOM UNIT

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



-Put a tape roll on the drum and thread the tape through the unit as shown on the label in the same manner as for the top unit;

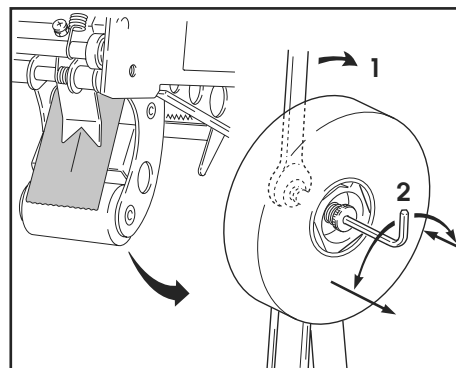
-Put the bottom unit back into its housing.




11.3 TAPE DRUM ALIGNMENT

 Check the centering of the tape on the rollers of the taping unit.

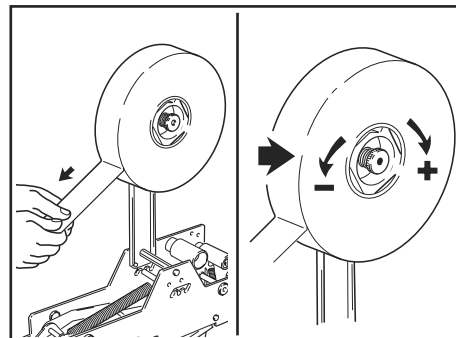
If necessary unscrew the nut **1** and adjust the screw **2**.




11.4 TAPE DRUM FRICTION BRAKE ADJUSTMENT

 Check the tape tension:

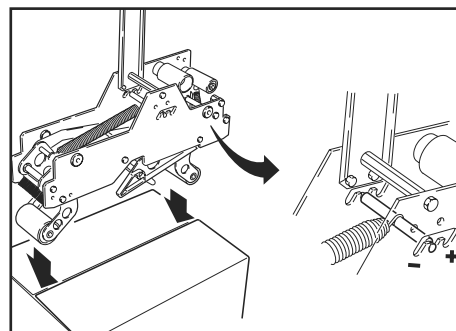
- with PVC the tape drum must be free
- with OPP the tape drum must be slightly frictioned



11.5 ADJUSTMENT OF TAPING UNITS ACCORDING TO THE TYPE OF BOXES

 Adjust the main spring:

- decrease the spring load for light boxes;
- increase the spring load for heavy boxes.



11-SET-UP AND ADJUSTMENTS

11.6 MAIN PRESSURE REGULATOR

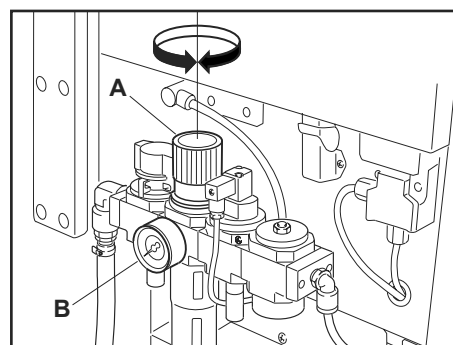
A) it adjusts the entry working pressure

B) gauge to read the entry air pressure

Optimal working pressure: 6 BAR

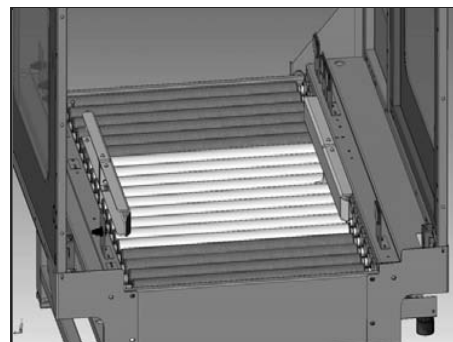
Feeding tube diameter: 10 mm

N.B.: in case the working pressure is below 6 BAR or the feeding tube has a small diameter, some malfunctions can happen! (es: the upper group comes down, the rear flap folder works but the machine stops)



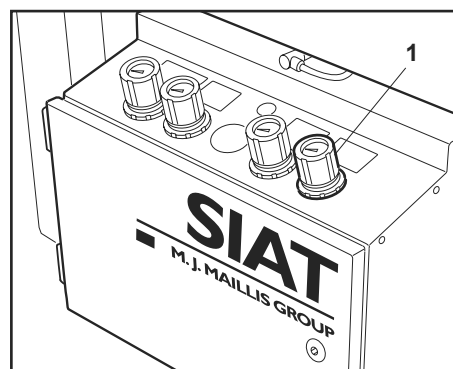
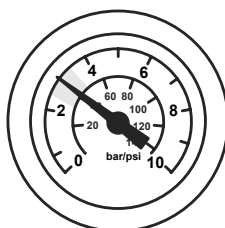
11.7 CENTERING GUIDES PRESSURE

1) Pressure regulator with built-in pressure gauge.



The pressure regulator **1** located on the front junction box adjusts the pressure of the centering guides of the infeed conveyor.

Working pressure: 2.5÷3.5 bar
(entry pressure: 6 bar)



11.8 SIDE DRIVES PRESSURE ADJUSTMENT

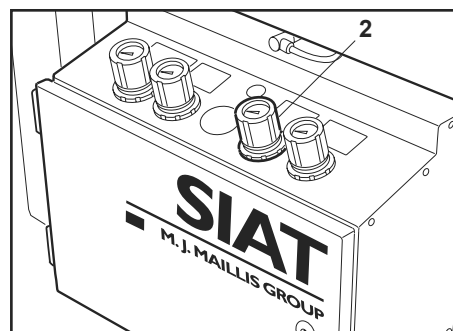
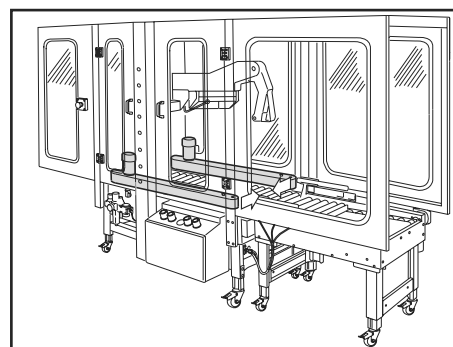
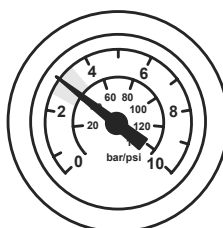
2) Pressure regulator with built-in pressure gauge.

The pressure regulator **2** located on the front junction box adjusts the pressure of the side drives against the box.

-Increase for strong or heavy boxes.

-Decrease for light boxes.

Working pressure: 2.5÷3.5 bar
(entry pressure: 6 bar)



11-SET-UP AND ADJUSTMENTS

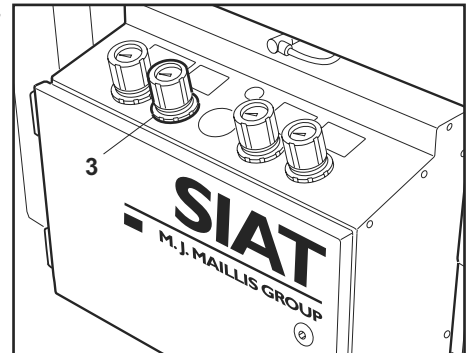
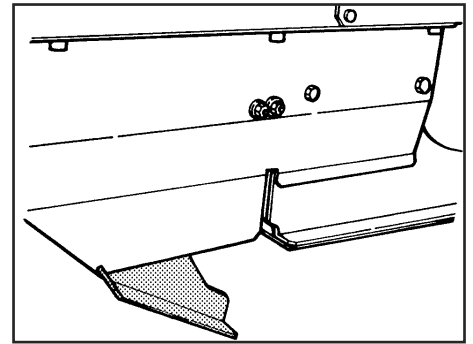
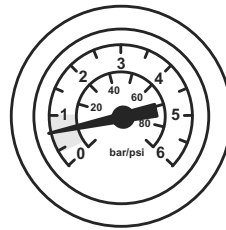
11.9 BOX HEIGHT PICK-UP

3) Pressure regulator with built-in pressure gauge.

The pressure regulator 3 adjusts the pressure according to the board strength.

- Decrease in case of light boxes.
- Increase in case of strong boxes.
- Minimum pressure must be adjusted so that the paddle returns automatically in position once the box is passed.

Working pressure: $0.5 \div 1.0$ bar
(entry pressure: 6 bar)



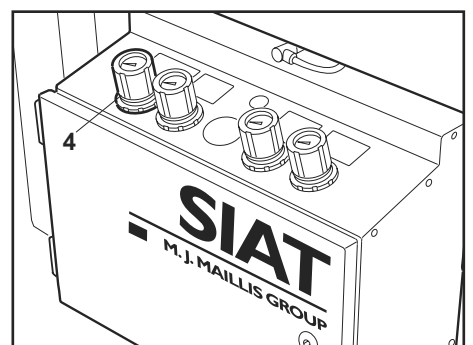
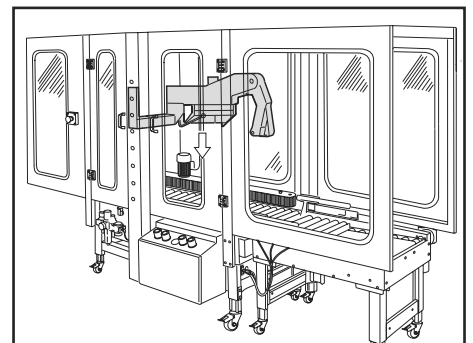
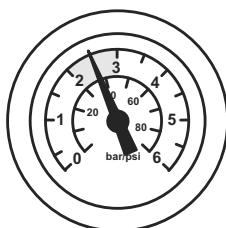
11.10 UPPER UNIT DESCENT PRESSURE REGULATOR

4) Pressure regulator with built-in pressure gauge.

The pressure regulator 4 adjusts the pressure according to the board strength.

- Decrease in case of light boxes.
- Increase in case of strong boxes.

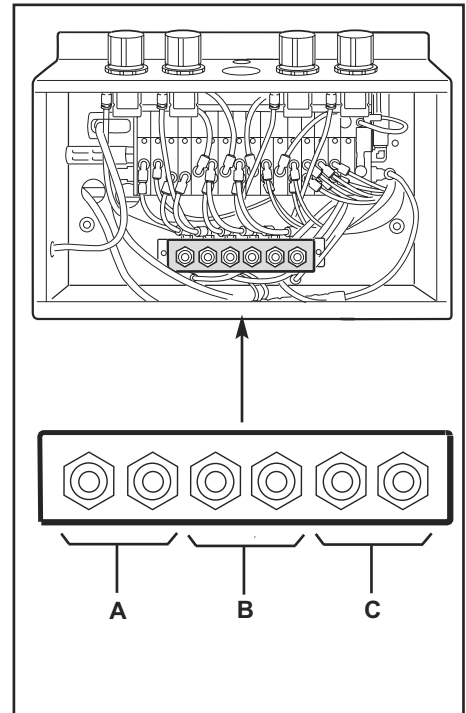
Working pressure: $2 \div 3$ bar
(entry pressure: 6 bar)



11-SET-UP AND ADJUSTMENTS

11.11 PNEUMATIC SPEED REGULATORS

- A) Side belts opening-closing speed regulators
- B) Centering guides (infeed conveyor) speed regulators
- C) Upper unit ascent-descent speed regulators



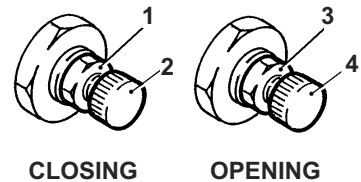
Side belts opening-closing speed regulators

These are not common operations. They have to be made only when it has been necessary to work on the pneumatic cylinder.

To change the speed, do as follows:

- 1) unscrew the locking nut 1
- 2) turn the knob 2 clockwise to reduce the belts closing speed; anticlockwise to increase the belts closing speed.
- 3) unscrew the locking nut 3
- 4) turn the knob 4 clockwise to reduce the belts opening speed, anticlockwise to increase the belts opening speed.

A



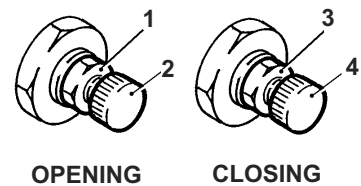
Centering guides opening-closing speed regulators

These are not common operations. They have to be made only when it has been necessary to work on the pneumatic cylinder.

To change the speed, do as follows:

- 1) unscrew the locking nut 1
- 2) turn the knob 2 clockwise to reduce opening speed; anticlockwise to increase opening speed.
- 3) unscrew the locking nut 3
- 4) turn the knob 4 clockwise to reduce closing speed, anticlockwise to increase closing speed.

B



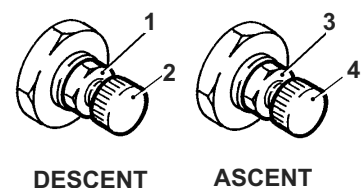
Upper unit ascent-descent speed regulators

These are not common operations. They have to be made only when it has been necessary to work on the pneumatic cylinder.

To change the speed, do as follows:

- 1) unscrew the locking nut 1
- 2) turn the knob 2 clockwise to reduce the descent speed; anticlockwise to increase the descent speed.
- 3) unscrew the locking nut 3
- 4) turn the knob 4 clockwise to reduce the ascent speed, anticlockwise to increase the ascent speed.

C



11-SET-UP AND ADJUSTMENTS

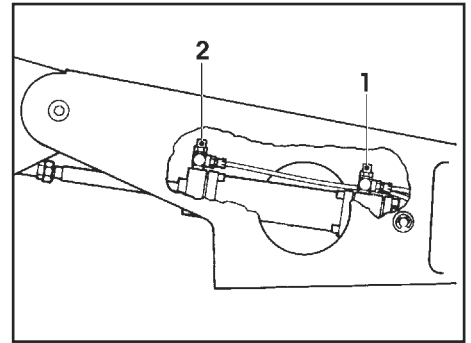
11.12 SPEED REGULATORS OF THE REAR FLAP FOLDER

These are not common operations. They have to be made only when it has been necessary to work on the pneumatic cylinder.

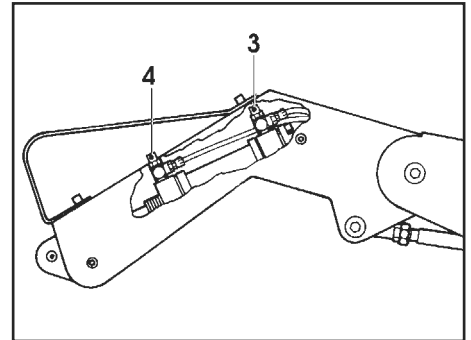
To change the speed, do as follows:

The speed of the rear flap folder unit can be adjusted by the flow regulators mounted on the pneumatic cylinders.. It is necessary to introduce a screwdriver into the hole corresponding to the regulator:

- 1) to adjust the descent speed of the arm.
- 2) to adjust the ascent speed of the arm.



- 3) to adjust the descent speed of the flap folder.
- 4) to adjust the ascent speed of the flap folder.



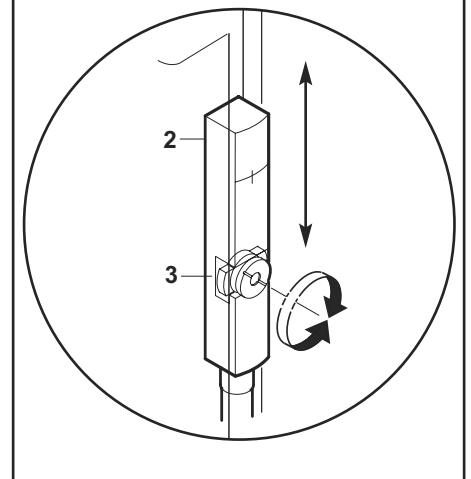
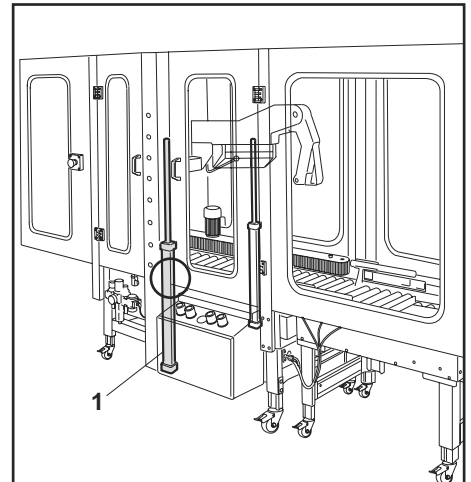
11.13 ADJUSTMENT OF THE UPPER UNIT HEIGHT

In case the height of the box to be sealed is not higher than 300 mm, it is possible to stop the ascent of the upper group so to reduce the time of the sealing cycle.

To limit the upper group ascent move down the magnetic sensor 2 located on the air cylinder 1, machine side operator, after have removed the guard.

Turn the cam screw 3 to reposition the sensor.

Position the sensor so that the upper unit stops at 100 mm above the box height.



11-SET-UP AND ADJUSTMENTS

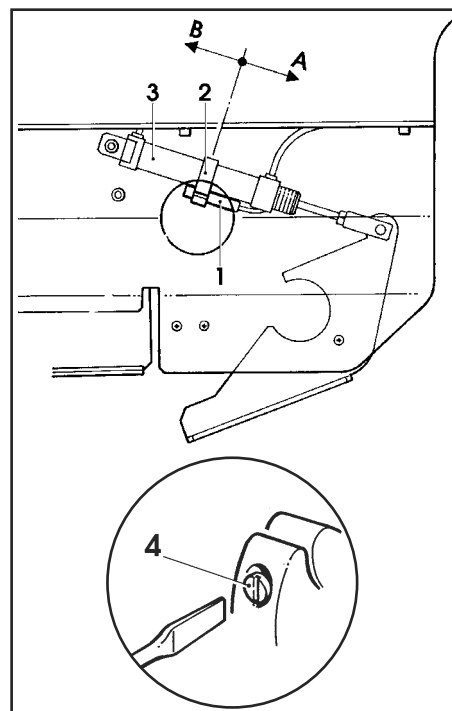
11.14 ADJUSTMENT OF THE SENSOR THAT STOPS THE DESCENT OF THE UPPER UNIT

The descent of the upper group is stopped when the sensor 1 is activated (yellow led up).

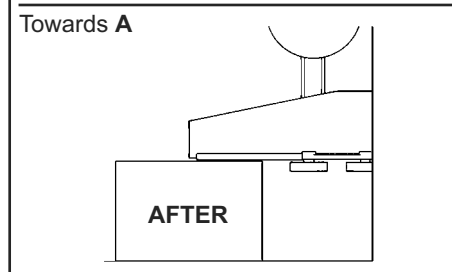
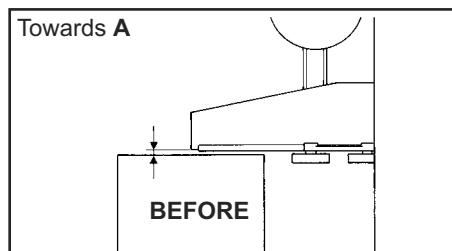
The sensor is mounted on the cylinder 2 by the support 3.

To change the intervention time of the sensor do as follows:

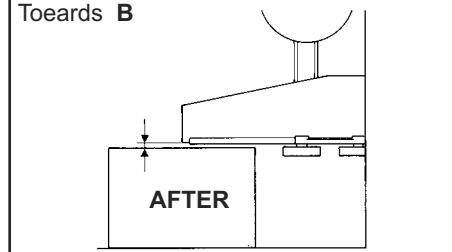
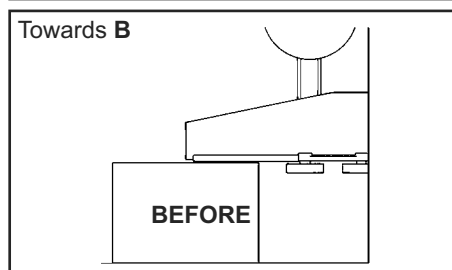
- 1) loosen, the scre 4 of the support;
- 2) move the support with the sensor along the cylinder;



Towards **A** to delay the braking.



Towards **B** to anticipate the braking.

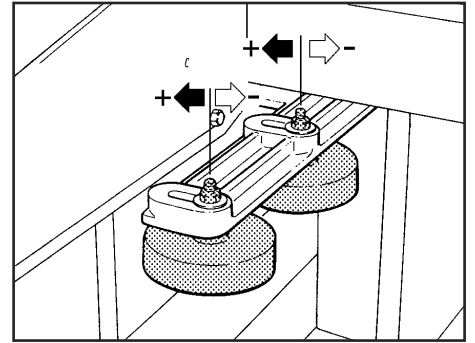


11-SET-UP AND ADJUSTMENTS

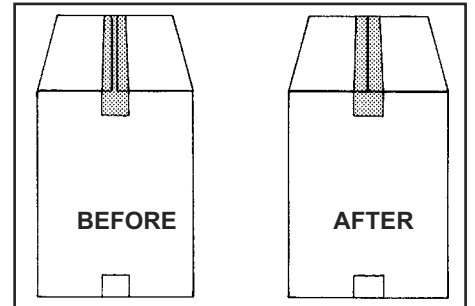
11.15 ADJUSTMENTS OF THE SIDE COMPRESSION ROLLERS

To increase or decrease the pressure of the side rollers on the box, do as follows:

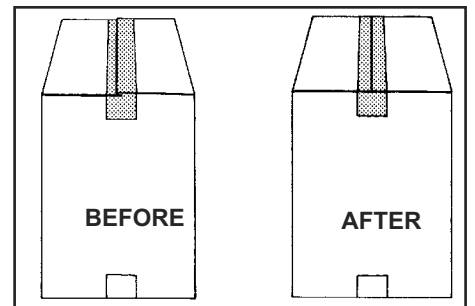
- loosen the nuts;
- change the position of the rollers;
- lock the nuts.



- increase the pressure when the upper flaps are not well closed after the sealing.



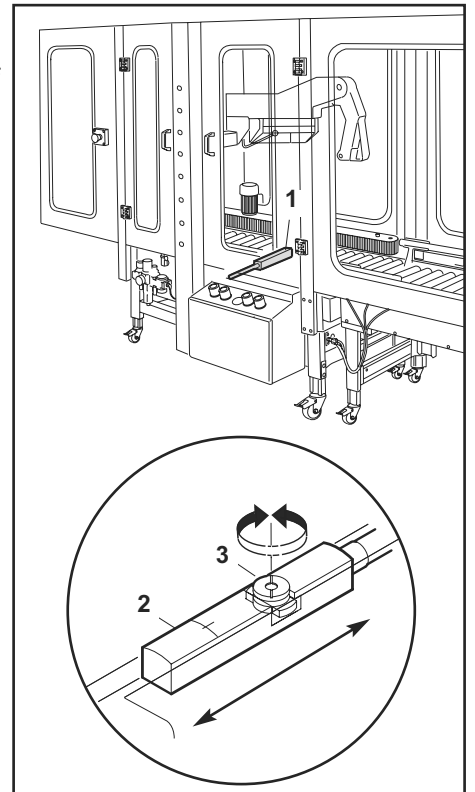
- decrease the pressure when the upper flaps are one upon the other.



