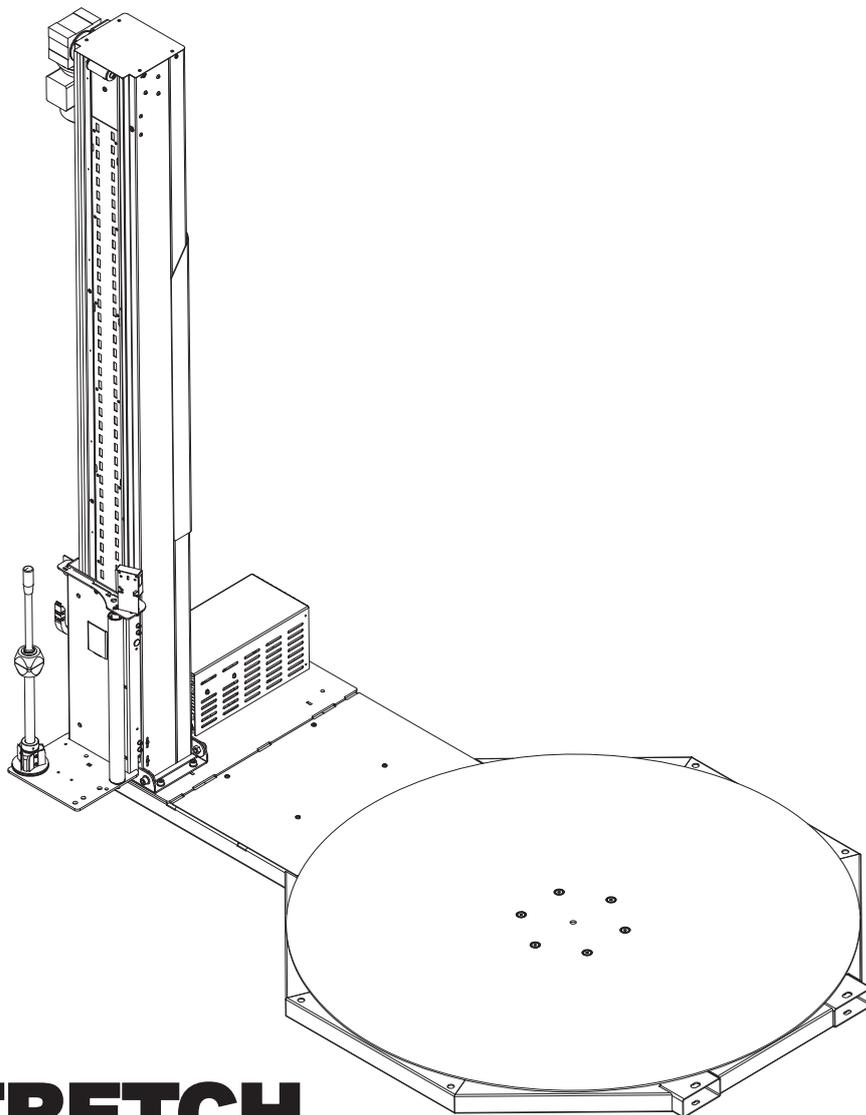


# SIAT

■ M. J. MAILLIS GROUP



## **FO-STRETCH**

FASCIAPALLET SEMIAUTOMATICO

***SEMI-AUTOMATIC PALLET STRETCHWRAPPER***

BANDEROLEUR SEMI-AUTOMATIQUE

*HALBAUTOMATISCHE PALETTENWICKELMASCHINE*

ENFARDADORA DE PALETS SEMIAUTOMATICA

MANUALE DI ISTRUZIONI E PARTI DI RICAMBIO

***INSTRUCTIONS MANUAL AND SPARE PARTS LIST***

MANUEL D'INSTRUCTIONS ET PIECES DETACHEES

*BEDIENUNGSANLEITUNG UND ERSTAZTEILLISTE*

MANUAL DE INSTRUCCIONES Y RECAMBIOS



Instruction manual for the use, safety, maintenance and spare parts concerning the semi-automatic pallet stretchwrapper "F0-STRETCH".

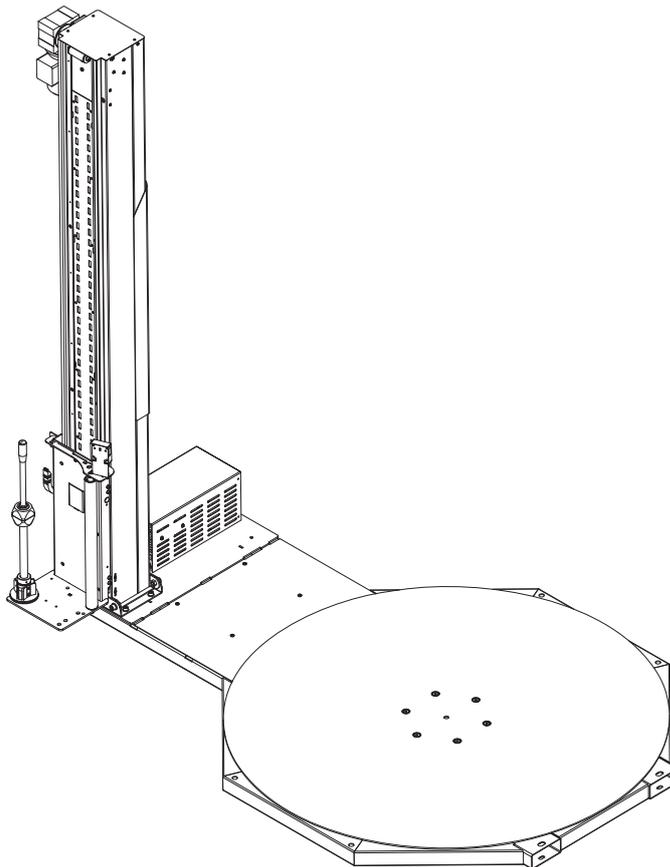
This publication is property of SIAT S.P.A.  
Via Puecher, 22 - 22078 TURATE (CO) - ITALY  
Tel. 02-964951 - Fax. 02-9689727

Edition December 2009

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Publication n. SMD00008K  
Release 0



# **F0-STRETCH**

## **SEMI-AUTOMATIC PALLET STRETCHWRAPPER**

-Capacity: 1200 kg

-Turntable diameter: 1500 mm

-Film tension adjustment: with mechanical tensioning brake on reel shaft

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**LIST OF ABBREVIATIONS, ACRONYMS AND UNUSUAL TERMS TO BE FOUND IN THIS MANUAL**

Dwg.	=	drawing
Encl.	=	enclosure
Ex.	=	example
Fig.	=	figure showing spare parts
Max.	=	maximum
Min.	=	minimum
Mod.	=	machine model
N.	=	number
N/A	=	not applicable
OFF	=	machine stopped
ON	=	machine running
OPP	=	oriented polypropylene adhesive tape
PLC	=	Programmable Logic Controller
PP	=	polypropylene
PTFE	=	Polytetrafluorethylene
PVC	=	Polyvinylchloride
Ref.	=	reference mark
SIAT	=	Società Internazionale Applicazioni Tecniche (Società per Azioni)

w = width  
h = height  
l = length

# 1-INTRODUCTION

---

## 1.1 MANUFACTURING SPECIFICATIONS

The machine has been designed and manufactured complying with the legal requirements in force at the date of its manufacture.

THE REFERENCE DOCUMENTS ARE:

**Directives 98/37/CE, 2006/95 CE, 89/336 CEE, 108/04 CE, 2002/96/CE, 2003/108/CE.  
UNI EN 415-6.2007**

## 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.

The electric schemes are enclosed to 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

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.

With reference to how much contained in this manual the manufacturer declines every responsibility in case of:

- use of the machine not conforming to the national laws on the safety,
- wrong predisposition of the installation site and/or of the supporting structures on which the machine will go to operate,
- defects of tension and power supply e/o of other energetic sources,
- missed or wrong observance of the instructions furnished in this instruction manual,
- changes to the machine non authorized,
- use from personal not trained,
- use of non genuine spare parts,
- use of accessories not authorized,
- God's actions.

### 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 update this manual.

## 2-GENERAL INFORMATION

### 2.1 SERIAL NUMBER OF THE MACHINE AND NAME OF THE MANUFACTURER

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

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

<b>SIAT</b> ■ M. J. MAILLIS GROUP
Via Puecher, 22 22078 TURATE (CO) - ITALY
Tel. 02-964951 Fax. 02-9682239 E-mail <a href="mailto:siat@siat.com">siat@siat.com</a>

AGENT/DISTRIBUTOR OR LOCAL AFTER SALE SERVICE:
---

## 2-SAFETY INFORMATIONS

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### 2.3 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 (Intended use: n 1 turn of job of 8 hours)

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 warrant the compliance of its machines with the laws of EEC and non-EEC countries in which the machines may be installed, it warrant compliance with laws or standards relating to the prevention of accidents or pollution.

Adaptation of Seller's machines to special laws or standards of the country of installation 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 INFORMATIONS

---

#### 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:



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 through the controls on the switchboard, to load and unload the pallets, to wrap the pallets, to load the stretch film reel.

NOTE: the factory manager should ensure that the operator has been properly trained on all the functions of the machine before starting work.

##### 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- SAFETY INFORMATIONS

#### 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:

- Stopped with electric power disconnected;
- Stopped with main switch on '0' or 'I';
- Running;

#### 3.5 STANDARD SUPPLY

N. 1 instructions manual and spare parts list

#### 3.6 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.

OPERATION	STATE OF THE MACHINE	OPERATOR'S SKILL	NUMBER OF OPERATORS
Installation and set up of the machine.	Stopped with electric power disconnected		2
Replacement of the stretch film reel, platform loading and unloading	Stopped with main switch on 'OFF' position.		1
Load wrapping	Running.		1
Ordinary maintenance.	Stopped with electric power disconnected.		2
Extraordinary maintenance (mechanical).	Stopped with electric power disconnected.		1
Extraordinary maintenance (electrical).	Stopped with electric power disconnected.		1

### 3-SAFETY INFORMATION

#### 3.8 RESIDUAL HAZARDS

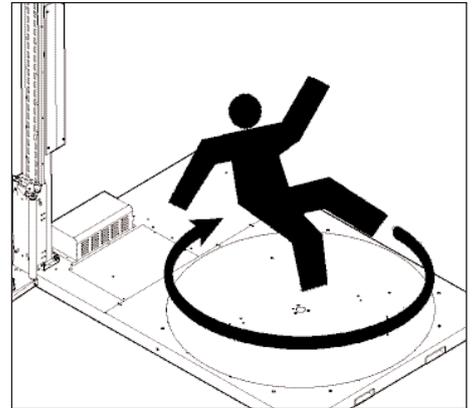
The pallet stretchwrapper has been designed following the CE directives, and incorporates various safety protections which should never be removed or disabled.

In spite of the precautions taken by the designers, the essential thing is that the operator and the maintenance specialists are informed of the following residual hazards that ca not be eliminated.



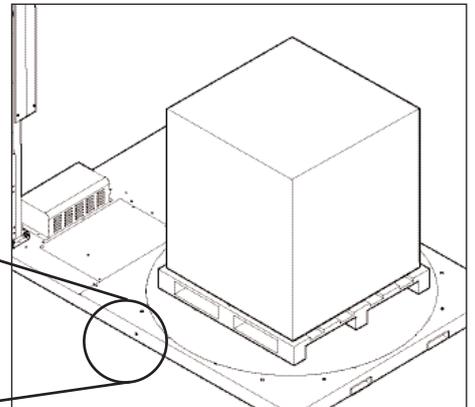
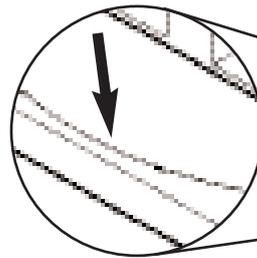
**WARNING! Turntable.**

Never step on the turntable, even when the machine is not working.  
Danger of falling from the turntable



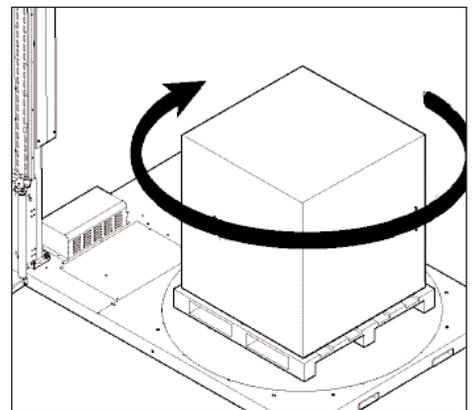
**WARNING! Turntable.**

Never touch the area between the turntable and the base of the machine.  
Risk of entanglement and/or crushing and/or falling



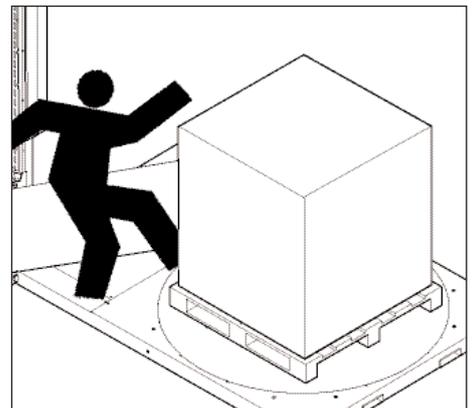
**WARNING! Rotating pallet**

Never touch the pallet when the machine is running.  
Risk of entanglement and/or crushing and/or falling



**WARNING! Rotating pallet**

Do not walk between the column and the pallet.  
Risk of entanglement and/or crushing



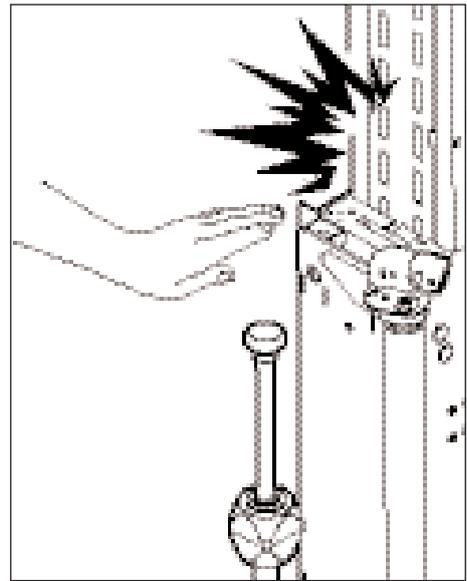
### 3- SAFETY INFORMATIONS

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**WARNING:** Film reel holder

Do not touch the area between the film carriage and the column.  
Risk of entanglement and/or crushing



#### 3.9 PERSONAL SAFETY MEASURES

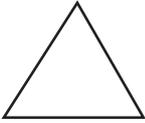
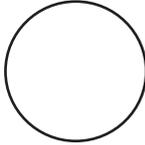
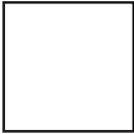
(Safety glasses, safety gloves, safety helmet, safety shoes, air filters, ear muffs).  
None is required, except when recommended by the user.

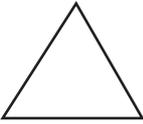
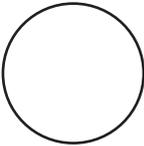
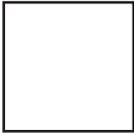
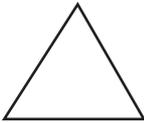
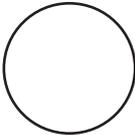
#### 3.10 PREDICTABLE ACTIONS WHICH ARE INCORRECT AND NOT ALLOWED

- Never attempt to hold up the rotation of the pallet.
- Never work without the safety protections.
- 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.
- Do not modify the machine or any part of it.  
The manufacturer will not be responsible for any modifications.
- Follow carefully the installation instructions of this manual.

### 3- SAFETY INFORMATIONS

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

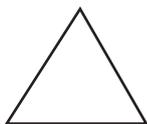
	SYMBOLS	COLOURS
	 DANGER AND PARTS IN MOVEMENT	YELLOW COLOUR
	 COMPULSORY ACTIONS/PROHIBITION	RED COLOUR
	 CONTROLS AND INFORMATION	LIGHT BLUE COLOUR

a	 Keep hands out of working parts Serious injuries may occur.	 Label code: S300109396A
b	 Attention! Disconnect the electric plug from the mains before any cleaning/servicing operation and before opening the electrical panel.	 Label code: S300109996A
c	 Shows the running direction of the turntable.	 Label code: S300104096A
d	 Shows the danger of falling from the turntable.	 Label code: S300109296B
e	 Shows the prohibition from stepping on the turntable.	 Label code: S300109596B

### 3- SAFETY INFORMATIONS

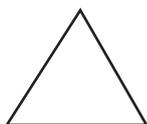
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f Shows the danger of being trapped between pallet and film.



Label code: S300110196A

g Caution! High voltage.



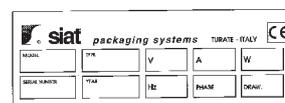
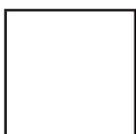
Label code: S300110096A

h Show the point for earth wire connection on the machine frame.



Label code: S300103996A

i Shows the identification data of the turntable and the column.



Label code: S340277700A

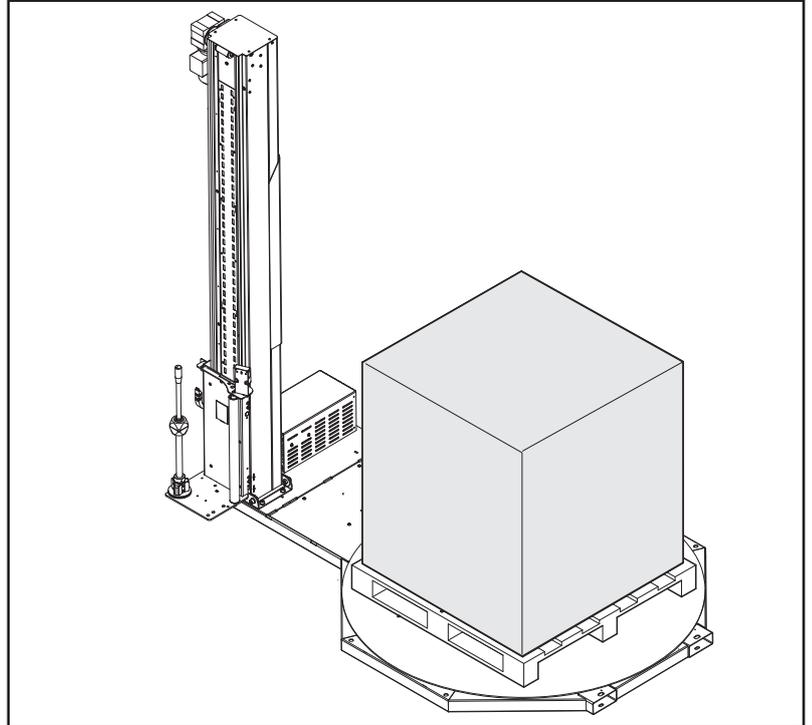
## 4-PRELIMINARY INFORMATION

### 4.1 GENERAL DESCRIPTION OF THE MACHINE

Semi-automatic machine for the wrapping of palletised loads with stretch film, adjustment of the film tension by mechanical brake on reel shaft.  
Adjustable turntable rotation speed, automatic cycle.

### 4.2 TECHNICAL SPECIFICATIONS

- Standard power supply = See data plate.
- Turntable motor: kW 0.37
- Film carriage motor: kW 0.12
- Mechanical brake on reel shaft.



### 4.3 PALLET DIMENSIONS

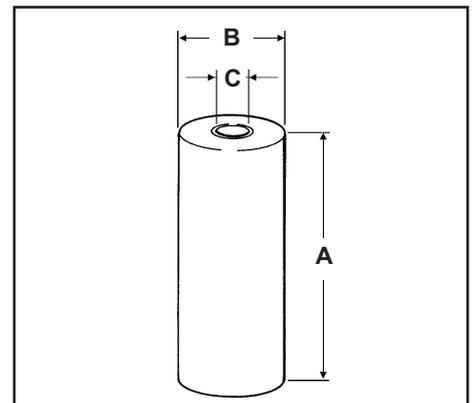
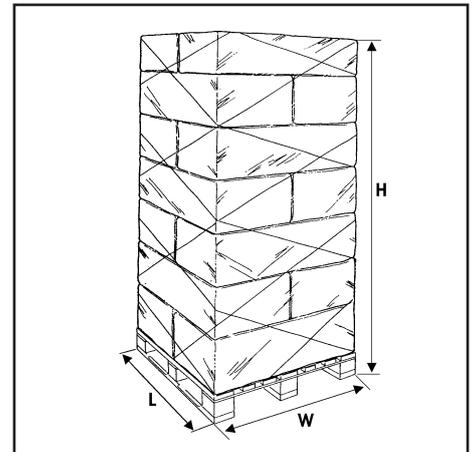
To wrap palletized loads with stretch film or net.  
Max. pallet dimensions: see table below.

