

# SIAT

■ M. J. MAILLIS GROUP



## SK1-S Type A

NASTRATRICE AUTOMATICA  
**AUTOMATIC CASE SEALING MACHINE**  
MACHINE ENRUBANNEUSE AUTOMATIQUE  
**AUTOMATISCHE KARTONVERSCHLIESSMASCHINE**  
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, safety, maintenance and spare parts concerning the case sealing machine model SK1-S Type A.

This publication is property of SIAT S.P.A.  
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Release 0



## **SK1-S** Type A

### **AUTOMATIC ADJUSTMENT CASE SEALING MACHINE WITH TOP AND BOTTOM DRIVE BELTS AND MANUAL BOX-SIZE ADJUSTMENT**

- Maximum box size **h.** 500 mm x **w.** 500 mm
- Adhesive tape 50 mm
- Belt speed 22 m per minute
- Production 800 boxes per hour (average)

	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		
Serial Number	2.1		
After-sale service	2.2		
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Fire emergency	14.2		
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Spare parts	last section		
		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
		Pict.	= picture
		PLC	= Programmable Logic Control
		PP	= polypropylene
		PTFE	= Polytetrafluorethylene
		PVC	= Polyvinylchloride
		Ref.	= reference mark
		SIAT SPA	= Società Internazionale Applicazioni Tecniche (Società per Azioni)
		Tav.	= Illustration
		w	= width
		h	= height
		l	= length
		ol	= overall length
		cbh	= conveyor bed height

## INTRODUCTION

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### 1.1 MANUFACTURING SPECIFICATIONS

The automatic case sealing machine Mod. SK1-S has been designed and manufactured complying with the legal requirements in force at the date of its manufacture.

THE REFERENCE DOCUMENTS ARE:

**Directive 98/37/CEE** on the standardisation of member States legislation on machines.

**Directive 89/336/EEC** on the standardisation of member States legislation on electromagnetic compatibility.

**Directive 73/23/EEC** on the standardisation of member States legislation on electrical materials to be used within certain voltage limits.

**UNI EN 292-1** Safety of machinery. Basic concepts general principles for design. Basic terminology methodology.

**UNI EN 292-2** Safety of machinery. Basic concepts general principles for design. Technical principles and specifications

**UNI EN 294** Safety of machinery. Safety distances to prevent danger zones being reached by the upper limbs.

**UNI EN 349** Safety of machinery. Minimum gaps to avoid crushing of parts of the human body.

**UNI EN 418** Safety of machinery. Emergency stop equipment, functional aspects. Principles for design.

**UNI EN 457** Safety of machinery. Auditory danger signals. General requirements, design and testing.

**UNI EN 954** Safety of machinery. Safety-related parts of control systems - General principles for design.

**UNI EN 1050** Safety of machinery. Principles or risk assessment.

**CEI EN 60204-1** Safety of machinery. Electrical equipment of machines. Part 1: General requirement.

### 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 update this manual.

## 2-GENERAL INFORMATION

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### 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			
	Model	Year	Ampere	Watt	
Type	Serial Number	Volt	Hertz	Phase	

### 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:
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## 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

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### 3.1 GENERAL SAFETY INFORMATION

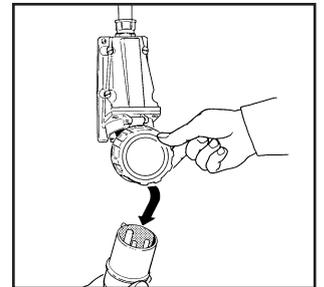
Read all the instructions carefully before starting the work with the machine; please pay particular attention to sections marked by the symbol



The machine is provided with a LOCKABLE EMERGENCY STOP BUTTON placed on the operator side of the machine; when this 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

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### 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;

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

## 3-SAFETY

### 3.7 RESIDUAL HAZARDS

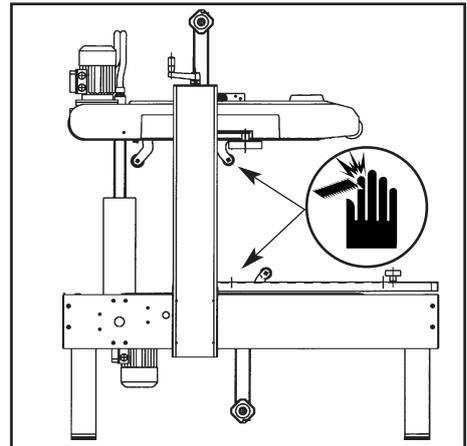
The case sealer SK1-S has been designed following the CE 392 directives, and incorporates various safety protections which should never be removed or disabled.

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.

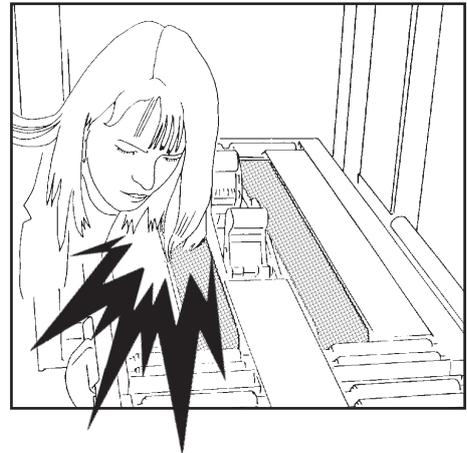
Blades are extremely sharp. Any error may cause serious injuries.



**WARNING!** Upper and lower drive belts.

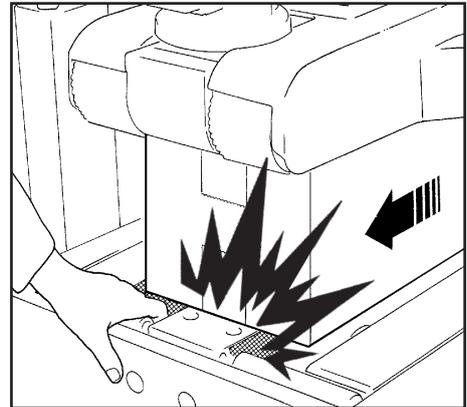
Never work on the machine with loose hair or loose garments such as scarfs, ties or sleeves.

Although protected, the drive belts may be dangerous.



**WARNING!** Cavity in the conveyor bed.

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



## 3-SAFETY

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### 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. (see paragraph 4.9)

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

### 3.9 PERSONAL SAFETY MEASURES

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

None is required, except when recommended by the user.

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

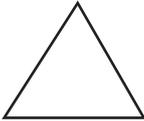
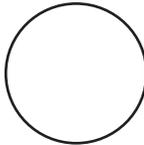
- Never try to stop or hold the box while it is being driven by the belts. Use only the EMERGENCY STOP BUTTON.
- Never work without the safety protections.
- Never remove or disable the safety devices.
- Only authorised personnel should be allowed to carry out the adjustments, repairs or maintenance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

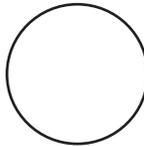


- The cleaning and maintenance operations must be performed after disconnecting the electric power.
- Clean the machine using only dry clothes or light detergents. Do not use solvents, petrols etc.
- Do not modify the machine or any part of it. The manufacturer will not be responsible for any modifications.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

### 3-SAFETY

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

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

a  Shows the rotating way of the handle to raise/lower the upper head.



Label code: 3.0.0103496/A

c  Shows the movements of the guides for the box centering.

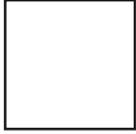


Label code: 3.0.01045.96A

### 3-SAFETY

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d

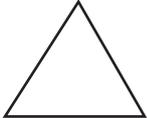


Before starting any maintenance operation the electrical power must be disconnected.



Label code: 3.0.01050.96A

e

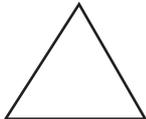


Shows the sharp knife on the taping head.



Label code: 3.0.01028.96A

g



Tape threading path for bottom taping and position of the sharp knife.



Label code: 3.0.01024.96A

h



Shows the running direction of the belts.

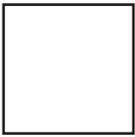


Label code: 3.0.01040.96A

### 3-SAFETY

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m

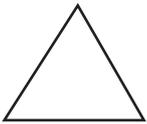


Shows the start / stop controls and that inside the circuit breaker box there is electric current.



Label code: 3.0.01090.96A

o



Shows the danger of the bottom drive belts when running.



Label code: 3.0.01031.96A

p



Shows the point for earth wire connection on the machine frame



Label code: 3.0.01039.96A

q



Identification data of the machine model, serial number and manufacturer



Label code: 3.0.01103.95

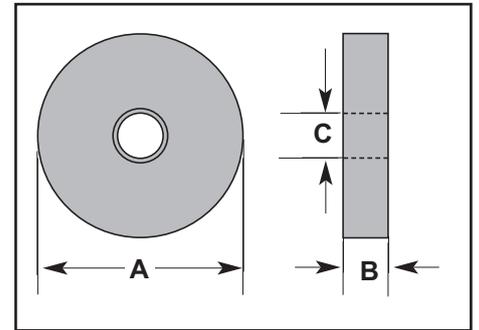
## 4-PRELIMINARY INFORMATION ON THE MACHINE

### 4.1 GENERAL DESCRIPTION OF THE MACHINE

Automatic case sealer with bottom drive belts and adjustment to the box size to be sealed.

### 4.2 TECHNICAL SPECIFICATIONS

- Production = 650 boxes/hour (average)
- Power supply = See machine data plate
- N.1 motor kW 0,1
- Taping unit K11, tape width 50 mm.
- Weight = 140 kg.
- Belts speed = 22 m per minute



**A** = 410 mm max  
**B** = 50 mm  
**C** = 76 mm

### 4.3 TAPE DIMENSIONS

Suitable adhesive tapes:

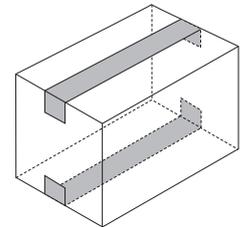
PVC

OPP

ADHESIVE PAPER

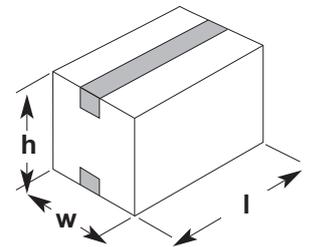
### 4.4 PURPOSE OF THE MACHINE

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



### 4.5 BOX-SIZE RANGE

The case sealer SK1-S is adjustable to any box sizes included in the range shown below.