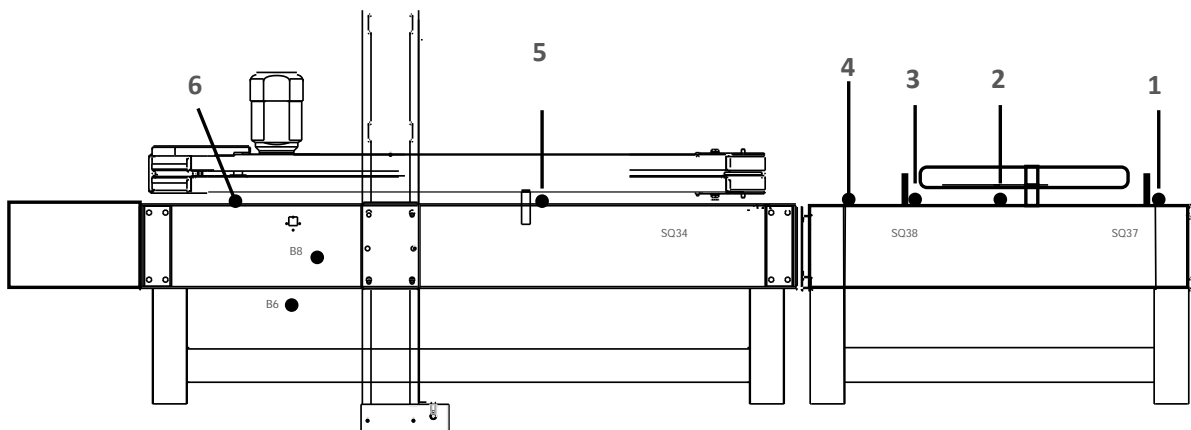
11.16 ADJUSTMENT OF THE MAGNETIC LIMIT SWITCH ON SIDE DRIVES AIR CYLINDER

The limit switch **2** on the air cylinder body check maximum closure of the side drives avoiding that the compression rollers hit the upper unit.

Some little adjustments are possible by moving the limit switch longitudinally on the cylinder body; to do this loose the cam screw **3**.



11-SET-UP AND ADJUSTMENTS



11.17 USE AND ADJUSTMENTS OF THE PHOTOCELLS

PHOTOCELL 1

The photocell does not operate at the first machine starting ; when is obscured by the next box the motorized plane of the infeed conveyor stops.

No adjustment is necessary.

PHOTOCELL 2

When is obscured by the box the motorized plane goes down and the side guides center the box.

No adjustment is necessary.

PHOTOCELL 3

It controls the closure of the side drives and and the descent of the rear flap folder.

The position can be changed according to box length; move the photocell towards **D** for long boxes, towards **S** for short boxes.

PHOTOCELL 4

It stops the side drives and control the upper unit descent.

No adjustment is necessary.

PHOTOCELL 5

When the box is passed it controls the machine reset for a new working cycle.

No adjustment is necessary.

PHOTOCELL 6

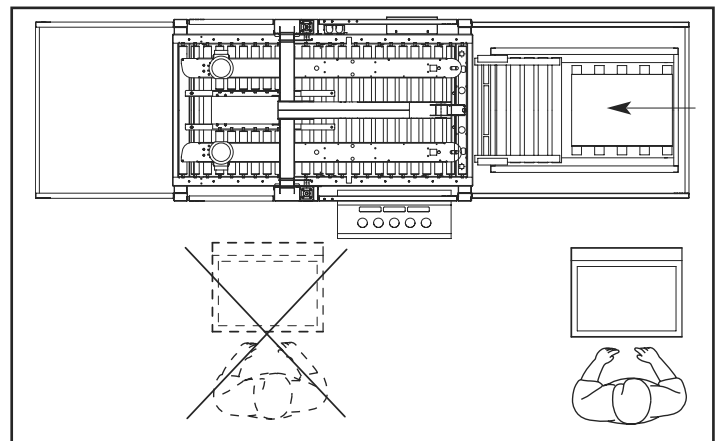
When is obscured stops the machine and activates the 'full line' warning light on the control board.

It's a temporary stop; he machine restarts just when the box is removed an so the photocell is rearmed.

No adjustment is necessary.

12-SET -UP AND ADJUSTMENTS

12.1 OPERATOR CORRECT WORKING POSITION



12.2 MACHINE STARTING

- Close the side safety guard
- Release the E-stop
- Give air to the circuit
- Turn the main switch in ON position
- Press the AUXILIARIES button
- Press the RESE button
- Press the START button

12.3 PRODUCTION STARTING

- Before starting, check the main functions of the machine
- 1 Entry air pressure 6 BAR, if pressure is below 5,5 the machine functions are not safe.
 - 2 Centering device pressure: 2,5÷3,5 BAR
 - 3 Side drive belts pressure: 2,3÷3,5 BAR
 - 4 Box height pick up pressure: suggested working pressure: 0,5÷1 BAR
 - 5 Upper unit descent pressure: 2÷3 BAR
 - 6 Press the START button and check that E-stops are working properly.
 - 7 Press the START button and check that machine stops if side guards are opened.

12.4 TAPE REPLACEMENT

Operator skill 1

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

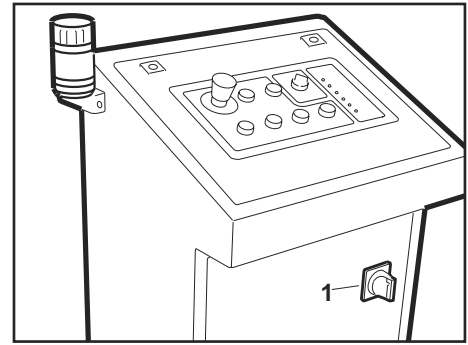
Pay attention to the cutting blades.



12-OPERATION

12.5 CLEANING

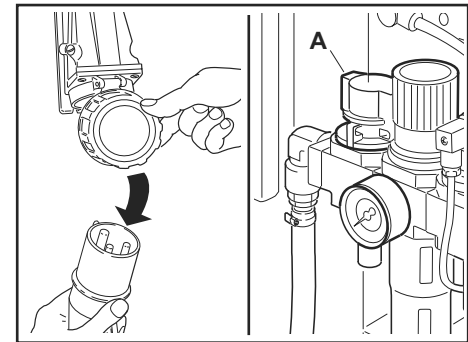
Before carrying out any cleaning or maintenance operation stop the machine by pressing the OFF button on the main switch.



Disconnect the electric power and disconnect pneumatic circuit through valve **A**.

CLEANING - Skill 1 operator
Use dry clothes or light detergents.

Do not use solvents or water jets.



12.6 ADJUSTMENTS

| OPERATIONS | OPERATOR'S SKILL | CHAPTER |
|--|------------------|---------|
| Tape replacement | 1 | 11.1 |
| Tape alignment | 1 | 11.2 |
| Checkout of the safety devices | 1 | 12.7 |
| Adjustment of the tape drum friction brake | 1 | 11.3 |
| Working bed height adjustment | 2 | 7.4 |
| Photocells adjustment | 2 | 11.17 |
| Side compression rollers adjustment | 2 | 11.15 |
| Taping heads adjustments | 2 | 11.2 |

12.7 SAFETY DEVICES CHECKOUT

- 1 Taping units blade guard;
- 2 Lockable emergency stop button;
- 3 Rigid protection plates mounted on the side drives;
- 4 Safety guards;

12-OPERATION

12.8 TROUBLE SHOOTING

| TROUBLE | CAUSE | SOLUTION |
|---|---|--|
| Tape is not centered on the box. | The side belts are not correctly positioned. | Check the position. |
| | The box flaps are not centered. | Check the flaps dimensions; the flaps must be equals. |
| | Tape is not positioned in the center of the taping head. | Adjust the tape position. |
| The length of the front tape leg on the box is not constant. | Tape path through the heads is not correct. | Check. |
| | Type unwind tension too loose. | Adjust the tension. |
| | Knurled roller friction too loose. | Adjust. |
| | Taping head idler rollers. | Clean and lubricate the rollers |
| The blade does not cut properly. | Blade dirty of adhesive. | Clean. |
| | Tape tension not enough. | Increase the friction on the core-holder. |
| | Springs on cutting lever not strong enough. | Replace. |
| | Blade damaged (broken teeth). | Replace the blade. |
| The tape is not well applied on the rear of the box. | Blade does not cut properly. | Replace/Clean. |
| | Main spring is not tensioned. | Adjust the spring tension. |
| | Adhesive residues on the head rollers. | Clean and lubricate the rollers. |
| The head comes down and crash the box. | The box does not stop properly against the gate (stop device) on the machine rollers. | Check the photocell position (4, paragraph 11.17). |
| | The box height pick-up is not correctly positioned. | Check the pressure value (0.5-1.0 bar). Check for jams (inside frictions) |
| | The magnetic limit switch on the the box height pick-up cylinder is not correctly positioned or is not working. | Check position of the magnetic limit switch. Check magnetic limit switch operation. |

12-OPERATION

| TROUBLE | CAUSE | SOLUTION |
|---|--|--|
| The box is not dragged under the head. | The box is too full load; box side flaps are opened. | Check. |
| | Driving pulley rings on motorizing side units are wornout. | Replace as necessary. |
| | Motorizing side units low pressure. | Check pressure value (working pressure 1.5-2.5 bar). |
| | The head is not correctly positioned; it is too down. | Check the magnetic limit switch position on the box height pick-up cylinder. |

13-MAINTENANCE AND REPAIRS

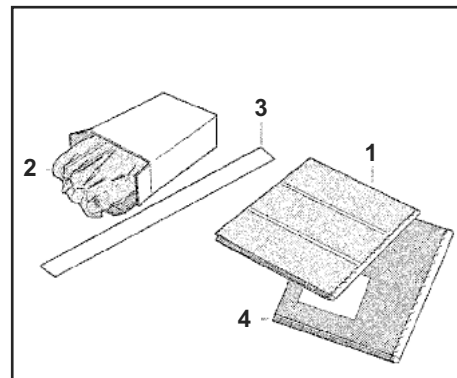
13.0 SAFETY MEASURES

(See section 3)

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

13.1 Tools kit and SPARE parts SUPPLIED WITH THE MACHINE

- 1 N.1 blade (spare blade for taping unit;
N.1 lower head spring
N.1 upper head spring
N.2 cutter spring
- 2 Tape threading tool (to feed the tape through the taping unit)
- 3 Instructions manual of the machine (SMB00055K)
- 4 Instructions manual of the taping unit



13.2 NATURE AND FREQUENCY OF MAINTENANCE OPERATIONS

| OPERATIONS | FREQUENCY | OPERATORS' SKILL | CHAPTER |
|---|-----------------|------------------|----------|
| Lubrications | Quarterly | 2 | 13.5-6-7 |
| Top taping head frame inspection brakes | Every two weeks | 2 | 13.2 |
| Blades cleaning | Weekly | 2 | 13.8 |
| Machine cleaning | Wekly | 1 | 12.5 |
| Checkout of safety devices | Daily | 1 | 13.4 |
| Blades replacement | as needed | 2 | 13.9 |
| Belts replacement | as needed | 2 | 13.10 |

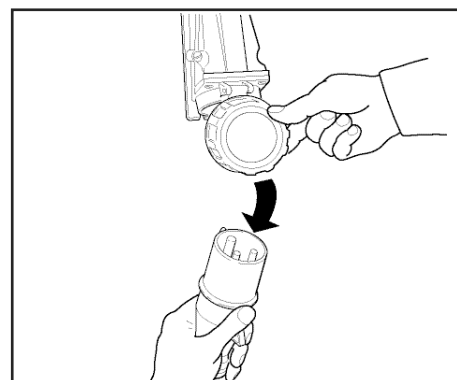
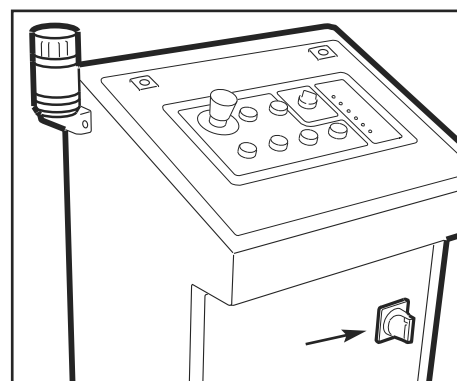
13.3 CHECKOUT TO BE PERFORMED BEFORE AND AFTER EVERY MAINTENANCE OPERATION

Always set the main switch on '0' (Off) position;

Disconnect the plug from the mains.

During the maintenace operations only the operator performing the main-tenance must work on the machine.

At the end of every maintenance operation check that all securities and the safety guards are working properly.



13-MAINTENANCE AD REPAIRS

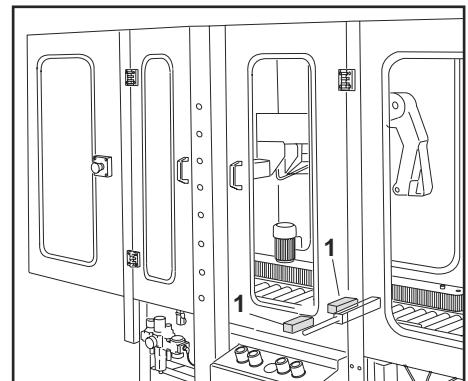
13.4 SECURITIES CH ECK-UP

- 1 Tape units blade guards;
- 2 Lockable emergency stop push-buttons;
- 3 Rigid protection plate mounted on the side drives;
- 4 Safety guards;

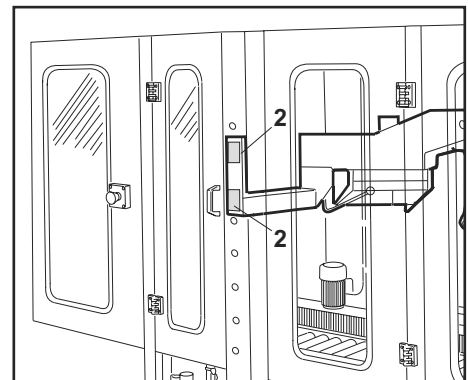
13.5 MACHINE LUBRICATION

Lubricate **quarterly** with grease/Metal/metal (see paragraph 13.6):

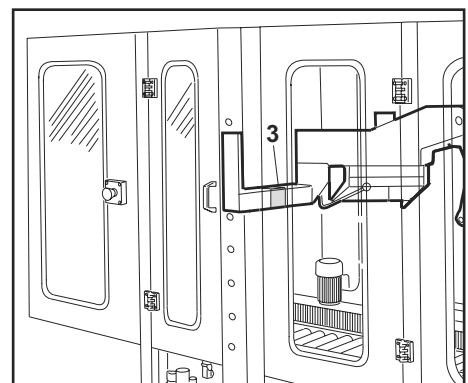
- 1 Slide cross bar ball guides for side drives (grease nipples on the blocks) ;



- 2 Columns-upper unit cross bar ball guides (grease nipples on the blocks);



- 3 Side compression rollers ball guides (grease nipples on the blocks).



13-MAINTENANCE AND REPAIRS

13.6 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)

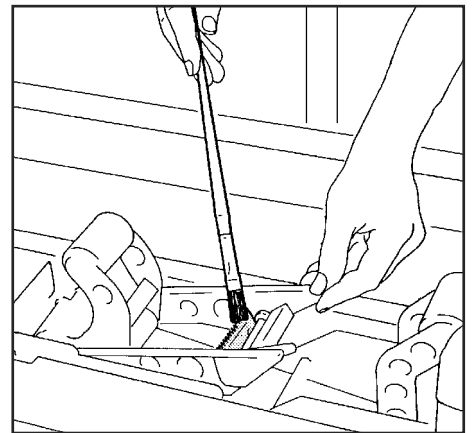
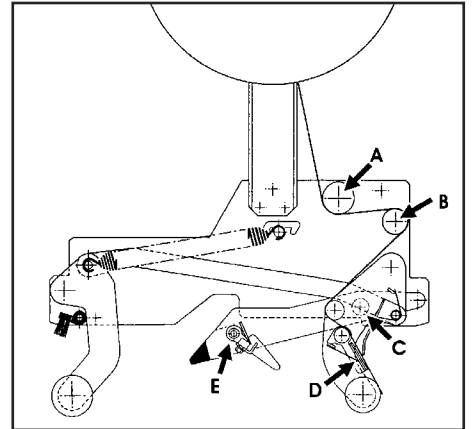
OIL TYPE:

regular lubricating oil or general purpose spray lubricant.

13.7 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



13.8 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.

13.9 BLADE REPLACEMENT

Skill 2 operator

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

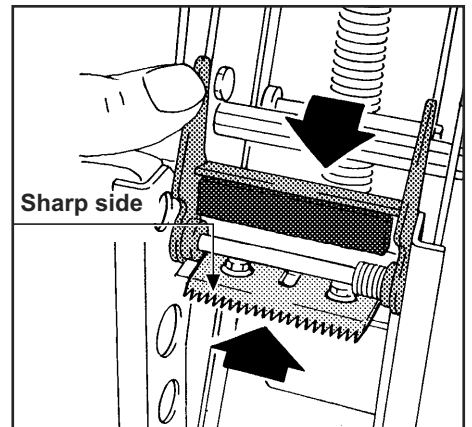
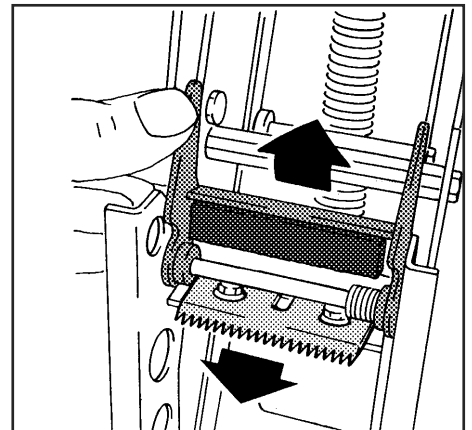
WARNING!

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..



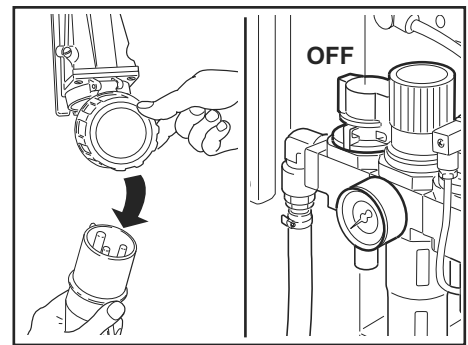
13-MAINTENANCE AND REPAIRS

13.10 SIDE DRIVE BELTS REPLACEMENT

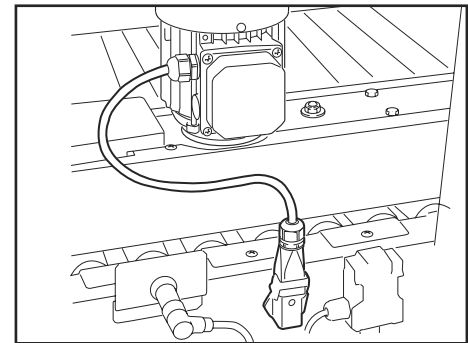
Skull 2 operator.

 **Notice:** in order to convey teh case correctly, it is necessary that both belts have the same level of wear.

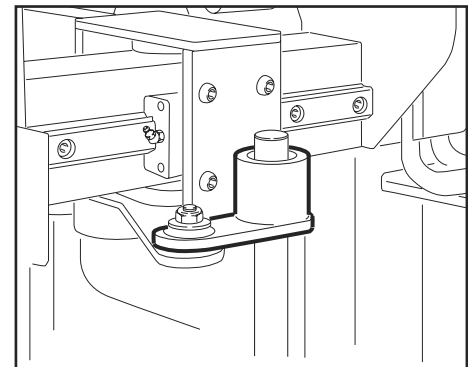
Remove the plug from the mains and take the air off the circuit.



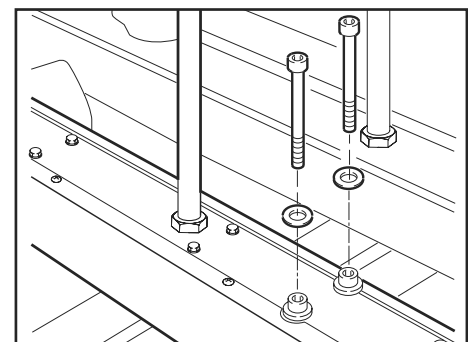
Disconnect the Klingel plug from the socket.



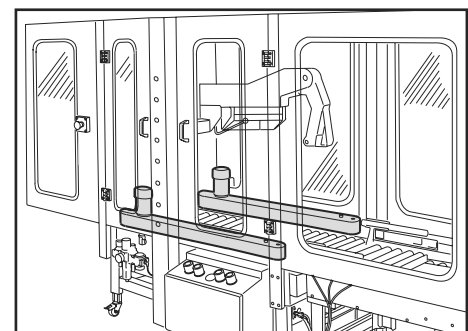
Losse and remove the bolts that fix the connecting rod to the side flap folder.



Remove the side drives locking screws.

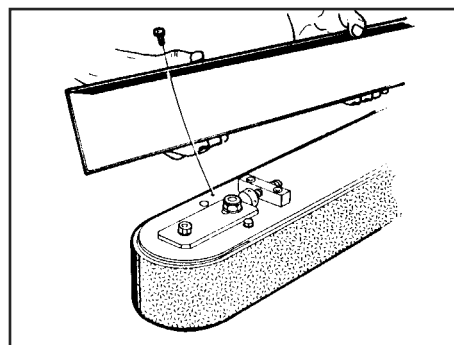


Remove the side drive and place it on a working table.

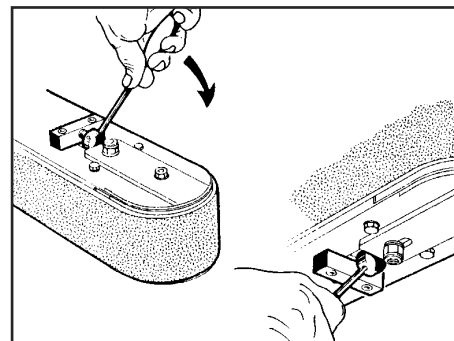


13-MAINTENANCE AND REPAIR

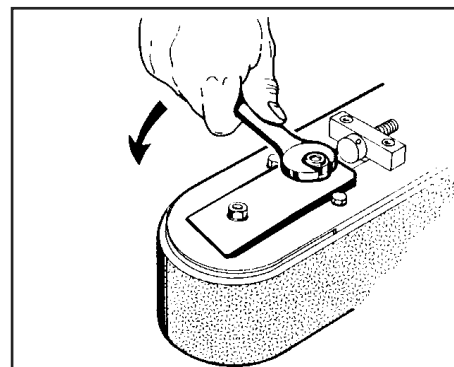
Remove the locking screws and the protection covers.