Turntable Ø mm	L mm	W mm	H mm	Max. capacity kg
1500	1200	800	2100	1200

### FILM ROLL DIMENSIONS

**A** = max 500 mm  
**B** = max 250 mm  
**C** = 75 mm

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



## 4- PRELIMINARY INFORMATION

### 4.4 MAIN COMPONENTS

The machine is composed of:

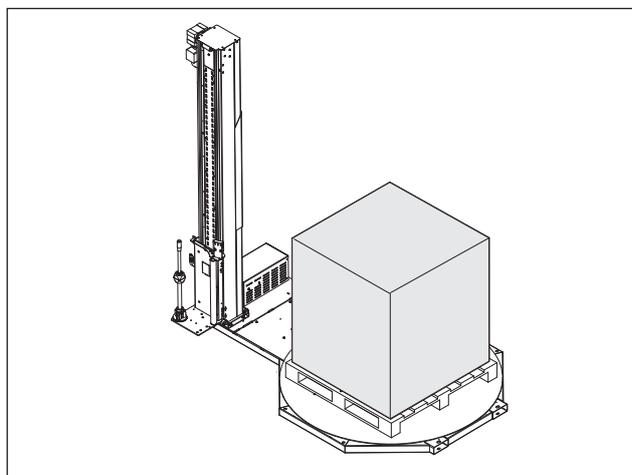
N. 1 platform, N. 1 turntable, N. 1 column, N. 1 film carriage, N. 1 control panel, N. 2 motors

### 4.5 OPERATING FLOW

- the working cycle is started by pressing the START button
- the turntable starts to rotate
- after some turntable rotations, the film carriage rises
- the photocell reads the maximum height of the load and stops the film carriage raising movement
- after some turntable rotations, the film carriage descends
- turntable stops just the carriage reaches the load bottom side

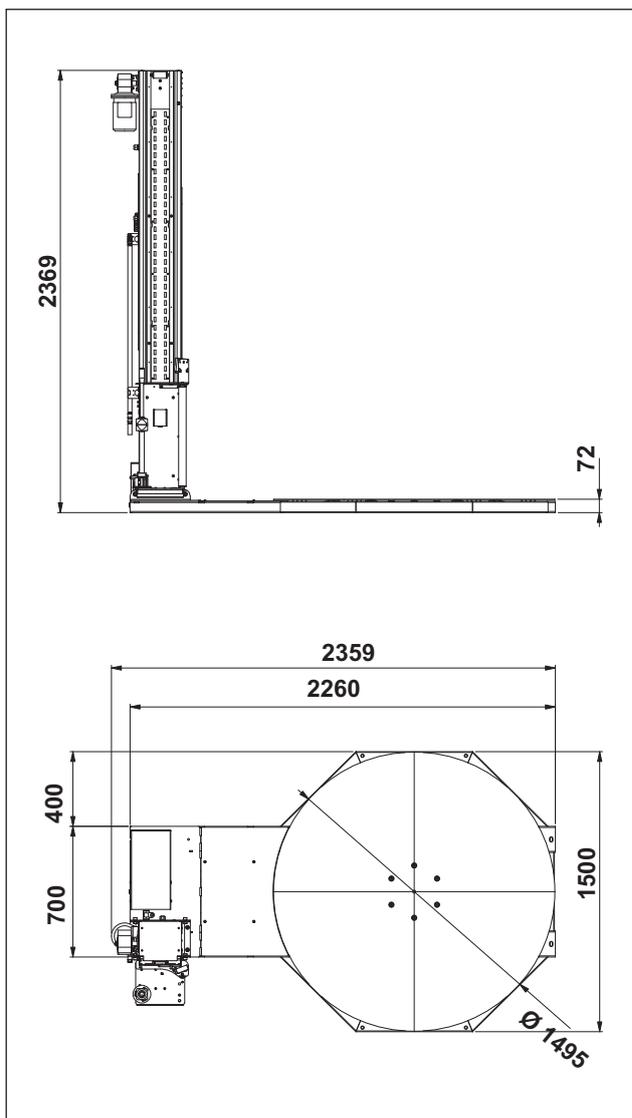
#### Environmental condition required:

- Temperature min. +5 °C, max. +40 °C,
- Umidity min. 30%, max. 80%, without condensate.
- Dust free environment..



### 4.6 OVERALL DIMENSIONS

Dimensions in mm



### 4.7 MACHINE NOISE MEASUREMENT

Acoustic pressure at 1 metre distance from the machine with the film roll inserted: 72 dB.

Acoustic pressure at a height of 1.6 metre above the machine with the film roll inserted: 72 dB.

The measurement was performed by a SPYRI-MINOPHON phonometer.

## 5-SHIPMENT - HANDLING - STORAGE

### 5.1 SHIPMENT AND HANDLING OF THE PACKED MACHINE

The machine can be lifted by using a forklift truck on the side with the label as in Fig.  
The packaging is suitable for travel by land, air and sea freight.

#### OVERALL PACKAGING DIMENSIONS

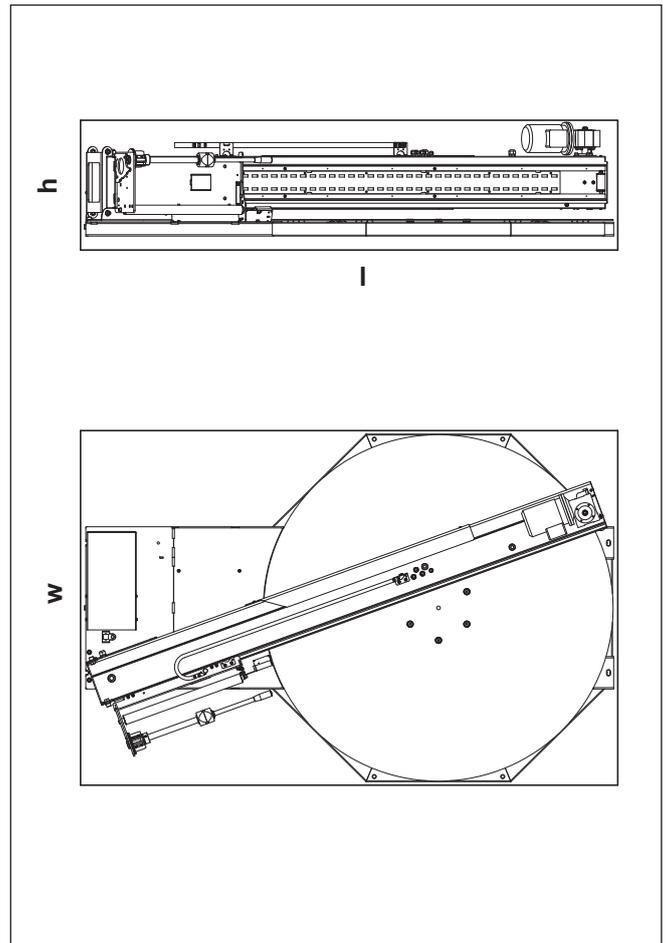
**l** = length 230 cm

**w** = width 153 cm

**h** = height 56 cm

Weight 360 kg

During shipment it is possible to stack a maximum of 4 machines.



### 5.2 SHIPMENT AND HANDLING OF THE UNPACKED MACHINE



Never move the machine without the packaging and when assembled. The handling of the assembled machine can cause serious injuries because the column weight can unbalance the machine.

Furthermore, the fixing of the column to the machine basement is unsuitable to bear the mechanical stress of transport.

### 5.3 STORAGE OF THE PACKED OR UNPACKED MACHINE

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

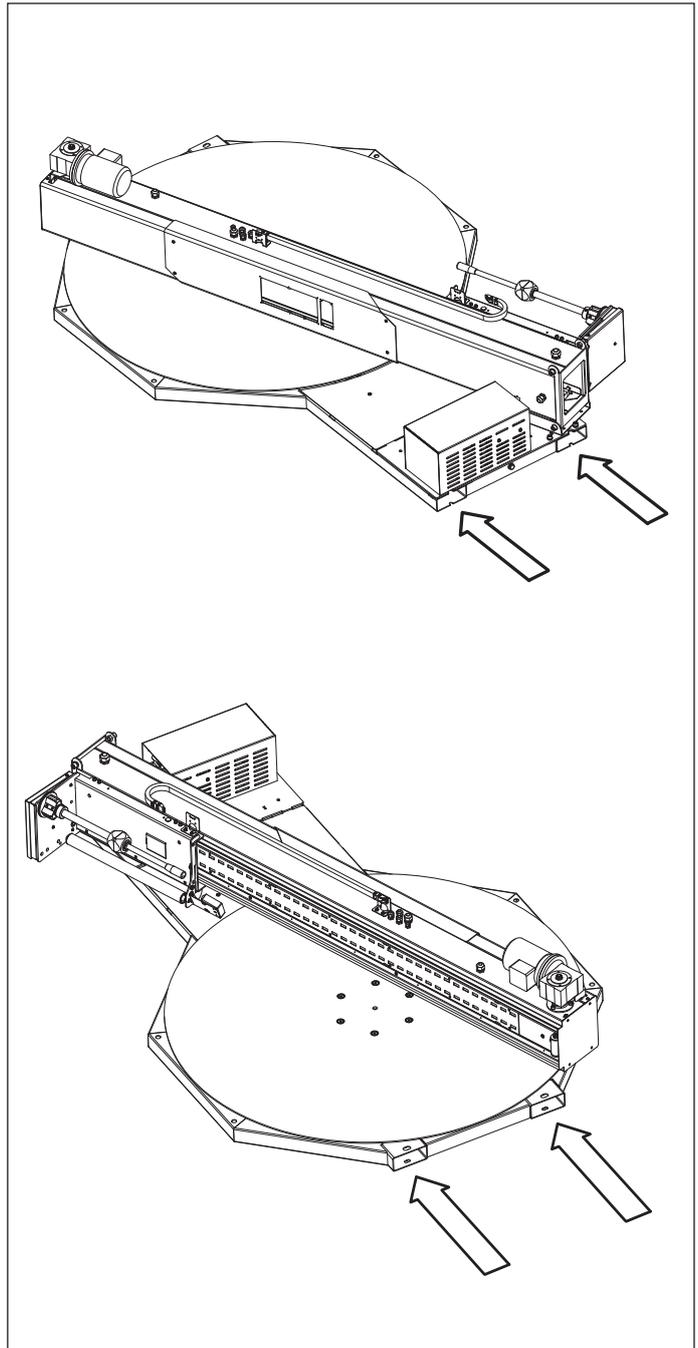
- store the machine in a dry, clean place;
- if the machine is unpacked it is necessary to protect it from the dust;
- it is possible to stack a maximum of 4 machines, if they are in their original packaging.

## 6-UNPACKING

### 6.1 MASCHINE UNPACKING

Use an adequate fork lift truck, slide the forks in the lower parts of the base, as in picture, lift and carry it to its installation location.  
Remove all packing parts.

Weight: **250 kg**



### 6.2 PACKAGING DISPOSAL

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

## 7-INSTALLATION

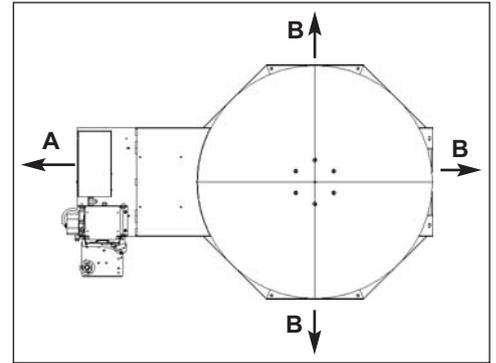
### 7.1. SAFETY MEASURES

(Read section 3 carefully).

### 7.2. SPACE REQUIRED FOR OPERATION AND MAINTENANCE

Min. distance from the wall: **A = 1000 mm. B = 2000 mm.**

Min. height = **3600 mm**



### 7.3 POSITIONING THE MACHINE BASE

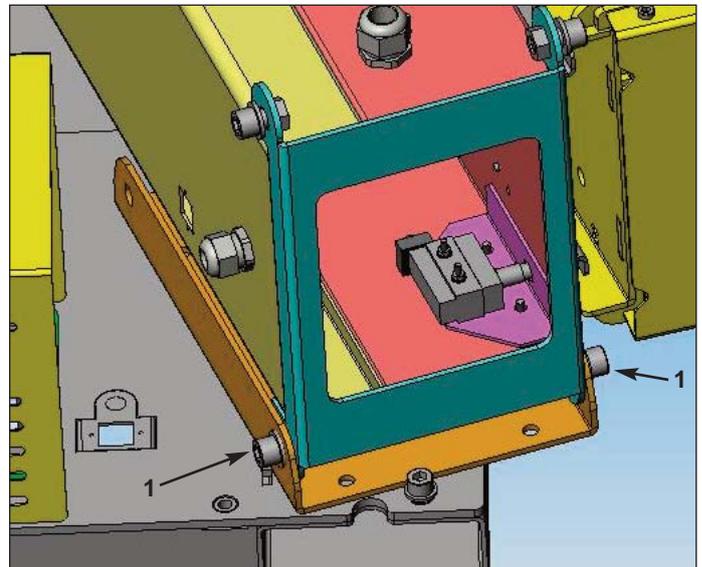
Lift the machine with a forklift truck and place in the working position

### 7.4 LEVELING

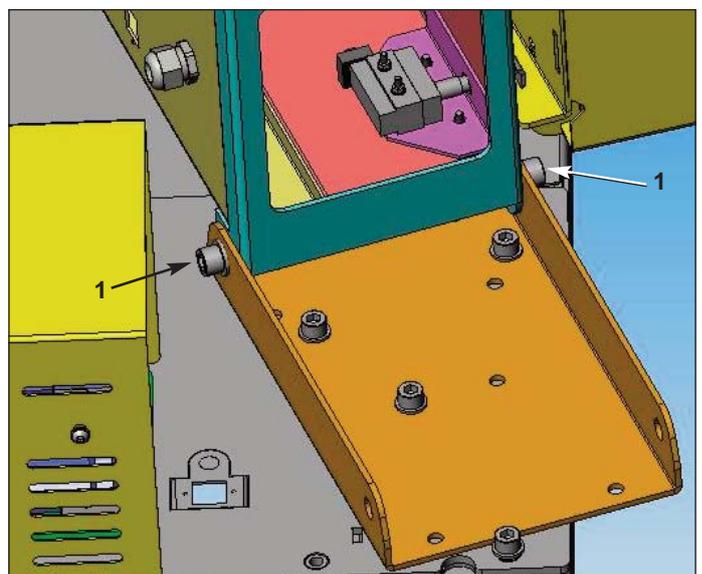
Set the platform on a flat surface to allow an even distribution of the weight. Positioning on an uneven surface will result in excessive wear of the mechanical parts supporting the turntable.

### 7.5 ASSEMBLY OF THE COLUMN

Remove the two screws (1) on the base of the column.

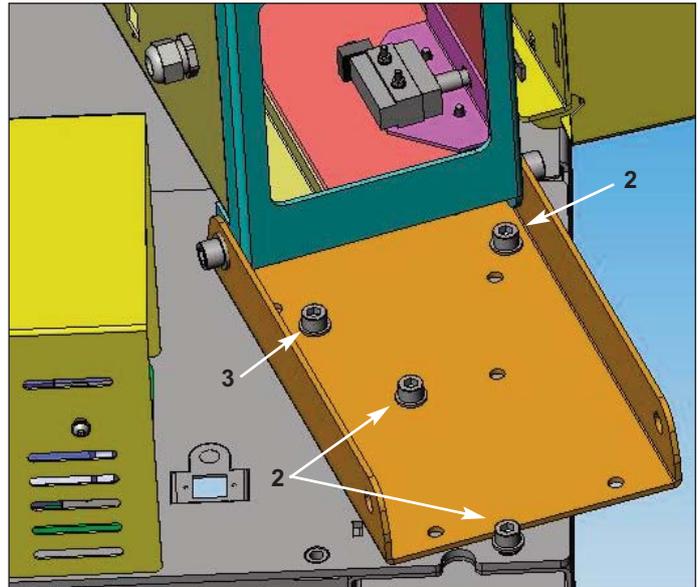


Push the column up to line up the fixing column/plate drillings to the opposite extremity of the same plate; re-screw the screws (1) that have been removed previously.

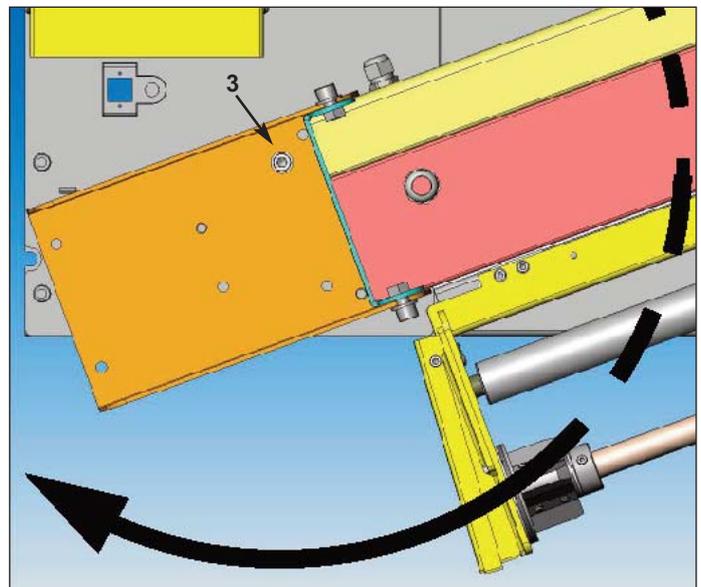


## 7-INSTALLATION

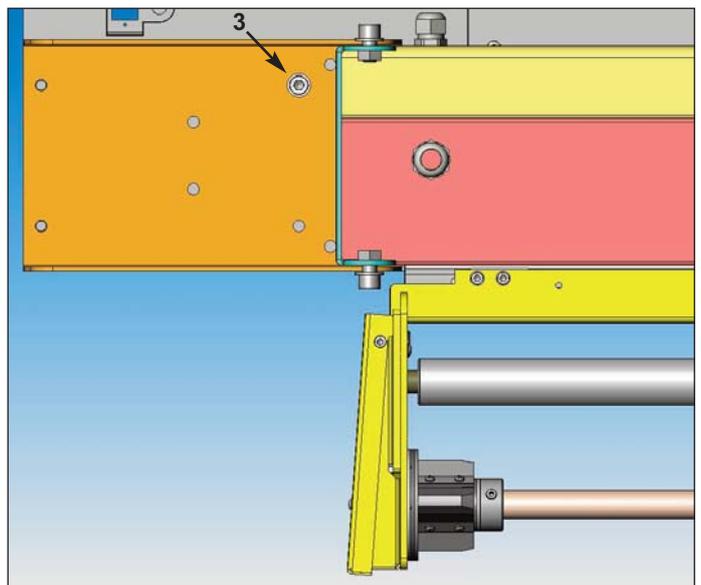
Remove the three screws (2).



Loosen but don't remove the screw (3).

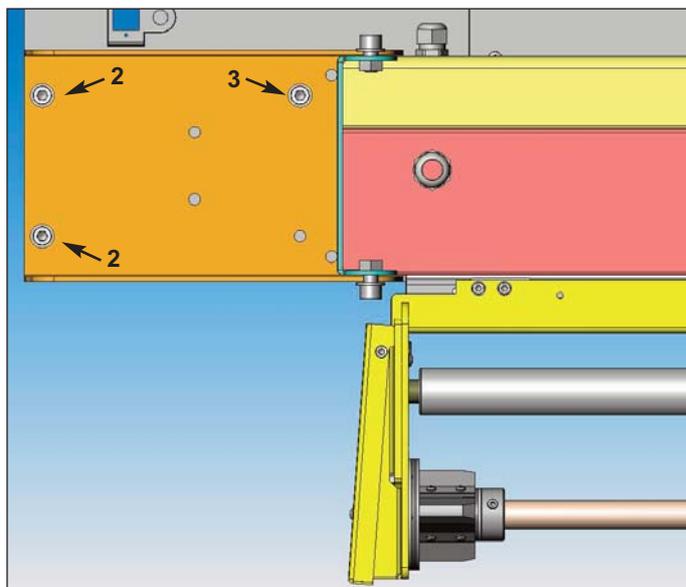


Turn, making fulcrum on the screw (3), as shown in the picture, the fixing column-plate group lining up the drillings of the fixing plate-base frame carefully.