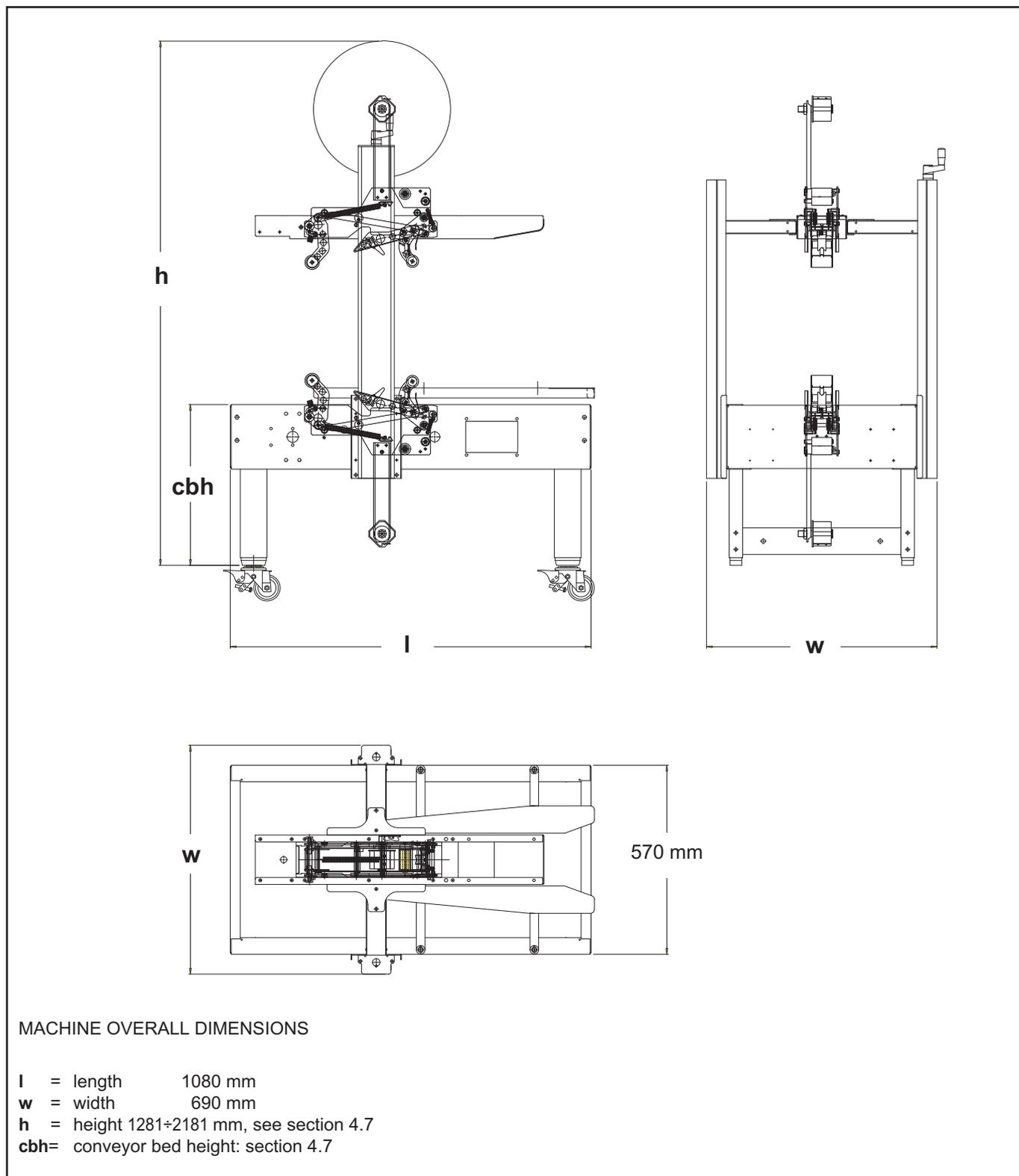
BOX SIZE			
	L	MIN	MAX
W		150	500
H		140	500
		110	500

#### NOTES

- + The box length (L) refers to the size in the seal direction.
- + The boxes should have a H/L ratio (HEIGHT/LENGTH) of 0,5 or higher. Boxes with a lower ratio should be test run to ensure perfect performance, which depends upon various factors such as box weight and rigidity.
- + Some special modifications are available from the manufacturer in order to seal box formats smaller or larger than the standard sizes described herein. If interested, please contact your Siat Service Dealer

## 4-PRELIMINARY INFORMATION ON THE MACHINE

### 4.6 DIMENSIONS



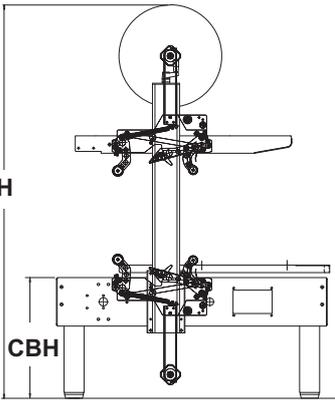
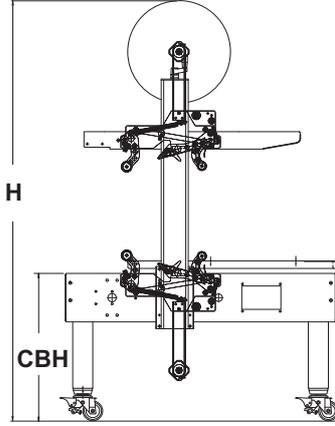
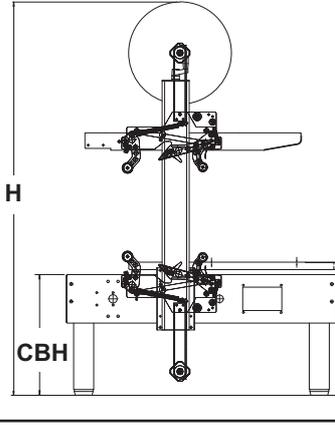
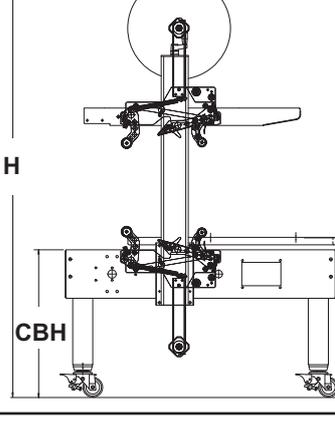
#### MACHINE OVERALL DIMENSIONS

- l** = length 1080 mm
- w** = width 690 mm
- h** = height 1281÷2181 mm, see section 4.7
- cbh**= conveyor bed height: section 4.7

### 4.7 CONVEYOR BED HEIGHT

The case sealer SK1 -S allows for a wide range of conveyor bed height. Various combinations are possible with the use of the optional accessories AS77 (casters) and AS80 (legs), as shown in the following page.

#### 4-PRELIMINARY INFORMATION ON THE MACHINE

	<h3>A WITH STANDARD LEGS</h3>				
	CONVEYOR BED HEIGHT		OVERALL DIMENSIONS		
		MIN      MAX		MIN      MAX	
	CBH	<b>485      825</b>	H	<b>1581      1921</b>	
			L	<b>1080      1080</b>	
			W	<b>690      690</b>	
	<h3>B WITH AS77 CASTERS (OPTIONAL)</h3>				
	CONVEYOR BED HEIGHT		OVERALL DIMENSIONS		
		MIN      MAX		MIN      MAX	
	CBH	<b>585      925</b>	H	<b>1681      2021</b>	
			L	<b>1080      1080</b>	
			W	<b>740      740</b>	
	<h3>C WITH AS80 LEGS (OPTIONAL)</h3>				
	CONVEYOR BED HEIGHT		<i>OVERALL DIMENSIONS</i>		
		MIN      MAX		MIN      MAX	
	CBH	<b>645      1135</b>	H	<b>1741      2081</b>	
			L	<b>1080      1080</b>	
			W	<b>690      690</b>	
	<h3>D WITH AS80 LEGS AND AS77 CASTERS (OPTIONAL)</h3>				
	CONVEYOR BED HEIGHT		OVERALL DIMENSIONS		
		MIN      MAX		MIN      MAX	
	CBH	<b>745      1235</b>	H	<b>1841      2181</b>	
			L	<b>1080      1080</b>	
			W	<b>690      690</b>	

## 4-PRELIMINARY INFORMATION ON THE MACHINE

### 4.8 MAIN COMPONENTS

The machine is composed of:

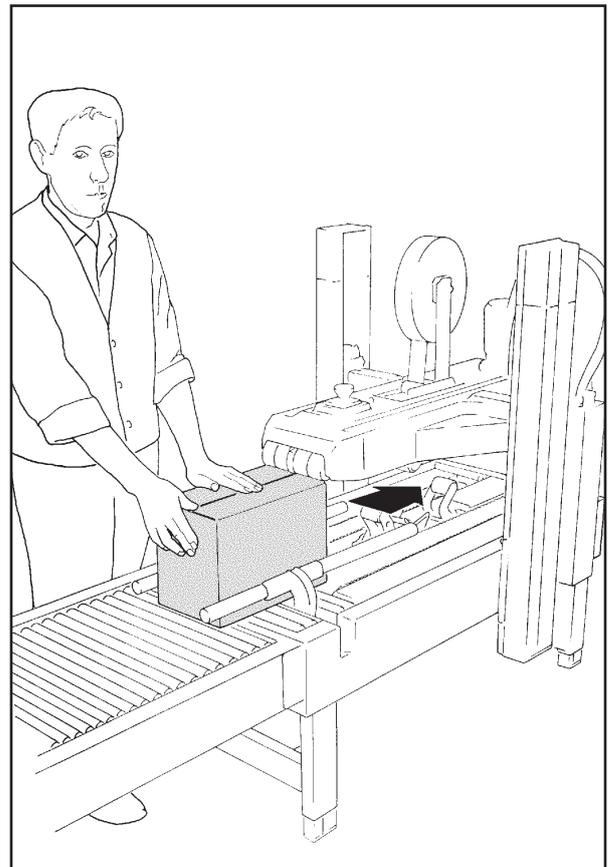
- N. 1 frame
- N. 4 adjustable legs
- N. 2 columns
- N. 1 taping unit
- N. 1 top head support
- N. 1 top drive belts assembly
- N. 1 bottom drive belts assembly
- N. 1 electric motor
- N. 1 emergency stop button
- N. 1 main switch

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

### 4.9 OPERATIVE FLOW

Once the box has been filled, close its top flaps and push it between the top and bottom drive belts. Keep hands always as shown on Picture.