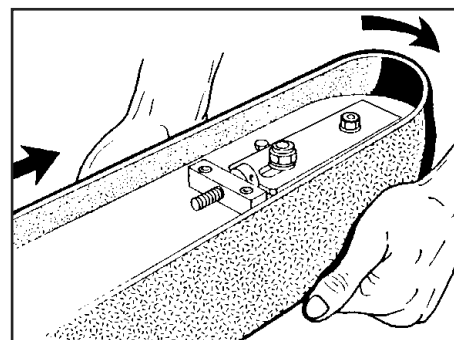
Loosen the tensioning screws.



Release the nut of the tensioning plate.



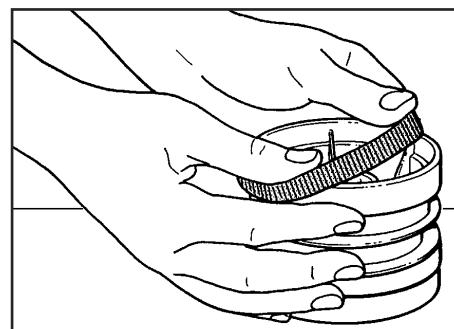
Remove and replace the drive belt.



WARNING!



Before setting the new belt, check the wear of the orange plastic rings on the drive pulleys: replace them if they are worn out.

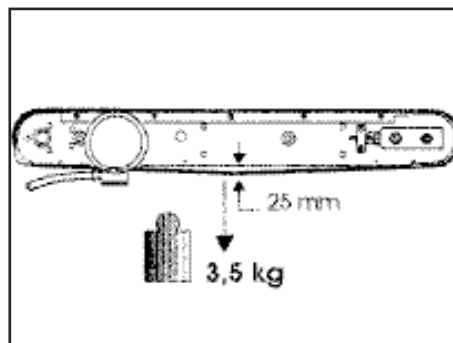


13-MAINTENANCE AND REPAIRS

13.11 ADJUSTMENT OF THE BELTS TENSION

Check the tension of the belt by pulling it outwards in the middle.

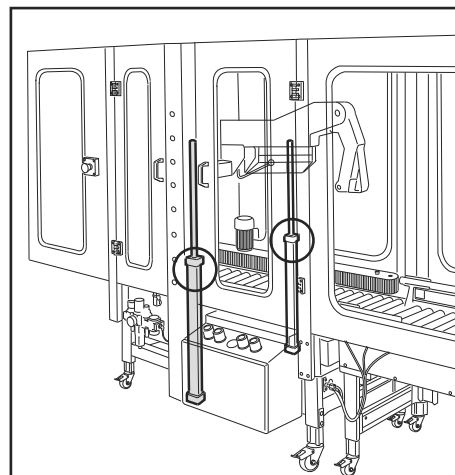
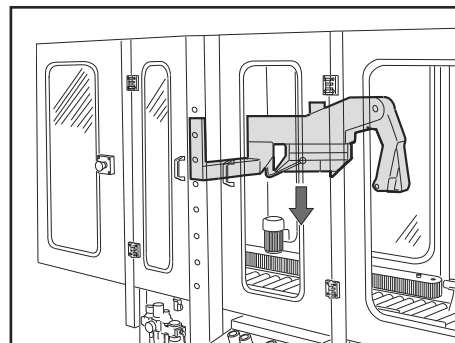
A force of 3,5 kg should produce a gap of 25 mm (1 inch) between the belt and the frame.



13.12 ADJUSTMENT OF THE UPPER ASSEMBLY DESCENT BRAKE

The brake adjustment must be done when the upper group does not stay in position and tends to come down further.

With the machine working push the stop emergency button or open the safety guarding; check that the top taping head frame remains in the correct position; eventually proceed to an adjustment as it follows.

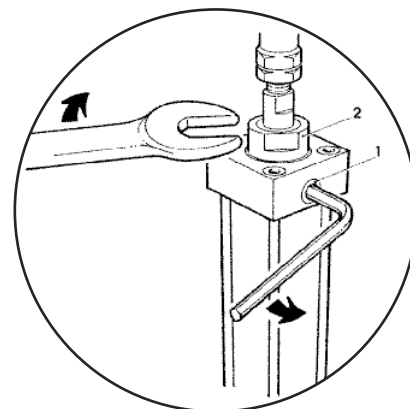


- Loosen the screw 1;
- Turn the ring nut 2 clockwise ;
- Tighten the screw 1.

Note: for additional informations check the documentation of the manufacturer attached to the present manual.

Do this operation on both cylinders.

Reset the machine for normal operation and re-check.



LIST OF THE MAINTENANCE OPERATIONS CARRIED OUT ON THE MACHINE

[illegible]

14-ADDITIONAL INSTRUCTIONS

14.1 INSTRUCTIONS FOR SCRAPPING AND DISPOSAL OF THE MACHINE

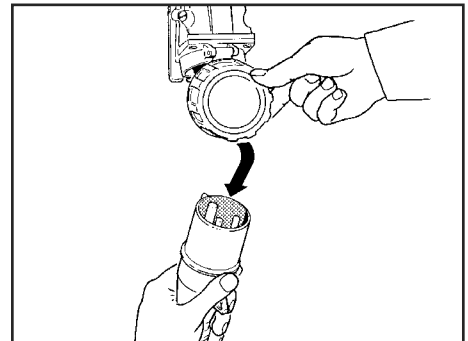
The machine is made of the following materials:

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

In order to dispose of the above materials please comply with the law in force in your country.

14.2 INSTRUCTIONS ON EMERGENCY SITUATIONS

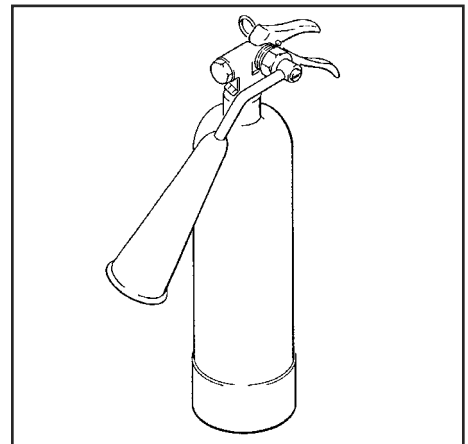
In case of danger/fire:
disconnect the electric power.



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 EEC 98/37, 91/368, 93/44 and 93/68.

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



SM446/650/HD

NASTRATRICE AUTOMATICA
AUTOMATIC CASE SEALING MACHINE
MACHINE ENRUBANNEUSE AUTOMATIQUE
AUTOMATISCHE KARTONVERSCHLIESSMASCHINE
PRECINTADORA AUTOMATICA

PARTI DI RICAMBIO
SPARE PARTS LIST
PIECES DETACHEES
ERSTAZTEILLISTE
RECAMBIOS

SIAT s.p.A. - Via Puecher, 22 - 22078 TURATE (CO) ITALY - P.O. BOX 1
Tel. 02-964951 - Telefax 02-9689727
<http://www.siat.com> - E-Mail: siat@siat.com

| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|-----------|------------|--------------|
| 15742 | Gruppo bancale | | SEB0000979 | SM446/650/HD |

| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|--------------|--|----------|------|
| 1 | SBA0012471 | Bancale assemblato c/ins. SM446-HS | 1 | pz |
| 3 | S471368700A | GAMBA SCORREVOLE FORMATORE ASS F144 SIAT | 4 | pz |
| 6 | S340382600A | PIEDINO 312525 LV.F-100-24-M16 x98 - F | 4 | pz |
| 7 | S450571517Z | GAMBA SCORR.FORMATORE CON RIV. F144/146 | 4 | pz |
| 8 | S300117997A | RIGHELLA MILLIM.F144/145 | 4 | pz |
| 9 | S320085993Z | STAFFA ESTERNA SM/XL/3M | 4 | pz |
| 10 | S321153793A | PIASTRINA FISSAGGIO GAMBA | 4 | pz |
| 11 | S340058493Z | VITE TCEI M8X16 ZINCATA | 26 | pz |
| 12 | S340012393Z | RONDELLA PIANA X VITE M8 ZINC. | 30 | pz |
| 13 | SBA0012473 | Profilo canalina banc. c/ins.SM446-HS | 2 | pz |
| 14 | S340031893Z | VITE TCEI M5X12 ZINCATA | 36 | pz |
| 15 | SBC0020745 | Carter canalina inferiore SM446-HS | 1 | pz |
| 17 | SBC0020748V | Carter dx canalina SM446-HS | 1 | pz |
| 20 | SBA0012472 | Canalina inf. bancale c/ins SM446-HS | 2 | pz |
| 21 | S4510003247A | Carter inferiore bancale c/inserti | 1 | pz |
| 22 | S340057793Z | Vite TCEI M6X16 zincata | 88 | pz |
| 23 | S340017593Z | Rondella piana per vite M6 zincata | 92 | pz |
| 24 | S3210009547A | Piastrina carter inf. bancale | 2 | pz |
| 25 | S320804247A | Staffa per passalamiera SM44 | 1 | pz |
| 26 | S340003393Z | Rondella tripla per vite M6 zincata | 44 | pz |
| 28 | S4510004847A | Canalina c/inserti | 1 | pz |
| 29 | S3210014947A | Coperchio canalina SM44-HD | 1 | pz |
| 30 | S340011293Z | Vite TCEI M5X16 zincata | 4 | pz |
| 31 | S340006193Z | Rondella piana per vite M5 zincata | 56 | pz |
| 32 | S4510005947A | Squadretta fissaggio canalina c/inserti | 2 | pz |
| 34 | SBC00020741V | Coperchio canalina bancale | 1 | pz |
| 35 | S3310004700A | Blocchetto supporto traversa | 2 | pz |
| 36 | S340012293Z | Vite TCEI M8X20 zincata | 24 | pz |
| 37 | S340220592Z | Ranella di safety "S" (Schnorr) /8 F144 | 8 | pz |
| 39 | SBC0019626 | Piastra fermascatoie AS26-HS | 1 | pz |
| 40 | SCB0000588 | Unità lineare DFM-40-50-P-A-GF Festo | 1 | pz |
| 41 | SBC0023339V | SUPPORTO CILINDRO GATE SM446-650-HD | 1 | pz |
| 42 | S340057793Z | VITE TCEI M6X16 ZINCATA | 4 | pz |
| 43 | S340017593Z | RONDELLA PIANA X VITE M6 ZINC. | 4 | pz |
| 44 | SBC0023360T | PIATTO FISSAGGIO MOTORIZZAZIONE | 1 | pz |
| 45 | SBC0023358T | BLOCCHETTO VERT. SUP. MOTORIZZAZIONI | 1 | pz |
| 46 | S340016093Z | VITE TCEI M6X20 | 2 | pz |
| 47 | S340017593Z | RONDELLA M6 | 6 | pz |
| 48 | SBC0023356T | BLOCCHETTO ANTER. SUP. MOTORIZZAZIONE | 1 | pz |
| 49 | SCA0001705 | Carrello THK - HSR-20-C-1SS | 1 | pz |
| 50 | SCA0001840 | ROTAIA GUIDA LINEARE MOD. HSR20-910 LG | 1 | pz |
| 51 | SBC0023349 | PIATTO SUP. TRAVERSA ANT.MOTORIZZAZIONI | 2 | pz |
| 52 | S340196893Z | VITE TCEI M6X30 | 4 | pz |
| 53 | SBC0023348V | TRAVERSA ANTERIORE MOTORIZZAZIONI | 1 | pz |

| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|----------------------|-----------|------------|--------------|
| 15748 | Trav. Scorr. Mot. As | | SEB0000979 | SM446/650/HD |

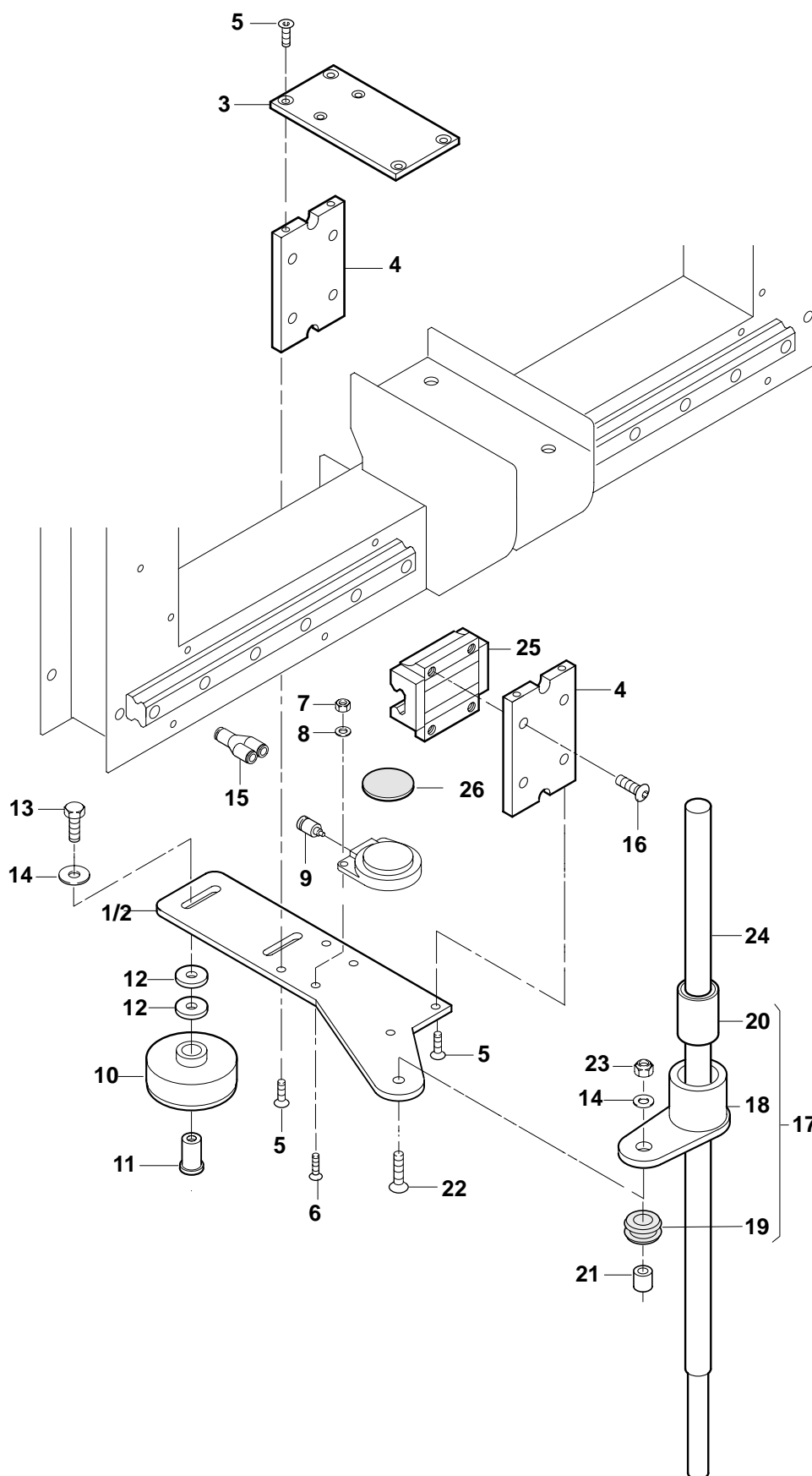
| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|--------------|--|----------|------|
| 1 | SBA0012476 | Traversa guida motorizzazioni c/inserti | 1 | pz |
| 2 | S4710003200A | Pignone 3/8" Z35 c/cuscinetto | 2 | pz |
| 3 | S3310004292A | Pignone Z=35 p=3/8" | 2 | pz |
| 4 | S3400156A | Cuscinetto 6005-2RS1 SKF | 2 | pz |
| 5 | S340019192Z | Anello arresto per foro 47 | 2 | pz |
| 6 | S330491693Z | Rondella /6,5/30X5 | 2 | pz |
| 7 | S340002693Z | Vite TE M6X16 zincata | 10 | pz |
| 8 | SCA0001651 | Rotaia guida lineare mod. HRS30-910LG | 1 | pz |
| 9 | S340004793Z | Vite TCEI M8X30 zincata | 8 | pz |
| 10 | S340028393Z | Dado autobloccante M8 bassp zincato | 14 | pz |
| 11 | S340012393Z | Rondella piana per vite M8 zincata | 26 | pz |
| 12 | SCA0000776 | Pattino guida lineare mod. HRS30LASSG | 2 | pz |
| 13 | S3310004993A | Blocchetto inf. Supporto motorizzazioni | 2 | pz |
| 14 | SBC0015307T | Blocchetto vert. Supp. Motorizz. SM44 | 2 | pz |
| 15 | S340020693Z | Vite TCEI M10X20 zincata | 12 | pz |
| 16 | S4410002147A | Piastra laterale guida mot. c/perno | 2 | pz |
| 17 | S340017593Z | Rondella piana per vite M6 zincata | 92 | pz |
| 18 | S3310004593A | Forcella sinistrorsa | 2 | pz |
| 19 | S3310004493A | Forcella destrorsa | 2 | pz |
| 20 | S3310004393A | Giunto catena | 2 | pz |
| 21 | S330560293Z | Vite tendicatena dx/sx SM4/F-104 | 2 | pz |
| 22 | S340004593Z | Vite TE M5X20 zincata | 4 | pz |
| 23 | S340025993Z | Dado autobloccante M5 zincato | 8 | pz |
| 24 | S340006193Z | Rondella piana per vite M5 zincata | 56 | pz |
| 25 | S3400278ZZZ | Maglia di giunzione P=9,525 | 4 | pz |
| 26 | S3400201ZZZ | Spezzone catena aperto P=3/8" L=65 passi | 2 | pz |
| 27 | S340058493Z | Vite TCEI M8X16 zincata | 26 | pz |
| 28 | SCB0000445 | Flangia oscillante SNCL-40"Festo" | 1 | pz |
| 29 | S3210009747A | Piastra fissaggio cilindro | 1 | pz |
| 30 | S340026793Z | Vite TE M6X30 zincata | 4 | pz |
| 31 | S340211493Z | Dado autobloccante M6 zincato | 4 | pz |
| 32 | S3802289ZZZ | Raccordo gomito 31990813 | 3 | pz |
| 33 | S340101693Z | Testa snodo M12X1,25 zincata | 2 | pz |
| 34 | S3110000900A | Tampone cilindro motorizzazione | 1 | pz |
| 35 | S320145093Z | Rondella speciale /12/45,5X4 | 1 | pz |
| 36 | S340003393Z | Rondella tripla per vite M6 zincata | 52 | pz |
| 37 | S340002193Z | Vite TE M6X12 zincata | 53 | pz |
| 38 | S380611400A | Finecorsa SME-8M-DS-24V-K-0,3-M8D | 6 | pz |
| 39 | SCB0001095 | Cilindro a norma DSBC-40275-PPVA-N3 | 1 | pz |
| 40 | S380606700A | Flangia oscill. SNCB-40 PNEUM. | 2 | pz |

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| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|-----------|------------|--------------|
| 15749 | Pressatori later | | SEB0000979 | SM446/650/HD |