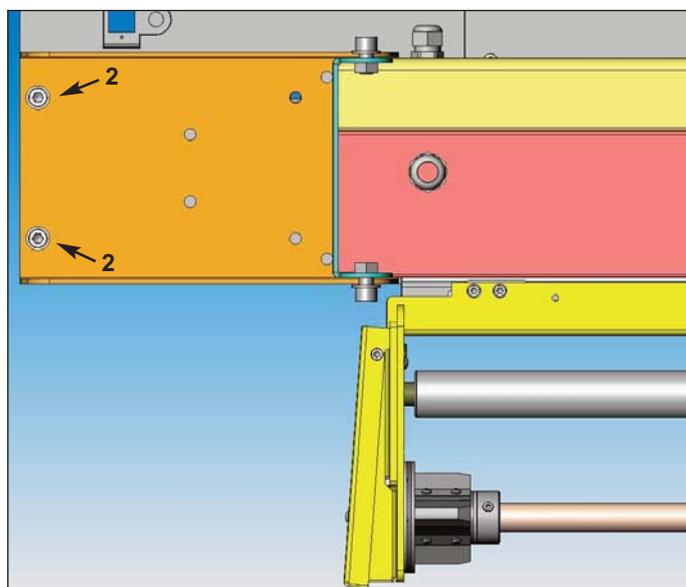


## 7-INSTALLATION

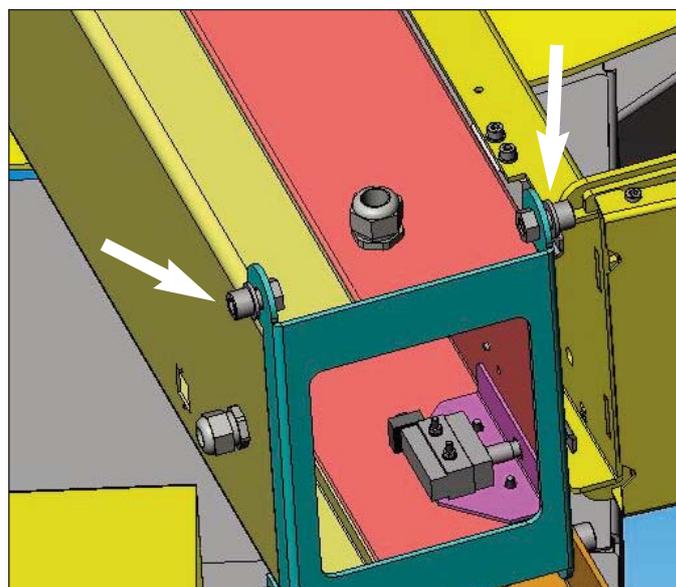
Re-screw two of the screws (2) that have been removed previously.



Remove screw (3).

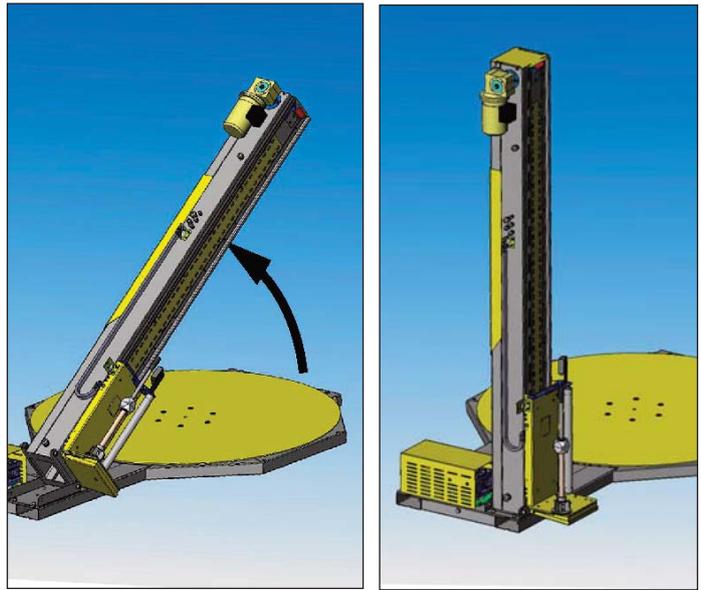


Unscrew the two screws placed on the column base.

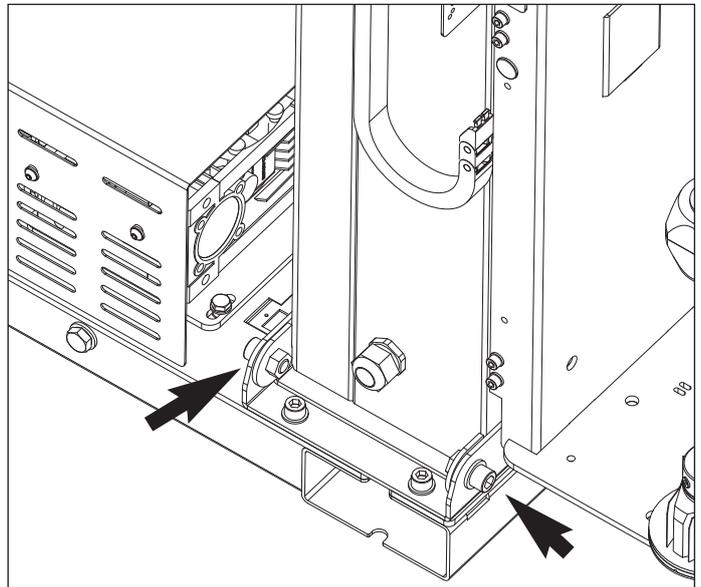


## 7-INSTALLATION

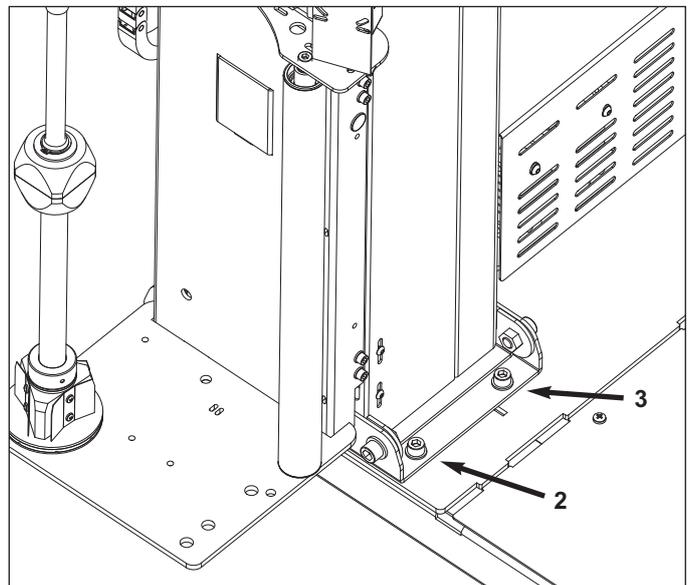
Lift the column up to bring it in vertical position



Re-screw the two screws that have been removed previously locking the column to column-fixing plate.



Lock the fixing plate to the base on the front side re-screwing the remaining screws (2,3).



## 7-INSTALLATION

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### 7.6 PRELIMINARY ELECTRICAL CHECKS

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

- 7.6.1 Make sure that the socket is provided with an earth protection circuit.
- 7.6.2 Make sure that both the mains voltage and frequency meet the indications of the serial number plate.
- 7.6.3 Check that the connection of the machine to the main meets the provisions of law and/or the safety regulations in your country.

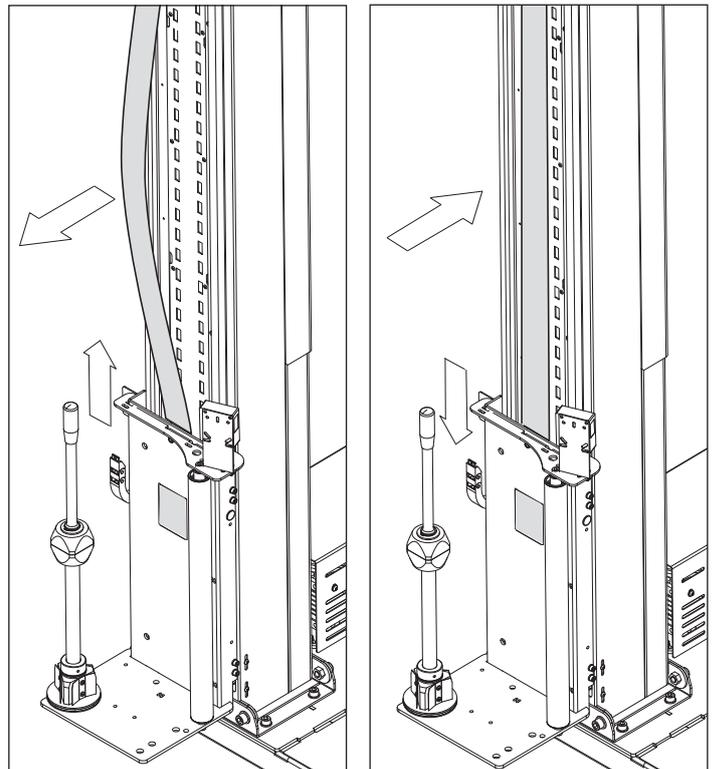
### 7.7 MACHINE CONNECTION TO THE MAINS AND CHECKS

- 7.7.1 Check that the mains switch is in 'O'-OFF position.
- 7.7.2 Connect cable supplied with the machine to a plug which complies with the safety regulations in your country.
- 7.7.3 Connect the plug to the mains.

### FIRST STARTING AND CHECK-OUT OF PHASES



Verify that the carriage lifting belt is well tense, otherwise it's necessary to unlock the mechanical protection to prevent the carriage fall, pulling the same lifting belt outside (up to lift also the carriage) and then release it slowly.

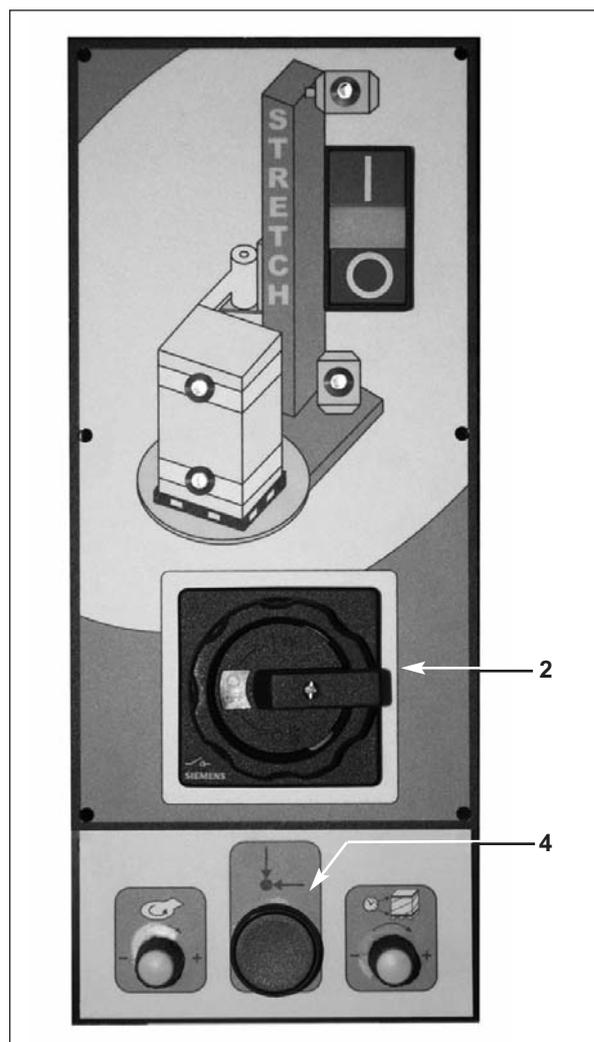


## 7-INSTALLATION

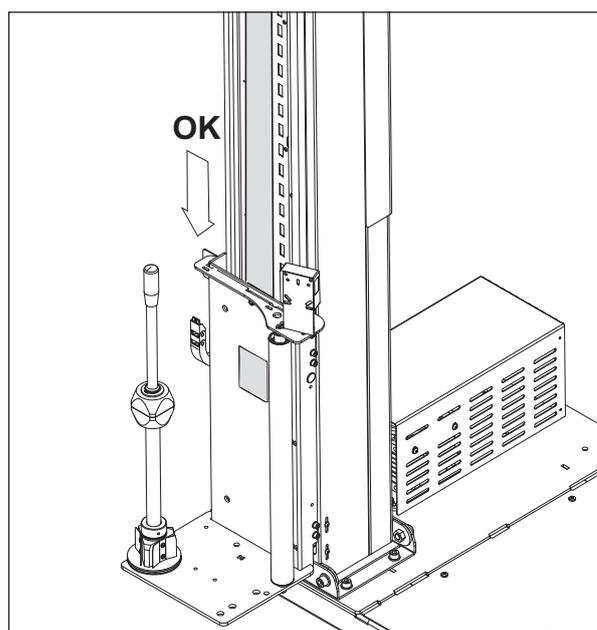
Remove any tools left on the machine.

Turn the main switch **2** clockwise to 'I'-**ON** position.

Press button **(4)**.



Verify that the carriage starts to go **down**, up to stop on the bottom limit switch position; otherwise turn the switch **(2)** on position "0" – "OFF", then disconnect the net cable and **exchange the cable of two of the power supply phases in the plug.**



## 8- CONTROLS

### 8.1 CONTROL PANEL

#### 1. START-STOP BUTTONS

Pressing the running green button (I) to start the wrapping cycle, it turns the warning white incorporated light.

Press the red button (O) to stop the wrapping cycle.

#### 2. MAIN SWITCH AND EMERGENCY STOP

Rotate clockwise on 'I-ON' position to give tension to electrical machine.

Rotate anti-clockwise on 'O-OFF' position to remove tension to electrical machine.

#### 3. ADJUSTMENT OF THE WRAPPING TIME OF THE PALLET LOW AND HIGH SIDES

It adjusts the carriage permanence time on the pallet low and high sides (load wrapping start and end).

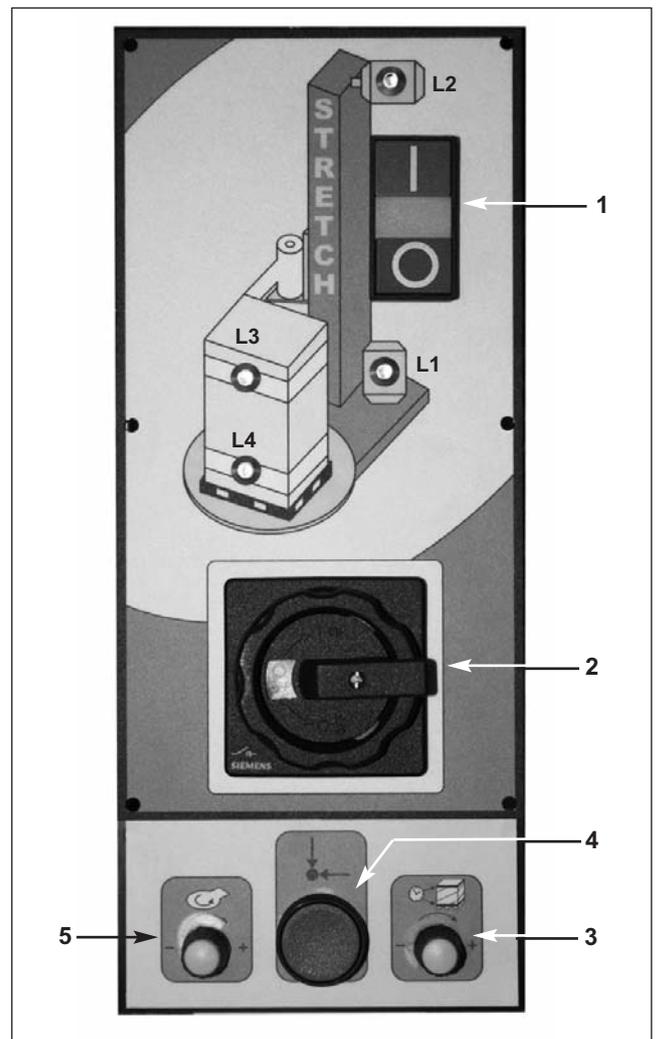
#### 4. "RESET" BUTTON

The button allows the "reset" of the machine starting conditions (carriage on bottom limit switch position and turntable on position "0").

The machine "reset" must be executed at the first starting, after a machine standard stop by button (1) if a complete wrapping cycle is not needed; an emergency stop by switch (2) or because of an intervention of a safety device.

#### 5. TURNTABLE ROTATION SPEED ADJUSTMENT

It adjusts the turntable speed and consequently if the speed is increased the film that is applied to the pallet is more.



#### **L1. CONTROL PANEL WARNING LIGHTS (LEDS):**

Turntable operation

#### **L2. CONTROL PANEL WARNING LIGHTS (LEDS):**

Film reel carriage operation

#### **L3. CONTROL PANEL WARNING LIGHTS (LEDS):**

Additional top film layers

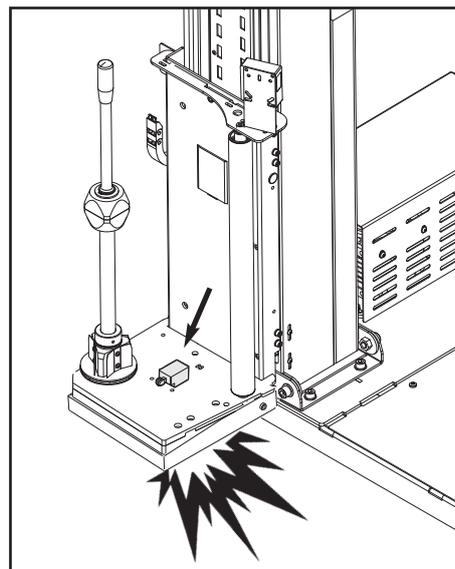
#### **L4. CONTROL PANEL WARNING LIGHTS (LEDS):**

Additional bottom film layers

## 9-SAFETY DEVICES

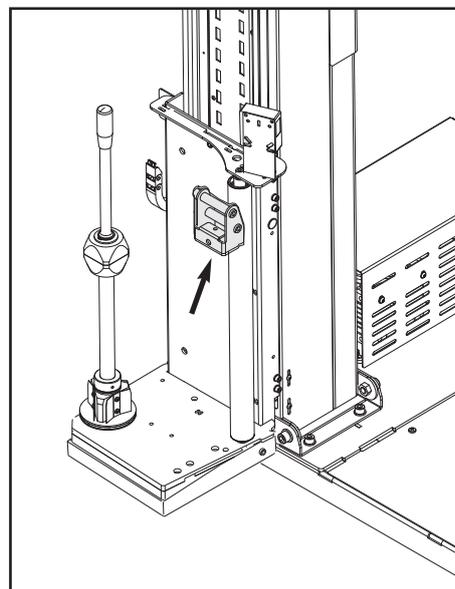
### 9.1 SAFETY SPATULA UNDER THE CARRIAGE

If activated, it stops immediately all the drivings of the machine (pressure with parts of the body or any obstacle between the safety spatula and the floor).



### 9.2 MECHANICAL FILM CARRIAGE FALL PROTECTION

This safety device lock the carriage in position on the column in the event of breakage of the raising belt.



## 10- SET UP AND ADJUSTMENT

### 10.0 SAFETY

All set up and adjustment operations must be carried out with Main Switch to **O-OFF** position.

#### MACHINE OPERATOR



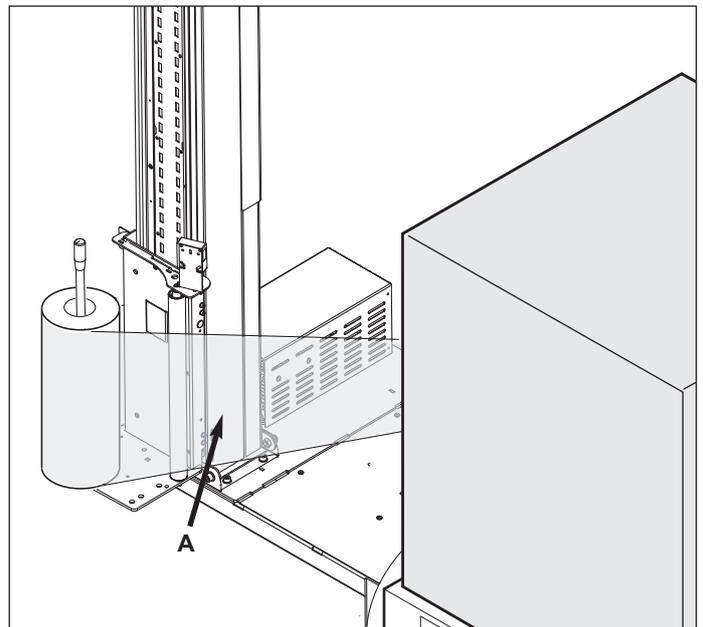
### 10.1 FILM THREADING

Position a reel of film on the reel holder as shown in the Figure.