The box will be automatically sealed with adhesive tape on the top and bottom box seams. Then it will be expelled on the exit conveyor.



### 4.10 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.

## 5-SHIPPING-HANDLING-PACKAGE

### 5.1 SHIPMENT AND HANDLING OF THE PACKED MACHINE

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

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

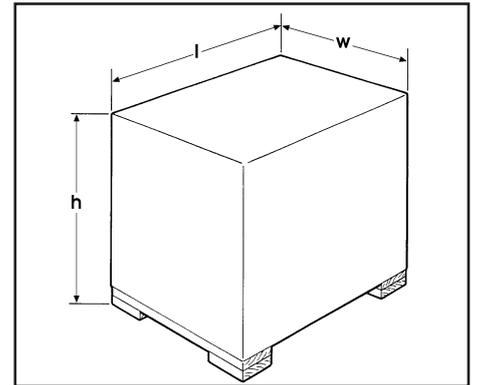
#### PACKAGING OVERALL DIMENSIONS

**l** = length 1300 mm

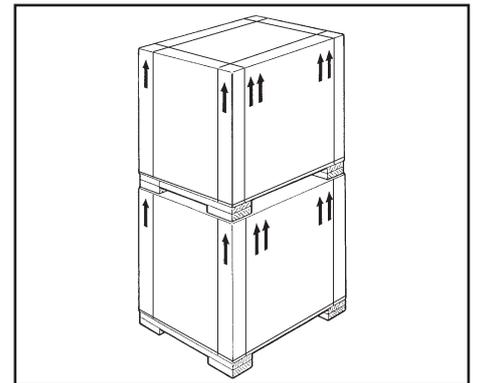
**w** = width 800 mm

**h** = height 1100 mm

Weight kg. 175



During the shipment it is possible to stack a maximum of 2 machines.



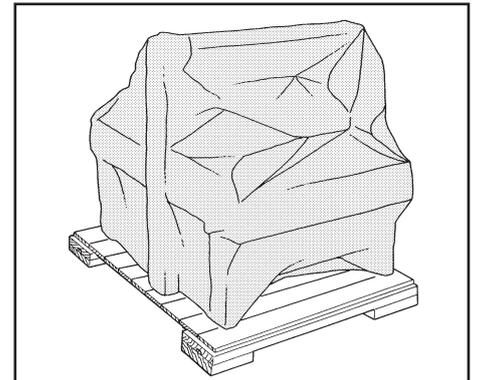
### 5.2 PACKAGING FOR OVERSEAS SHIPMENT (OPTIONAL)

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

### 5.3 SHIPMENT AND HANDLING OF THE UNPACKED MACHINE

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

The transportation of the machine without packaging may cause damage and accidents. In case it is necessary to relocate the machine, lift it with belts as shown in Picture.



#### MACHINE OVERALL DIMENSIONS

length 1080 mm.

width 740 mm.

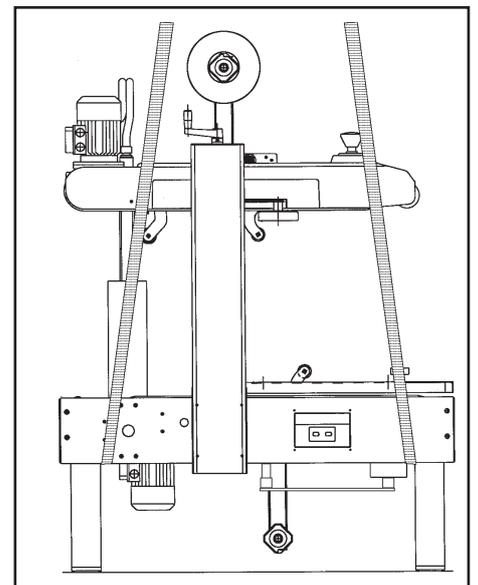
height min.1581; max. 1921 mm.

Weight kg 140

### 5.4 STORAGE OF THE PACKED OR UNPACKED MACHINE

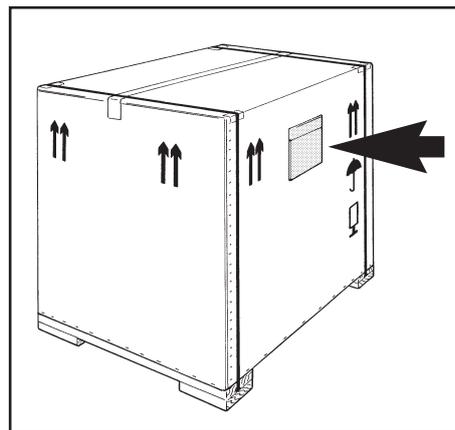
If the machine is left inactive for a long period, please take the following precautions:

- store the machine in a dry and clean place;
- if the machine is unpacked it is necessary to protect it from the dust and do not stack anything over the machine;
- it is possible to stack a maximum of 2 machines, if they are in their original packing.

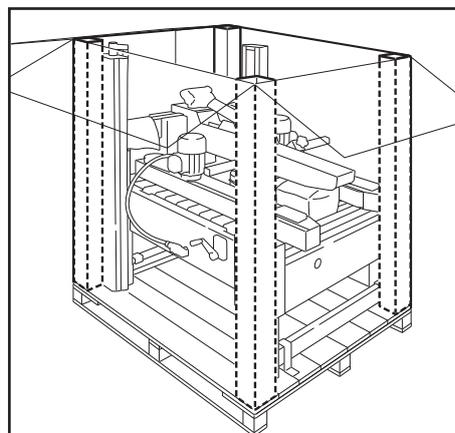


## 6-UNPACKING

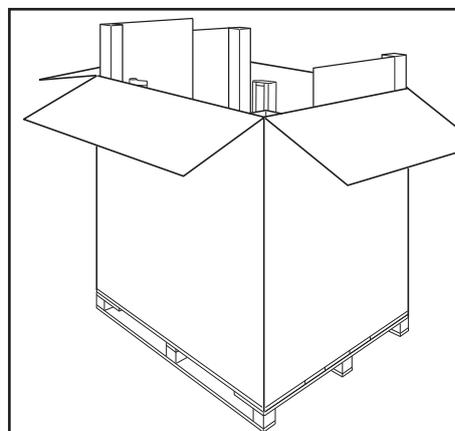
- 6.1 The envelope attached to the external side of the packing case contains the instructions concerning the unpacking of the machine.



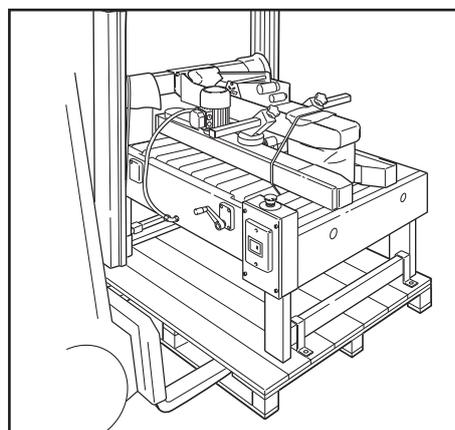
Machine layout inside the packing.



- Cut the plastic strap.
- Open the top of the carton.
- Withdraw the carton angles.
- Lift and remove the carton.

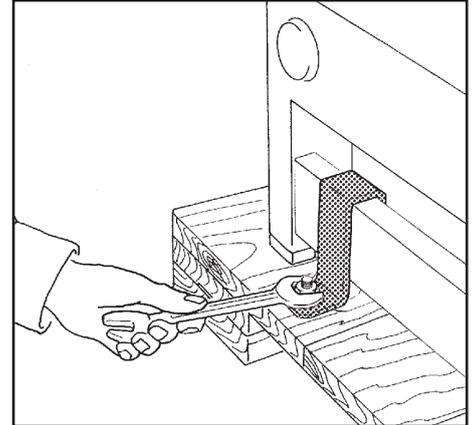


Use a forklift to carry the machine to its working location.  
(Weight of machine + pallet = Kg. 165)



## 6-UNPACKING

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



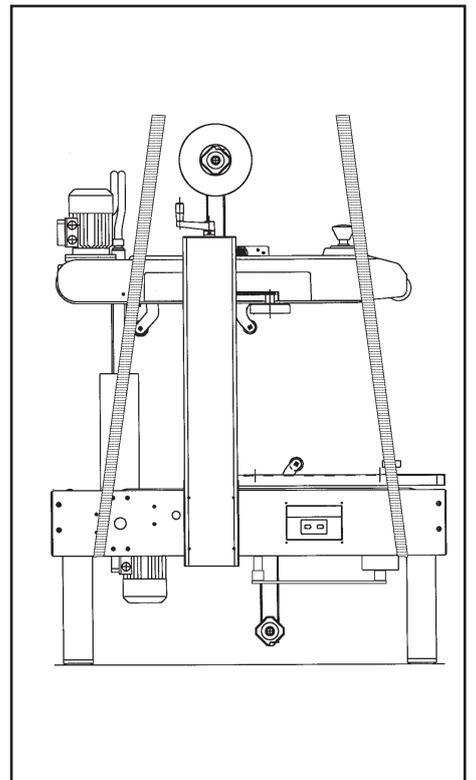
Uplift the machine by using belts or ropes. Pay attention to place the belts in the points shown in Picture and remove the wooden pallet. (Machine weight 137,5 kg).

### 6.2 PACKAGING DISPOSAL

The packaging of the machine Mod. SK1 -S is composed of:

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

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



## 7-INSTALLATION

### 7.0 SAFETY MEASURES

(Read section 3 carefully).