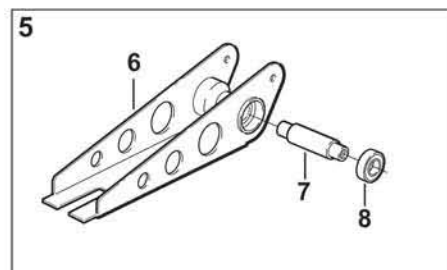
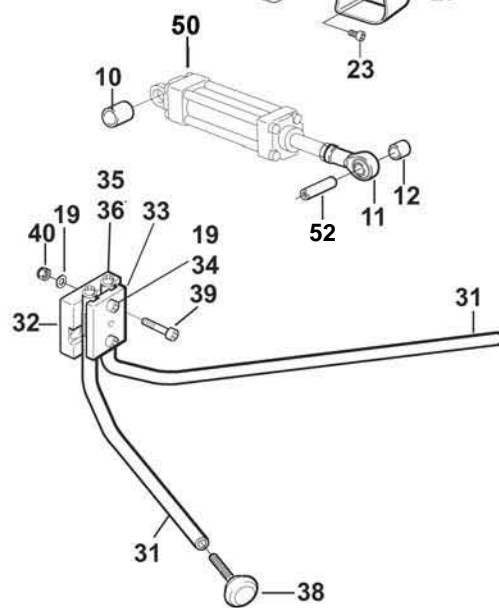
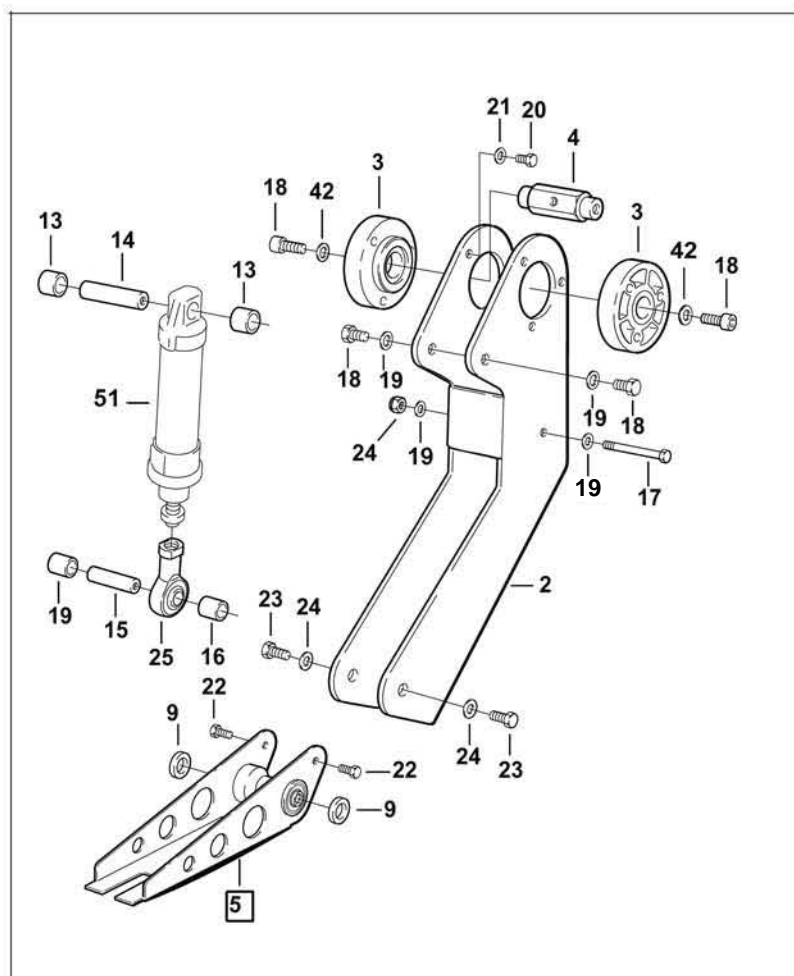
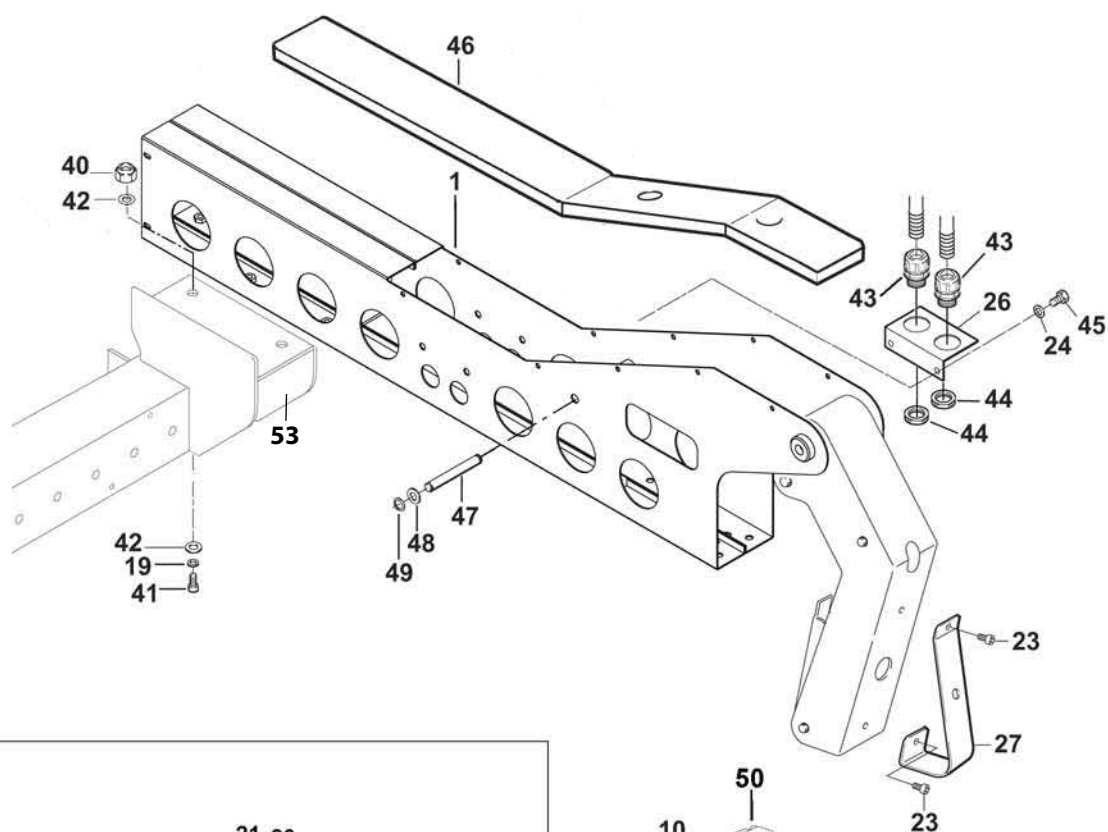
| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|--------------|---|----------|------|
| 1 | S3210014247A | Piastra inf. Dx pressatori laterali | 1 | pz |
| 2 | S3210014347A | Piastra inf. Sx pressatori laterali | 1 | pz |
| 3 | S3210014547A | Piastra sup. pressatori laterali | 2 | pz |
| 4 | S3310004147A | Blocchetto unione piastre | 4 | pz |
| 5 | S340005393Z | Vite TSVEI M6X16 zincata | 16 | pz |
| 6 | S340040393Z | Vite TSVEI M5X16 zincata | 8 | pz |
| 7 | S340002393Z | Dado M5 zincato | 20 | pz |
| 8 | S340006193Z | Rondella piana per vite M5 zincata | 56 | pz |
| 9 | SCB0000415 | Raccordo QSM-M3-4-I "Festo" | 4 | pz |
| 10 | S310175300A | Pressatore laterale SM8-P 120a | 4 | pz |
| 11 | S350207593Z | Perno per rulli pressatori 700A | 4 | pz |
| 12 | S330535393Z | Rondella /8,5X25X4 | 16 | pz |
| 13 | S340028093Z | Vite TE M8X20 zincata | 8 | pz |
| 14 | S340065593Z | Rondella tripla per vite M8 zincata | 12 | pz |
| 15 | S3801683ZZZ | Raccordo Y LEGRIS31400600 | 2 | pz |
| 16 | S340507793A | Vite TBEI M8X20 zincata | | pz |
| 17 | S4310000100A | Biella c/cuscinetto e ammortizz. | 2 | pz |
| 18 | S4410002747A | Biella Ass. | 2 | pz |
| 19 | SCA0000861 | Passacavo in gomma serie "EZ" 15089 | 4 | pz |
| 20 | G15320201ZZ | Manicotto a sfere 0670-220-40 | 2 | pz |
| 21 | S3310005193A | Bussola per ammortizzatore | 2 | pz |
| 22 | S340017293Z | Vite TSVEI M8X30 zincata | | pz |
| 23 | S340028393Z | Dado autobloccante M8 basso zincato | 14 | pz |
| 24 | SBC0016029 | Asta guida pressatori SM44-HS | 2 | pz |
| 25 | SCA0000769 | Pattino per guida lineare MOD.HRS25ASSG | 6 | pz |
| 26 | S4210000000A | Piastra di bloccaggio c/tampone | 4 | pz |

20/05/2013



| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|-----------|------------|--------------|
| 15750 | Chiudifalda pos | | SBA0014354 | SM446/650/HD |

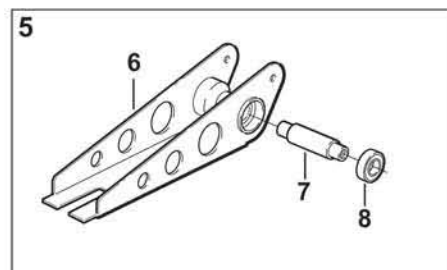
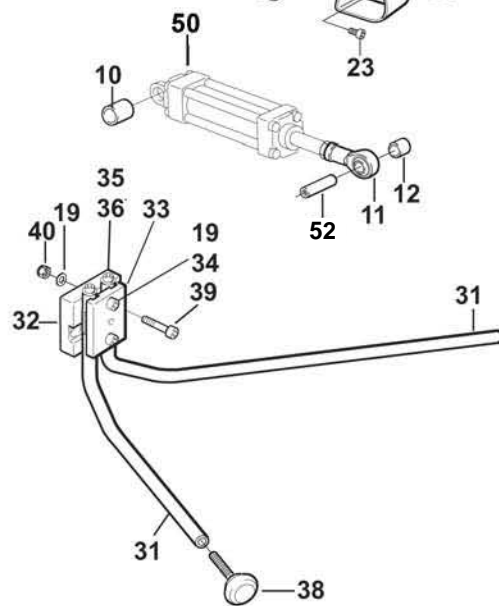
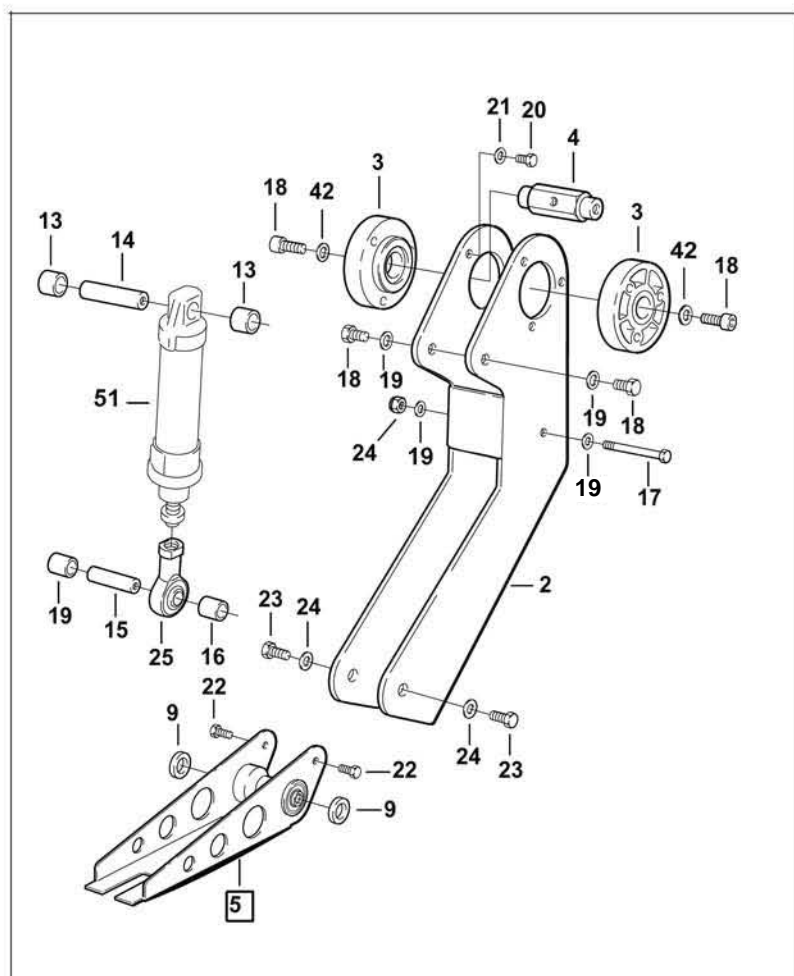
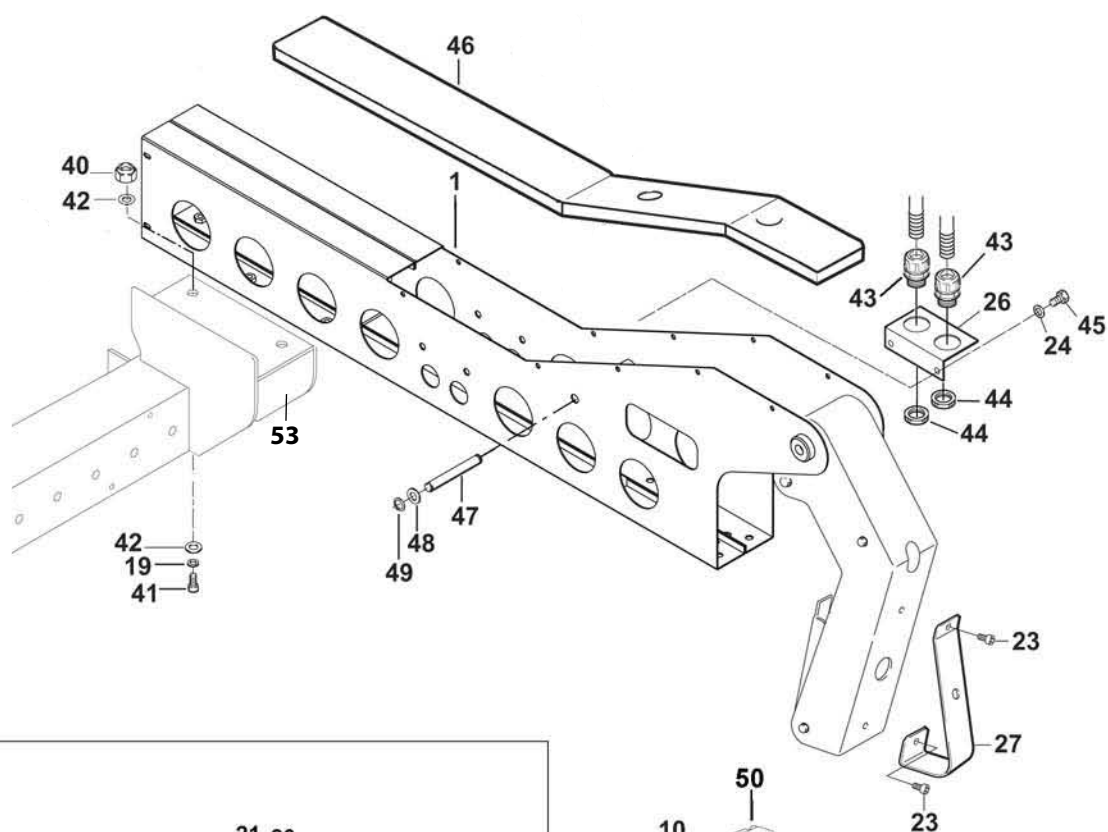
| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|--------------|---|----------|------|
| 1 | SBA0012493 | Supporto chiudifalde sup. c/ins. | 1 | pz |
| 2 | SBA0012393 | Braccio chiudifalde ass. c/ins. | 1 | pz |
| 3 | S4304333ZZZ | FLANGIA FULL DI BEARING E DADI 800a/3M | 2 | pz |
| 4 | S332244492A | Perno braccio chiudifalde sup. | 1 | pz |
| 5 | S471228100A | Chiudifalda post. Ass. Mod. 19900 | 1 | pz |
| 6 | S440741517A | Chiudifalda ass. vern. | 1 | pz |
| 7 | S332243492A | Perno chiudifalda post. Mod. 19 | 1 | pz |
| 8 | S3400166ZZZ | Cuscinetto 6001 2RS | 2 | pz |
| 9 | S332243592A | DIST CHIUDIF POST. SM116-800RF-S 19900 | 6 | pz |
| 10 | S332304093A | Dist. X cerniera cil. Chiudifalde 19900 | 1 | pz |
| 11 | S340114593A | Testa a snodo M16X1,5 c/dado | 1 | pz |
| 12 | S332244892A | Distanziale per testa a snodo /16 19900 brun. | | pz |
| 13 | S350121893Z | Distanziale cilindro braccio XL336 | | pz |
| 14 | S350098493Z | DISTANZIALE FORATO XL336 | 1 | pz |
| 15 | S332243692A | PERNO ATTACCO CIL.CHIUDIF 800rf-s/3M MOD | 1 | pz |
| 16 | S332243792A | DIST. PERNO ATTACCO CIL.SM116 800rf-s/3M | 2 | pz |
| 17 | S340224593Z | Vite TCEI M5X65 zincata | | pz |
| 18 | S340028093Z | Vite TE M8X20 zincata | 8 | pz |
| 19 | S340012393Z | Rondella piana per vite M8 zincata | 30 | pz |
| 20 | S330787693Z | Vite TE M6X16 spec. | 2 | pz |
| 21 | S340000693Z | Rondella dentellata per vite M6 | | pz |
| 22 | S330535693Z | Vite TE M6X12 spec. | 40 | pz |
| 23 | S340002193Z | Vite TE M6X12 zincata | 53 | pz |
| 24 | S340017593Z | Rondella piana per vite M6 zincata | 92 | pz |
| 25 | S340101093Z | TESTA A SNODO M10X1,25 ZINCATA | 1 | pz |
| 26 | S3210014447A | Squadretta per molla a bandella | 1 | pz |
| 27 | S320157784B | Prolunga chiudifalda post. SM44 | 1 | pz |
| 31 | S332248993A | Chiudifalde laterali Mod.19900 zinc. | 2 | pz |
| 32 | S332352492A | Blocchetto fix chiudifalde | | pz |
| 33 | S332352593A | Morsetto fix chiudifalde | 1 | pz |
| 34 | S340004793Z | Vite TCEI M8X30 zincata | 8 | pz |
| 35 | S340005193Z | Vite TCEI M6X12 zincata | 2 | pz |
| 36 | S340003393Z | Rondella tripla per vite M6 zincata | 52 | pz |
| 38 | S3100884ZZZ | PROTEZIONE ASTA 12AF-SM116 | 2 | pz |
| 39 | S340299793Z | Vite TCEI M8X100 zincata 120af | | pz |
| 40 | S340028393Z | Dado autobloccante M8 basso zincato | 14 | pz |
| 41 | S340048693Z | Vite TCEI M8X25 zincata | 2 | pz |
| 42 | S340006393Z | Rondella elastica diam. 8 | 16 | pz |
| 43 | SCC0001412 | Raccordo dritto PA6 NW23 M32-B | 8 | pz |
| 44 | SCC0001413 | Controdado PAM32 P68032 | 8 | pz |
| 45 | S340057793Z | Vite TCEI M6X16 zincata | 88 | pz |
| 46 | SBA0012494 | Carter superiore chiudifalde c/ins. | 1 | pz |



| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|-----------|------------|--------------|
| 15750 | Chiudifalda p | | SBA0014354 | SM446/650/HD |

| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|-------------|---|----------|------|
| 47 | SBC0020561T | Perno cilindro chiudifalda SM446-HS | 1 | pz |
| 48 | S340006293Z | Rondella piana per vite M12 zincata | | pz |
| 49 | S340094592Z | Anello di sicurezza 8 DIN 6799 | 4 | pz |
| 50 | SBA0014355 | Cilindro chiudifalde 1 ass. "Festo" | 1 | pz |
| 51 | SBA0014357 | Cilindro chiudifalde 2 ass. "Festo" | 1 | pz |
| 52 | S332244792A | PERNO ATTACCO CIL ARM 800rf-s/3M MOD.19 | 1 | pz |
| 53 | SBA0014323 | Traversa sup. chiudifalda c/ins. | 1 | pz |

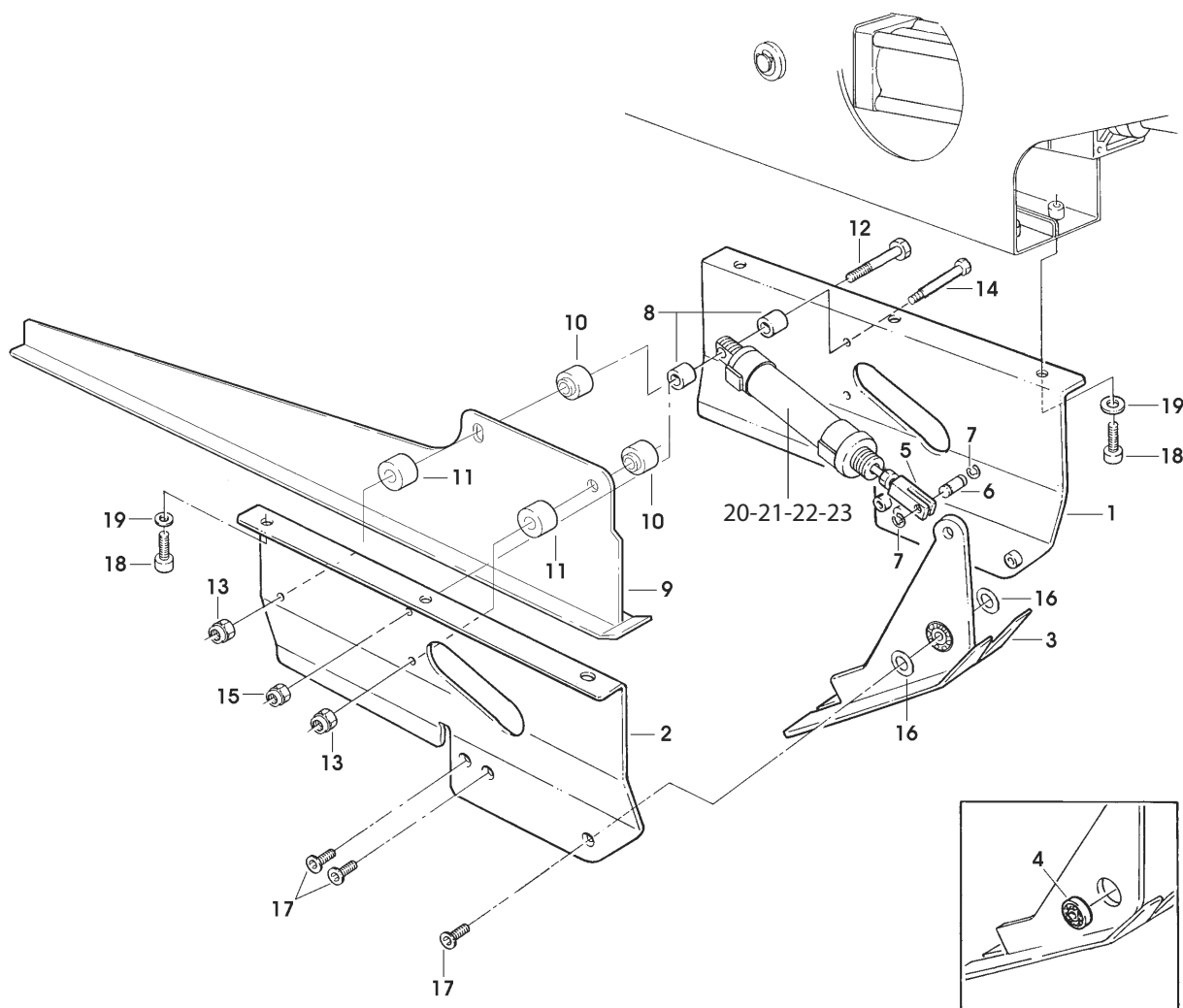
21/05/2013



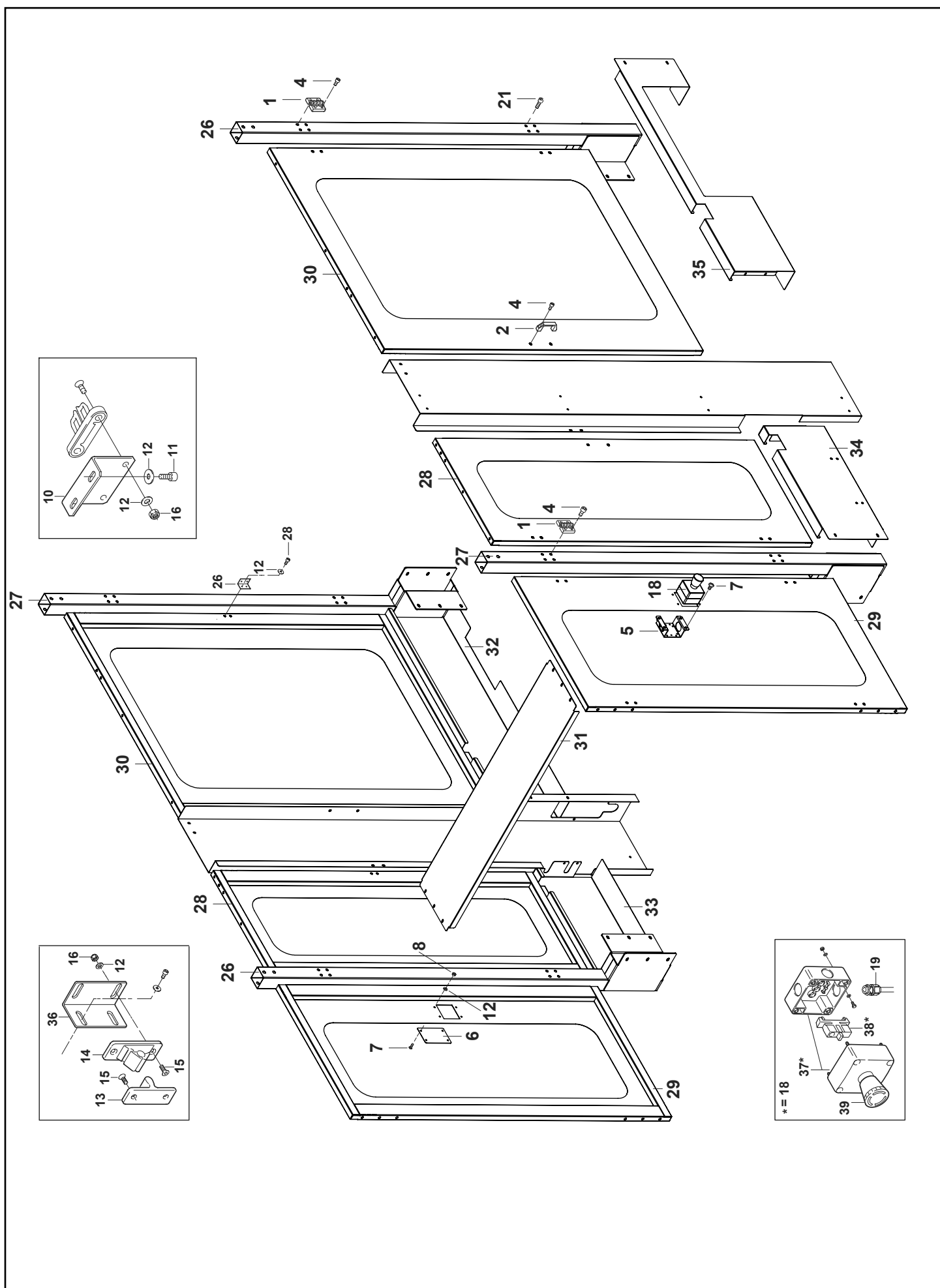
| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|-----------|----------|--------------|
| 15751 | Posiz. Altezza | | | SM446/650/HD |

| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|-------------|--|----------|------|
| 1 | S440743084A | SEMICORPO DX SUPP C/SCAT.800rf-s/3 BRIL | 1 | pz |
| 2 | S320954384A | SUPP GUIDA SCATOLE SX 800rf-s/3M BRILL. | 1 | pz |
| 3 | S450542798Z | POSIZ ALTEZ CON BEARING 800rf-s/3M 19900 | 1 | pz |
| 4 | S3401147ZZZ | CUSCINETTO 618/9 9/17x4 | 1 | pz |
| 5 | S331035493Z | forcella x cil. Sm44/plc | 1 | pz |
| 6 | S330789293Z | perno x forcella 6/14 sm44 zinc. | 1 | pz |
| 7 | S340083992Z | anello arresto 4 din 6799 br. | 2 | pz |
| 8 | S330789493Z | dist. X cil./16 sm44 zinc. | 2 | pz |
| 9 | S440742284A | GUIDASCATOLE ASS. 800rf-s/3M BRILLANTAT | 1 | pz |
| 10 | S330758593Z | dist. X rib. Guida SM44 zinc. | 2 | pz |
| 11 | S330758493Z | dist. X guida SM44 zinc. | 2 | pz |
| 12 | S340064893Z | vite TE M6x40 zinc. | 2 | pz |
| 13 | S340025893Z | dado autoblocc. Basso M6 | 2 | pz |
| 14 | S331125493Z | vite spec. M5 x SM44/800 rf | 1 | pz |
| 15 | S340025993Z | dado autoblocc. M5 zinc. | 1 | pz |
| 16 | S320812498A | rondella per cusc. pos. 800rf\3m mod.39800 | 2 | pz |
| 17 | S340002893Z | vite TSVCR M4x8 zinc. | 3 | pz |
| 18 | S340057793Z | vite TCEI M6x16 zinc. | 6 | pz |
| 19 | S340017593Z | rondella piana x vite M6 zinc. | 6 | pz |
| 20 | S3802292ZZZ | cilindro DSNV 16-50-PPV-A | 1 | pz |
| 21 | SCB0000419 | kit di fissaggio SM BR | 1 | pz |
| 22 | S380611400A | finecorsa SME | 1 | pz |
| 23 | S47112300A | scarico rapido | 1 | pz |

21/05/2013

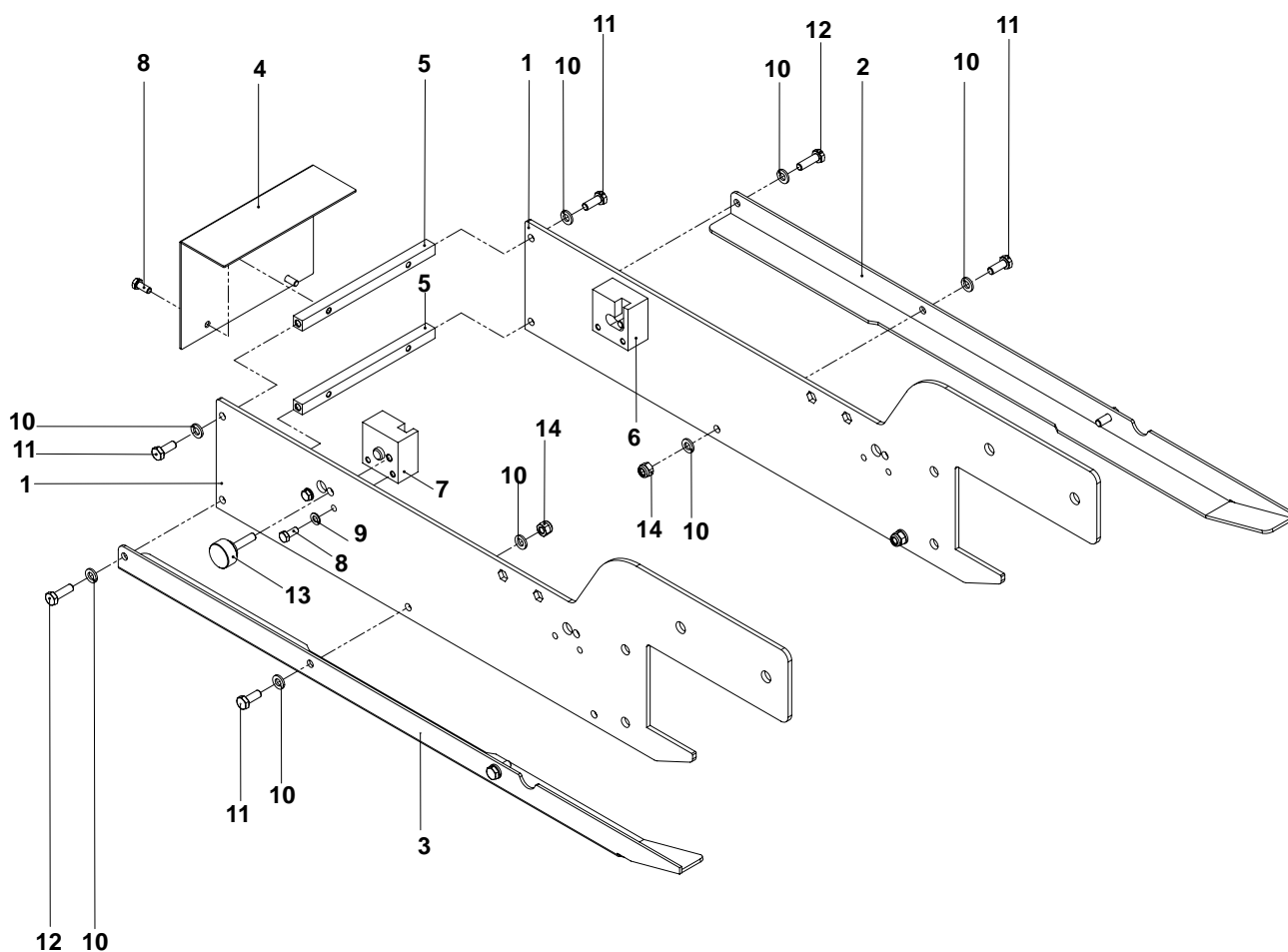


| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|-----------|--------------------|--|----------|--------------|
| 15752 | Gruppo protezioni | | | SM446/650/HD |
| Posizione | Ricambio | Descrizione | Quantità | U.M. |
| 1 | S340398000A | Cern. Elesa CFA.65 CH-6 Cod. 422232 SM | 8 | pz |
| 2 | S3801095ZZZ | Maniglia M443/110 | 2 | pz |
| 3 | S340003393Z | Rondella tripla x vite M6 zincata | 32 | pz |
| 4 | S340057793Z | Vite TCEI M6X16 zincata | 52 | pz |
| 5 | S450480817Z | Supporto int. c/ins. HM11-T | 1 | pz |
| 6 | S320580617A | Piastrina di chiusura HM11_t | 3 | pz |
| 7 | S340072093Z | Vite testa mezza tonda M5X12 croce zinc. | 12 | pz |
| 8 | S340002393Z | Dado M5 zincato | 12 | pz |
| 9 | S340006193Z | Rondella piana x vite M5 zincata | 12 | pz |
| 10 | S3210011247A | Squadretta interruttore di sic. | 2 | pz |
| 11 | S340031893Z | Vite TCEI M5X12 zincata | 16 | pz |
| 12 | S340006193Z | Rondella piana x vite M5 zincata | 16 | pz |
| 13 | S3401707ZZZ | Aggancio x blocco a scatto T330 | 2 | pz |
| 14 | S3401601ZZZ | Blocco a scatto spec. F144 | 2 | pz |
| 15 | S340051693Z | Vite TSVEI M5X12 zincata | 8 | pz |
| 16 | S340025993Z | Dado autobloccante M5 zincato | 4 | pz |
| 17 | S340006193Z | Rondella piana x vite M5 zincata | 4 | pz |
| 18 | S471168900A | Pulsante emergenza ass. SM/XL "Siemens" | 1 | pz |
| 19 | S3802139ZZZ | Bocchettone Skintop ST11 | 1 | pz |
| 20 | S3802144ZZZ | Controdado GMP13,5 | 1 | pz |
| 21 | S340012293Z | Vite TCEI M8X20 zincata | 16 | pz |
| 22 | S340006393Z | Rondella elastica Diam. 8 | 16 | pz |
| 23 | S340057793Z | Vite TCEI M6X16 zincata | 8 | pz |
| 24 | S340003393Z | Rondella tripla x vite M6 zincata | 8 | pz |
| 25 | SBC0007078V | Cerniera fissa | 4 | pz |
| 26 | SBA0012426V | Montante protezioni dx ass. SM446-HS | 2 | pz |
| 27 | SBA0012427V | Montante protezioni sx ass. SM446-HS | 2 | pz |
| 28 | SBA0012463 | Sportello L=552 assemblato SM446-HS | 2 | pz |
| 29 | SBA0012467 | Pannello fisso L=700 ass. SM446-HS | 2 | pz |
| 30 | SBA0012465 | Sportello L=1080 assemblato SM446-HS | 2 | pz |
| 31 | SBC0020749V | Unione pannelli fissi SM446-HS | 1 | pz |
| 32 | SBC0020775V | Carter copertura anteriore dx | 1 | pz |
| 33 | SBC0020777V | Carter copertura posteriore dx | 1 | pz |
| 34 | SBC0020778V | Carter copertura posteriore sx | 1 | pz |
| 35 | SBC0020780V | Carter copertura anteriore sx | 1 | pz |
| 36 | S3210011547A | Squadretta fissaggio blocco a scatto | 2 | pz |
| 37 | S3805196ZZZ | Scatola gialla 3SB3801-0AC | 1 | pz |
| 38 | S3805197ZZZ | Contatto NC 3SB3420-0C | 1 | pz |
| 39 | S3805198ZZZ | Pulsante emerg. 3SB3000-1HA20 | 1 | pz |



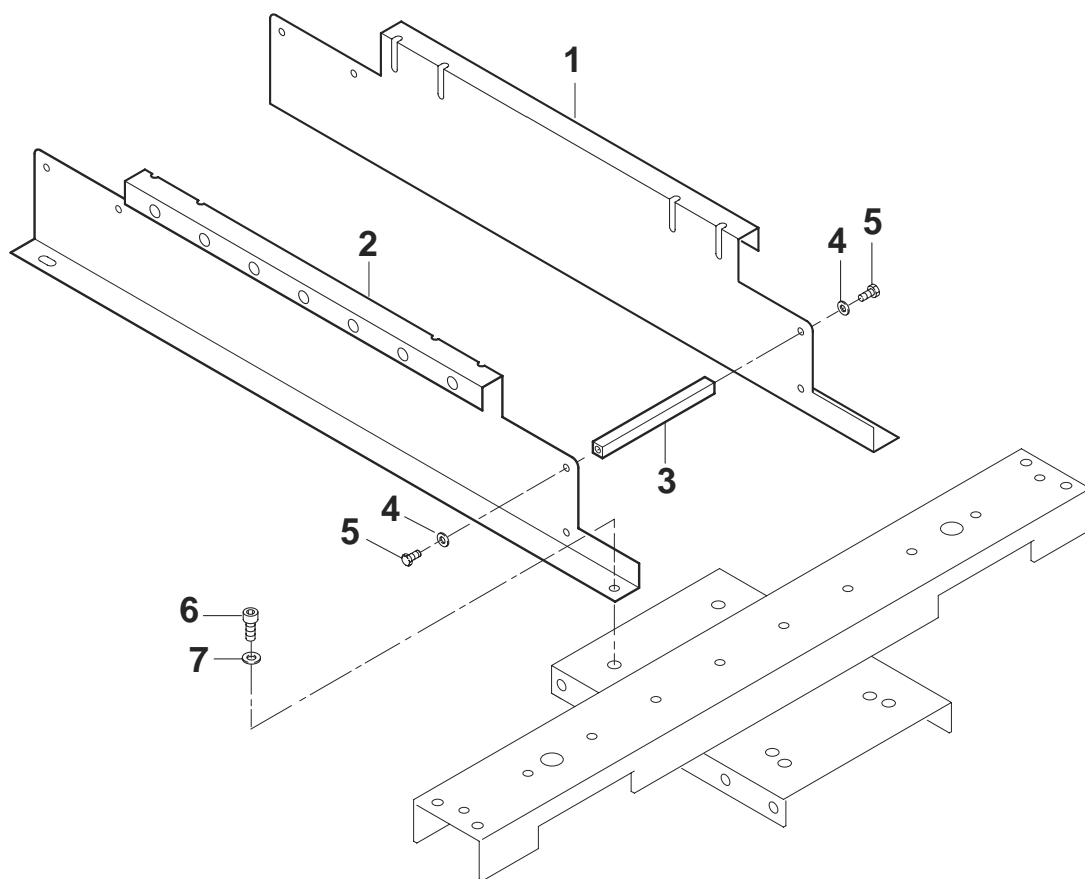
| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|----------------------|-----------|----------|--------------|
| 15753 | Gr. porta unità sup. | | | SM446/650/HD |

| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|-------------|---|----------|------|
| 1 | SBC20638V | Spalla porta unità sup. | 2 | pz |
| 2 | SBC00020641 | Scivolo destro porta unità sup. | 1 | pz |
| 3 | SBC00020642 | Scivolo sinistro porta unità sup. | 1 | pz |
| 4 | SBC0014869V | Carter spalla porta unità | 1 | pz |
| 5 | S330892993Z | Distanziale 10X10X150 | 2 | pz |
| 6 | S332586695A | Bloc. Destro fissaggio K13 Top - 120af-3M | 2 | pz |
| 7 | S332586795A | Bloc. sinistro fissaggio K13 Top - 120af-3M | 2 | pz |
| 8 | S340037193Z | Vite TE M5X12 zincata | 8 | pz |
| 9 | S340006193Z | Rondella piana x vite M5 zincata | 56 | pz |
| 10 | S340017593Z | Rondella piana x vite M6 zincata | 92 | pz |
| 11 | S340002693Z | Vite TE M6X16 zincata | 10 | pz |
| 12 | S340005793Z | Vite TE M6X20 zincata | | pz |
| 13 | S3403407ZZZ | Manopola zigrinata B. 193/20 P-M6X25 | 1 | pz |
| 14 | S340211493Z | Dado autobloccante M6 zincato | 4 | pz |

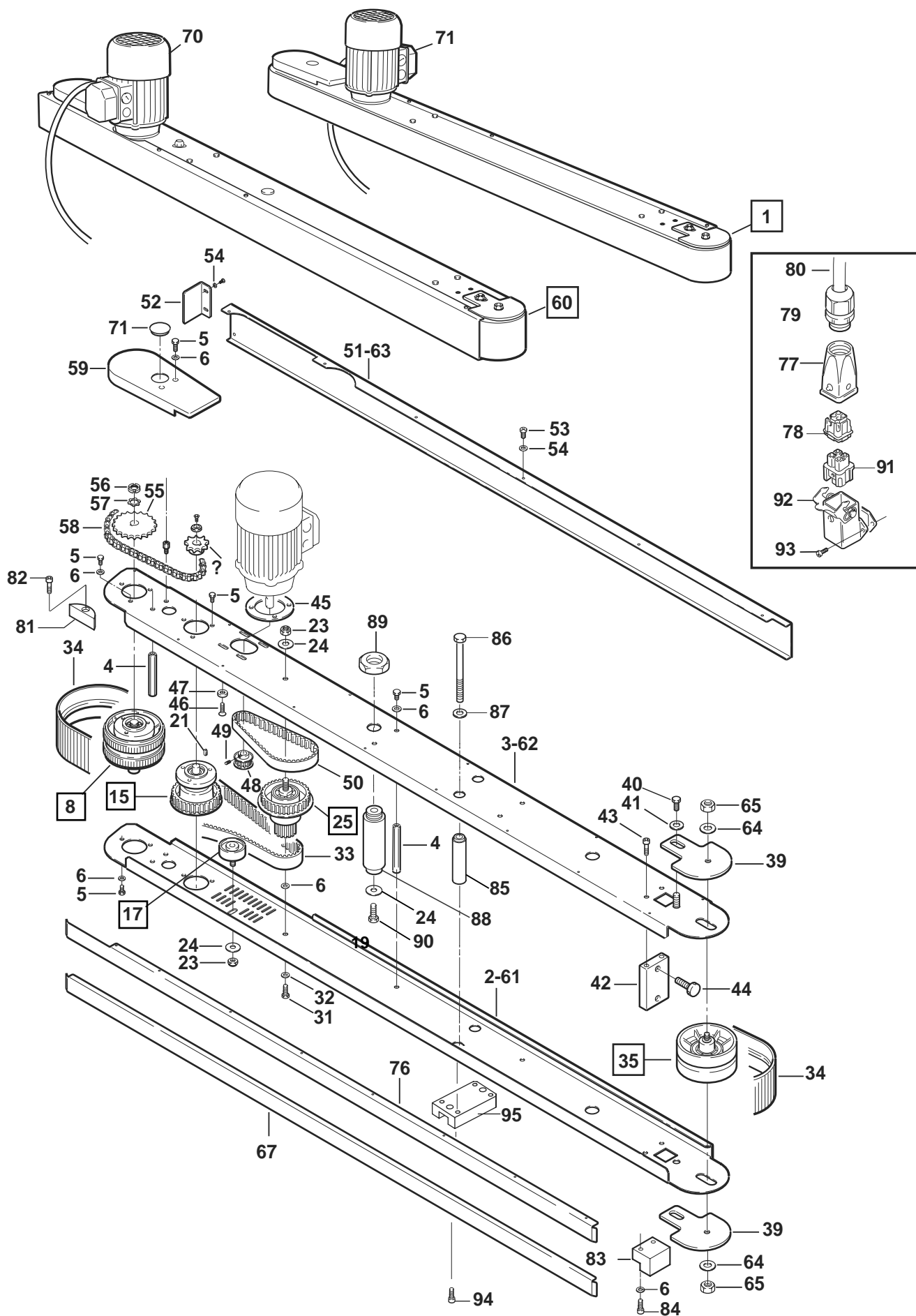


| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|----------------------|-----------|----------|--------------|
| 15754 | Gr. porta unità inf. | | | SM446/650/HD |