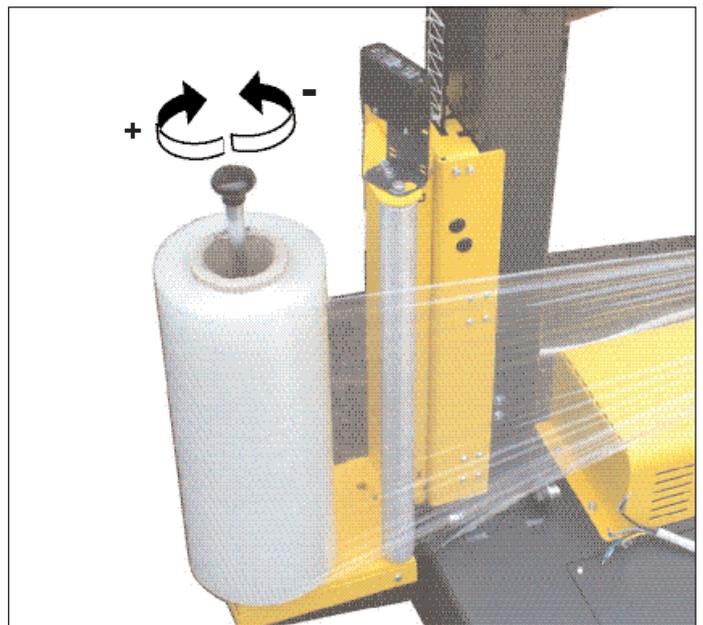


Secure the film to the pallet as shown in the figure.

**Note:** Most stretchable films have an adhesive side (**A**). Make sure that this side is positioned as in the drawing. If the film reel is wound with the adhesive side inwards, reverse it.



### 10.2 TENSION FILM ADJUSTMENT BY MECHANICAL BRAKE ON REEL SHAFT



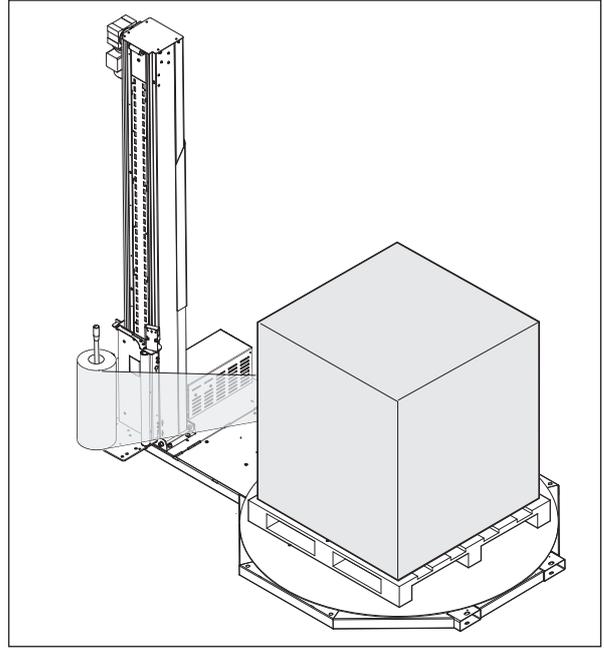
## 11-OPERATION

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### 11.1 STARTING CYCLE

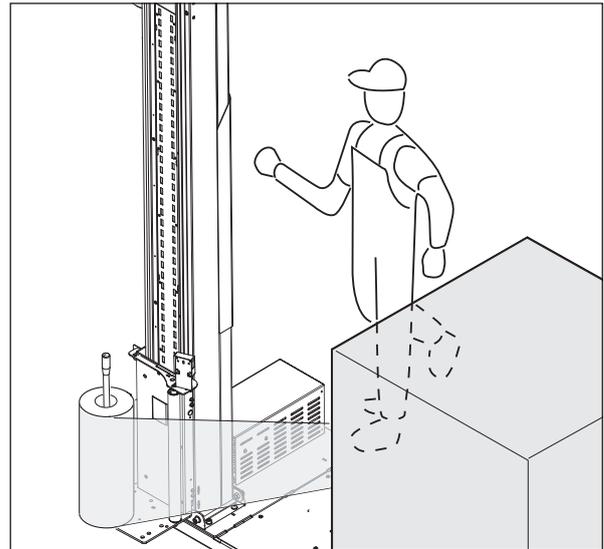
#### Working flow:

- Press start push button (I);
- Turntable starting;
- Bottom film layers (3);
- Film reel carriage ascent;
- Film reel carriage stop with time delay over the pallet (timer T1, control panel inside, see paragraph 12).
- Additional top film layers (3)
- Carriage descent;
- 'Fix position stop' of the turntable at the end of the cycle.



### 11.2 CORRECT OPERATOR WORKING POSITION

The correct operator working position is in front of the control panel during the entire pallet wrapping cycle.



### 11.3 FILM REEL REPLACEMENT

- when turntable stops, turn the Main switch on **OFF** position;
- replace the reel (sect. 10);
- restart production.

## 11-OPERATION

---

### 11.4 DURING OPERATION

#### 11.4.1 NORMAL SOP (BREAK CYCLE)

Press the red stop button (1).

To restart press the green running button (1).

- If the machine has been stopped during the ascent of film carriage, the cycle starts again with temporized wrapping load from stop position then ascent, top wrapping descent.
- If the machine has been stopped with film carriage on the top of the load the cycle starts again with temporized wrapping load from stop position then descent.
- If the machine has been stopped during the descent of film carriage, the cycle starts again with temporized wrapping load from stop position then ascent, top wrapping, descent.

#### 11.4.2 EMERGENCY STOP

Turn the main switch "2" on position "O" – "Off"; turn the main switch on position "I" – "ON" to restart, press "reset" button (4) then the green start button (1).

#### 11.4.3 STOP FOR DIFFERENT PRODUCTION DEMAND (ES. PARTIAL WRAPPING)

Press the red stop button (1), cut the film and remove the load.

Press "reset" button (4) then the green start button (1) to restart.

#### 11.4.4 STOP TO OPERATE ON SECURITY LIMIT SWITCH LOWER TILTING PANEL

Press "reset" button (4) then the green start button (1) to restart.

#### 11.4.5 STOP FOR MISSING ELECTRICAL POWER

Press "reset" button (4) then the green start button (1) to restart.

**Note: Before to re-start await 30/40 seconds for the correct restore of the electronic logic control.**

### 11.5 END PRODUCTION MACHINE STOP

With carriage in its position turn main switch (2) on position 'O-OFF'.

Disconnect the plug from the control panel.

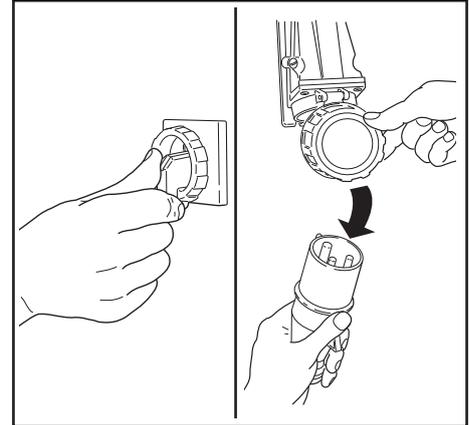
## 12- MAINTENANCE AND REPAIRS

### 12.1 SAFETY

Before every maintenance operation press the OFF button on the main switch and disconnect the plug from the control panel.

During the maintenance operation only the operator responsible for this duty should work on the machine.

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



### 12.2 TYPE AND FREQUENCY OF CHECKS AND MAINTENANCE OPERATIONS



#### MACHINE OPERATOR

**Machine cleaning:** daily.

Every cleaning operation must be made with appropriate equipment and product. Clean some foreign matter with suction, cloth, etc.

**Don't use water and solvents.**



#### ELECTRICAL/MECHANICAL MAINTENANCE TECHNICIAN

**Check out of the safety devices:** Daily

**Film carriage raising belt wear check:** Weekly

**Turntable belt wear check , lubrication and check out of tension:** Quarterly

#### DURING THE MAINTENANCE:

**Switch off all electric powers on machine before proceeding with maintenance operation.**

**Put on the machine an appropriate panel with “ MACHINE UNDER MAINTENANCE - DON'T SWITCH ON”**

**Don't bypass the security devices on the machine.**

**If necessary, advise with appropriate warning signals and work with carefulness.**

**Verify, before switch on the machine, that all maintenance people are away from the machine and tools or material are outside of it.**

**All moving and trasmission parts must be protected from accidental contacts. Check that all safety guards are in the right position before switch on the machine.**

**Check all tools are good conditions and they have an insulating handle.**

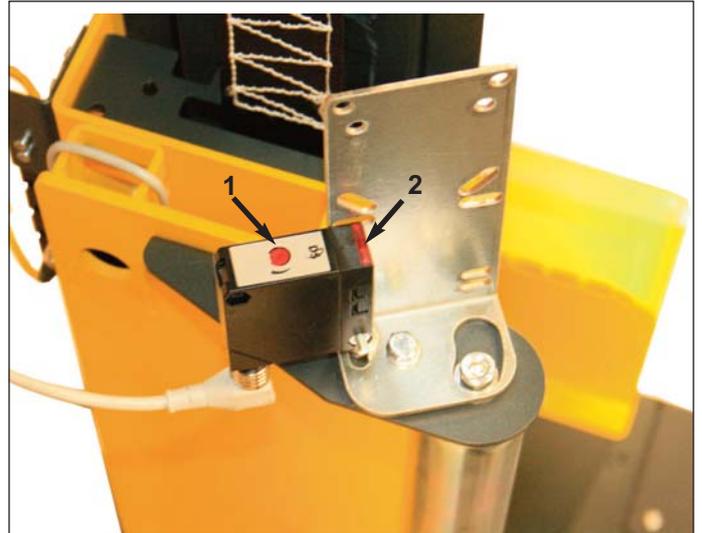
## 12- MAINTENANCE AND REPAIRS

### 12.3 PHOTOCELL ADJUSTMENT



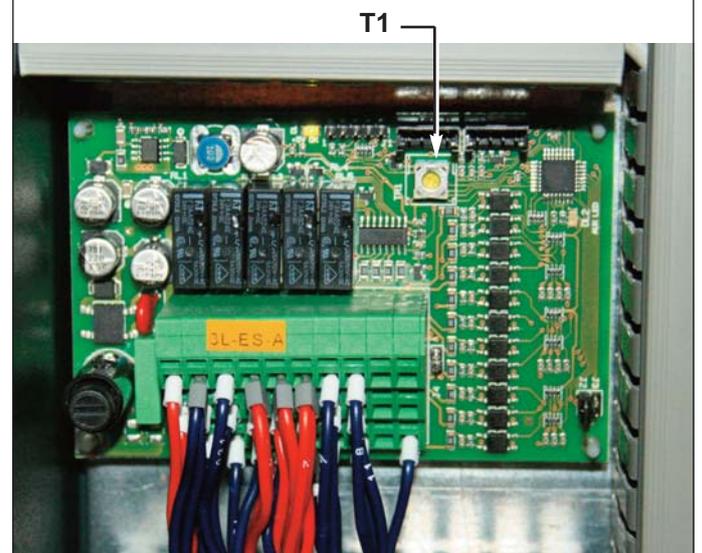
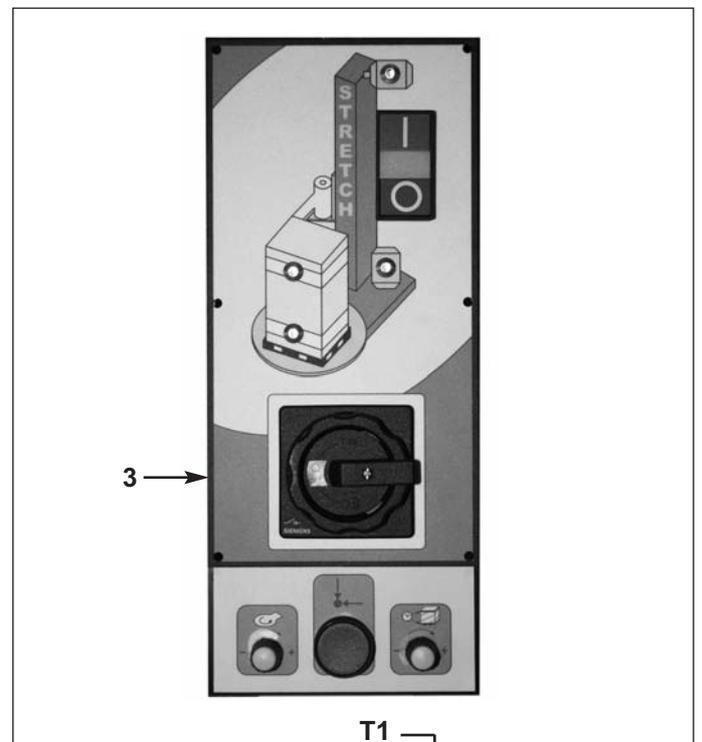
#### Sensitivity

1. Sensitivity adjustment trimmer
2. Photocell led activates



#### Activation delay

Open the control board (3) and adjust the magic eye activation delay timer (T1) (time that intervenes between the overcoming of the load upper part by the reading magic eye and the same magic eye activation).



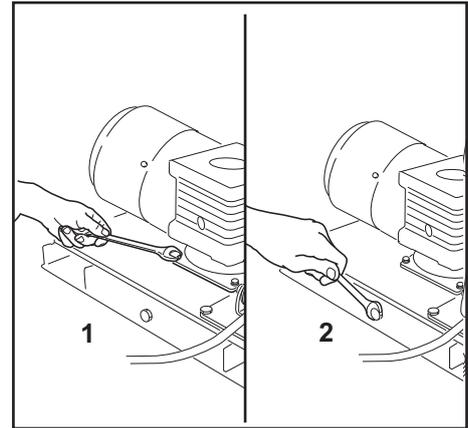
## 12- MAINTENANCE AND REPAIRS

### 12.4 TURNTABLE BELT TENSIONING - LUBRICATION

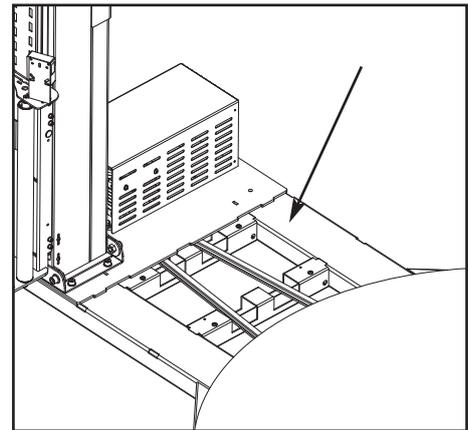


Loosen the locking screws **1** of the motor support plate and act as necessary on the adjustment screw **2**.

After have done retighten locking screws **1**.

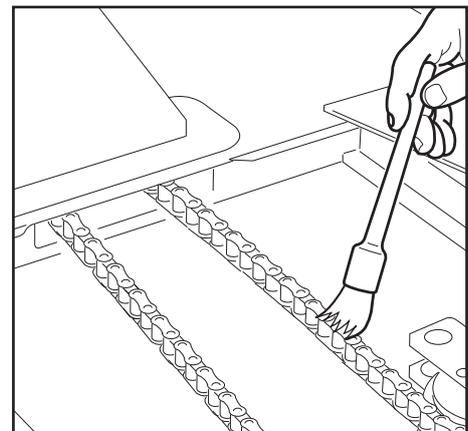


Remove the protection cover



Lubricate with grease for chains.

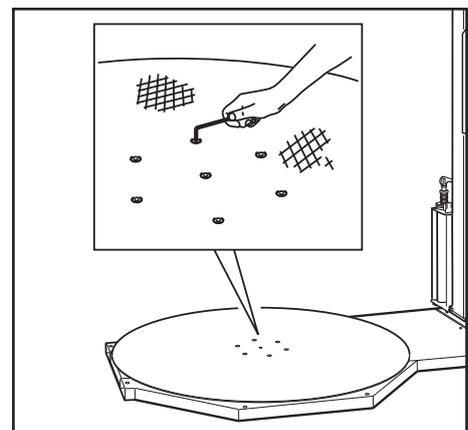
Replace and fix the protection cover.



### 12.5 REPLACEMENT OF TURNTABLE RUNNING WHEELS

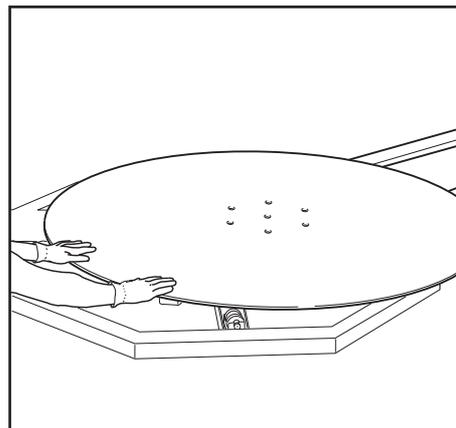


Remove the three turntable locking screw.

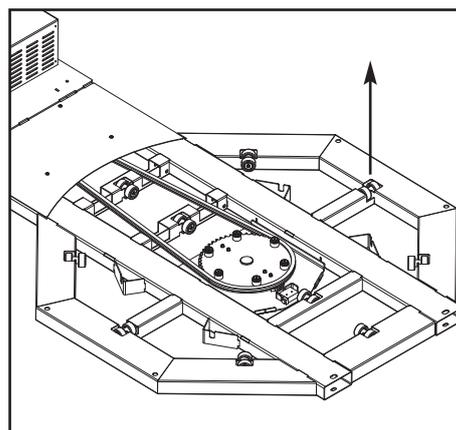


## 12- MAINTENANCE AND REPAIRS

Push the turntable onto the forks of a pallet-jack or of a forklift.

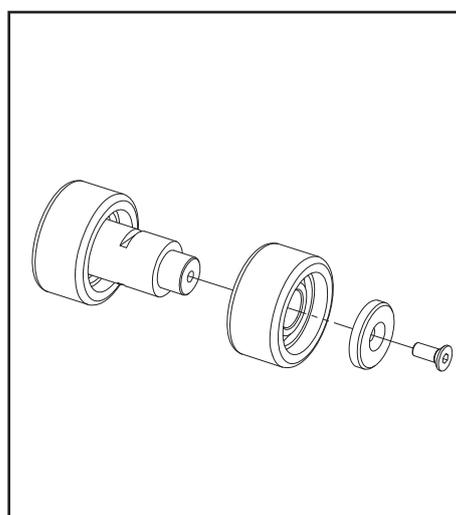


Remove wheel units.



Disassembly the units and replace the damaged components as required.

**Use only genuine spare parts.**



### 12.6 REPLACEMENT OF THE CARRIAGE BELT



Contact **SPECIALIST FROM THE MANUFACTURER.**



## 13 - ADDITIONAL INSTRUCTIONS

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### 13.1 INSTRUCTIONS FOR SCRAPPING AND DISPOSAL OF THE MACHINE

The machine is made of the following materials:

- Steel frame;
- Polyester belt;
- Nylon-polyurethane wheels.

In case of disposal of the materials comply with the law in force in your country.

Follow the RAEE Directive for the disposal of electric-electronic type components.

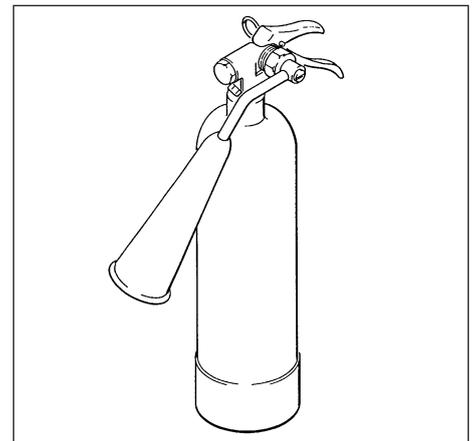
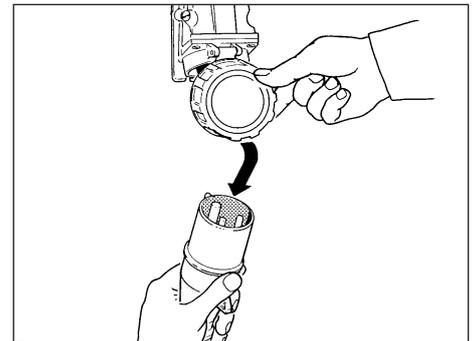
Please inform the Seller or the Manufacturer of the machine scrapping and return the identification data plate with CE marking.