### 7.1 ENVIRONMENTAL CONDITIONS REQUIRED

-Min. temperature = 5 °C; Max. temperature = 40 °C

-Min. humidity 30%; Max. humidity 80%

-Dust-free environment

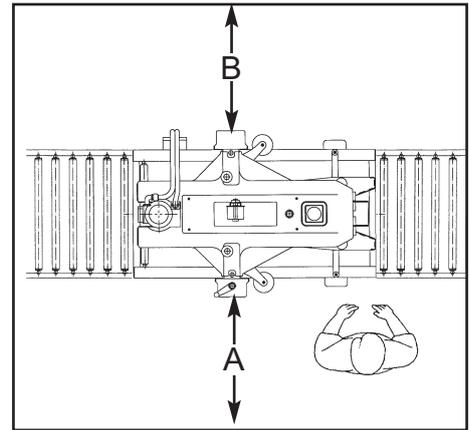
### 7.2 SPACE REQUIRED FOR OPERATION AND MAINTENANCE

Min. distance from the wall:

**A = 1000 mm.**

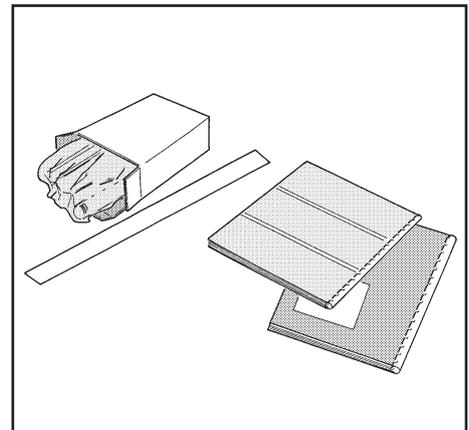
**B = 700 mm.**

Min. height = 2500 mm.



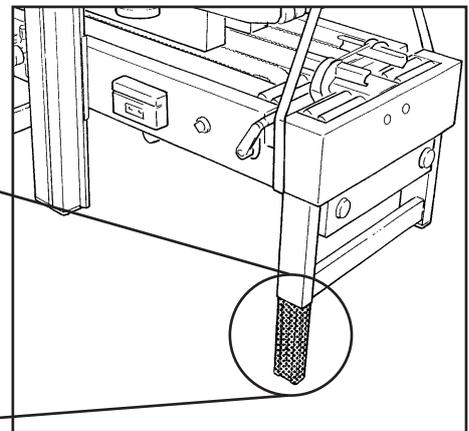
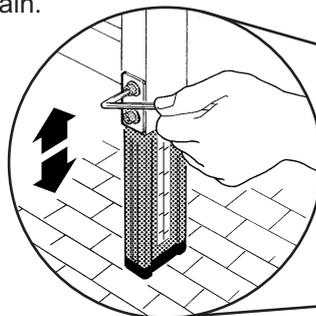
### 7.3 SPARE PARTS AND THREADING TOOL FOR TAPING HEADS SUPPLIED WITH THE MACHINE

For a detailed description see section 13.1.



### 7.4 MACHINE POSITIONING

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.

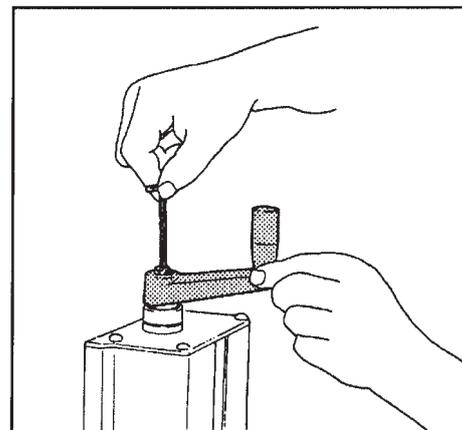


## 7-INSTALLATION

---

### 7.7 POSITIONING OF THE CRANK

Insert the handle in its housing.  
Lock it with the screw.



### 7.9 PRELIMINARY ELECTRIC CHECK-OUT

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

- 7.9.1 Make sure that the socket is provided with a ground protection circuit and that both the mains voltage and the frequency match the specifications on the machine plate.
- 7.9.2 Check that the connection of the machine to the mains meets the safety regulations in your country.
- 7.9.3 The machine is fitted with a main switch having a maximum breaking power of 6 kA and a short-circuit breaker pre-set at 120 A.  
The user will be responsible of testing the short-circuit current in its facility and should check that the short-circuit amperage setting on the main switch of the machine is compatible with all the components of the mains system.

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## 7-INSTALLATION

### 7.10 MACHINE CONNECTION TO THE MAINS AND CHECK-OUT

Power supply = 0,13 kW

Maximum breaking power of the main switch = 6 kA (230/400 V)

For technical features of the main switch: see section **15-ENCLOSURES**.

-Push the LOCKABLE EMERGENCY STOP BUTTON

-The magnetothermic main switch is normally turned OFF.

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

### 7.11 CHECK-OUT OF PHASES (FOR THREE-PHASE MAINS ONLY)

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

-Remove any tools from the conveyor bed.

-Release the lockable emergency stop button turning it clockwise.

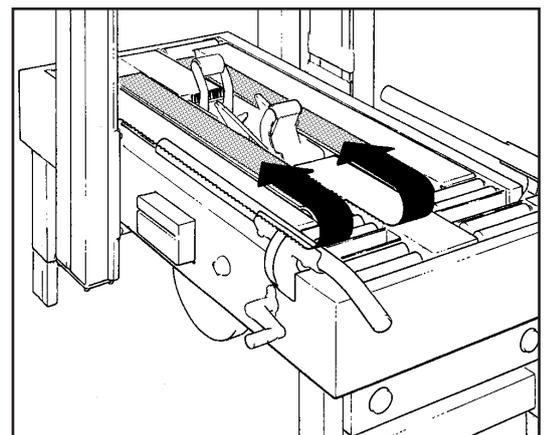
-Push button ON of the main switch.

-Check the rotation direction of the side drive belts.

-In case they rotate in the wrong way, please reverse 2 phases on the plug.



Correct rotation direction of the side drive belts.



## 8-THEORY OF OPERATION

---

### 8.1 DESCRIPTION OF THE WORKING CYCLE

After having closed manually the flaps of the case, the operator pushes it under the top infeed end in order to avoid the opening of the top flaps.

Further pushing causes the bottom belts to drive the box through the taping units, which automatically seal the bottom seams.

Afterwards the case is expelled on the exit conveyor.

### 8.2 OPERATING MODES

The case sealer Mod. SK1-S has only one automatic working mode, with:

- The EMERGENCY STOP BUTTON unlocke
- The start button pushed ON

### 8.3 HOW TO STOP THE MACHINE

#### 8.3.2 NORMAL STOP AND EMERGENCY STOP

The lockable button for normal and emergency stop is located on the infeed side of the top head.

(This part is not produced by the machine manufacturer. For its technical specifications see section **15-EN-CLOSURES**).

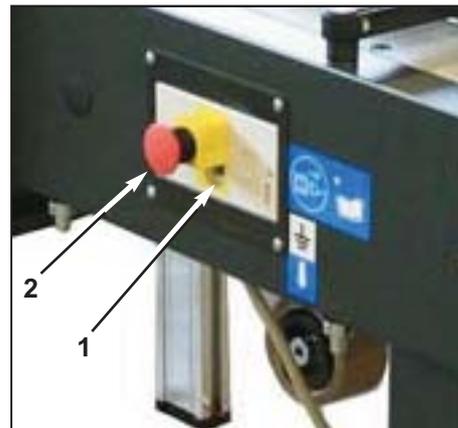
## 9-CONTROLS IN BRIEF

### 9.1 START BUTTON (1)

It starts the box drive belts.

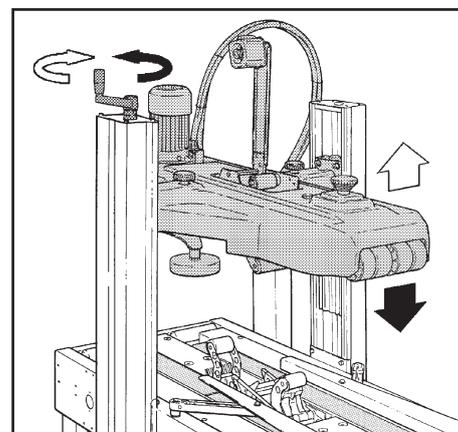
### EMERGENCY AND STOP BUTTON (2)

It stops the machine cycle.



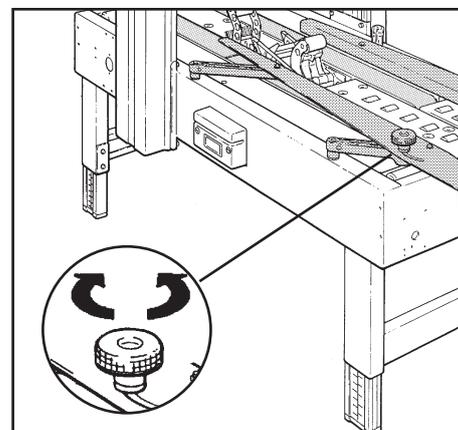
### 9.2 BOX WIDTH ADJUSTMENT CRANK

It adjusts the upper head according to the box height.



### 9.3 BOX WIDTH ADJUSTMENT KNOBS

It adjusts the side guides according to the box width.



## 10-SAFETY DEVICES OF THE MACHINE

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### 10.1 BLADE GUARDS

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

### 10.2 EMERGENCY STOP BUTTON

The lockable emergency stop button is placed in handy position.

### 10.4 ELECTRIC SYSTEM

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

(See section **ENCLOSURES 15.5**)

## 11-SET-UP AND ADJUSTMENTS

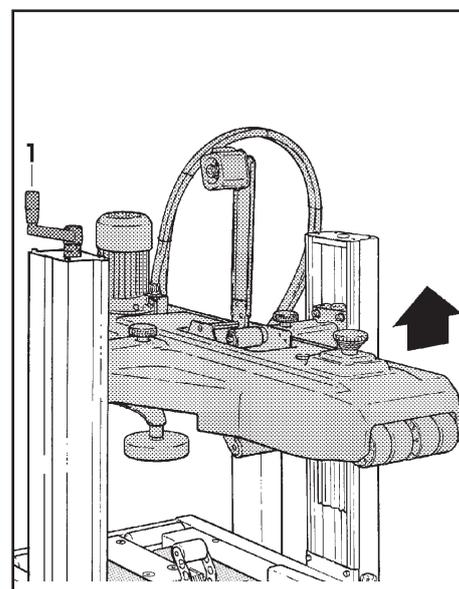
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### 11.0 SAFETY

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

### 11.2 TAPE LOADING ON THE BOTTOM UNIT

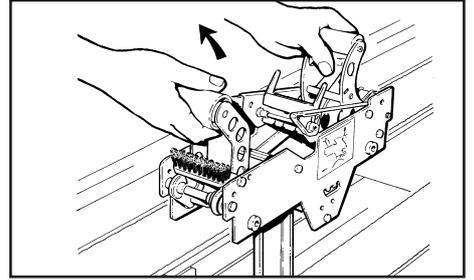
Turn clockwise the handle 1 to raise the upper group..