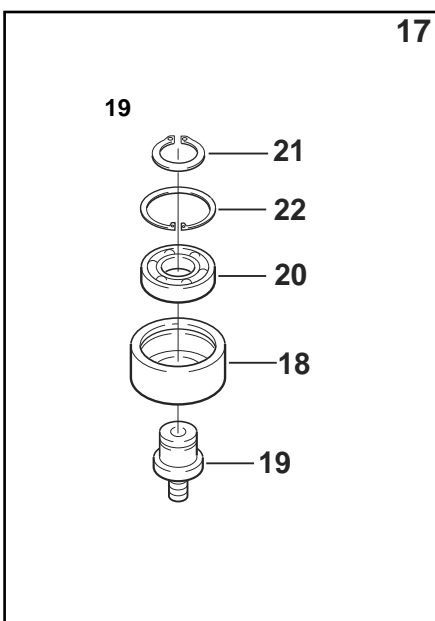
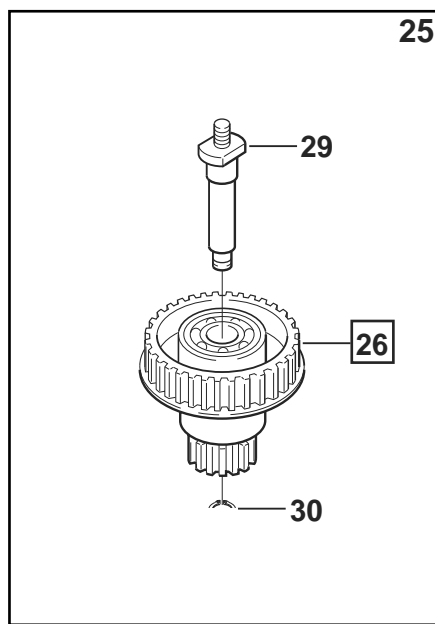
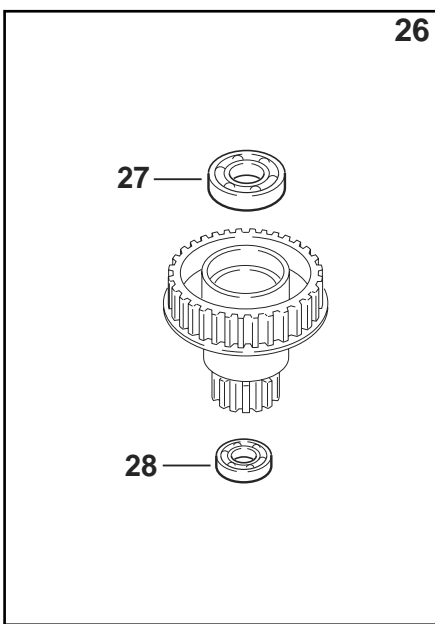
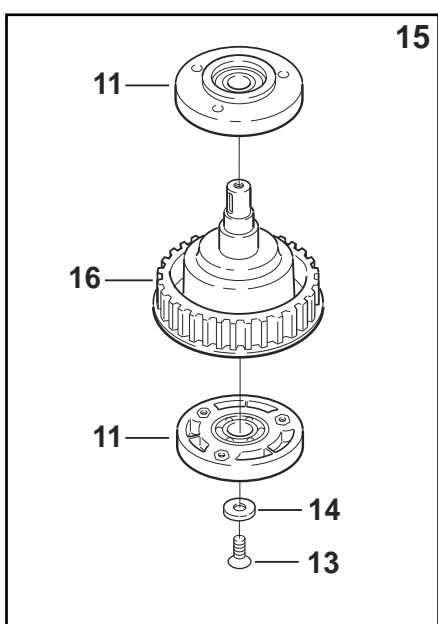
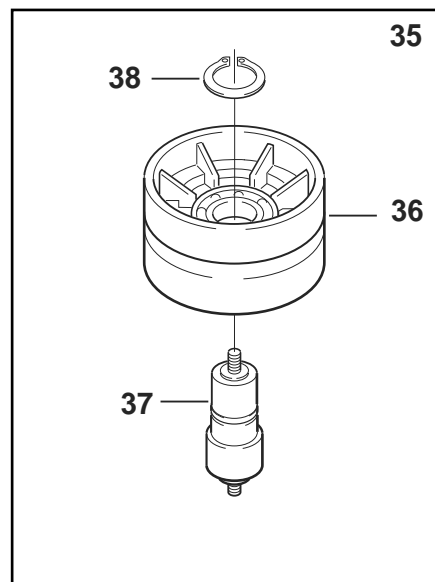
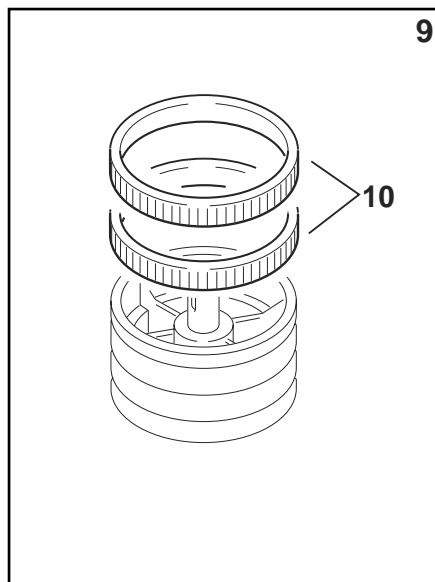
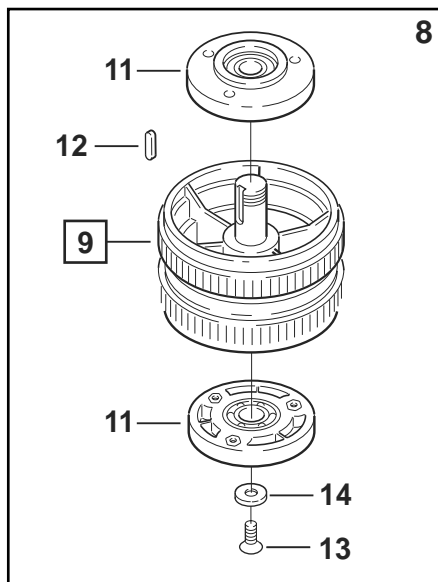
| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|-------------|--------------------------------------|----------|------|
| 1 | SBA0012478 | Spalla dx porta unità inf. c/inserti | 1 | pz |
| 2 | SBA0012479 | Spalla sx porta unità inf. c/inserti | 1 | pz |
| 3 | S330628493Z | Distanziale 12X12X140 SM11 zincato | 3 | pz |
| 4 | S340002193Z | Vite TE M6X12 zincata | 53 | pz |
| 5 | S340017593Z | Rondella piana per vite M6 zincata | 92 | pz |
| 6 | S340058493Z | Vite TCEI M8X16 zincata | 26 | pz |
| 7 | S340012393Z | Rondella piana per vite M8 zincata | 30 | pz |



| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|-----------|--------------------|---|----------|--------------|
| 15755 | Gruppo motorizz. | | | SM446/650/HD |
| Posizione | Ricambio | Descrizione | Quantità | U.M. |
| 1 | SBA0012480 | Motorizz. Dx 220/240-380/415V 50 HZ | 1 | pz |
| 2 | SBA0012482 | Guida sup. dx motorizz. c/inserti | 1 | pz |
| 3 | SBA0012483 | Guida inf. dx motorizz. c/inserti | 1 | pz |
| 4 | s330596093Z | Distanziale es. 10X81 zincato | 16 | pz |
| 5 | S340002193Z | Vite TE M6X12 zincata | 53 | pz |
| 6 | S340017593Z | Rondella piana x vite M6 zincata | 92 | pz |
| 7 | S331092092Z | Pignone 3/8" Z=13 x motorizz. SM11XL | 2 | pz |
| 8 | SBA0001152 | Puleggia motrice post. ass. | 2 | pz |
| 9 | SBA0001154 | Puleggia motrice ass. c/anelli | 2 | pz |
| 10 | S310054048Z | Anello x puleggia | 4 | pz |
| 11 | S4603370ZZZ | Flangia compl. di cuscinetto e dadi | 8 | pz |
| 12 | S3400281ZZZ | Linguetta 5X5X12 | 6 | pz |
| 13 | S340051693Z | Vite TSVEI M5X12 zincata | 24 | pz |
| 14 | S330595193Z | Rondella 5,5X/20X4 | 6 | pz |
| 15 | SBA0001151 | Puleggia motrice dentata ass. | 2 | pz |
| 16 | S460425600A | Puleggia PD30-L075F ass. | 2 | pz |
| 17 | S470405100A | Galoppino ass. 12AF XL | 2 | pz |
| 18 | S330906792Z | Galoppino tendicinghia | 2 | pz |
| 19 | S330906892Z | Perno per galoppino | 2 | pz |
| 20 | S3400017ZZZ | Cuscinetto 6004 2RS NTN SKF | 2 | pz |
| 21 | S340006892Z | Anello arresto per albero 20 brunito | 2 | pz |
| 22 | S340044592Z | Anello arresto per foro 42 brunito | 2 | pz |
| 23 | S340028393Z | Dado autobloccante M8 basso zincato | 14 | pz |
| 24 | S340065593Z | Rondella tripla x vite M8 zincata | 12 | pz |
| 25 | S470405200A | Puleggia doppia ass. | 2 | pz |
| 26 | S4503371ZZZ | Puleggia di rinvio SM11 | 2 | pz |
| 27 | S3400193ZZZ | Cuscinetto 6000 2RS | 2 | pz |
| 28 | S3400095A | Cuscinetto 6203 2RS | 2 | pz |
| 29 | S330596292Z | Perno x puleggia rinvio | 2 | pz |
| 30 | S340018792Z | Anello arresto 10 DIN 471 brunito | 2 | pz |
| 31 | S340002693Z | Vite TE M6X16 zincata | 10 | pz |
| 32 | S340003393Z | Rondella tripla x vite M6 zincata | 52 | pz |
| 33 | S3402679ZZZ | Cinghia dentata 240L075 | 2 | pz |
| 34 | SCA0001654 | Cinghia trascinamento anello ch. 75x4010+-3.5 | 2 | pz |
| 35 | S470405300A | Puleggia folle ass. | 2 | pz |
| 36 | S4601730ZZZ | Puleggia folle comp. | 2 | pz |
| 37 | S330596492B | Perno puleggia folle brunito SM | 2 | pz |
| 38 | S340010492Z | Anello arresto x albero /25 brunito | 2 | pz |
| 39 | S320428047Z | Piastra tendicinghia motorizz. SM | 4 | pz |
| 40 | S340059693Z | Vite TE M10X25 zincata | 4 | pz |
| 41 | S340107693Z | Rondella tripla x vite M10 zincata | 4 | pz |
| 42 | S3311650ZZZ | Blocchetto x motorizz. F144 | 2 | pz |
| 43 | S340016093Z | Vite TCEI M6X20 zincata | 8 | pz |

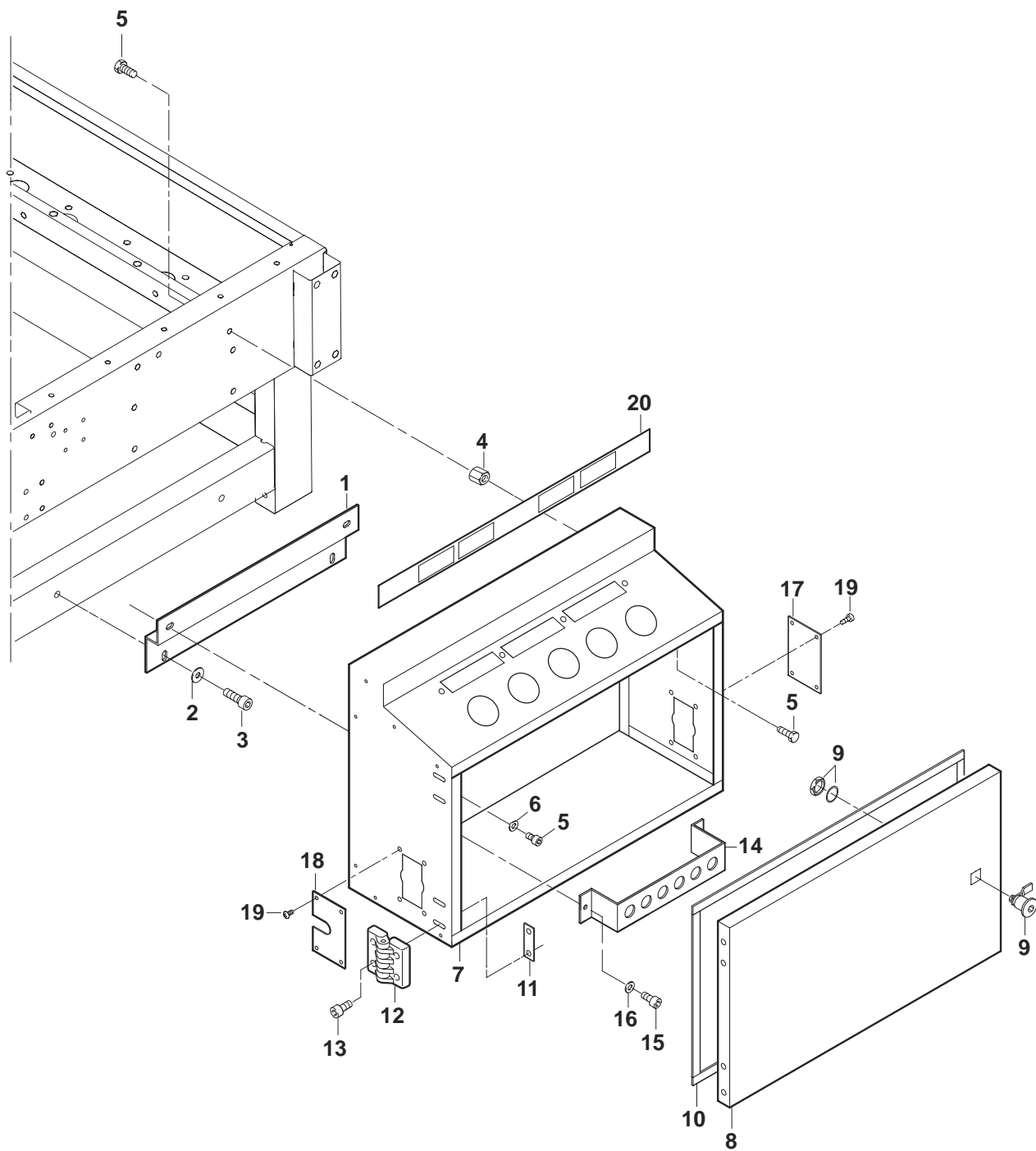


| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|-----------|--------------------|---|----------|--------------|
| 15755 | Gruppo motorizz. | | | SM446/650/HD |
| Posizione | Ricambio | Descrizione | Quantità | U.M. |
| 44 | S331163893Z | Vite spec. x tensionamento | 4 | pz |
| 45 | S3101491ZZZ | Distanziale x motori SM/XL/3M | 2 | pz |
| 46 | S340005593Z | Vite TSVEI M5X20 zincata | 8 | pz |
| 47 | S350050693Z | Rondella fissaggio motori | 8 | pz |
| 48 | S330962392Z | (C) Puleggia dentata 20XL050 brunita | 1 | pz |
| 49 | S340038892Z | Grano EIPP M5X6 brunito | 2 | pz |
| 50 | S3401593ZZZ | Cinghia dentata 160XL050 | 2 | pz |
| 51 | SBA0012484 | Carter motorizz. dx c/inserti | 1 | pz |
| 52 | S321628440A | Protezione pos. motorizzazioni | 2 | pz |
| 53 | S340037193Z | Vite TE M5X12 zincata | 8 | pz |
| 54 | S340006193Z | Rondella piana x vite M5 zincata | 56 | pz |
| 55 | S330655192Z | Pignone P=3/8" Z=28 SM brunito | 2 | pz |
| 56 | S3400094ZZZ | Ghiera KM2 | 2 | pz |
| 57 | S3400913ZZZ | Rosette di sicurezza MB2 | 2 | pz |
| 58 | S3401851ZZZ | Cat. Ring. Chiuso 3/8" 52 passi comp. Giun. | 2 | pz |
| 59 | S310068905Z | Carter catena | 2 | pz |
| 60 | SBA0012481 | Motorizz. Sx 220/240-380/415V 50HZ | 1 | pz |
| 61 | SBA0012488 | Guida inf. Sx motorizz. c/inserti | 1 | pz |
| 62 | SBA0012486 | Guida sup. sx motorizz. c/inserti | 1 | pz |
| 63 | SBA0012489 | Carter motorizz. Sx c/inserti | 1 | pz |
| 64 | S340012393Z | Rondella piana x vite M8 zincata | 30 | pz |
| 65 | S340000393Z | Dado M8 zincato | 4 | pz |
| 66 | SBC0020714 | Scivole sup. dx motorizz. SM446-HS | 1 | pz |
| 67 | SBC0020719 | Scivolo inf. Motorizz. SM446-HS | 3 | pz |
| 70 | S3803441ZZZ | MOT H63A4 220V/240V 380/415V 50H 0.13KW | 2 | pz |
| 71 | SCA0000213 | Tappo in plastica serie "Heyco" | 2 | pz |
| 76 | SBC0020769 | Scivolo sup. sx motorizzazioni | 1 | pz |
| 77 | S3801458ZZZ | Custodia vol. uscita verti. PG11 105121 | 4 | pz |
| 78 | S3801455ZZZ | Inserto maschio 4 POLI 3P+T | 2 | pz |
| 79 | S3802139ZZZ | Bocchettone skintop ST11 | 9 | pz |
| 80 | SCC0000518 | CAVO OLFLEX-CLASSIC 400 P 4G1.5 MMQ | 1 | m/l |
| 81 | SBC0003252 | Tendicinghia set aumento velocità | 2 | pz |
| 82 | S340014193Z | Vite TCEI M5X25 zincata | 4 | pz |
| 83 | S3110001100A | Pattino scorrimento motorizzazioni SM44 | 2 | pz |
| 84 | S340002093Z | Vite TCEI M6X30 zincata | 4 | pz |
| 85 | S3310004693A | Distanziale fissaggio motorizzazioni | 4 | pz |
| 86 | S340206393Z | Vite TE M10X110 | | pz |
| 87 | S330039593Z | Rondella /10,5/26X4 zincata | | pz |
| 88 | S330748593Z | Cannotto filettato SM44/12RF | 2 | pz |
| 89 | S331121093Z | DADO SPEC FIL./22X1,5 H=8 SM44/SM44-PLC/ | 2 | pz |
| 90 | S340032493Z | Vite TE M8X16 zincata | | pz |
| 91 | S3801456ZZZ | Inserto femmina 3P+T | 2 | pz |
| 92 | S3801459ZZZ | Custodia pannello con uscita lat. 104235 | 2 | pz |
| 93 | S340179393Z | Vite TCBRC M4X12 zincata | 12 | pz |
| 94 | SBC00016032T | Blocchetto fissaggio motorizz. | 2 | pz |
| 95 | S340001593Z | Vite TCEI M6X25 zincata | | pz |



| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|-----------------------|-----------|----------|--------------|
| 15756 | Gr. Cass. imp. Pneum. | | | SM446/650/HD |

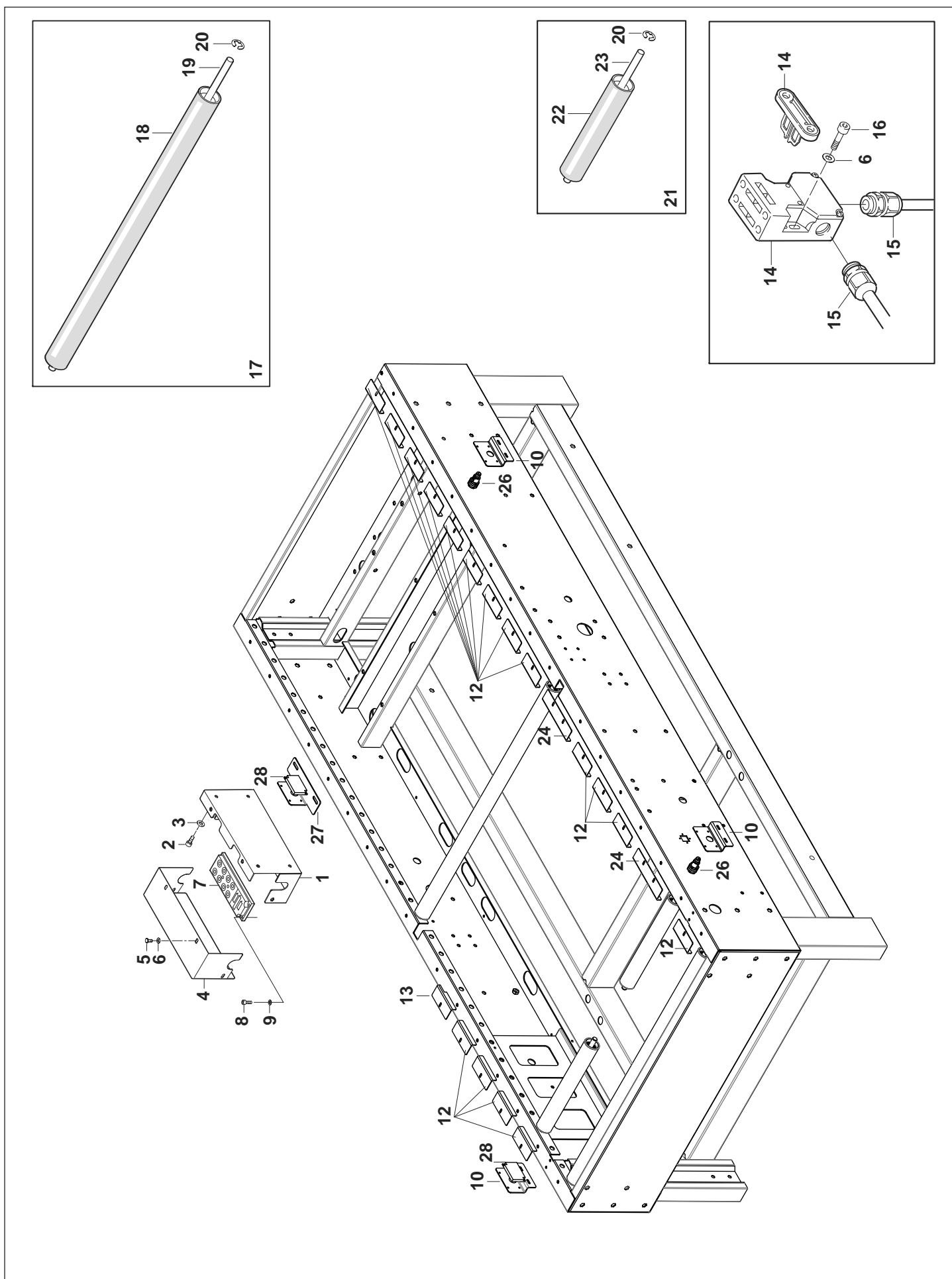
| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|--------------|--|----------|------|
| 1 | SBC00020744V | Staffa fissaggio cassetta | 1 | pz |
| 2 | S340065593Z | Rondella tripla x vite M8 zincata | 12 | pz |
| 3 | S340028093Z | Vite TE M8X20 zincata | 8 | pz |
| 4 | S3310003893A | Distanziale fissaggio cassetta | 4 | pz |
| 5 | S340203293Z | Vite TCEI M8X12 zincata | 4 | pz |
| 6 | S340012393Z | Rondella piana x vite M8 zincata | 30 | pz |
| 7 | S4510003547A | Cassetta impianto pneum. c/inserti | 1 | pz |
| 8 | S4510003647A | Sportello scatola imp. Pneum. c/inserti | 1 | pz |
| 9 | S3402920ZZZ | Serratura "SOUTHCO E5-2-0115-111" WS3 | 1 | pz |
| 10 | S340215405Z | Gomma spugna F144 | 1,8 | Mt |
| 11 | S4510003447A | Piastrina fissaggio sportello c/inserti | 2 | pz |
| 12 | S340398000A | Cer. ELES-A-CFA,65 CH-6 COD. 422232 SM | 10 | pz |
| 13 | S340057793Z | Vite TCEI M6X16 zincata | 88 | pz |
| 14 | S3210010847A | Supporto regolatori di flusso | 1 | pz |
| 15 | S340057793Z | Vite TCEI M6X16 zincata | 88 | pz |
| 16 | S340017593Z | Rondella piana x vite M6 zincata | 92 | pz |
| 17 | S3210011147A | Piastra chiusura cassetta imp. pneum. | 1 | pz |
| 18 | S3210011447A | Piastra x guaina cassetta imp. pneum. | 1 | pz |
| 19 | S340072093Z | Vite testa mezza tonda M5X12 croce zincata | 69 | pz |
| 20 | S3010001000A | Etichetta adesiva box pneumatica | 1 | pz |
| 21 | SCB0000462 | Regolatore c/man. MS4-1/4-LR-D5-VS-DM2 | 4 | pz |
| 22 | S3804614ZZZ | Multy TE 33041008 | 2 | pz |
| 23 | SCB0000473 | Regolatore di velocità ass. | 6 | pz |
| 24 | S3010001000A | Etichetta adesiva box pneumatica | 1 | pz |
| 25 | G17772013ZZ | Riduttore di pressione LRP-1/4-10 | 1 | pz |
| 26 | SCB0000936 | Unità valvole ass. IT_CS.1324304 FESTO | 1 | pz |



| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|-----------|------------|--------------|
| 15757 | Gruppo bancale | | SEB0000979 | SM446/650/HD |