### 13.2 INSTRUCTIONS ON EMERGENCY SITUATIONS

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

#### **FIRE**

In the event of fire, use a CO2 extinguisher.  
Do not use water.



## 14 - ENCLOSURES

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### 14.1 STATEMENT OF CONFORMITY

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

### 14.2 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.

### 14.3 EMISSIONS OF RADIATIONS, GAS, VAPOURS AND DUST

Nothing to report

### 14.4 ELECTRIC TESTS

Electric tests:

1 - Continuity of the ground circuit

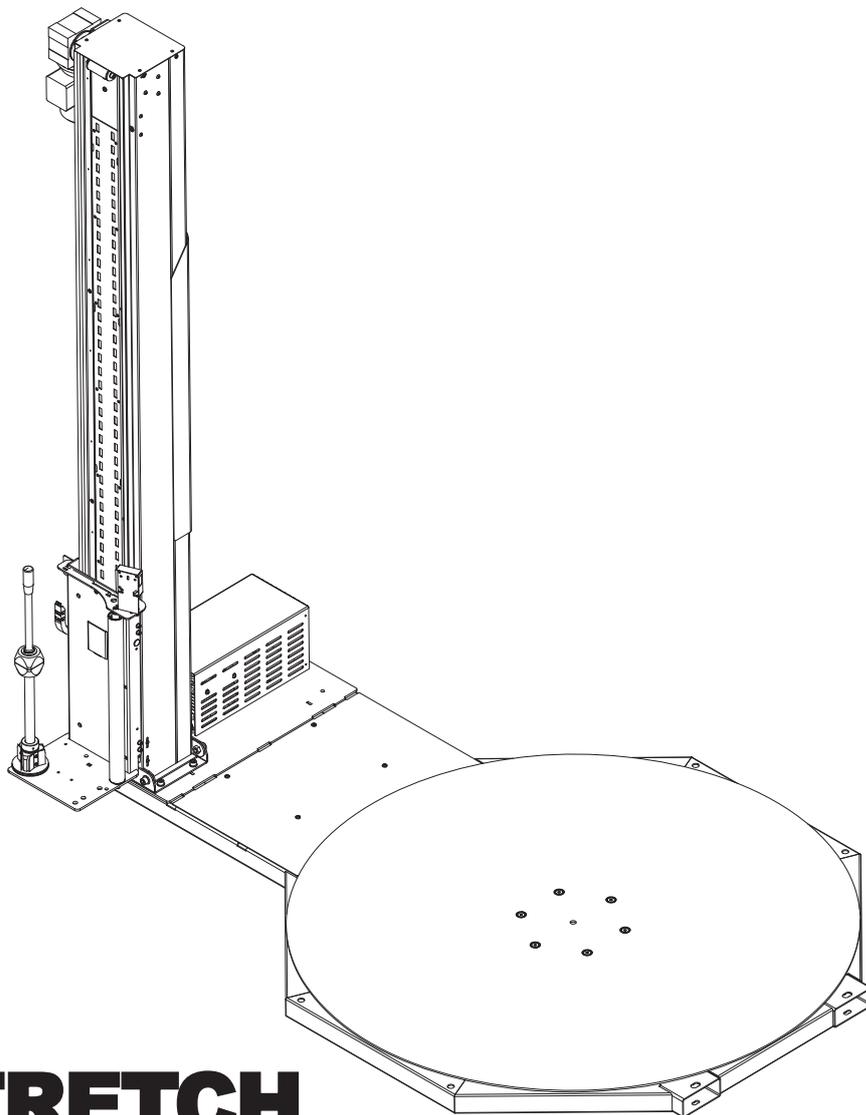
2 - Insulation resistance

3 - High voltage insulation

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

# SIAT

■ M. J. MAILLIS GROUP



## FO-STRETCH

### FASCIAPALLET SEMIAUTOMATICO

*SEMI-AUTOMATIC PALLET STRETCHWRAPPER*

*MACHINE A PALETTISER AVEC FILM ETIRABLE SEMI-AUTOMATIQUE*

*HALBAUTOMATISCHE PALETTENWICKELMASCHINE*

*ENFARDADORA DE PALES SEMIAUTOMATICA*

### MANUALE DI ISTRUZIONI E PARTI DI RICAMBIO

*INSTRUCTIONS MANUAL AND SPARE PARTS LIST*

*MANUEL D'INSTRUCTIONS ET PIECES DETACHEES*

*BEDIENUNGSANLEITUNG UND ERSTAZTEILLISTE*

*MANUAL DE INSTRUCCIONES Y RECAMBIOS*



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## CATALOGO PEZZI DI RICAMBIO COME ORDINARE

Per ordinare i pezzi di ricambio si prega di indicare nell'ordine:

MODELLO ESATTO DELLA MACCHINA/NUMERO DI MATRICOLA DELLA MACCHINA/NUMERO DELLA FIGURA DEL CATALOGO RICAMBI IN CUI COMPARE IL PEZZO RICHIESTO/NUMERO DI POSIZIONE DEL PEZZO RICHIESTO NELLA FIGURA/NUMERO DI CODICE DEL PEZZO/DESCRIZIONE DEL PEZZO/QUANTITÀ DESIDERATA

**ATTENZIONE:** LA MACCHINA VIENE COSTANTEMENTE MIGLIORATA DAI PROGETTISTI, E IL CATALOGO DEI RICAMBI SUBISCE PERIODICI AGGIORNAMENTI. È INDISPENSABILE CHE OGNI ORDINE DI PARTI DI RICAMBIO MENZIONI IL NUMERO DI MATRICOLA DELLA MACCHINA, LEGGIBILE SULLA TARGHETTA METALLICA DI IDENTIFICAZIONE DELLA MACCHINA.

**Il costruttore si riserva la facoltà di apportare modifiche alle macchine senza preavviso.**

## SPARE PARTS CATALOGUE HOW TO ORDER

When ordering spare parts, please define each part as follows:

MODEL OF MACHINE/SERIAL NUMBER OF MACHINE/NUMBER OF THE FIGURE IN THE SPARE PARTS CATALOGUE IN WHICH THE REQUESTED PARTS APPEARS/NUMBER OF POSITION OF THE REQUESTED PART IN THE FIGURE/PART NUMBER/DESCRIPTION/ DESIRED QUANTITY

**WARNING:** THE MACHINE IS CONSTANTLY REVISED AND IMPROVED BY OUR DESIGNERS. THE SPARE PARTS CATALOGUE IS ALSO PERIODICALLY UPDATED. IT IS VERY IMPORTANT THAT ALL THE ORDERS OF SPARE PARTS MAKE REFERENCE TO THE SERIAL NUMBER OF THE MACHINE, WHICH IS PUNCHED ON THE METAL NAME PLATE ON THE MACHINE.

**The manufacturer reserves the right to modify the machine at any time without notice.**

## CATALOGUE PIECES DETACHEES COMMENT COMMANDER

Pour commander les pièces de rechange, il est nécessaire d'indiquer dans l'ordre:

MODELE EXACTE DE LA MACHINE/NUMÉRO D'IDENTIFICATION DE LA MACHINE/NUMÉRO DU TABLEAU DANS LE CATALOGUE PIECES DE RECHANGE DANS LEQUEL FIGURE LA PIECE DEMANDÉE/NUMÉRO DE POSITION DANS LE CATALOGUE DE LA PIECE DEMANDÉE CODE DE LA PIECE/DESCRIPTION/QUANTITÉ DÉSIRÉE

**ATTENTION:** La machine est améliorée constamment par des projetteurs, et le catalogue des pièces de rechange subit périodiquement des mises à jour. Il est donc indispensable, que chaque commande de pièces de rechange mentionne le numéro d'identification de la machine, lisible sur la plaque métallique d'identification de la machine.

**Le constructeur se réserve le droit d'apporter des modifications aux machines sans préavis aucun.**

## ERSATZTEILE-KATALOG ERSATZTEIL-BESTELLUNG

Für die Bestellung der Ersatzteile, müssen folgende Informationen mitgeteilt werden

GENAUES MASCHINENMODELL/  
MATRIKELNUMMER DER MASCHINE/BILDNUMMER DES ERSATZTEILEKATALOGES, AUF DEM DAS GEFRAGTE TEIL BGEBILDET IST/  
POSITIONSNUMMER DES GEFRAGTEN TEILES AUF DEM BILD/BESTELLNUMMER DES ERSATZTEILE/BESCHREIBUNG DES ERSATZTEILES/ GEWÜNSCHTE MENGE

**ACHTUNG:** DIE QUALITÄT UND SICHERHEIT DER MASCHINE WIRD VON DER ENTWICKLUNGSARBEIT STÄNDIG VERBESSERT. DER ERSATZTEILE KATALOG WIRD PERIODISCH AKTUALISIERT. ES IST DAHER NOTWENDIG, DAß ALLE ERSATZTEIL-BESTELLUNGEN IMMER DIE MATRIKELNUMMER ERWÄHNEN, DIE AUF DEM METALLSCHILD DER MASCHINE STEHT.

**Der Hersteller behält sich die Möglichkeit vor, eventuelle Änderungen an der Maschine ohne Vorabinformation durchzuführen.**

## CATALOGO PIEZAS DE RECAMBIO COMO PEDIR

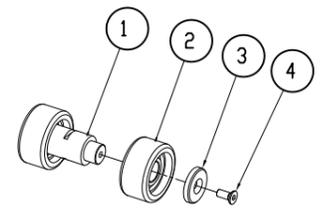
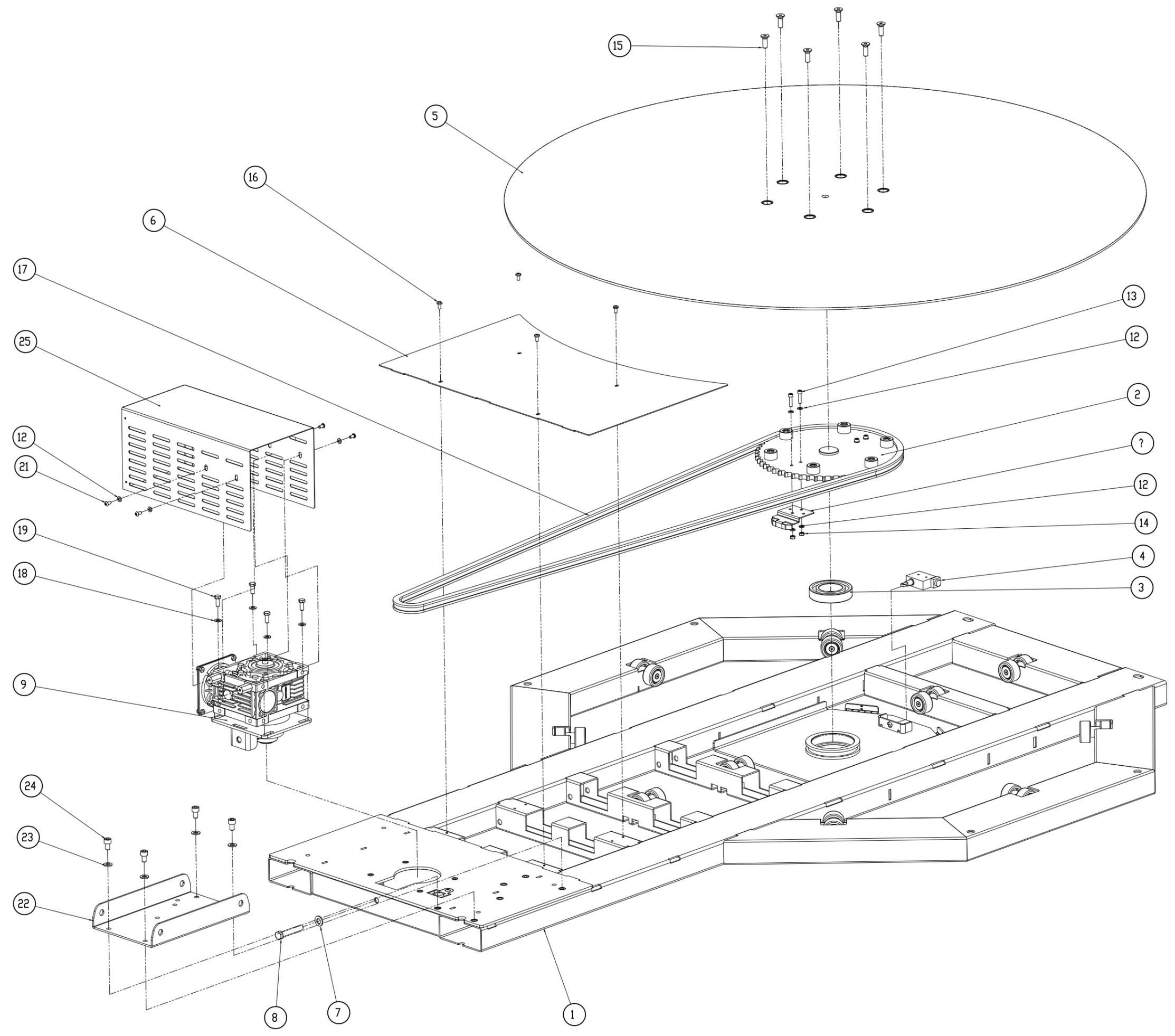
Para pedir las piezas de recambio se ruega indicar en el pedido:

MODELO EXACTO DE LA MÁQUINA/ NÚMERO DE MATRÍCULA DE LA MÁQUINA/NÚMERO DE LA FIGURA DEL CATÁLOGO RECAMBIOS EN LOS QUE APARECE LA PIEZA PEDIDA/ NÚMERO DE POSICIÓN DE LA PIEZA SOLICITADA EN LA FIGURA/ NÚMERO DE CÓDIGO DE LA PIEZA/ DESCRIPCIÓN DE LA PIEZA/CANTIDAD DESEADA

**ATENCIÓN!** LA MÁQUINA ES CONSTANTEMENTE MEJORADA POR LOS PROYECTISTAS, POR LO QUE EL CATÁLOGO DE RECAMBIO ES ACTUALIZADO PERIÓDICAMENTE. ES INDISPENSABLE QUE TODOS LOS PEDIDOS DE PIEZAS DE RECAMBIO HAGAN MENCIÓN DEL NÚMERO DE MATRÍCULA DE LA MÁQUINA, LEGIBLE EN LA PLACA METÁLICA DE IDENTIFICACIÓN DE LA MÁQUINA.

**El fabricante se reserva la facultad de aplicar modificaciones a las máquinas sin previo aviso.**

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Pos.	Quantità	Codice	Denominazione
1	1	SBC0010239T	PERNO ROTELLE BASE
2	2	SBA000485I	RUOTA BASE
3	2	S330221593A	RONDELLA M6,5/20M5
4	2	S340049932A	VITE TS/VEI M6x15 ZINCATI

Pos.	Quantità	Codice	Denominazione
1	1	SBA000527V	BASE IS SAL B. FO
2	1	S440852300A	CORONA 3/4 755 COMP. WS150
3	1	S3401751227	CUSCINETTO SGLI 255
4	1	SBA000082	PREPARATO FINECOSA CINGHIA
5	1	SBA009396V	PIATTAFORMA ROTANTE COMP. STRETCH
6	1	SBC0010239V	PANNELLO SPEZZIONE
7	1	S340062932	RONDELLA PIANA X VITE M6 ZINC.
8	1	S340049932	VITE TE M6x15 BRONITA
9	1	SBA000533	PIATTAFORMA VSF. POKA
10	14	SBA000535	RUOTE BASE POKA
11	2	SBC0006138	CAMMA PIATTAFORMA PAKLET
12	12	S340179932	RONDELLA PIANA X VITE M6 ZINC.
13	4	S340005932	VITE TCEI M6x20 ZINCATI
14	4	S340025932	SMO M6 ZINCATO A BASSA RESIST.
15	6	S340178932	VITE TS/VEI M6x15 ZINCATI
16	4	S340514932A	VITE TROBATE M6x12 TESTA TCBOR (EXTR)
17	1	SCA000922	SPEZZIONE CATENA 3/4 172 M6 COMP. GIUNTO
18	4	S340129932	RONDELLA PIANA X VITE M6 ZINC.
19	4	S340028932	VITE TE M6x15 ZINCATI
20	2	SBC0010101	RUOTA A RINNIFFI BASE
21	4	S340149932	VITE TCEI M6x12 ZINC.
22	1	SBC0014283V	PIASTRA FISSAGGIO COLONNA
23	5	S340029932	RONDELLA PIANA X VITE M6 ZINC.
24	4	S3400849932	VITE TCEI M6x15 SERIE L
25	1	SBC0009329	CAMMA BASE STRETCH

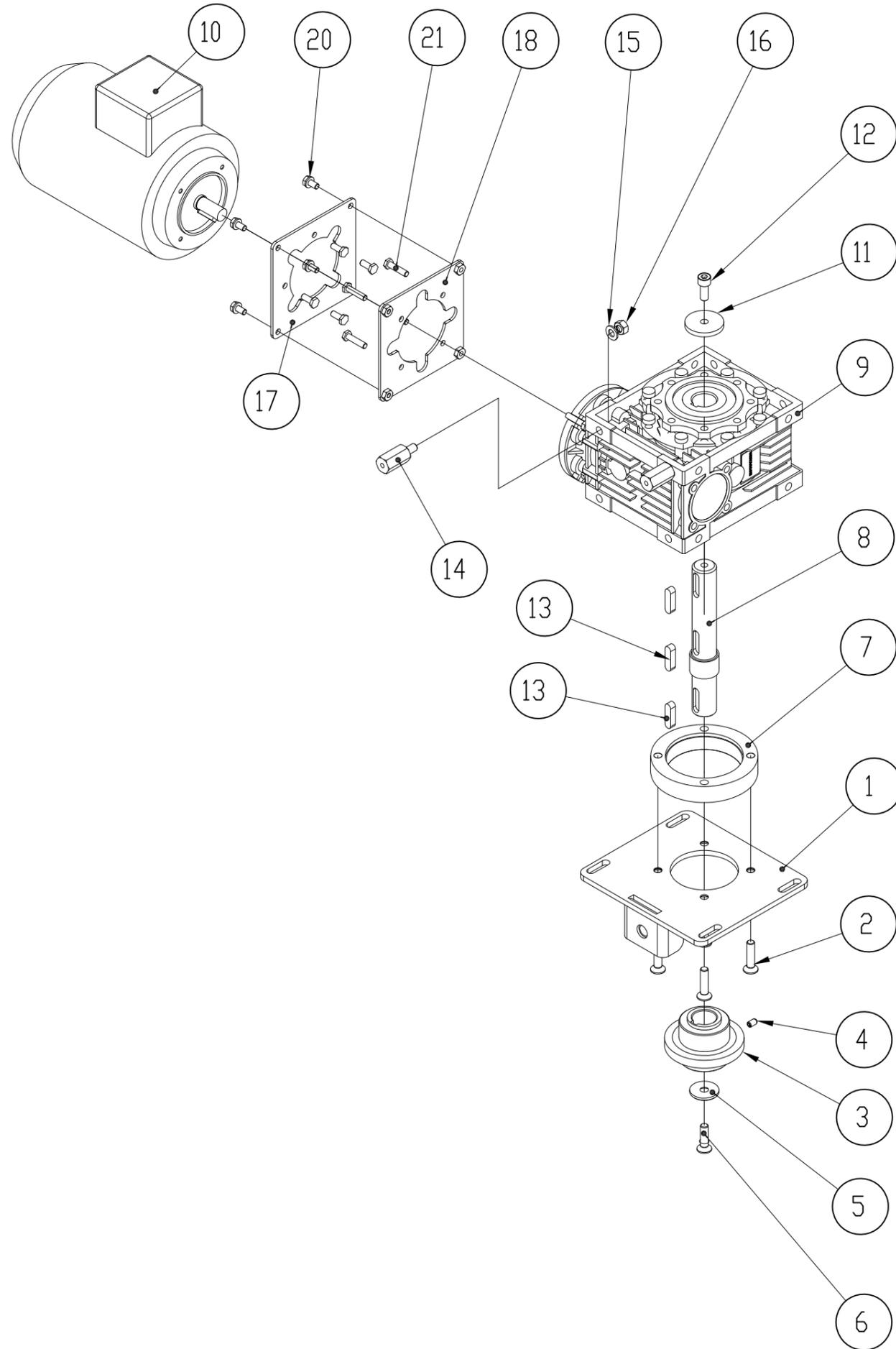
TOLLERANZE GENERALI DI LAVORAZIONE (salvo specifiche diverse)

QUOTE LINEARI	FORSI NEI
0-10	±0,10
10-30	±0,15
30-100	±0,20
100-300	±0,30
300-1000	±0,40
1000-3000	±0,50
3000-10000	±0,60
10000-30000	±0,70
30000-100000	±0,80
100000-300000	±0,90
300000-1000000	±1,00
1000000-3000000	±1,10
3000000-10000000	±1,20
10000000-30000000	±1,30
30000000-100000000	±1,40
100000000-300000000	±1,50
300000000-1000000000	±1,60
1000000000-3000000000	±1,70
3000000000-10000000000	±1,80
10000000000-30000000000	±1,90
30000000000-100000000000	±2,00
100000000000-300000000000	±2,10
300000000000-1000000000000	±2,20
1000000000000-3000000000000	±2,30
3000000000000-10000000000000	±2,40
10000000000000-30000000000000	±2,50
30000000000000-100000000000000	±2,60
100000000000000-300000000000000	±2,70
300000000000000-1000000000000000	±2,80
1000000000000000-3000000000000000	±2,90
3000000000000000-10000000000000000	±3,00

TRATTAMENTO: F0  
 CODICE: SBA000533  
 DESCRIZIONE: GR.PIATTAFORMA WS15 FO  
 DATA: 06.05.2009  
 AUTORE: A.Verga  
 VERIFICATO: 15  
 APPROVATO: 1  
 MATERIALE: SBA000533-ET A0

A meno di legge il ribaltamento la proprietà di questo disegno con diritto di riprodotto, resterà in esecuzione e renderlo noto a terzi.