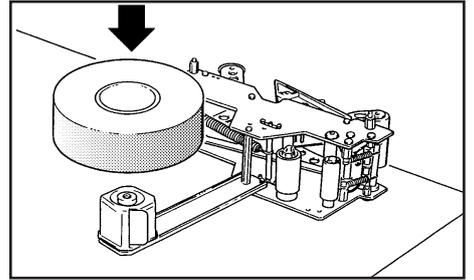
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## 11-SET-UP AND ADJUSTMENTS

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



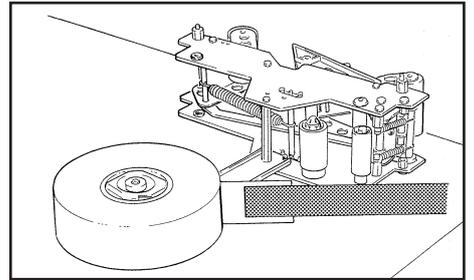
Put a tape roll on the drum.



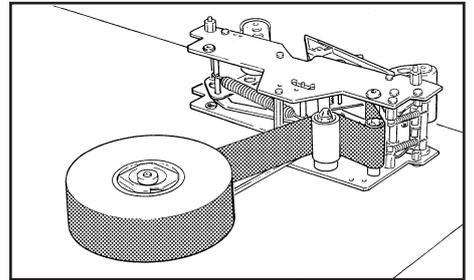
**WARNING! Very sharp blade. It may cause serious injuries.**



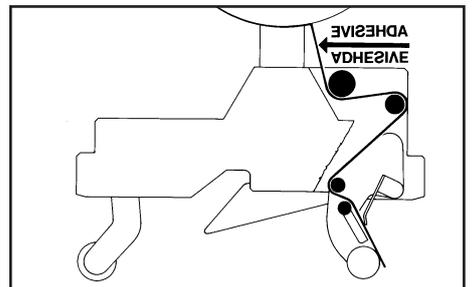
. Attach the tape leg to the threading tool (supplied with the tools kit).



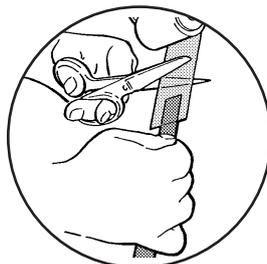
Insert the plastic threading leader through the taping unit. Take care to keep hands away from the tape cutting blades. (see section 3.11-g).



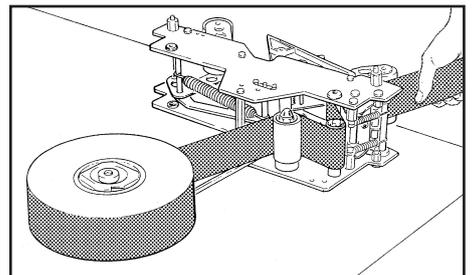
Follow the path through the unit as shown on Picture and make sure that the adhesive side is placed on the correct side.



Pull and cut off the excess tape.



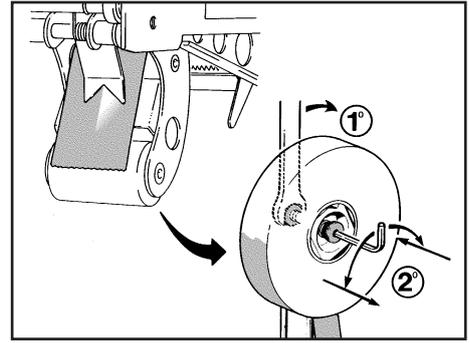
Put again the taping head into its seat..



## 11-SET-UP AND ADJUSTMENTS

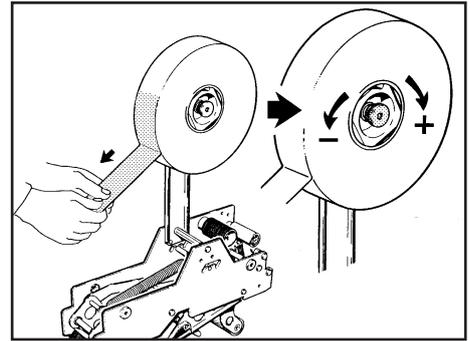
### 11.3 TAPE DRUM ALIGNMENT

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



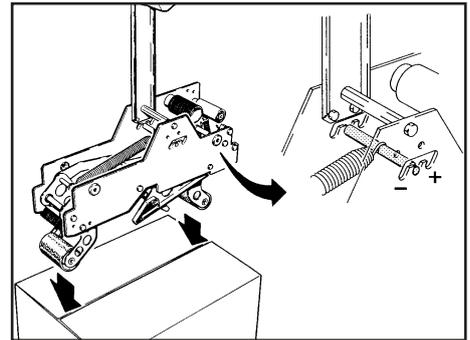
### 11.4 TAPE DRUM FRICTION BRAKE ADJUSTMENT

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



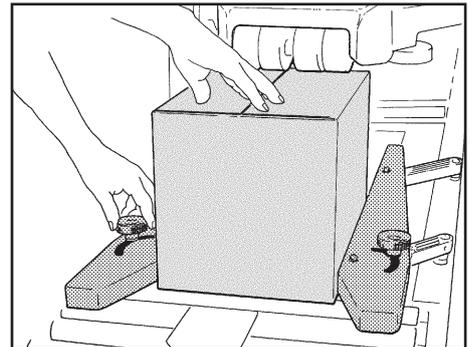
### 11.5 ADJUSTMENT OF TAPING UNITS ACCORDING TO THE TYPE OF BOXES

-  Adjust the main spring:
- decrease the spring load for lightcardboard cases;
  - increase the spring load for robustcardboard cases.



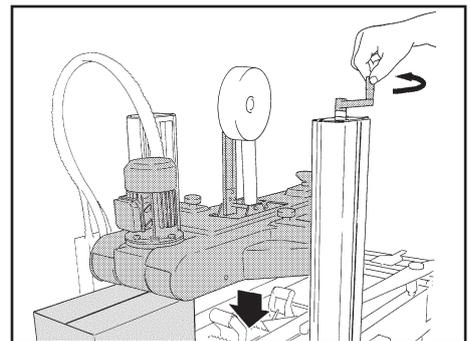
### 11.6 BOX WIDTH ADJUSTMENT

-  Center the box right in the middle of the conveyor bed. Approach and fix the side guides using the proper knobs.



### 11.7 BOX HEIGHT ADJUSTMENT

-  Position the box on the exit side of the machine. Using the proper crank, lower the top head until it slightly presses the box.



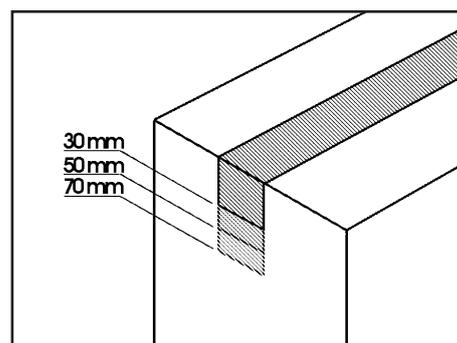
## 11-SET-UP AND ADJUSTMENTS

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### SPECIAL ADJUSTMENTS

#### 11.9 CHANGE OF THE TAPE LEG LENGTH

The tape leg length can vary from 70 to 50 to 30 mm. To adjust the tape leg length refer to the manual of the K12 taping unit, supplied with the machine.



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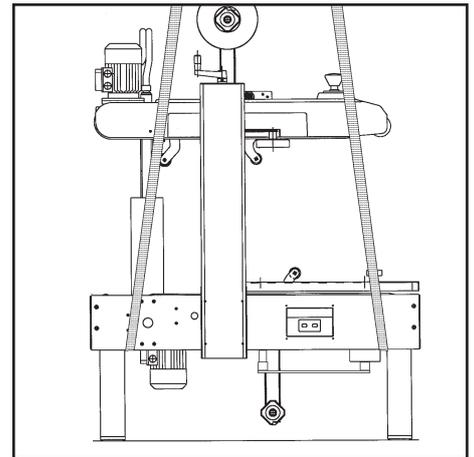
## 11-SET-UP AND ADJUSTMENTS

### OPTIONAL ACCESSORIES

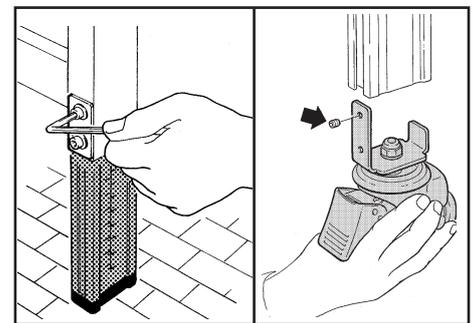
#### 11.11 AS77 CASTERS (OPTIONAL) (code nr. 7.8.04337.00B)

To make easier the machine displacement, it is possible to fit the optional casters. Doing this, the conveyor bed height and the machine overall dimensions change (see section 4.7).

Lift the machine as shown on Picture.



Remove the pad-feet, insert the casters fixing them with the two dowels and set the desired conveyor bed height (refer to the graduated leg label). (Caster height = 100 mm-4 inch).

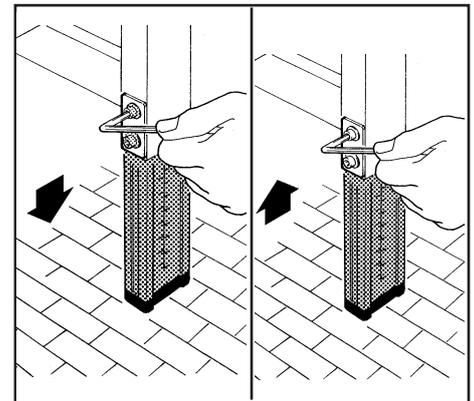


#### 11.12 AS80 LEGS (OPTIONAL) (Kit code nr. 7.8.04413.00A)

To obtain a higher range of conveyor bed height as indicated at section 4.7, it is necessary to replace the inner legs with the longer AS80 legs.