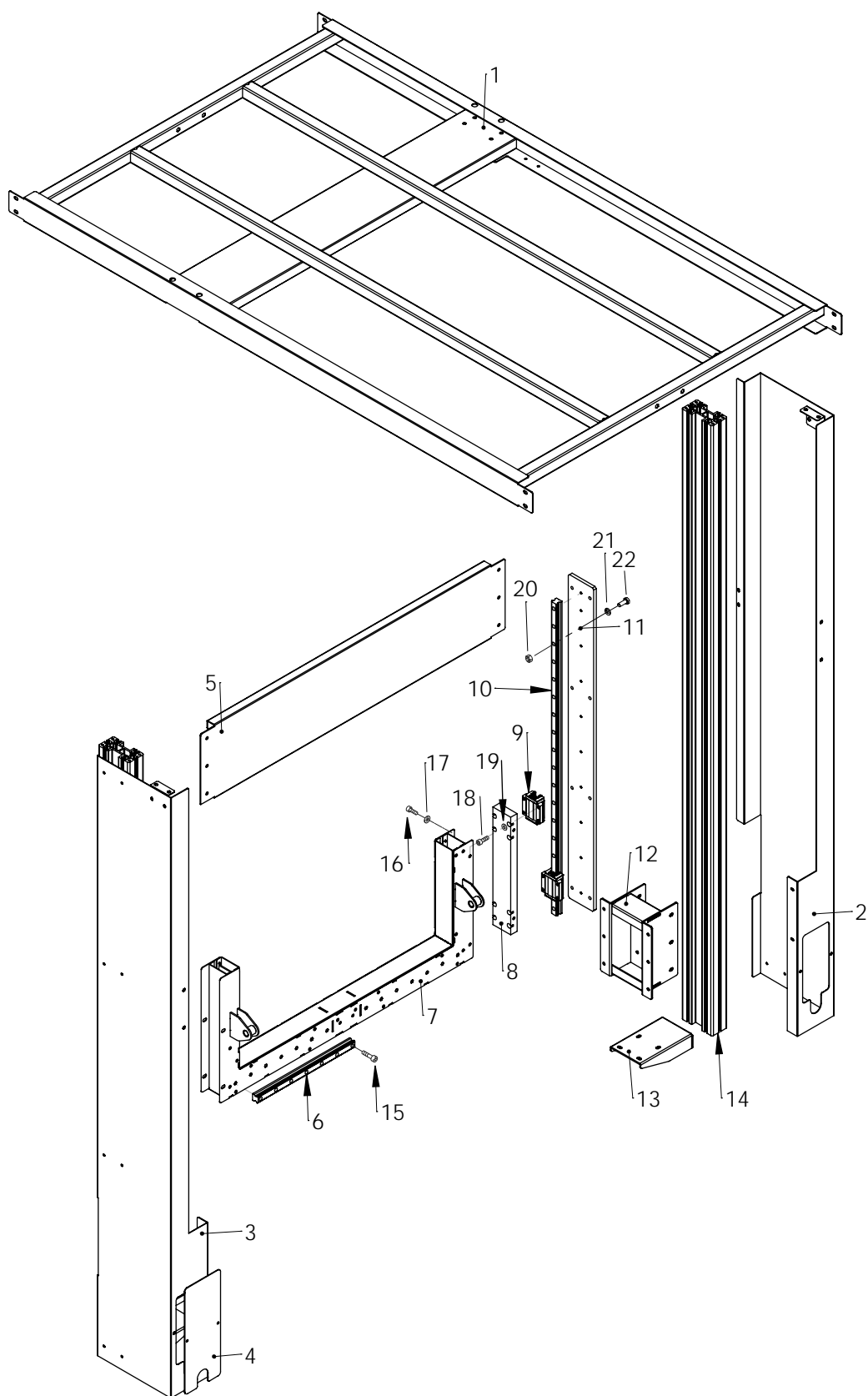
| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|--------------|---|----------|------|
| 1 | S4510005147A | Supporto piastra connettori c/inserti | 1 | pz |
| 2 | S340057793Z | Vite TCEI M6X16 zincata | 88 | pz |
| 3 | S340017593Z | Rondella piana x vite M6 zincata | 92 | pz |
| 4 | S3210015147A | Carter protezione connettori | 1 | pz |
| 5 | S340037193Z | Vite TE M5X12 zincata | 8 | pz |
| 6 | S340006193Z | Rondella piana x vite M5 zincata | 56 | pz |
| 7 | SCC0000738 | Box M12 8 vie 5p calotta estraibile | 1 | pz |
| 8 | S340042093Z | Vite TCEI M4X16 zincata | | pz |
| 9 | S340004393Z | Rondella piana x vite M4 zincata | 12 | pz |
| 10 | S3210009847A | Piastrina fotocellula/catadiottro | 3 | pz |
| 12 | S3210009447A | Squadretta bloccaggio rulli | 17 | pz |
| 13 | S3210010747A | Squadretta c/scarico bloccaggio rulli | 1 | pz |
| 14 | S380752900A | Finecorsa di sicurezza SK-A2Z M | 4 | pz |
| 15 | S3802139ZZZ | Bocchettone skintop ST11 | 9 | pz |
| 16 | S340011293Z | Vite TCEI M5X16 zincata | 4 | pz |
| 18 | SBA0012431 | Rullo ass. L=800 SM446-HS | 25 | pz |
| 19 | SBC0020663T | Perno per rullo L=800 SM446-HS | 25 | pz |
| 20 | S340102492Z | Anello arresto 12 SP 220 | | pz |
| 21 | SBA0012433 | Rullo assemblato L=295 SM446-HS | 16 | pz |
| 22 | SBC0020666T | Perno per rullo L=295 SM446-HS | 16 | pz |
| 24 | SBC0020758V | Squadra dx bloccaggio rulli SM446-HS | 2 | pz |
| 26 | SCC0002807 | FOT.POLARIZZATA 24V PNP M12 E3F1-RP21 | 2 | pz |
| 27 | S3210009647A | Squadra fotocellula lato cassetta pneum | 1 | pz |
| 28 | S3802029ZZZ | CATARIFRANGENTE E39-R1 SM44 | 2 | pz |

26/06/2013



| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|-----------|------------|--------------|
| 15758 | Gr. colonne guide | | SEB0000979 | SM446/650/HD |

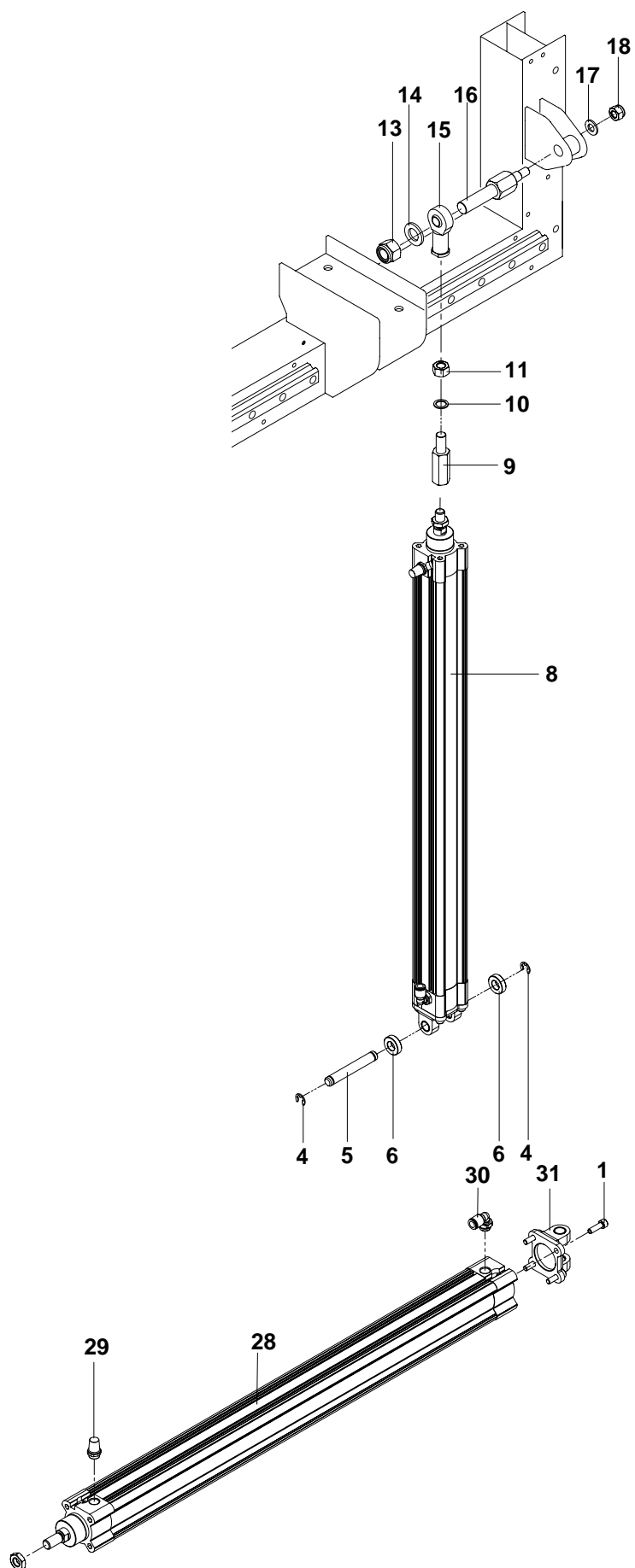
| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|-------------|---|----------|------|
| 1 | SBA0012473 | Struttura superiore assemblata | 1 | pz |
| 2 | SBC0020631V | Protezione dx colonna fissa SM446-HS | 2 | pz |
| 3 | SBC0020630V | Protezione sx colonna fissa SM446-HS | 1 | pz |
| 4 | SBC0020750V | Carter protez. colonna dx SM446-HS | 2 | pz |
| 5 | SBC0020687V | Traversa colonne fisse SM446-HS | 1 | pz |
| 6 | SCA0001652 | Rotaia guida lineare Mod. HSR25-380LG | 2 | pz |
| 7 | SBA0014322V | Traversa superiore chiudifalde SM446-HD | 1 | pz |
| 8 | SBC0020563 | Blocchetto fissaggio traversa SM446-HS | 2 | pz |
| 9 | SCA0000769 | Pattino x guida lineare Mod.HRS25ASSG | 6 | pz |
| 10 | SCA0001362 | Rotaia guida lineare Mod. HRS25-1060LG | 2 | Mt |
| 11 | SBC0020558T | Piastra fissaggio rotaia SM446-HS | 2 | pz |
| 12 | SBA0012409 | Supporto colonna ass. SM446-HS | 2 | pz |
| 13 | SBC0020629V | Staffa inferiore colonna fissa SM446-HS | 2 | pz |
| 14 | SBC0020613 | Colonna fissa SM446-HS | 2 | pz |
| 15 | S340001593Z | Vite TCEI M6X25 zincata | | pz |
| 16 | S340058493Z | Vite TCEI M8X16 zincata | 26 | pz |
| 17 | S340012393Z | RONDELLA PIANA X VITE M8 ZINC. | 30 | pz |
| 18 | S340048693Z | VITE TCEI M8X25 ZINCATA | 2 | pz |
| 19 | S340012393Z | RONDELLA PIANA X VITE M8 ZINC. | 30 | pz |
| 20 | S340000293Z | DADO M6 ZINCATO | 24 | pz |
| 21 | S330972893Z | Rondella speciale /6,5X20X4 Z. | | pz |
| 22 | S340003093Z | Vite TSVEI M6X25 zincata | | pz |

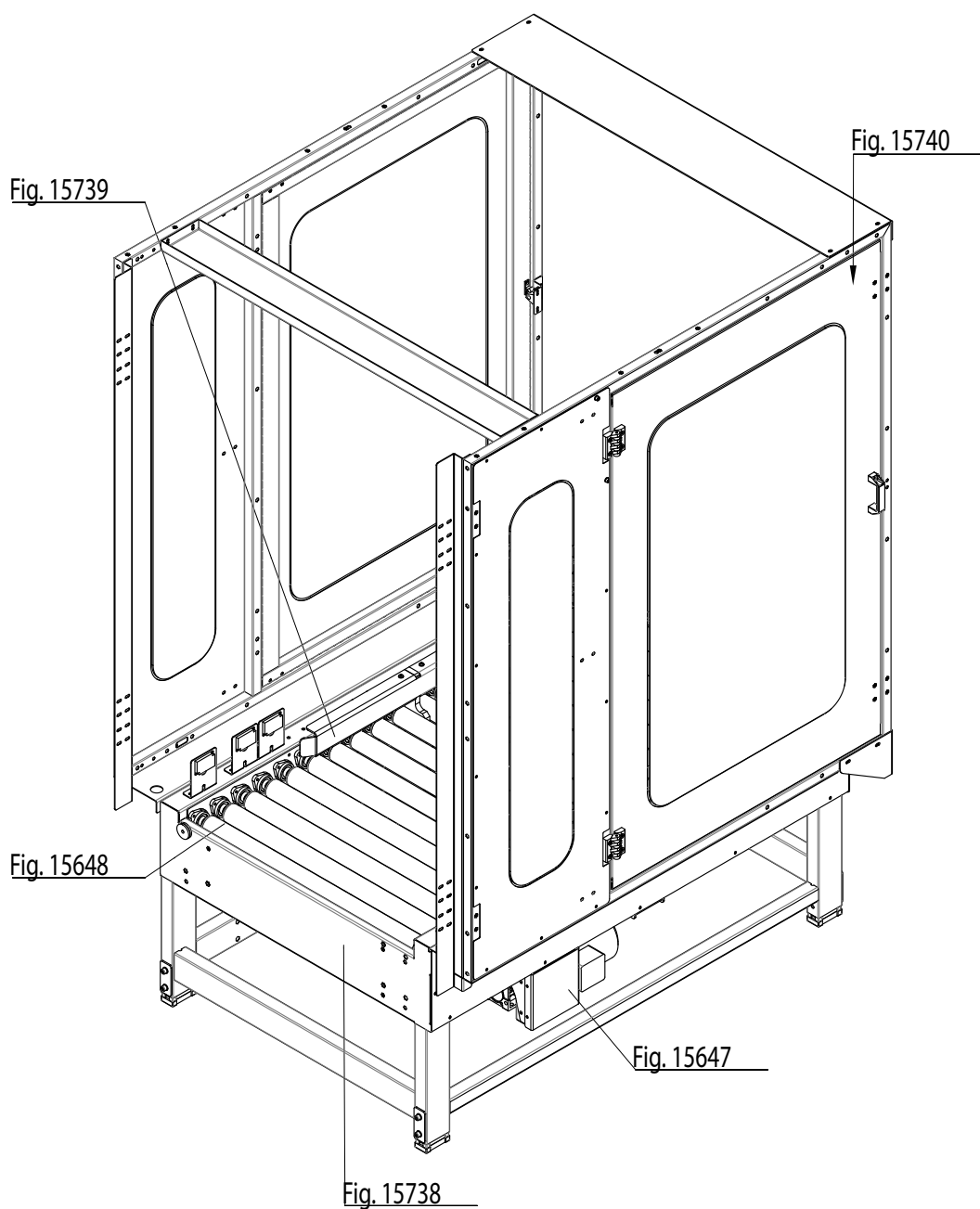


| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|-----------|------------|--------------|
| 15759 | Gr. Bancale | | SEB0000979 | SM446/650/HD |

| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|--------------|-------------------------------------|----------|------|
| 1 | S340028093Z | Vite TE M8x20 zinc. | 8 | pz |
| 4 | S340094592Z | Anello di sicurezza 8 DIN 6799 | 4 | pz |
| 5 | S331079593Z | Perno attacco cil. /40 | 2 | pz |
| 6 | S3310010193Z | Dist. Inf. Cil. Colonne | 4 | pz |
| 8 | SBA0014346 | Gr. Cilindro soll. s/mot. | 2 | pz |
| 9 | SBC0015180T | Dist. Att. Cilindro | 2 | pz |
| 10 | S340230292Z | Ranella di safety "S" (Schnorr) | 2 | pz |
| 11 | S340001893Z | Dado M12 zinc. | 2 | pz |
| 13 | S340125893A | Dado autobl. M16 zinc. | 2 | pz |
| 14 | S340142093Z | Rondella piana x vite M16 zinc. | 2 | pz |
| 15 | S340101693Z | Testa a snodo M12 x 1,25 zinc. | 2 | pz |
| 16 | S3310003992A | Perno sup. attacco cil. | 2 | pz |
| 17 | S340021993Z | Rondella piana x vite M10 zinc. | 2 | pz |
| 18 | S340043893Z | Dado autobl. M10 basso | 2 | pz |
| 28 | SCB0000048 | Cilindro a norme DNCKE 40-600-PPV-A | 1 | pz |
| 29 | S3800448ZZZ | Silenziatore 1\4" | 2 | pz |
| 30 | S3802289ZZZ | Raccordo gomito 31990813 | 2 | pz |
| 31 | S380606700A | Flangia oscillante SNCB-40 pneum. | 2 | pz |

21/05/2013

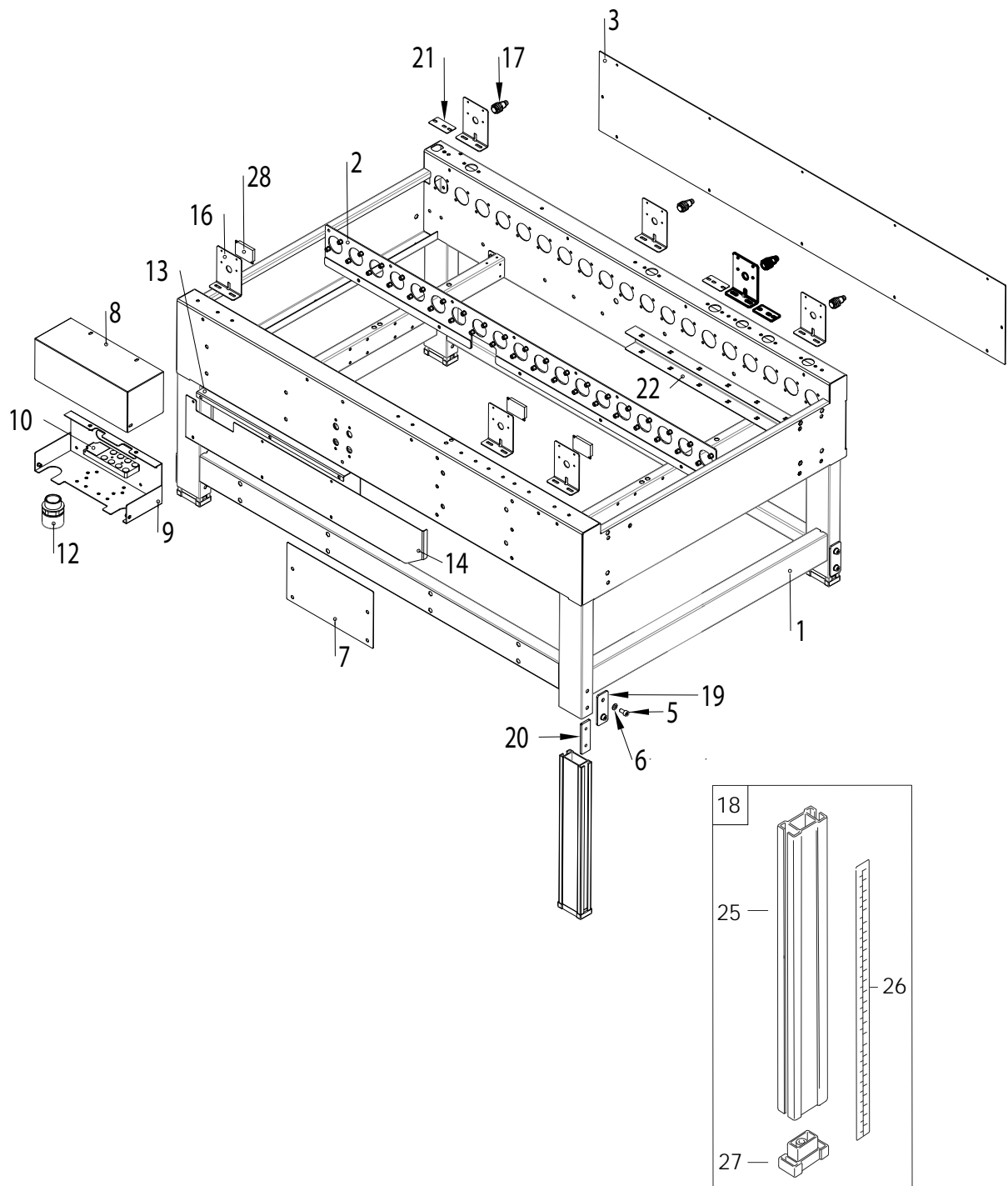




| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|-----------|------------|-------------|
| 15738 | | | SEI0001639 | AS26-650-HD |

| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|-------------|--|----------|------|
| 1 | SBA0012430 | BANCALE C/INS. AS26-650-HS | 1 | pz |
| 2 | SBA0012435 | PIASTRA FIANCATA DX C/INS. AS26-650-HS | 1 | pz |
| 3 | SBC0020648V | CARTER BANCALE AS26-650-HS | 1 | pz |
| 4 | S331802593A | RONDELLA DIAM. 8/40 SP WS3/3000 | 18 | pz |
| 5 | S340058493Z | VITE TCEI M8X16 ZINCATA | 13 | pz |
| 6 | S340012393Z | RONDELLA PIANA X VITE M8 ZINC. | 8 | pz |
| 7 | SBC0023235V | COLONNA TASTATORE C/INS. AS26-650-HS | 1 | pz |
| 8 | SBC0019742V | CARTER CONNESS. CONNETTORI AS26 HS | 1 | pz |
| 9 | SBA0011695 | SUPPORTO PIASTRA CONNET. C/INS AS26 HS | 1 | pz |
| 10 | SCC0000738 | BOX M12 8 VIE 5p. CALOTTA ESTRAIBILE | 1 | pz |
| 12 | S380606500A | RACCORDO DIRITTO "BVND-M406" TEAFLEX | 1 | pz |
| 13 | SBA0012445 | CANALINA C/INS. AS26-650-HS | 1 | pz |
| 14 | SBC0020700V | CARTER CANALINA BANCALE AS26-650-HS | 1 | pz |
| 16 | SBC0019745V | SQUADRA FOTOCEL./CATADIOTTRO AS26 HS | 10 | pz |
| 17 | SCC0002807 | TFC POLAR E3F2-R4B4-M1-M-E PNP M12 | 4 | pz |
| 18 | S4304737ZZZ | GAMBA CON PIEDINO SA2 SR4 | 4 | pz |
| 19 | S320589893A | STAFFA PER GAMBE E TRAVERSE SIAT 2000 | 4 | pz |
| 20 | S320567193A | PIASTRINE FISS. GAMBA | 4 | pz |
| 21 | SBC0020710V | SQUADRA FTC INGRESSO MACCHINA | 2 | pz |
| 22 | SBC0020712V | CANALINA FISSAGGIO CAVI SU BANCALE | 1 | pz |
| 25 | S350259895A | GAMBA SCORREVOLE ESTRUSA SA2 SR4 | 4 | pz |
| 26 | S300098295A | RIGHELLA MILLIM. PER GAMBA H=440 SA2 SR4 | 4 | pz |
| 27 | S310149805Z | TAPPO (PIEDINO) SERIE 2000 NERO | 4 | pz |
| 28 | S3802029ZZZ | CATARIFRANGENTE | 4 | pz |