Note



Rev.	N. ECO	Data	Descrizione della modifica	Disegnato	Controllato
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10	1	SCC0002115	MDT.71B4 B14 C105 0.37Kw230/400V 50Hz		
10	1	SCC0002124	MDT.71B4 B14 C105 0.37Kw 440V 50Hz 3PH		

Pos.	Quantità	Codice	Denominazione
1	1	SBA0006536V	FLANGIA SUPPORTO M.RIDUTTORE V.S.F.
2	4	S340066993Z	VITE TSVEI M8X35 ZINCATA
3	1	S332945600A	PIGNONE Z=12 -3/4" WS15
4	1	S340046292Z	GRAND EIPC M6X10 BR.
5	1	S331823893A	RONDELLA /8 SP.4mm HS
6	1	S340017293Z	VITE TSVEI M8X30 ZINC.
7	1	S332624000A	ANELLO DISTANZIALE W
8	1	SBC0010292T	ALBERO RIDUTTORE BASE
9	1	S380621700A	RID. MOTOVARIO NMRV063 PAM71 B14 i:40
11	1	S331802593A	RONDELLA DIAM.8/40 SP WS3/3000
12	1	S340012293Z	VITE TCEI M8X20 ZINCATA
13	3	S3400481ZZZ	LINGUETTA 7X8X30
14	2	SBC0010409T	DISTANZIALE FISSAGGIO CARTER
15	2	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
16	2	S340000393Z	DADO M8 ZINCATO
17	1	SBC0012531	FLANGIA ADATTAM. LATO MDT.
18	1	SBA0007579	FLANGIA ADATTAM.C-DADI
19	4	S340002193Z	VITE TE M6X12 ZINCATA
20	4	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
21	4	SBC0012508	VITE SPECIALE M6x25
22	4	SBC0012507	VITE SPECIALE M6x15

TOLLERANZE GENERALI DI LAVORAZIONE (salvo specifiche diverse)

QUOTE LINEARI									FORI H11		-PER I PARTICOLARI DI MACCHINA UTENSILE RIMOVERE TUTTE LE BAVE E ROMPERE TUTTI GLI SPIGOLI S <sub>0</sub> 0,1-0,4 con	
CLASSE DI TOLLERANZA	Fino a 6	da 6 a 30	da 30 a 120	da 120 a 315	da 315 a 1000	da 1000 a 2000	da 2000 a 4000	oltre 4000	ALBERI h11	ANGOLI ±30'	LAVORATI	LAMIERA
grossolano <input type="checkbox"/>	±0.2	±0.5	±0.8	±1.2	±2	±3	±4	±5			3.2	3.2
medio <input type="checkbox"/>	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3			✓	✓
preciso <input type="checkbox"/>	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5	-	-				

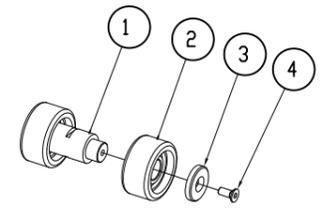
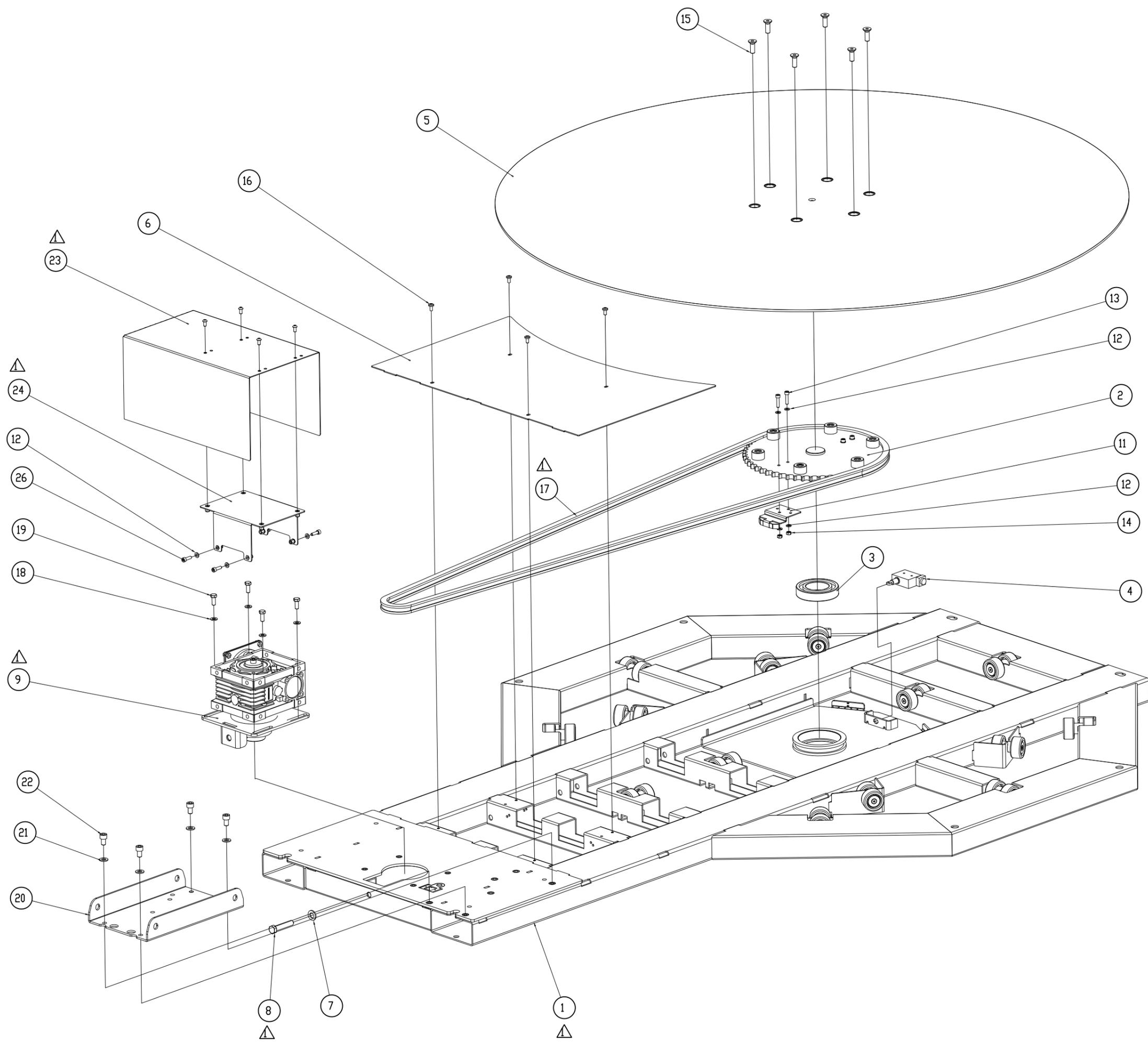
MACCHINA  
FO-STRETCH

 <b>SIAT</b> M. J. MAILLIS GROUP	CODICE <b>SBA0006537</b> DESCRIZIONE <b>RIDUTTORE PREMONT. WS2</b> SOTTODESCRIZIONE	Verniciato 0 REV. 1	Disegnato <b>A.Verga</b> Data <b>29-12-2009</b> Dis. N. <b>SBA0006537-AT</b>	Visto  Scala <b>1:5</b> Formato <b>A3</b>	Tavola <b>2 di 2</b>
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//  ⊥  ⊙  ⊕  ✓  ✓  
 LAVORATI: 3.2 LAMIERA: 3.2  
 SUB TAGLI

Codice secondario

A termini di legge ci riserviamo la proprietà di questo disegno con divieto di riprodurlo, metterlo in esecuzione o renderlo noto a terzi



Pos.	Quantità	Codice	Denominazione
1	1	SBC000291	PERNO ROTELLE BASE
2	2	SBA0004931	ROTTA BASE
3	2	S30029593A	RONDELLA 16,5/20,5
4	2	S34009593A	VITE 13V61 M6X10 ZINCATO

Pos.	Quantità	Codice	Denominazione
1	1	SBA0009687V	BASE COMP. FB-STRETCH
2	1	S44005290A	CORONA 3/4 ZNS COMP. WS10
3	1	S340178272	CUSCINETTO 6201 2RS
4	1	S380000813	PRECALATO FINECORSA CINGHIA
5	1	SBA0009261V	PIATTAFORMA ROTANTE COMP. STRETCH
6	1	SBC000279V	PANNELLO ISPEZIONE
7	1	S340006293Z	RONDELLA PIANA X VITE M6 ZINC.
8	1	S340006292Z	VITE T6 M6 X 50
9	1	SBA0009689	REDUTTORE VSF PREM. FB-STRETCH
10	14	SBA0006535	ROTTA BASE PREM.
11	2	SBC0006638	CAMMA PIATTAFORMA PAULET
12	12	S340017993Z	RONDELLA PIANA X VITE M6 ZINC.
13	4	S34000593Z	VITE T6 M6 X 20 ZINCATO
14	4	S340029593Z	DAURO M6 ZINCATO A BASSA RESIST.
15	6	S340018293Z	VITE 13V61 M6X10 ZINCATO
16	4	S340014093A	VITE TRILOBATE M6X12 TESTA T6CBK CTXTR
17	1	S34000394	SPEZZONE CATENA 3/4" 180 M6COMPAGNITO
18	4	S34000293Z	RONDELLA PIANA X VITE M6 ZINC.
19	4	S34000993Z	VITE T6 M6 X 20 ZINCATO
20	1	SBC0014363V	PIASTRA FISSAGGIO COLONNA
21	5	S34001293Z	RONDELLA PIANA X VITE M6 ZINC.
22	4	S340004992Z	VITE T6 M6 X 20 ZINCATO
23	1	SBC0004503V	CARTER RIB. VSF BASE FB-STRETCH
24	1	SBA0007957	STAFFA FISSAGGIO CARTER VSF 2V1 C/INS.
25	4	S340174993Z	VITE T6 M6 X 20 ZINC.
26	4	S34000693Z	VITE T6 M6 X 20 ZINCATO

TOLLERANZE GENERALI DI LAVORAZIONE (salvo specifiche diverse)

TOLLERANZE LINEARI		TOLLERANZE ANGOLARI		TOLLERANZE DI BILANCIA	
mm	mm	mm	mm	mm	mm
0-10	0-10	0-10	0-10	0-10	0-10
10-20	10-20	10-20	10-20	10-20	10-20
20-30	20-30	20-30	20-30	20-30	20-30
30-40	30-40	30-40	30-40	30-40	30-40
40-50	40-50	40-50	40-50	40-50	40-50
50-60	50-60	50-60	50-60	50-60	50-60
60-70	60-70	60-70	60-70	60-70	60-70
70-80	70-80	70-80	70-80	70-80	70-80
80-90	80-90	80-90	80-90	80-90	80-90
90-100	90-100	90-100	90-100	90-100	90-100

TRATTAMENTO: F0

REVISIONE: SBA0008533

DESCRIZIONE: GRUPPI PIATTAFORMA WS15 F0

DATA: 12.01.2010

SCALE: 1:5

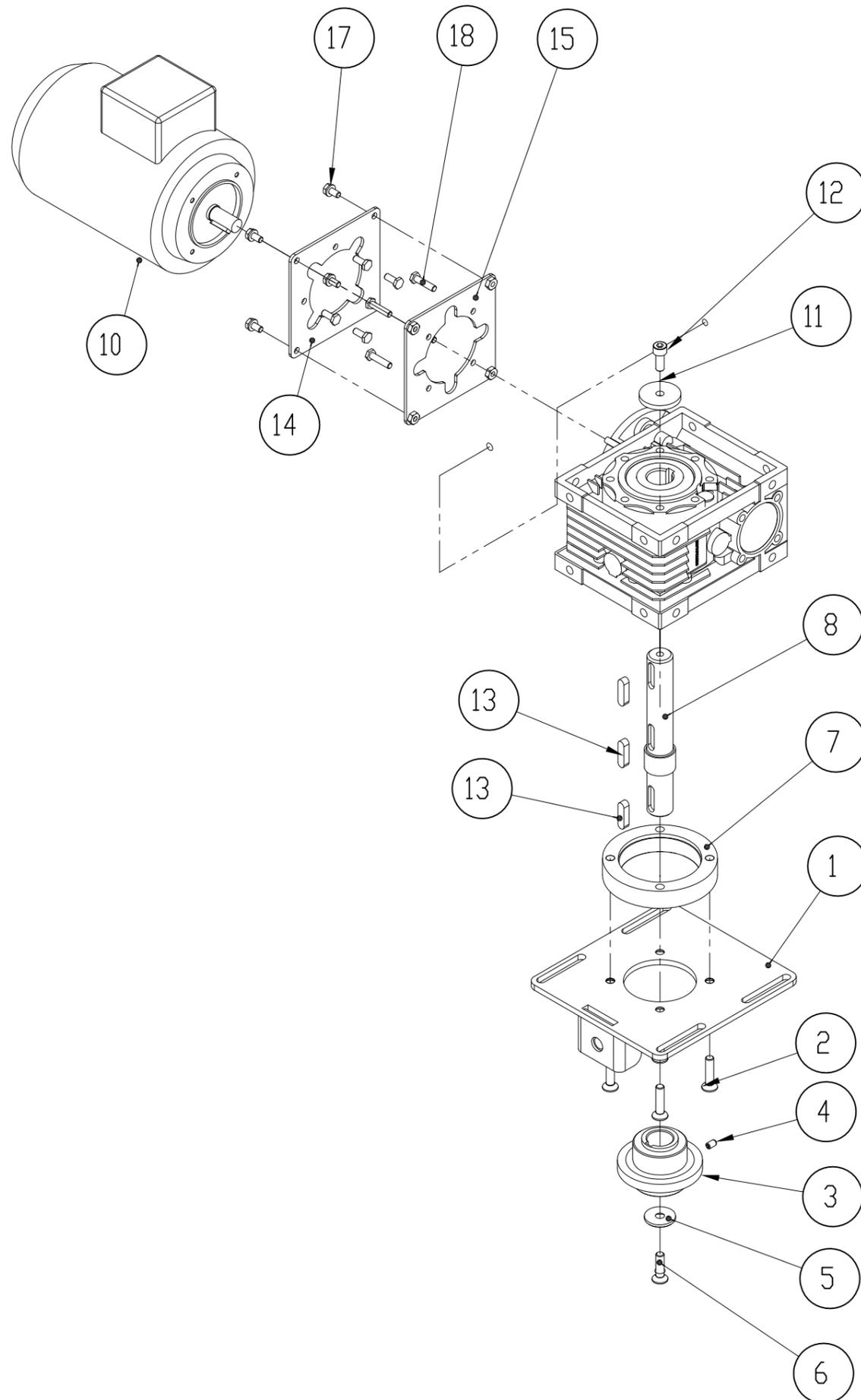
FOGLIO: 1 di 1

PRODOTTORE: SBA0008533-ET

PRODOTTORE: A0

A meno di legge di riservare la proprietà di questo disegno con diritto di riproduzione, vietando la esecuzione o reimpiego a terzi.

Note



Rev.	N. ECD	Data	Descrizione della modifica	Disegnato	Controllato
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10	1	SCC0002115	MT.71B4 B14 C105 0.37Kw230/400V 50Hz		
10	1	SCC0002124	MT.71B4 B14 C105 0.37Kw 440V 50Hz 3PH		

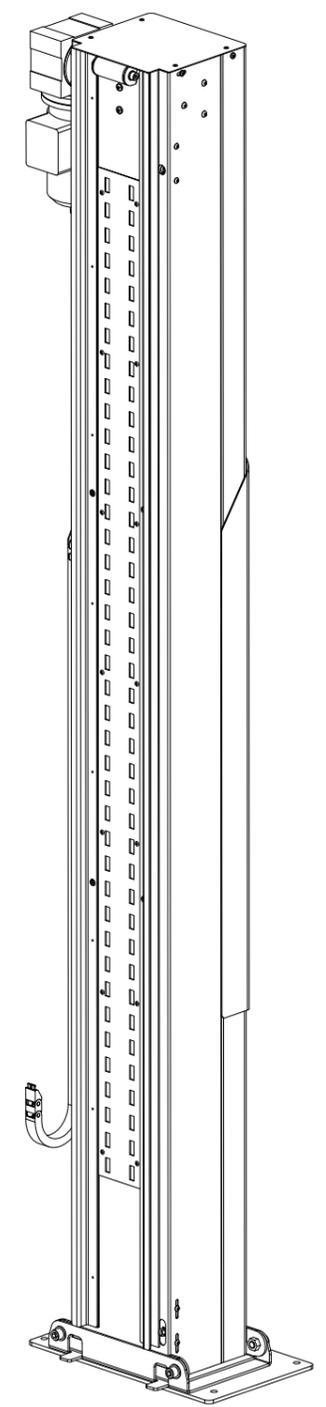
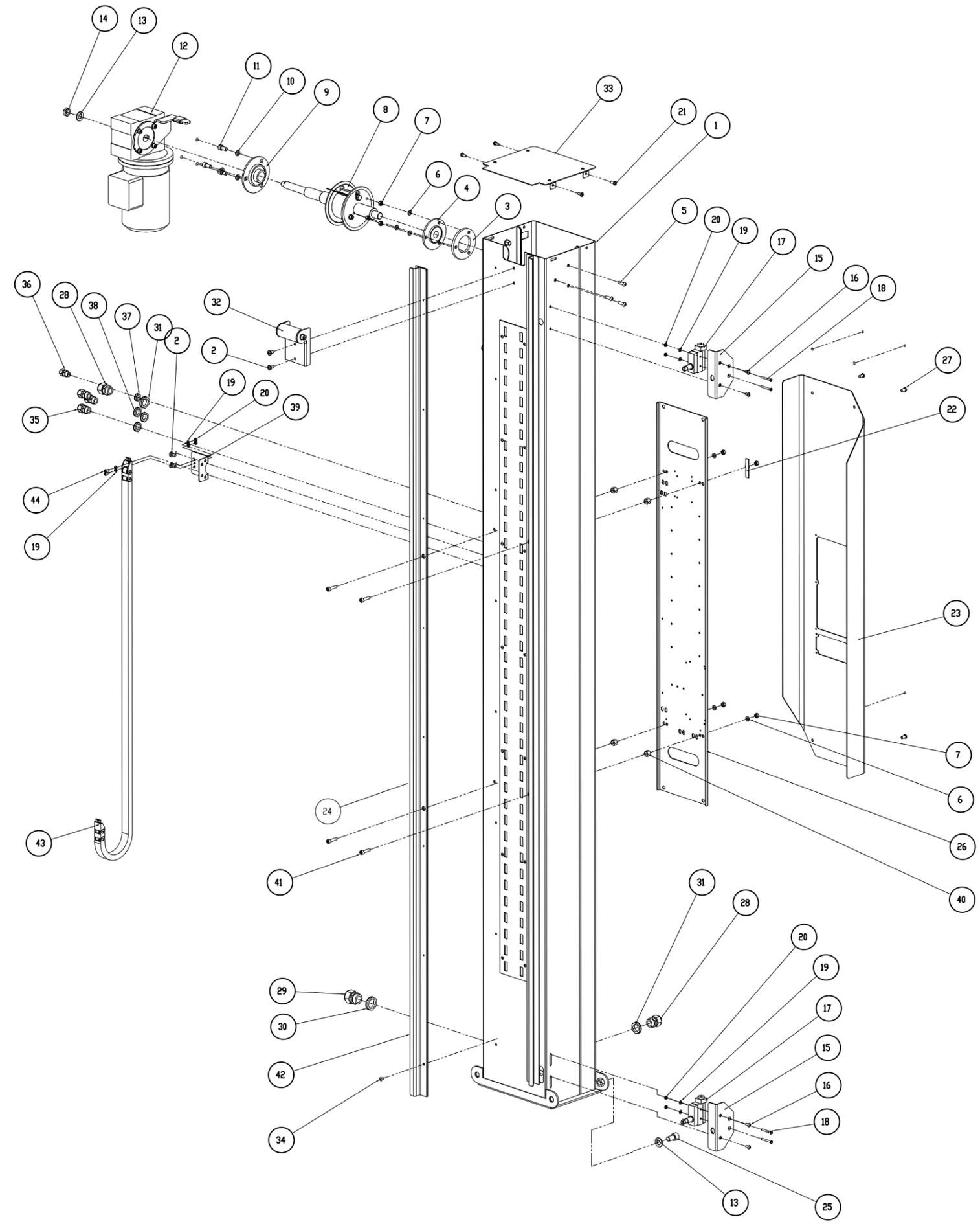
Pos.	Quantità	Codice	Denominazione
1	1	SBA0009688V	FLANGIA SUPP.RID.VSF.COMP.F0-STRETCH
2	4	S340066993Z	VITE TSVEI M8X35 ZINCATA
3	1	S332945600A	PIGNONE Z=12 -3/4" WS15
4	1	S340046292Z	GRAND EIPC M6X10 BR.
5	1	S331823893A	RONDELLA /8 SP.4mm HS
6	1	S340017293Z	VITE TSVEI M8X30 ZINC.
7	1	S332624000A	ANELLO DISTANZIALE W
8	1	SBC0010292T	ALBERO RIDUTTORE BASE
9	1	S380621700A	RID. MOTOVARIO NMRV063 PAM71 B14 i:40
11	1	S331802593A	RONDELLA DIAM.8/40 SP WS3/3000
12	1	S340012293Z	VITE TCEI M8X20 ZINCATA
13	3	S3400481ZZZ	LINGUETTA 7X8X30
14	1	SBC0012531	FLANGIA ADATTAM. LATO MT.
15	1	SBA0007579	FLANGIA ADATTAM.C-DADI
16	4	S340002193Z	VITE TE M6X12 ZINCATA
17	4	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
18	4	SBC0012508	VITE SPECIALE M6x25
19	4	SBC0012507	VITE SPECIALE M6x15