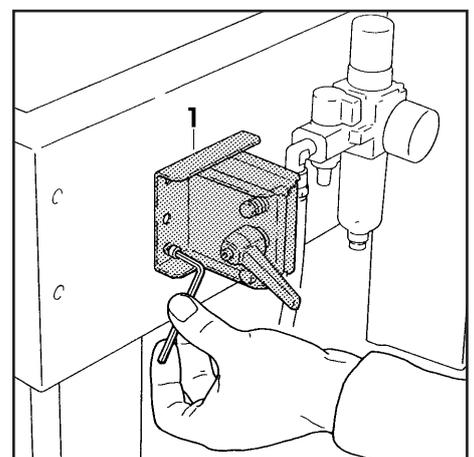
Uplift the machine as shown on Picture.

Unlock the screws and take out the legs. Insert the new legs and block them at the desired height.



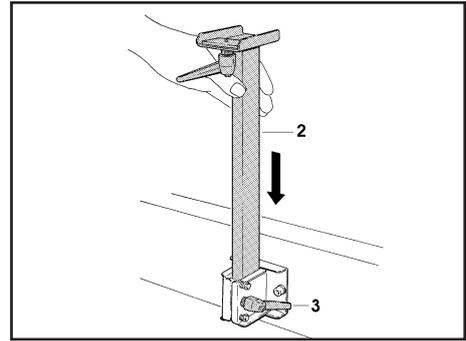
#### 11.13 ATTACHMENT FOR THE KOMPATTO INK-JET MARKER (OPTIONAL) (code nr. 7.8.04044)

Fix the guide 1 to the machine frame using the proper screws supplied with the Kompatto unit.

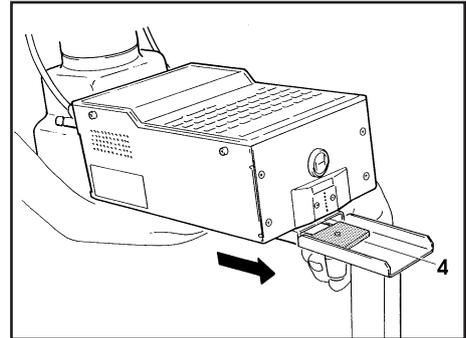


## 12-OPERATION

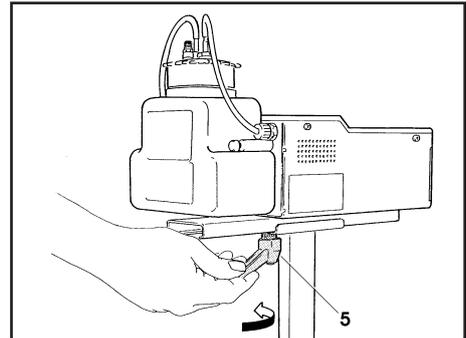
Insert the adjustable support **2** into the guide and lock it with the knob **3**.



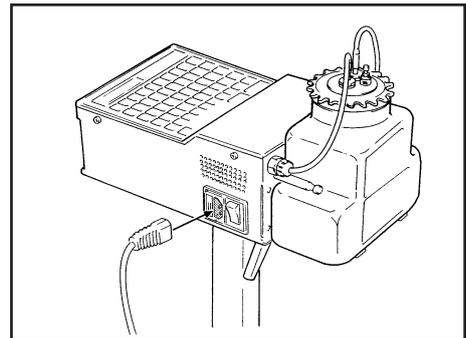
Slide the printing head into the horizontal plate of the support. Make sure to position correctly the plate **4**.



Block with handle **5**.

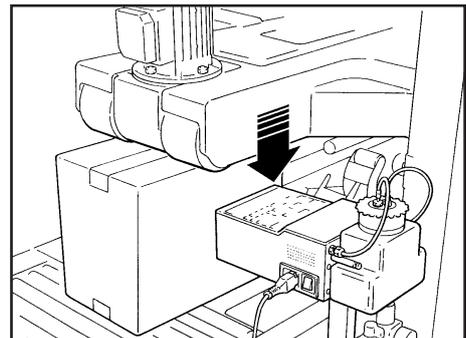


After checking that the voltage on the Kompatto nameplate matches your local voltage, connect the power cord to the mains.



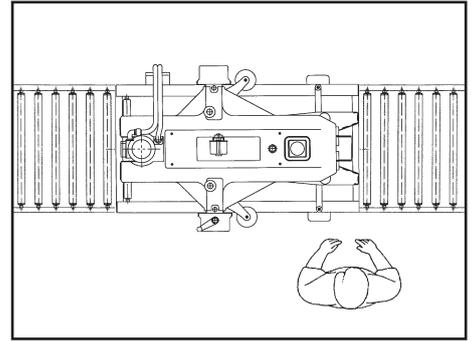
**WARNING:** the Kompatto can interfere with the machine upper assembly. Before adjusting the machine for a new box format, always slide the Kompatto unit fully outwards.

**NB:** for all instructions about set-up, operation, maintenance of the Kompatto ink jet marker, please refer to the relevant manual.



## 12-OPERATION

### 12.1 OPERATOR'S CORRECT WORKING POSITION



### 12.2 STARTING THE MACHINE

Push the main switch ON.

### 12.3 STARTING PRODUCTION

After having adjusted the machine according to the box dimensions (height-width), let the machine idle for a while and check its safety devices (see section 12.8). Then start the working cycle.

### 12.4 TAPE REPLACEMENT

**Be careful with the blades !**

Skill 1 operator

When needed, replace the tape roll, as follows:

- Press the LOCKABLE EMERGENCY STOP BUTTON;
- Repeat all the operations shown in sections 11.1 and/or 11.2



### 12.5 BOX SIZE ADJUSTMENT

Repeat all the operations shown in sections 11.6, 11.7, 11.8

### 12.6 CLEANING

Before carrying out any cleaning or maintenance operation stop the machine by pressing the STOP.

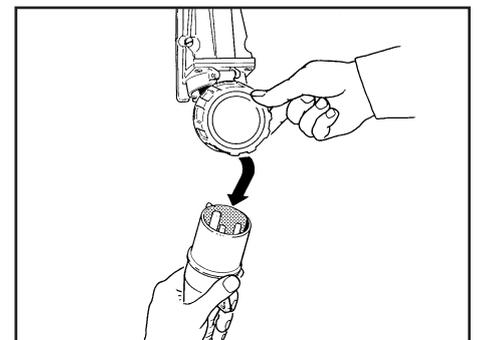


Disconnect the electric power.



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

**Do not** use solvents or water jets.



## 12-OPERATION

### 12.6 TABLE OF ADJUSTMENTS

OPERATIONS	OPERATOR'S SKILL	SECTIONS
Tape loading	1	11.1 - 11.2
Tape alignment	1	11.3
Checkout of the safety devices	1	12.8
Adjustment of tape drum friction brake	1	11.4
Box size adjustment	1	11.6
Adjustment of tape applying spring	1	11.5
Conveyor bed height adjustment	1	7.4
<b>Special adjustment:</b> Tape leg	2	11.9

### 12.7 SAFETY DEVICES CHECKOUT

1 Taping units blade guard (section 10.1)

2 Lockable emergency stop button (section 10.1)

### 12.8 TROUBLE SHOOTING

TROUBLE	CAUSE	SOLUTION
When pressing the ON button, the machine does not start.	The lockable emergency stop button is pressed. Short circuit in the electrical system.	Release the emergency stop button by turning it anticlockwise. Check the electrical system.
The magnetothermic protection opens the main switch.	Motor under stress . Thermal cut-out not at correct amperage setting.	Check that the drive belts are not blocked Set the correct amperage.
The motor runs but the side drive belts stop.	Belts tension too low. Worn out drive pulleys.	Adjust belt tension. Check the wear of the rings and replace them when necessary.
Drive belts turn but do not convey the box.	Worn out belts Flap compression rollers are too close inward.	Replace drive belts. Reposition.

## 13-MAINTENANCE AND REPAIRS

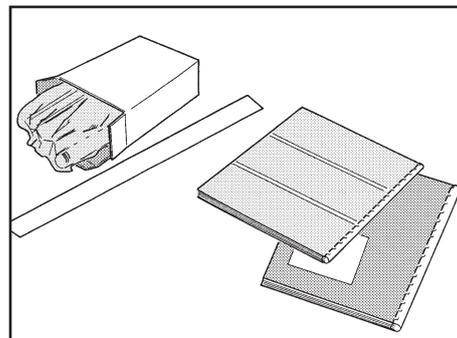
### 13.0 SAFETY MEASURES

(see section 3)

Carrying out maintenance and repairs may imply the necessity to work in dangerous situations. This machine has been designed making reference to the standards EN292 NOV. 92/6.1.2 and EN292/2 NOV. 92/5.3.

### 13.1 SPARE PARTS SUPPLIED WITH THE MACHINE

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



### 13.2 RECOMMENDED FREQUENCY OF CHECK-OUTS AND MAINTENANCE OPERATIONS

OPERATIONS	FREQUENCY	OPERATOR'S SKILL	SECTION
Lubrication	Quarterly	2	13.5-6-7
Blade cleaning	Weekly	2	13.8
Machine cleaning	Weekly	1	12.5
Checkout of safety devices	Daily	1	13.4
Blade replacement	//	2	13.9
Side drive belts replacement	//	2	13.10

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

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 of this duty must work on the machine.

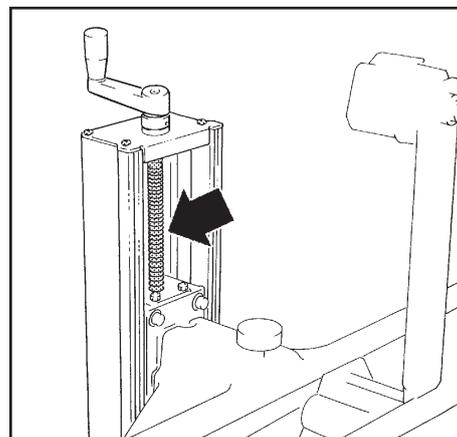
At the end of every maintenance operation check the safety devices.

### 13.4 SAFETY DEVICES CHECK-OUT

- 1 Taping units blade guard (section 10.1)
- 2 Lockable emergency stop button (section 10.1)

### 13.5 MACHINE LUBRICATION

Lubricate quarterly the column's endless screw.