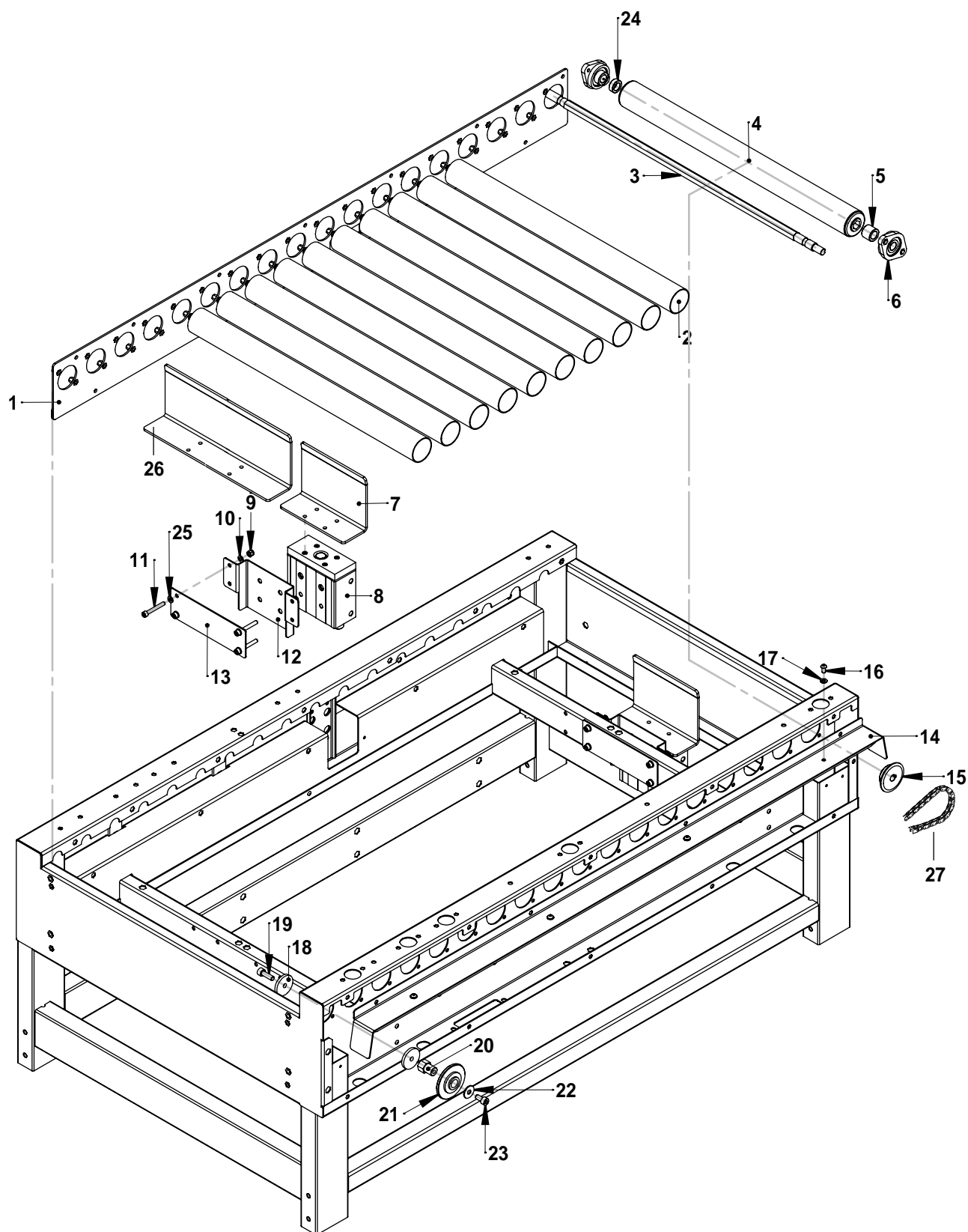
Data **26/06/2013**



| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|-----------|------------|-------------|
| 15648 | | | SEI0001639 | AS26-650-HD |

| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|-------------|--------------------------------------|----------|------|
| 1 | SBA0012435 | piastra fiancata dx c\ins. | 1 | pz |
| 2 | SBA0012424 | ruzzo ass. | 9 | pz |
| 3 | SBC0020697T | albero x rullo | 19 | pz |
| 4 | SBA0012423 | ruzzo zigrinato ass. | 10 | pz |
| 5 | SBC0019651T | dist. D15-24 sp. 19,5 | 19 | pz |
| 6 | S460424605A | supp. c\bearing trasp. Tape ct | 38 | pz |
| 7 | SBC0019626 | piastra fermascatoie | 2 | pz |
| 8 | SCB0000588 | unità lineare DFM-40-50-p-a-gf festo | 2 | pz |
| 9 | S340025893Z | dado esag. Autoblocc. M6 | 4 | pz |
| 10 | S340017593Z | rosetta piana M6 iso 7089 zinc. | 4 | pz |
| 11 | S340011093Z | vite tcei m6x45-24N iso 4762 zinc. | 4 | pz |
| 12 | SBC0019625V | supp. Cilindro gate | 2 | pz |
| 13 | SBC0021332V | piastra rinforzo | 2 | pz |
| 14 | SBC0021704V | angolare fix pattino | 1 | pz |
| 15 | S330766492Z | pignone per rullo Z=17 3\8" | 38 | pz |
| 16 | S340174993Z | vite TBEI M6x12 iso 7380 zinc. | 4 | pz |
| 17 | S340017593Z | rosetta piana M6 ISO 7089 zinc. | 4 | pz |
| 18 | S331802593A | rondella D8\40 sp. Ws3\3000 | 5 | pz |
| 19 | S340048693Z | vite TCEI M8x25-25N ISO 4762 zinc. | 5 | pz |
| 20 | S332465792A | alberino x ingr. Trasp. Mot. | 5 | pz |
| 21 | S340397000A | pignone tendicatena full di bearing | 5 | pz |
| 22 | S340065593Z | rosetta tripla M8 zinc. | 5 | pz |
| 23 | S340058493Z | vite TCEI M8x16 16V ISO 4762 zinc. | 5 | pz |
| 24 | SBC0019832T | dist. D15-24 sp. 8,5 | 19 | pz |
| 26 | SBC0023936 | Piastra fermascatoie as26 650 hd\hs | 1 | pz |
| 27 | SCA0001657 | Spezzone catena asp. 3\8" 335 passi | 1 | pz |

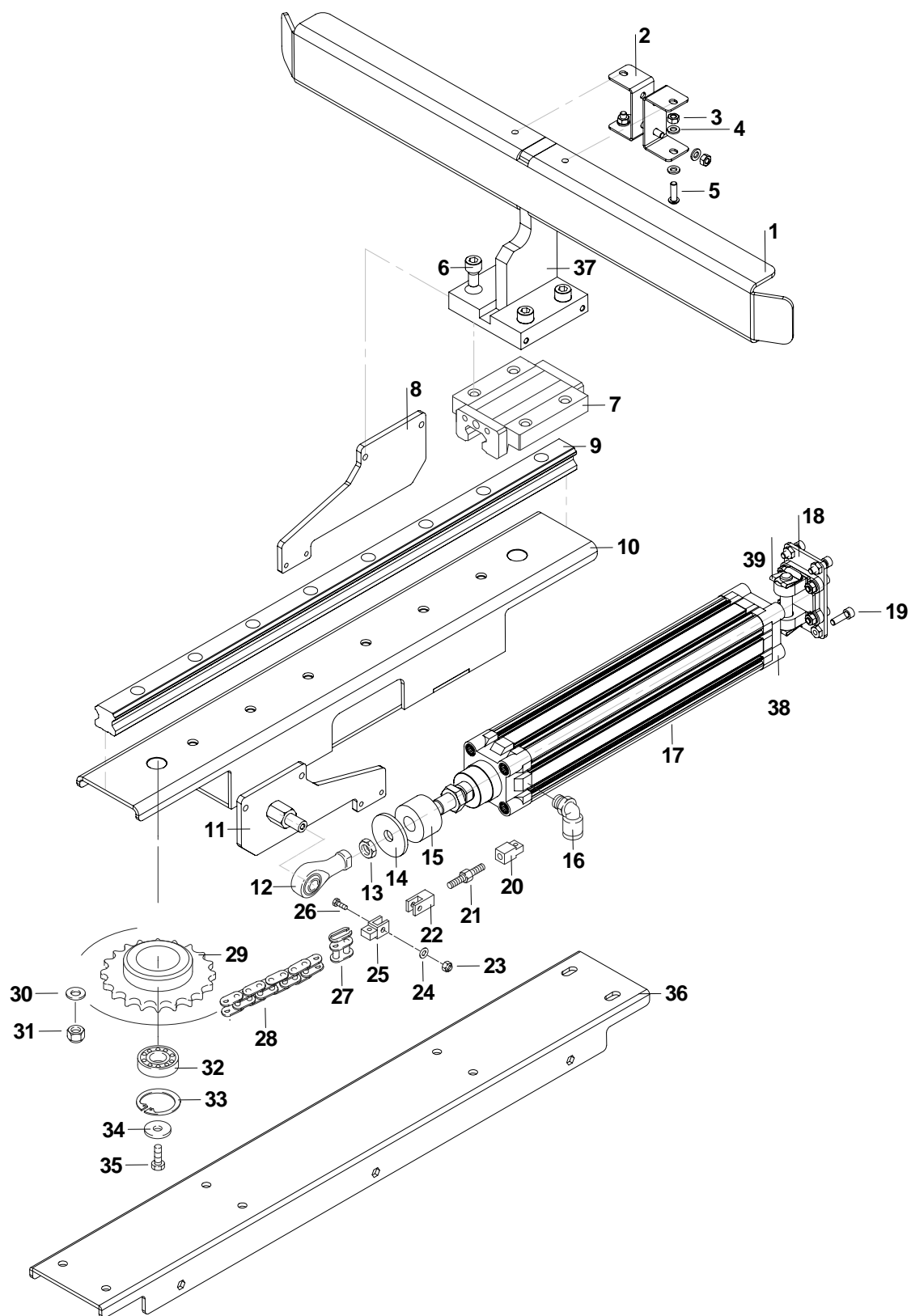
Data **08/05/2013**



| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|-----------|------------|-------------|
| 15739 | | | SEI0001639 | AS26-650-HD |

| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|--------------|---------------------------------------|----------|------|
| 1 | SBC0020677V | guida centr. Vern. | 2 | pz |
| 2 | SBC0019636 | staffa fix guida | 4 | pz |
| 3 | S340023593Z | dado M6 zinc. A bassa resist. | 16 | pz |
| 4 | S340017593Z | rondella piana x vite M6 zinc. | 32 | pz |
| 5 | SCA0000133 | vite TBEI M6x20 iso 7380 zinc. | 8 | pz |
| 6 | S340020693Z | vite TCEI M10 x 20 zinc. | 8 | pz |
| 7 | SCA0000776 | pattino guida lineare mod. HRS30LASSG | 2 | pz |
| 8 | SBC0020707V | piastra lat. Centr. s\perno | 1 | pz |
| 9 | SCA0001274 | rotaia guida lineare | 1 | pz |
| 10 | SBA0012447V | traversa gruppo centr. | 10 | pz |
| 11 | SBA0012439V | piastra lat. Centr. Ass. | 1 | pz |
| 12 | S340114593A | Testa a snodo | 1 | pz |
| 13 | \ | \ | 1 | pz |
| 14 | S320145093Z | Rondella spec.\12\45,5x4 | 1 | pz |
| 15 | SBC0021331 | Tampone cilindro motorizz. | 1 | pz |
| 16 | S3802289ZZZ | Raccordo gomito 31990813 | 1 | pz |
| 17 | SCB0001094 | cilindro a norme DSBC-50-275-PPVA | 1 | pz |
| 18 | SBA0012449V | gr. Cilindro guide | 1 | pz |
| 19 | S340026793Z | vite TE M6x30 zinc. | 4 | pz |
| 20 | S3310004593A | Forcella sinistrorsa | 1 | pz |
| 21 | S330560293Z | Vite tend. Dx\sx SM4\F-104 | 1 | pz |
| 22 | S3310004493A | Forcella destrorsa | 1 | pz |
| 23 | S340025993Z | Dado autoblocc. M5 zinc. | 1 | pz |
| 24 | S340006193Z | Rondella piana x vite M5 zinc. | 1 | pz |
| 25 | S3310004393A | Giunto catena | 1 | pz |
| 26 | S340004593Z | Vite TE M5x20 zinc. | 1 | pz |
| 27 | S3400278ZZZ | Maglia di giunzione P=9,525 | 1 | pz |
| 28 | SCA0001657 | spezzone catena aperto | 1 | pz |
| 29 | S331600200A | Pignone | 1 | pz |
| 30 | S340012393Z | Rondella piana x vite M8 zinc. | 1 | pz |
| 31 | S340028393Z | Dado autoblocc. M8 basso zinc. | 1 | pz |
| 32 | S3400156A | Cuscinetto 6005-2RS1 SKF NTN | 1 | pz |
| 33 | S340019192Z | Anello arresto x foro 47 | 1 | pz |
| 34 | S330491693Z | Rondella\6,5\30x5 | 1 | pz |
| 35 | S340002693Z | Vite TE M6x16 zinc. | 1 | pz |
| 36 | SBC0020673V | traversa sost. Centr. | 1 | pz |
| 37 | SBA0011624T | blocchetto centr. Compl. | 2 | pz |
| 38 | SCB0000965 | flangia oscillante SNCL50 FESTO | 2 | pz |
| 39 | S380630300A | \ | 2 | pz |

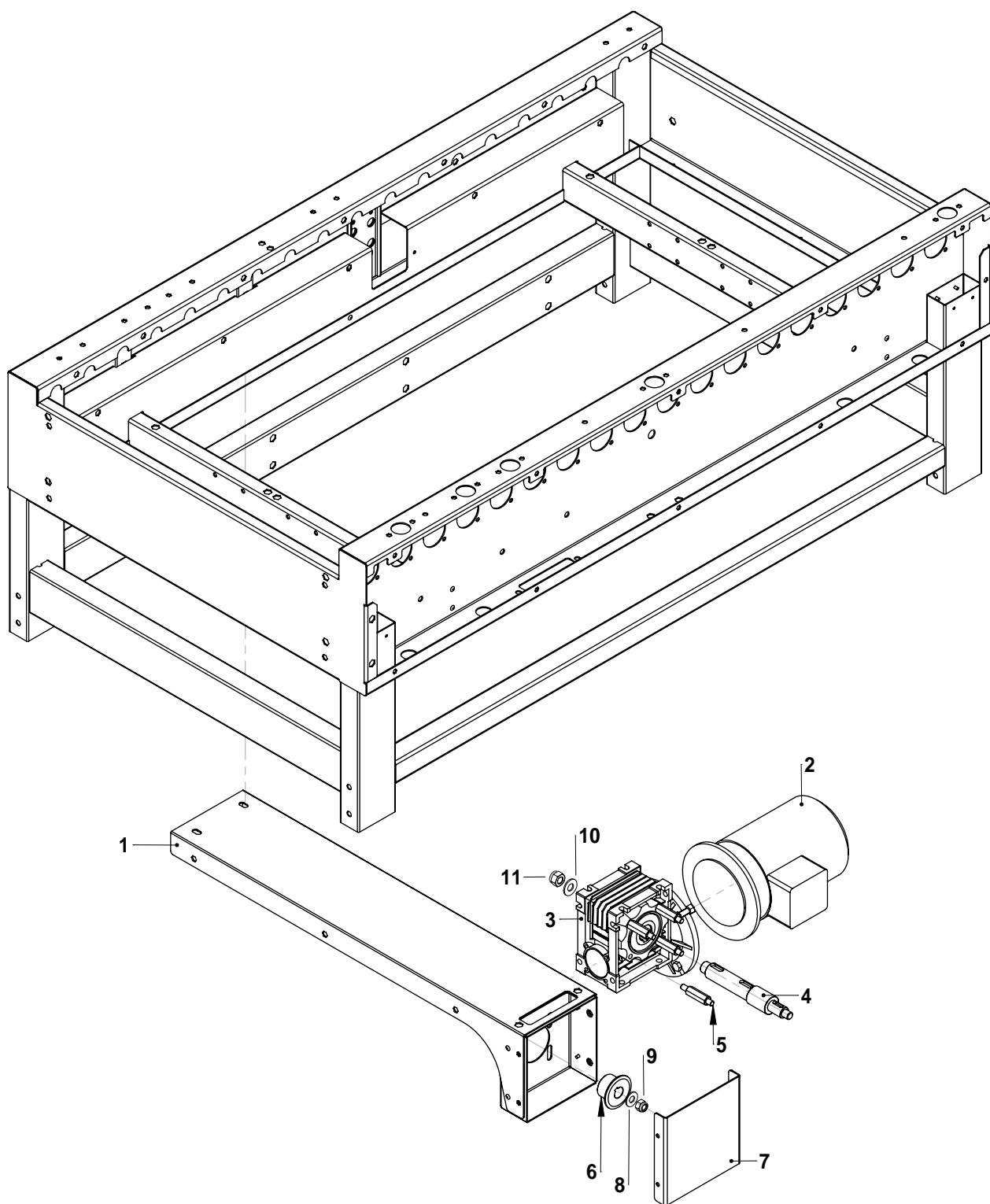
Data 08/05/2013



| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|-----------|------------|-------------|
| 15647 | | | SEI0001639 | AS26-650-HD |

| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|-------------|--------------------------------------|----------|------|
| 1 | SBA0012436V | supp. Rid. Ass. | 1 | pz |
| 2 | S3803569ZZZ | mot. H71 B5B6 220\240V-380\415V 50Hz | 1 | pz |
| 3 | SCA0001595 | rid. Nmrv 050 pam71 B5 rap.1:7,5 | 1 | pz |
| 4 | SBC0019647T | albero rif. | 1 | pz |
| 5 | SBC0019649T | colonnina rid. | 4 | pz |
| 6 | S331600200A | pignone 3\8" Z17 trasp. Nastro | 1 | pz |
| 7 | SBC0019665V | carter motorizz. | 1 | pz |
| 8 | S340342293Z | rondella tripla x vite M12 zinc. | 1 | pz |
| 9 | S340223393Z | dado spec. Autoblocc. M12 P1 | 1 | pz |
| 10 | S321244193A | rondella D29\18 sp.3 WS150 | 1 | pz |
| 11 | S340054393Z | dado M18 medio tabbing system | 1 | pz |

Data **08/05/2013**



| Figura | Descrizione figura | Magazzino | Prodotto | Descrizione |
|--------|--------------------|------------|------------|-------------|
| 15740 | Gr. Protezioni | SBA0014254 | SEI0001639 | AS26-650-HD |

| Posizione | Ricambio | Descrizione | Quantità | U.M. |
|-----------|-------------|---------------------------------|----------|------|
| 1 | SBA0012457 | Pannello laterale prem. | 2 | pz |
| 2 | SBA0012461 | Telaio laterale prem. | 2 | pz |
| 3 | S340398000A | Cerniera elesa cfa 65 ch6 | 4 | pz |
| 4 | S3801095ZZZ | Maniglia M443/110 | 2 | pz |
| 5 | S3401707ZZZ | Aggancio x blocco a scatto T330 | 2 | pz |
| 6 | S3401601ZZZ | Blocco a scatto spec. | 2 | pz |
| 7 | SBC0020115V | Squadretta supp. Blocco scatto | 2 | pz |
| 8 | S340017593Z | Rondella piana x vite M6 zinc. | 7 | pz |
| 9 | S340057793Z | Vite tcei M6x16 zinc. | 9 | pz |
| 10 | S340005093Z | Vite tsvei M6x20 zinc. | 8 | pz |
| 12 | S340040393Z | Vite tsvei M5x16 zinc. | 2 | pz |
| 13 | S340006193Z | Rondella piana x vite M5 zinc. | 6 | pz |
| 14 | S340025993Z | Dado autoblocc. M5 zinc. | 2 | pz |
| 15 | S340031893Z | Vite tcei M5x12 zinc. | 2 | pz |
| 16 | S340038293Z | Vite tcei M5x40 zinc. | 2 | pz |
| 17 | SBC0020731V | Staffa fix protez. | 2 | pz |
| 18 | SBC0020676V | Angolare rinforzo protez. | 1 | pz |
| 19 | SBC0020733V | Staffa dx fix prot. | 1 | pz |
| 20 | SBC0020739V | Lamiera chiusura bancale sx | 1 | pz |
| 21 | SBC0023216V | Lamiera chiusura bancale dx | 1 | pz |
| 22 | SBC0020734V | Staffa sx fix prot. | 1 | pz |
| 23 | S3802388ZZZ | Finecorsa di safety c\staffa | 2 | pz |
| 24 | SBC0021080V | Staffa rinf. Prot. | 1 | pz |
| 25 | S340051693Z | Vite tsvei M5x12 zinc. | \ | pz |
| 26 | SBC0021081 | staffa rinforzo prot. x imballo | 1 | pz |

Data **27/06/2013**