TOLLERANZE GENERALI DI LAVORAZIONE (salvo specifiche diverse)

QUOTE LINEARI									FORI H11		-PER I PARTICOLARI DI MACCHINA UTENSILE RIMUOVERE TUTTE LE BAVE E ROMPERE TUTTI GLI SPIGLI Sn 01-04 con 3.2				
CLASSE DI TOLLERANZA	fino a 6	da 6 a 30	da 30 a 120	da 120 a 315	da 315 a 1000	da 1000 a 2000	da 2000 a 4000	oltre 4000	ALBERI h11	ANGOLI ±30'	-PER I PARTICOLARI IN LAMIERA IN LUOGO DI EVENTUALI RACCORDI POSSONO ESSERE ESEGUITI SMUSST A 45° DI PARI MISURA				
grossolano	±0.2	±0.5	±0.8	±1.2	±2	±3	±4	±5			LAVORATI SU	LAMIERA			
medio	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3			3.2	3.2			
preciso	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5	-	-			SUI TAGLI				
MATERIALE										MACCHINA					
TRATTAMENTO										F0-STRETCH					
CODICE										REV. 1		Disegnato A.Verga		Visto	
DESCRIZIONE										Data		Scala		Tavola	
SOTTODESCRIZIONE										29-12-2009		1:5		2 di 2	
Dis. N.										SBA0009689-ET		Formato		A3	
Codice secondario															



A termini di legge ci riserviamo la proprietà di questo disegno con divieto di riprodurlo, metterlo in esecuzione o renderlo noto a terzi



H= 2100 mm

Pos.	Quantità	Codice	Denominazione
1	1	SBA000574	GRUPPO COLONNA C/ING. V5100
2	4	S34054093A	VITE TROLOBATE M4X2 TESTA TCRBR CEXTR
3	1	S32165520M	ROSTAZIALE PER SUPPORTO URP203 V5100
4	1	S340341427Z	SUPPORTO FLANGIATO URP203/NXK
5	3	S34000093Z	VITE T8X1 M6x20 ISO 7380 ZINC.
6	7	S34000293Z	RENDELLA PIANA X VITE M6 ZINC.
7	7	S34000293Z	BADO M6 ZINCATO
8	1	S47142820M	PULLEGIA C/ALBERO PREM. V51
9	1	S340321027Z	SUPPORTO "NSX URP203"
10	3	S34000693Z	RENDELLA ELASTICA DIAM6
11	3	S34000493Z	VITE T8X1 M6x12
12	1	S34000049Z	MATERIALE DI FISSAMENTO
13	5	S34000693Z	RENDELLA PIANA X VITE M6 ZINC.
14	1	S34022393Z	BADO SPECIALE/ROD. M2 P.1
15	2	S45020047Z	SQUADRETTA MICRO C/ING. V5100
16	4	S34012553Z	VITE T8X1 M6x10 KIT X KIT3
17	2	S38020632Z	FINE COPRA BARE-S025
18	4	S34000493Z	VITE TSVEI M4X5 ZINCATA
19	10	S34000493Z	RENDELLA PIANA X VITE M4 ZINC.
20	6	S34000093Z	BADO M4 ZINCATO
21	4	S34019893Z	VITE T8X1 M6x12 ZINC.100%Zn
22	1	S340321027Z	S340321027Z COPRA M6x12 TIPS ISO 1002m
23	1	S8000628V	SPORTELLO QUADRO EL. FO
24	2	SBA000957I	
25	4	S34019893Z	VITE T8X1 M6x12 ZINCATA
26	1	S32165520A	PANNELLO COMPONENTI V51
27	4	S34019893Z	VITE T8X1 M6x12 ZINC.
28	3	S38020630A	BUCCHETTONE PRESSACAVO M6X15 GRIGIO
29	1	S38054400A	BUCCHETTONE PRESSACAVO M6X15 GRIGIO
30	1	S38054400A	BADO PER BUCCHETTONE M6X15 GRIGIO
31	3	S38054400A	BADO PER BUCCHETTONE M6X15 GRIGIO
32	1	SBA00001Z	PALLA RIVOLTO PER X
33	1	SBA000694S	CARTER COLONNA COMP. STRETTA
34	16	S34051300A	RIVETTO "AVVERBA" IN ACCIAIO COB.100%Zn
35	3	S38054400A	BUCCHETTONE PRESSACAVO M6X15 GRIGIO
36	1	S38054400A	BADO PER BUCCHETTONE M6X15 GRIGIO
37	1	S38054400A	BADO PER BUCCHETTONE M6X15 GRIGIO
38	3	S38054400A	BADO PER BUCCHETTONE M6X15 GRIGIO
39	1	S8000994	SQUADRETTA CATENA P.ZAVI
40	4	S33208693A	COLONNINA QUADRO V5100 ZINC.
41	4	S34000193Z	VITE T8X1 M6x12 ZINCATA
42	2	SBA000957I	SET GUIDA CARB.
43	1	S34020000A	PAT. FORIFICAVI Ø20-15-50-1300- M4-F1
44	4	S34000693Z	VITE T8X1 M6x12 ZINCATA

TOLLERANZE GENERALI DI LAVORAZIONE (salvo specifiche diverse)

QUOTE LINEARI		FORI H9		ALBERI H7	
mm	mm	mm	mm	mm	mm
0-10	±0.10	0-10	±0.012	0-10	±0.008
10-30	±0.12	10-30	±0.015	10-30	±0.010
30-50	±0.15	30-50	±0.020	30-50	±0.015
50-100	±0.20	50-100	±0.025	50-100	±0.020
100-150	±0.25	100-150	±0.030	100-150	±0.025
150-200	±0.30	150-200	±0.035	150-200	±0.030
200-300	±0.35	200-300	±0.040	200-300	±0.035
300-500	±0.40	300-500	±0.045	300-500	±0.040
500-1000	±0.50	500-1000	±0.055	500-1000	±0.050

MATERIALE: ACCIAIO

FINITAMENTO: 0

TRATTAMENTO: 0

CONDIZIONE: everreggio

GRUPPO COLONNA FO

DATA: 02.12.2009

FOGLIO: 14

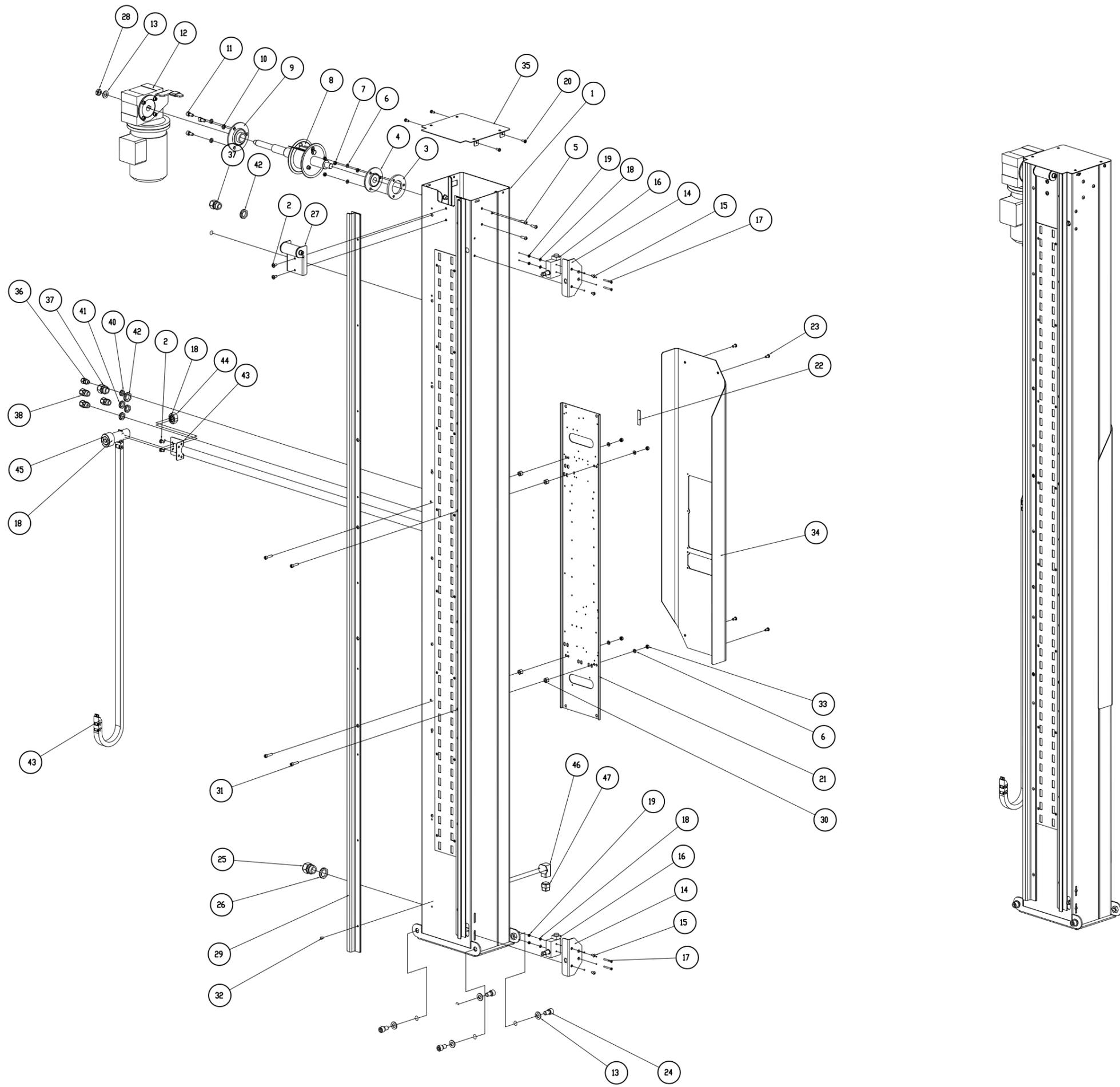
TOTALE: 1 di 1

CODICE: SBA000957Z

SOTTODESCRIZIONE: SBA000957Z-ET

SCALE: AO

Note



H= 2400 mm

Pos.	Quantità	Codice	Denominazione
1	1	SBA003453	GRUPPO COLONNA C/INS.
2	4	S34054093A	VITE TRILIBRATE M6x12 TESTA TORX C/EXTR.
3	1	S32615200A	DISSIPATORE PER SUPPORTO LIBRF52 - V3000
4	1	S34034147Z	SUPPORTO FLANGIATO LIBRF 203/ANSK
5	3	SCA000133	VITE T8x10 ISO 7380 Zinc.
6	7	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
7	3	S34002593Z	DAISO M6 ZINCATO A BASSA RESIST.
8	1	S34003451	PULLEGIA C/VALERIO PREM VSI
9	1	S34032027Z	SUPPORTO "M6" LIBRF-203"
10	3	S34006393Z	RONDELLA ELASTICA DUMB
11	3	S340058493Z	VITE TCEI M6x15
12	1	S34000452	METRIORITTORE PREVENT.
13	5	S340002593Z	RONDELLA PIANA X VITE M6 ZINC.
14	2	S49020847Z	SGUARDIETTA MICRO C/INCLV300
15	4	S340217593Z	VITE T8x10 KIT X K13
16	2	S38026327Z	FINE CORSA DAMC-5020
17	4	S34009493Z	VITE T8x10 M6x15 ZINCATO
18	8	S340002593Z	RONDELLA PIANA X VITE M6 ZINC.
19	4	S34000193Z	DAISO M4 ZINCATO
20	4	S34019893Z	VITE TORX M6x12 ZINC.100u/3M
21	1	S32164517A	PANNELLO COMPONENTI VSI
22	1	S34031227Z	341037Z GOMMA ANCS. TIPO R60 10x30mm
23	4	S3401493Z	VITE T8x10 M6x15 ZINC.
24	4	S34018493Z	VITE T8x10 M6x15 ZINCATO
25	1	S38059400A	BUCCHETTE PRESSACAVO M6x15 GRIGIO
26	1	S38059400A	DAISO PER BUCCHETTE M6x15 GRIGIO
27	1	SBA000812	BULLI FINITI PREM.
28	1	S34023393Z	DAISO SPECIALE D/CC. M2 P1
29	2	SBA000604	SET GUIDA CARB. COL. 2400
30	4	S33220893A	COLONNINA QUADRO V3000 ZINC.
31	4	S34000193Z	VITE TCEI M6x15 ZINCATO
32	18	S34051300A	BIVITTE "AV/BR" IN ACCIAIO COLONNI-0
33	4	S340002593Z	DAISO M6 ZINCATO
34	1	S30014208V	SPERTELLINO QUADRO EL. F8
35	1	SBA000805	CARTER COLONNA COMP. STRETCH
36	1	S38059400A	BUCCHETTE PRESSACAVO M6x15 GRIGIO
37	2	S38059400A	BUCCHETTE PRESSACAVO M6x15 GRIGIO
38	3	S38059400A	BUCCHETTE PRESSACAVO M6x15 GRIGIO
39	1	S34052200A	CAT. PORTACAVI ISO25-ISO-300-M6-F1
40	1	S38059400A	DAISO PER BUCCHETTE M6x15 GRIGIO
41	3	S38059400A	DAISO PER BUCCHETTE M6x15 GRIGIO
42	2	S38059400A	DAISO PER BUCCHETTE M6x15 GRIGIO
43	1	S38009914	SGUARDIETTA CATENA PLACAVI
44	2	S34003227Z	DAISO M6x15 GRIGIO
45	2	FAM. VITI TCEI	FAMIGLIA VITE TCEI
46	1	S38014927Z	CUSTODIA PANNELLO C/USCITA LAT. 104235
47	1	SC0000020	INSERTO X CONTATTI F. SP+1 A GRUP. CO

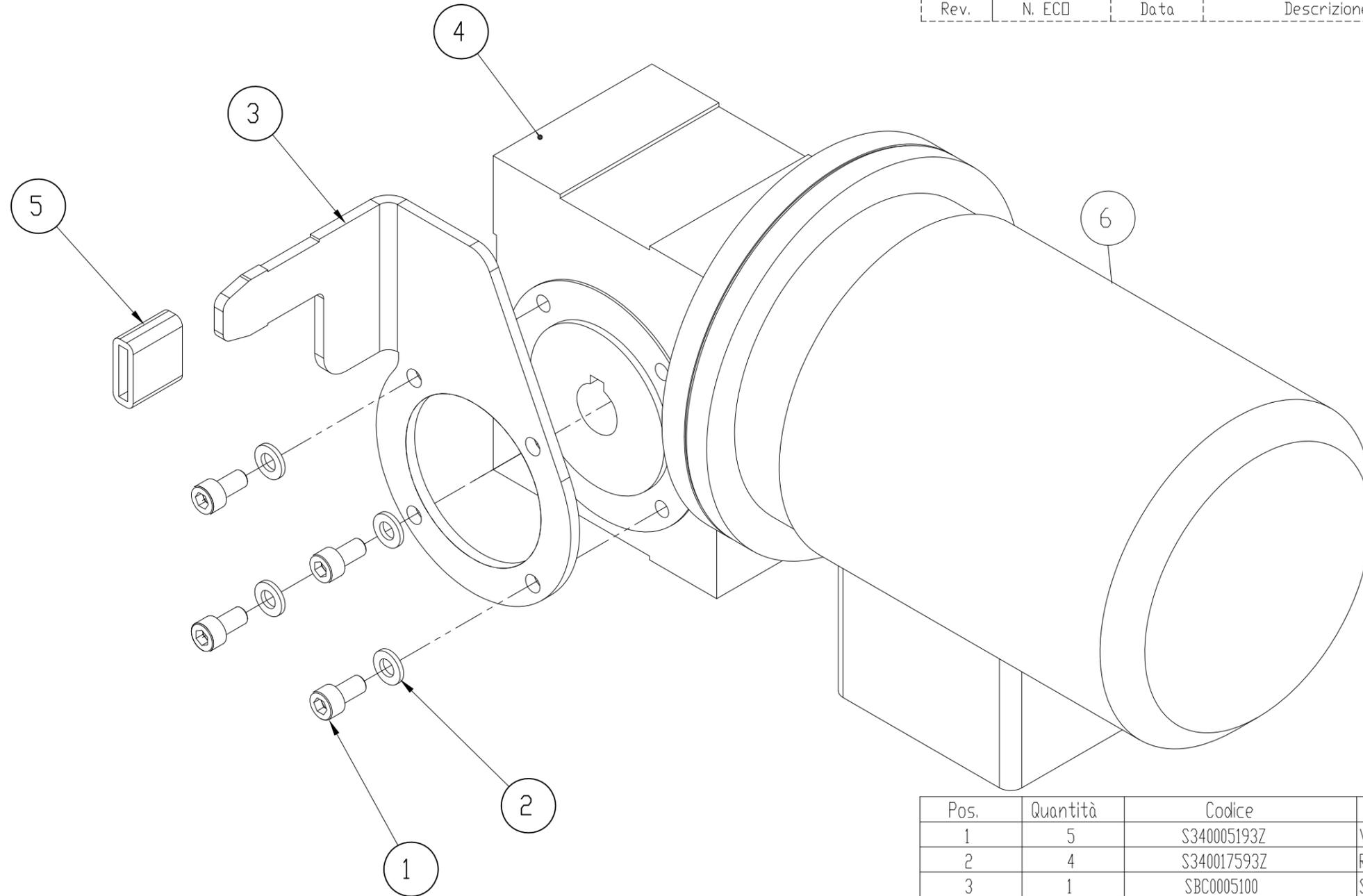
TOLLERANZE GENERALI DI LAVORAZIONE (salvo specifiche diverse)

Dimensione	±0.1	±0.2	±0.3	±0.4	±0.5	±0.6	±0.8	±1.0	±1.2	±1.5	±2.0	±3.0	±4.0	±5.0	±6.0	±8.0	±10.0
precisato	0.05	0.08	0.10	0.12	0.15	0.18	0.20	0.25	0.30	0.35	0.40	0.50	0.60	0.70	0.80	1.00	1.20
non precisato	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.50	0.60	0.70	0.80	1.00	1.20	1.50	2.00	2.50	3.00