## 13-MAINTENANCE AND REPAIR

### 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)

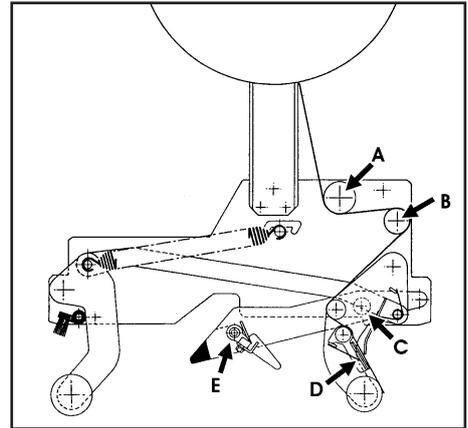
#### OIL TYPE:

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

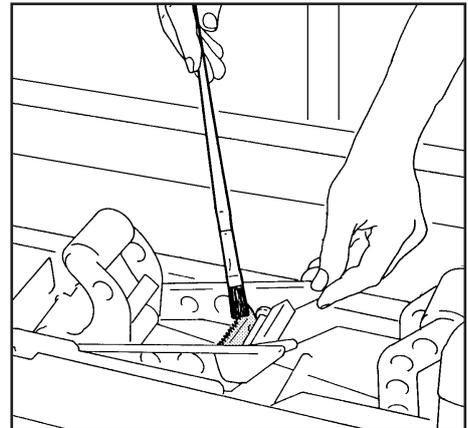


### 13.8 BLADE CLEANING



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

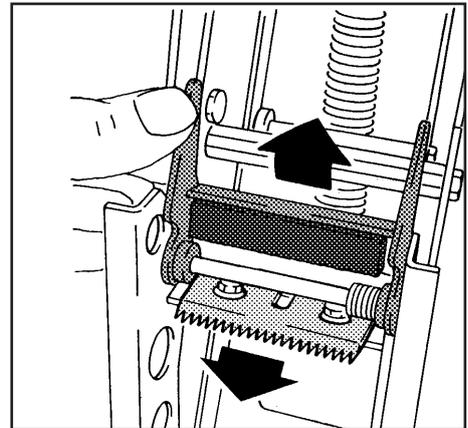
Skill 2 operator

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

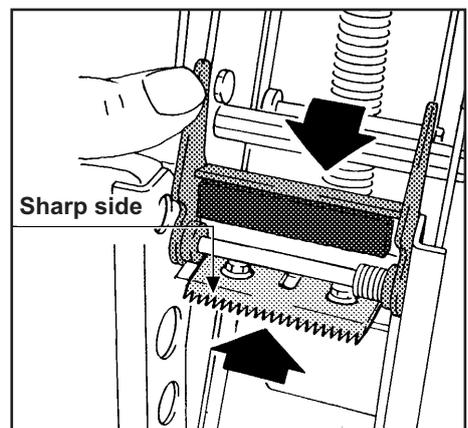
#### WARNING!

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..

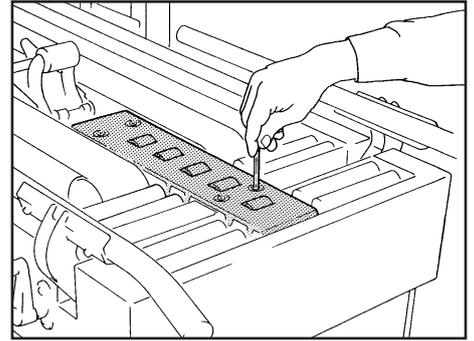


## 13-MAINTENANCE AND REPAIRS

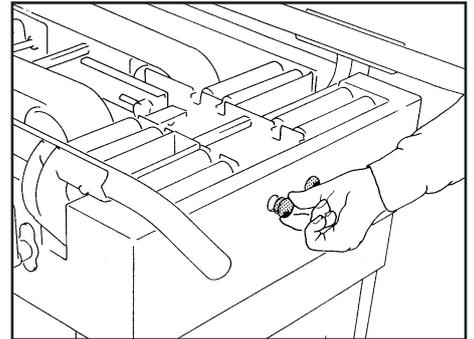
### 13.10 BOTTOM DRIVE BELTS REPLACEMENT

Skill 2 operator

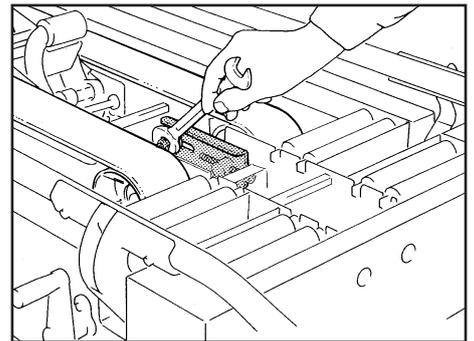
- Remove screws.
- Take the protection cover away.



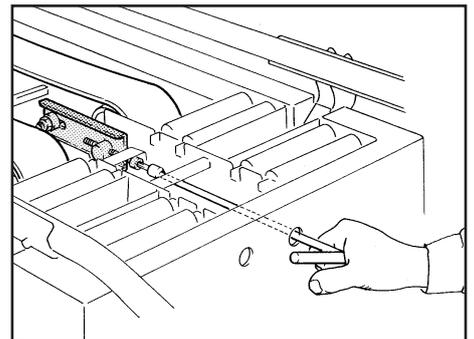
- Take the two caps away.



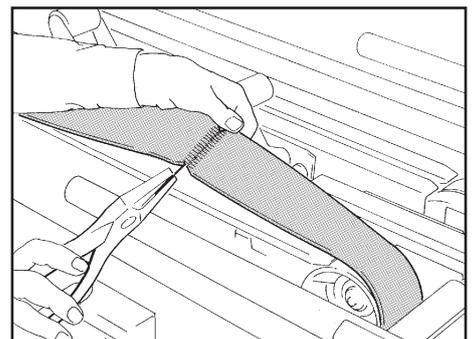
Loosen the locking nut.



Loosen the tensioning screw.



- Cut the worn belt.
- Position the new belt.
- Insert between the lace a nylon hinge.
- Adjust the belt tension.





## 14-ADDITIONAL INSTRUCTIONS

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### 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

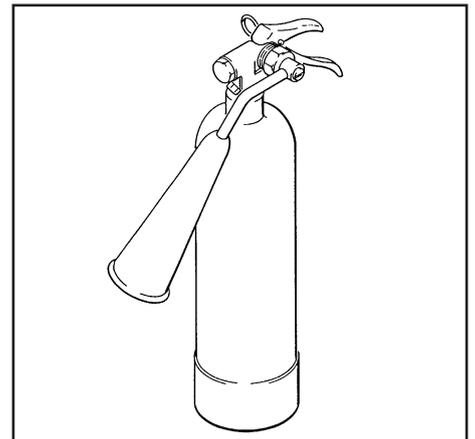
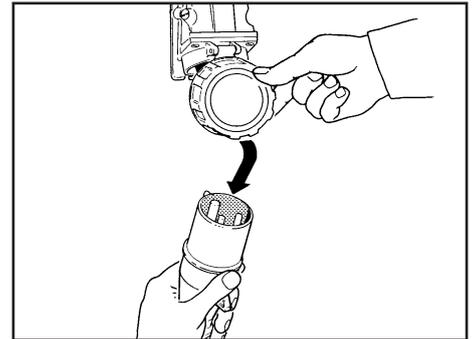
#### **ISTRUZIONI PER SITUAZIONI DI EMERGENZA**

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

#### **FIRE**

In case of fire use an extinguisher containing CO<sub>2</sub>.

**DO NOT** use water.



## 15-ENCLOSURES

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### 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.

To order replacement labels, please refer to the article codes shown on **Figure 5709** in the spare parts catalogue.

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

Nothing to report

### 15.4 ELECTRIC TESTS

Electric tests:

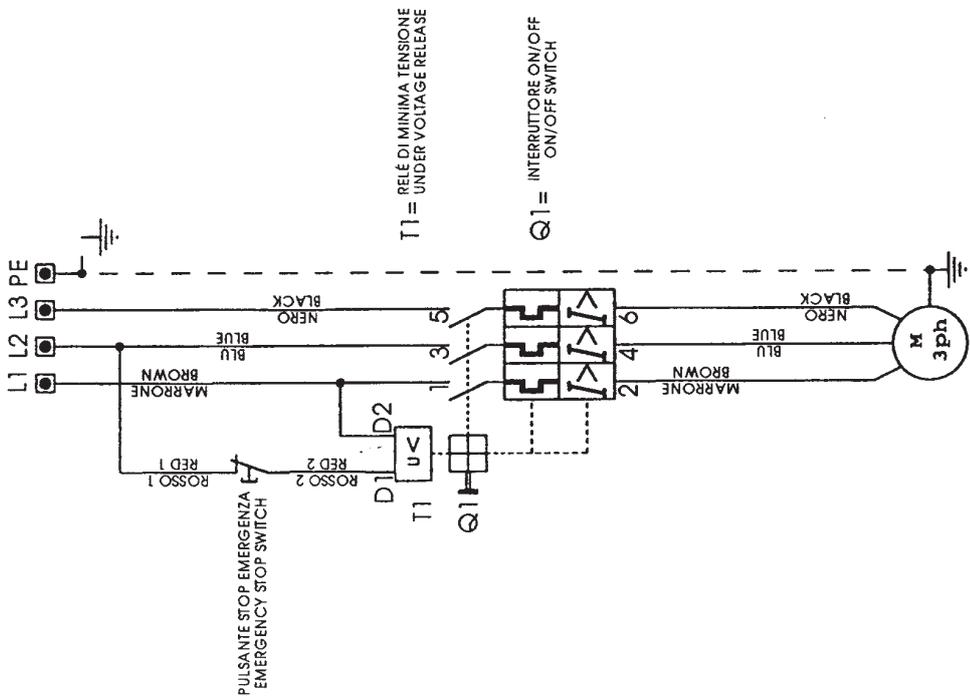
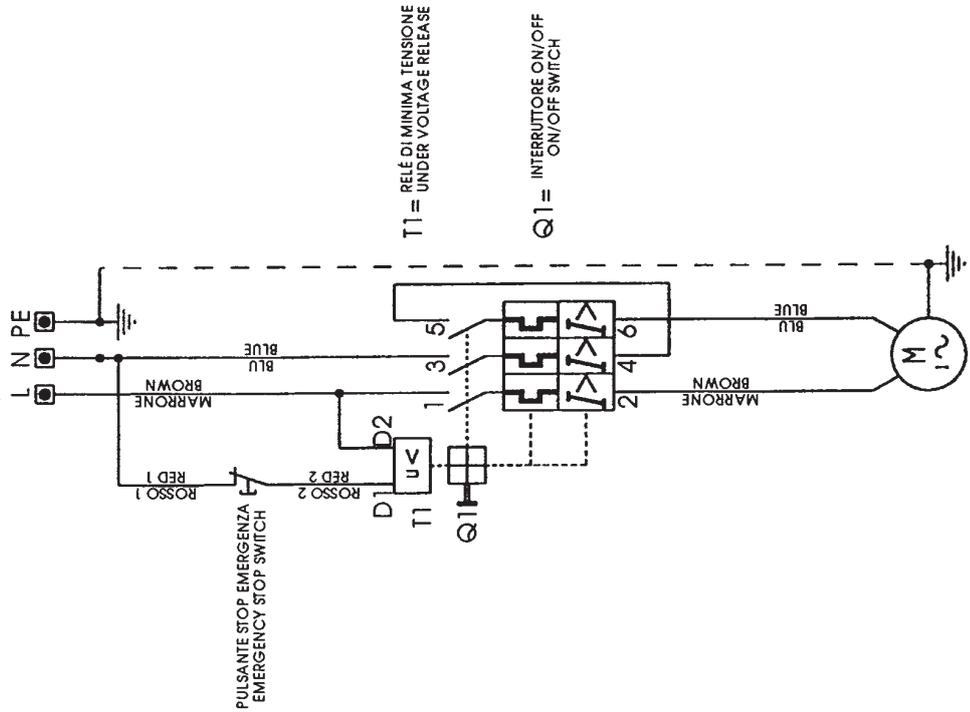
1 - Continuity of the ground circuit