TRATTAMENTO: 0  
 CODICE: SBA0009698  
 DATA: 12.01.2010  
 AUTORE: everengio  
 SCALA: 1:1  
 FOLIO: 1 di 1  
 SBA0009698-ET A0

Note

Rev.	N. ECO	Data	Descrizione della modifica	Disegnato	Controllato
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6	1	SCC0000094	MOTORE MDC71 S1 CLASSE F PASTIGLIA TERM 220V 60HZ MF FLANGIA /ALBERO RIDOTTI
6	1	SCC0000095	MOT. H63 C6 B5 S1 CLASSE F PAST.TERMICA 220V 60HZ 3F - 200V 50/60HZ 3F
6	1	SCC0000096	MOT. H63 C6 B5 S1 CLASSE F PAST.TERMICA 220/240V-380/415V 50HZ - 440V 60HZ 3F
6	1	SCC0000097	MOT. H63 C6 B5 S1 CLASSE F PAST.TERMICA 440V 50HZ 3F
6	1	SCC0000098	MOTORE MDC71 A6 B5 S1 RID.63 PAST.TER. 220/240V 50HZ MF

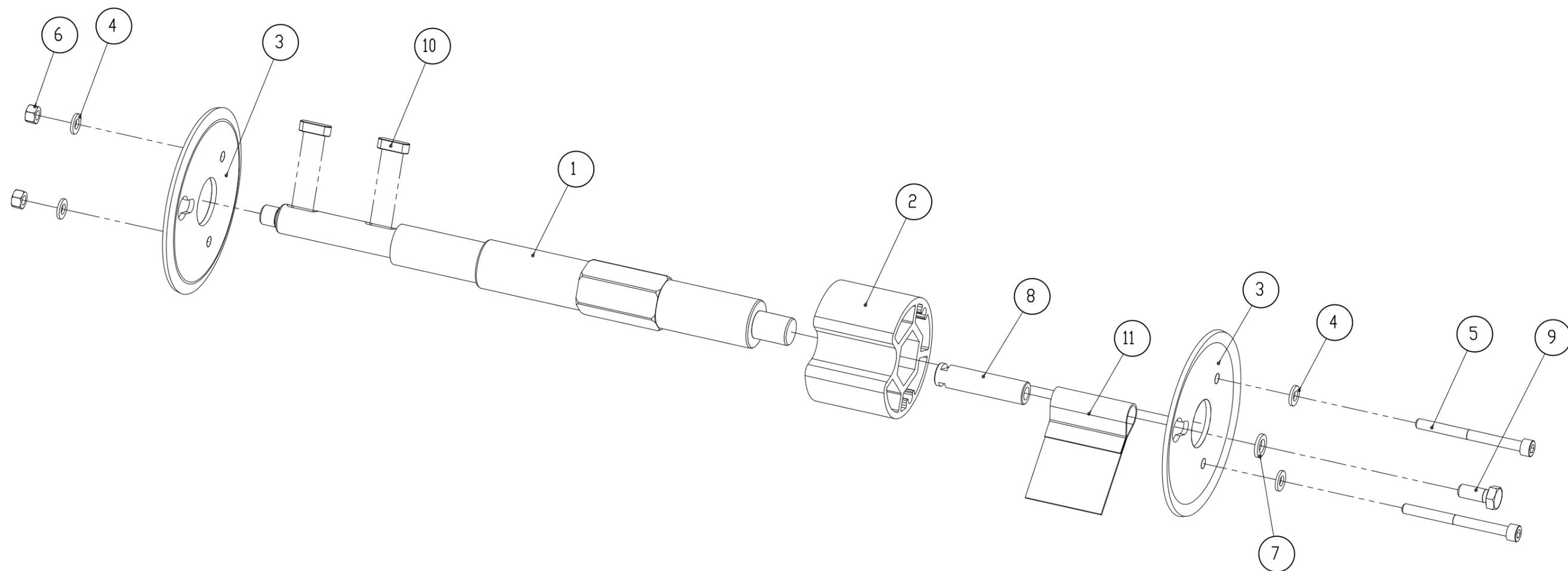
Pos.	Quantità	Codice	Denominazione
1	5	S340005193Z	VITE TCEI M6X12 ZINCATA
2	4	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
3	1	SBC0005100	STAFFA DI REAZIONE
4	1	S3805202ZZZ	**RIDUTT.*MOTOVARIO NMRV-040i1 PAM63B5*
5	1	S3801649ZZZ	TUBO RITORNO EST./19 INT./14

TOLLERANZE GENERALI DI LAVORAZIONE (salvo specifiche diverse)

CLASSE DI TOLLERANZA	QUOTE LINEARI								FORI H11	-PER I PARTICOLARI DI MACCHINA UTENSILE RIMOVERE TUTTE LE BAVE E ROMPERE TUTTI GLI SPIGOLI Sm. 01-04 con 32	-PER I PARTICOLARI IN LAMIERA IN LUOGO DI EVENTUALI RACCORDI POSSONO ESSERE ESEGUITI SMOSSI A 45° DI PARI MISURA
	fino a 6	da 6 a 30	da 30 a 120	da 120 a 315	da 315 a 1000	da 1000 a 2000	da 2000 a 4000	oltre 4000			
grossolano	±0.2	±0.5	±0.8	±1.2	±2	±3	±4	±5	ALBERI h11		
medio	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	ANGOLI ±30'		
preciso	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5	-	-			
MATERIALE										MACCHINA	
TRATTAMENTO										Verniciato	
										<b>PAKLET</b>	
										Disegnato everrengia	
CODICE SBA0008452										Visto -	
DESCRIZIONE MOTORIDUTTORE PREMONT.										Data 21.04.2009	
SOTTODESCRIZIONE										Scala 1:1.5	
A termini di legge ci riserviamo la proprietà di questo disegno con divieto di riprodurlo, metterlo in esecuzione o renderlo noto a terzi										Tavola 1 di 1	
Dis. N. SBA0008452-ET										Formato A3	
Codice secondario											

Note

Rev.	N. ECD	Data	Descrizione della modifica	Disegnato	Controllato
EC060029A	28/10/03	Aggiunto sistema smontaggio cinghia		CMi	



Pos.	Quantità	Codice	Denominazione
1	1	S332945592A	ALBERO RIDUTTORE MATOVARIO NMRV040-WS1
2	1	S331907681A	MOZZO PUL WS2 LAV PARTIC
3	2	SBC0000501	FLANGIA PULEGGIA
4	4	S340017592Z	RONDELLA PIANA X VITE M6 BRUN.
5	2	S340001993Z	VITE TCEI M6X70 ZINCATA
6	2	S340000293Z	DADO M6 ZINCATO
7	1	SCA0000044	ROSETTA ELASTICA 8.4x14.4 UNI 1751 A
8	1	S332950093A	BUSSOLA CINGHIA WS2
9	1	S340028092Z	VITE TE M8X20 BR.
10	2	S3400238ZZZ	LINGUETTA 6X6X20
11	1	S310151200A	CINGHIA SOLLEVAMENTO WS3

**TOLLERANZE GENERALI DI LAVORAZIONE (salvo specifiche diverse)**

CLASSE DI TOLLERANZA	QUOTE LINEARI								FORI H11
	fino a 6	da 6 a 30	da 30 a 120	da 120 a 315	da 315 a 1000	da 1000 a 2000	da 2000 a 4000	oltre 4000	
grossolano	±0.2	±0.5	±0.8	±1.2	±2	±3	±4	±5	ALBERI h11 ANGOLI ±30'
medio	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	
preciso	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5	-	-	

**MATERIALE** MACCHINA

**TRATTAMENTO** Verniciato

**W.S.**

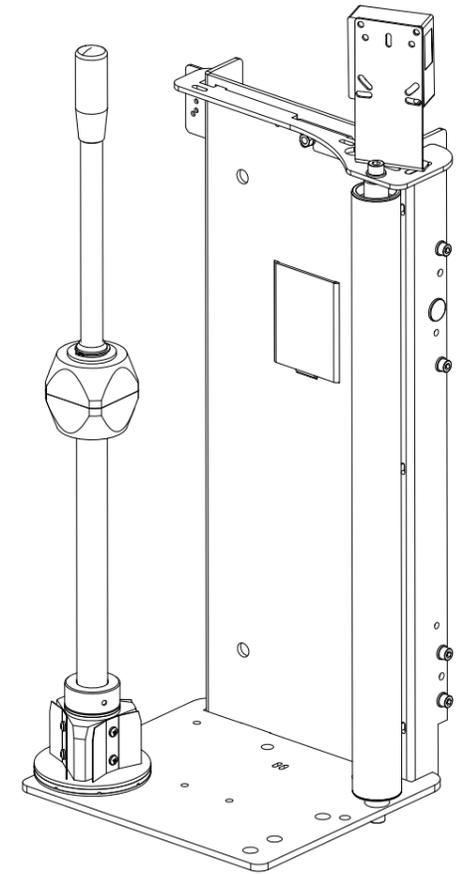
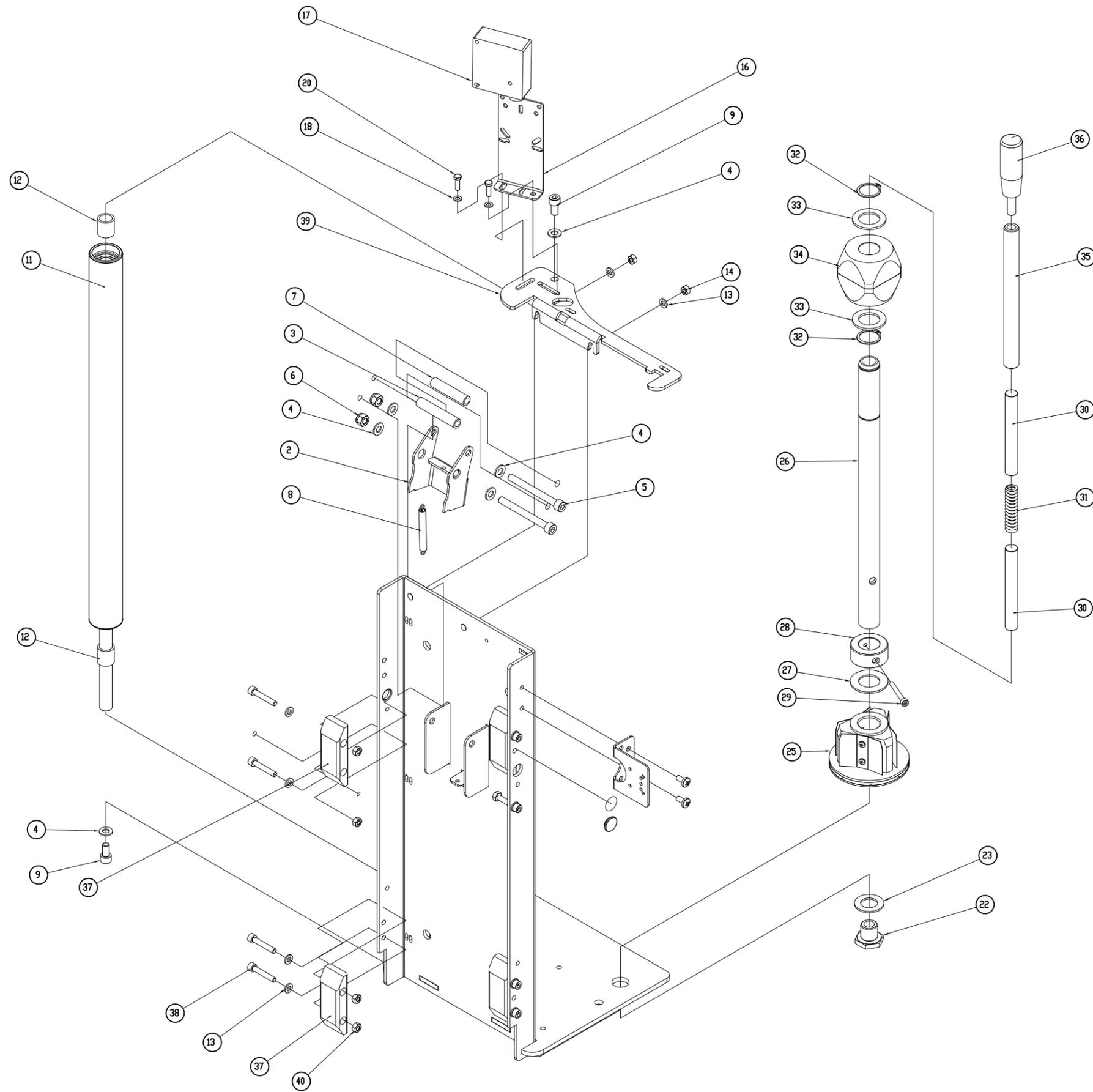
**SIAT** M. J. MAILLIS GROUP

CODICE: S471428200A  
 DESCRIZIONE: PULEGGIA C/ALBERO PREM. WS1  
 SOTTODESCRIZIONE:  
 REV. 3  
 Disegnato: Brime  
 Data: 26.05.2004  
 Scala: 1:2.5  
 Tavola: 1 di 1  
 Dis. N.: S471428200A-ET  
 Formato: A3  
 Codice secondario:

-PER I PARTICOLARI DI MACCHINA UTENSILE RIMOVERE TUTTE LE BAYE E ROMPERE TUTTI GLI SPIGOLI Sm. 0.1-0.4 con 3.2  
-PER I PARTICOLARI IN LAMIERA IN LUOGO DI EVENTUALI RACCORDI POSSONO ESSERE ESEGUITI SMUSI A 45° DI PARI MISURA

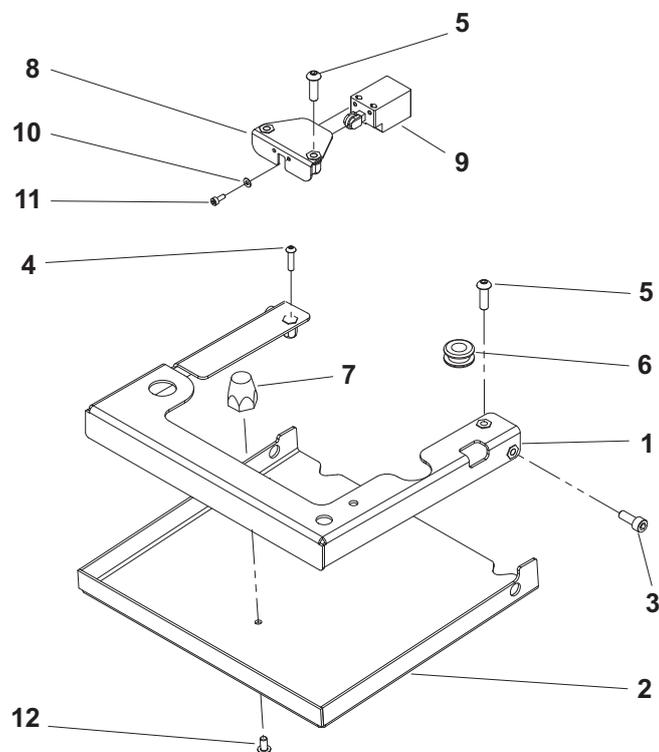
LAVORATI IN: LAMIERA  
3.2 3.2  
SUI TAGLI

A termini di legge ci riserviamo la proprietà di questo disegno con divieto di riprodurlo, metterlo in esecuzione o renderlo noto a terzi



Pos.	Quantità	Codice	Denominazione
1	1	SBA0006044V	CARRELLI PORTABOB. COMP. SWI M-SM-FM
2	1	S320926496A	CORPO FRENO WS100 INOX
3	1	S332208592A	PERNO ROTAZIONE FRENO WS100 BRUN.
4	6	S340012393Z	RONDELLA PIANA X VITE M6 ZINC.
5	2	S340129293Z	VITE TCEI M8X80 ZINC.
6	2	S340028393Z	DADO AUTOBLOCCANTE M6 ZINCATO
7	1	S332208492A	PERNO ATTACCO CINGHIA WS100 BRUN/WS100
8	1	S370031898A	MOLLA FRENO WS3
9	2	S340058493Z	VITE TCEI M8X16
10	1	SBC0008524	ALBERINO RULLO FOLLE
11	1	SBA0005213	RULLO DI CONTRASTO COMPLETO
12	2	SBC0008523	DISTANZIALE RULLO
13	10	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
14	2	S34000293Z	DADO M6 ZINCATO
15	2	S310071605Z	TAPPO /19
16	1	SBC0000246	SQUADRETTA ATTACCO FOTOCELLULA WS
17	1	SCC0000577	FTC TASTI, 2m PNP NO/NC M12 RL25-8-2000
18	3	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
19	1	S340006198Z	RONDELLA PIANA X VITE M5 INOX
20	2	S34003293Z	VITE TE M5X16 ZINCATA
21	2	S34000293Z	DADO M5 ZINCATO
22	1	SBC0008060	VITE SPECIALE M20x1
23	1	S320699093A	RONDELLA RULLO A SBALZO APS
24	1	S321256098A	DISCO INOX DIAM.95/20,5 SP2 WS
25	1	SBA0009600	MANICOTTO PORTAB. FREMO. PREMO.
26	1	SBC0011879	ALBERO PORTABOBINA FO STRETCH
27	1	SBC0011560	RONDELLA NYLON Ø25,5-45 SP2
28	1	SBC0011887	GHIERA PORTABOBINA
29	1	S340038293Z	VITE TCEI M5X40 ZINCATA
30	2	SBC0011888	PERNO FRENO
31	1	SBC0011885	MOLLA COMPRESSIONE De=15 filo Ø3 L=60
32	2	S340010492Z	ANELLO ARRESTO X ALBERO /25 BR.
33	2	S321205693A	RONDELLA DIAM.40/25,5X2,5 ZINC. RA
34	1	SBA0005198	MANICOTTO PORTABOBINA COMPLETO
35	1	SBC0011889	ALBERO SPINTORE MOLLA
36	1	SCA0001050	IMPUGNATURA "ELESIA 1.280/65 p-M10x30"
37	4	SBC00016381	PATTINO PORTABOBINA
38	8	S340036793Z	VITE TCEI M6X35 ZINCATA
39	1	SBC0005104V	MENSOLA SUPPORTO FOTOCELLULA
40	8	S340023593Z	DADO M6 ZINCATO A BASSA RESIST
41	1	SBC0009914	SQUADRETTA CATENA P.CAVI
42	2	S340514093A	VITE TRILOBATE M6X12 TESTA TCBCR (CTEXTR)

TOLLERANZE GENERALI DI LAVORAZIONE (salvo specifiche diverse)									
QUOTE LINEARI					FORI H11				
CLASSE DI TOLLERANZA	Fig. 10	Fig. 11	Fig. 12	Fig. 13	Fig. 14	Fig. 15	Fig. 16	Fig. 17	Fig. 18
grossolano	±0,2	±0,3	±0,4	±0,5	±0,6	±0,7	±0,8	±0,9	±1,0
medio	±0,1	±0,2	±0,3	±0,4	±0,5	±0,6	±0,7	±0,8	±0,9
preciso	±0,05	±0,1	±0,15	±0,2	±0,3	±0,4	±0,5	±0,6	±0,7
ANGOLI ±30'									
MATERIALE									
TRATTAMENTO					MATERIALE				
CODICE SBA0009577					MATERIALE MACCHINA				
DESCRIZIONE GR. PORTABOBINA EM FO					MATERIALE MACCHINA				
SOTTODESCRIZIONE					MATERIALE MACCHINA				
SOTTODESCRIZIONE					MATERIALE MACCHINA				



### Portabobina EM

Pos.	Q.tà	Codice	Denominazione
1	1	SBA0007166	FISSAGGIO BASCULANTE SW1 EM-M-FM C-INS.
2	1	SBC0011671	PANNELLO BASCULANTE SW1 EM-M-FM
3	2	S340057793Z	VITE TCEI M6X16 ZINCATA
4	1	S340316593Z	VITE TBEI M6X25 ZINCATA
5	3	SCA0000133	Vite TBEI M6x20 ISO 7380 Zinc.
6	1	SCC0001627	PASSACAVO IN GOMMA "EZ" ART.11087
7	1	SBC0011534	CAMMA MICRO SICUREZZA
8	1	SBA0007169	SQUADRETTA FISS. MICRO SICUREZZA C-INS
9	1	SCC0001605	FINECORSA DI SICUREZZA 1 NC "IMP 2"
10	2	S340055893Z	RONDELLA PIANA X VITE M3 ZINC.
11	2	S340319193Z	VITE TCEI M3X8 ZINCATA
12	1	S340217593Z	VITE TBEI M5X10 KIT X K13