2 - Insulation resistance

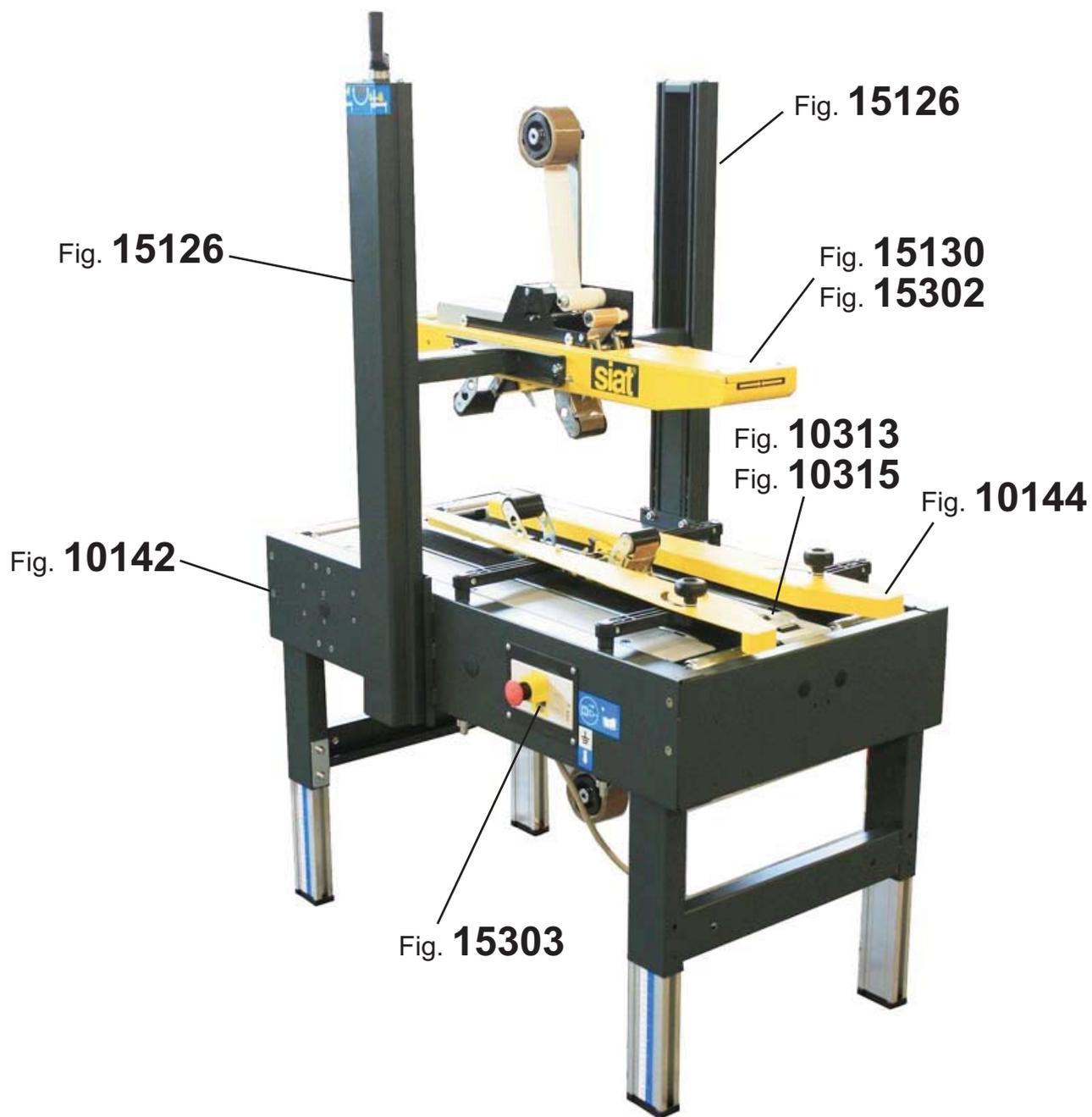
3 - High voltage insulation

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

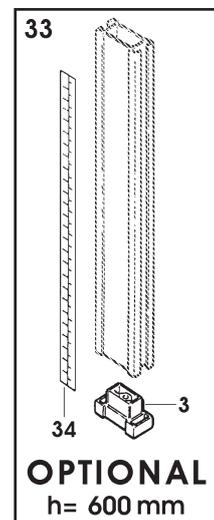
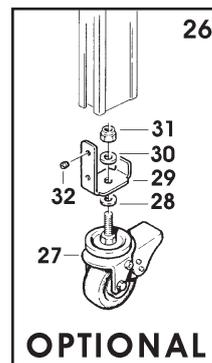
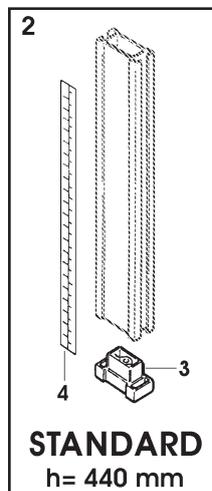
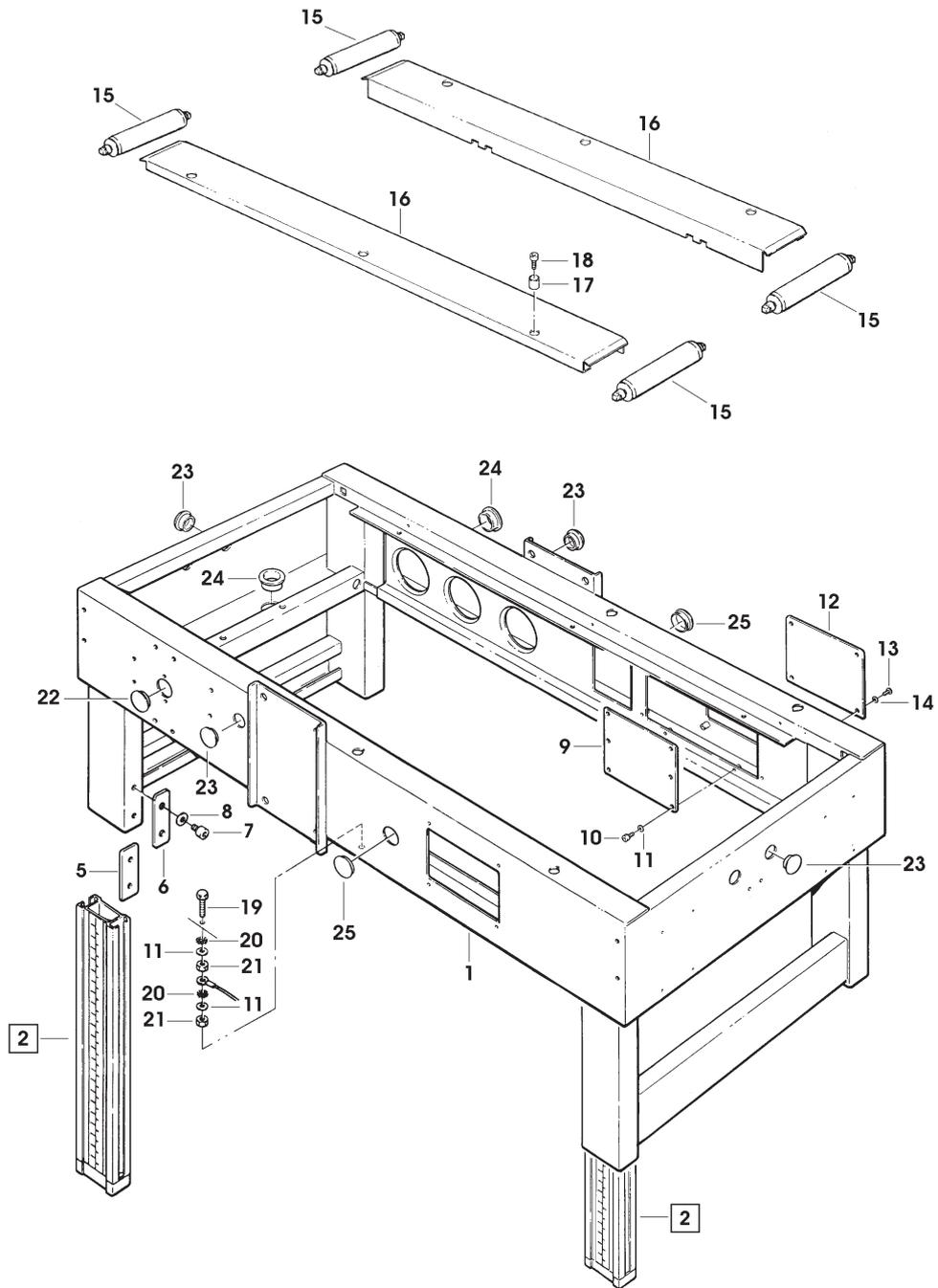
# 16-DRAWINGS AND SCHEMATICS



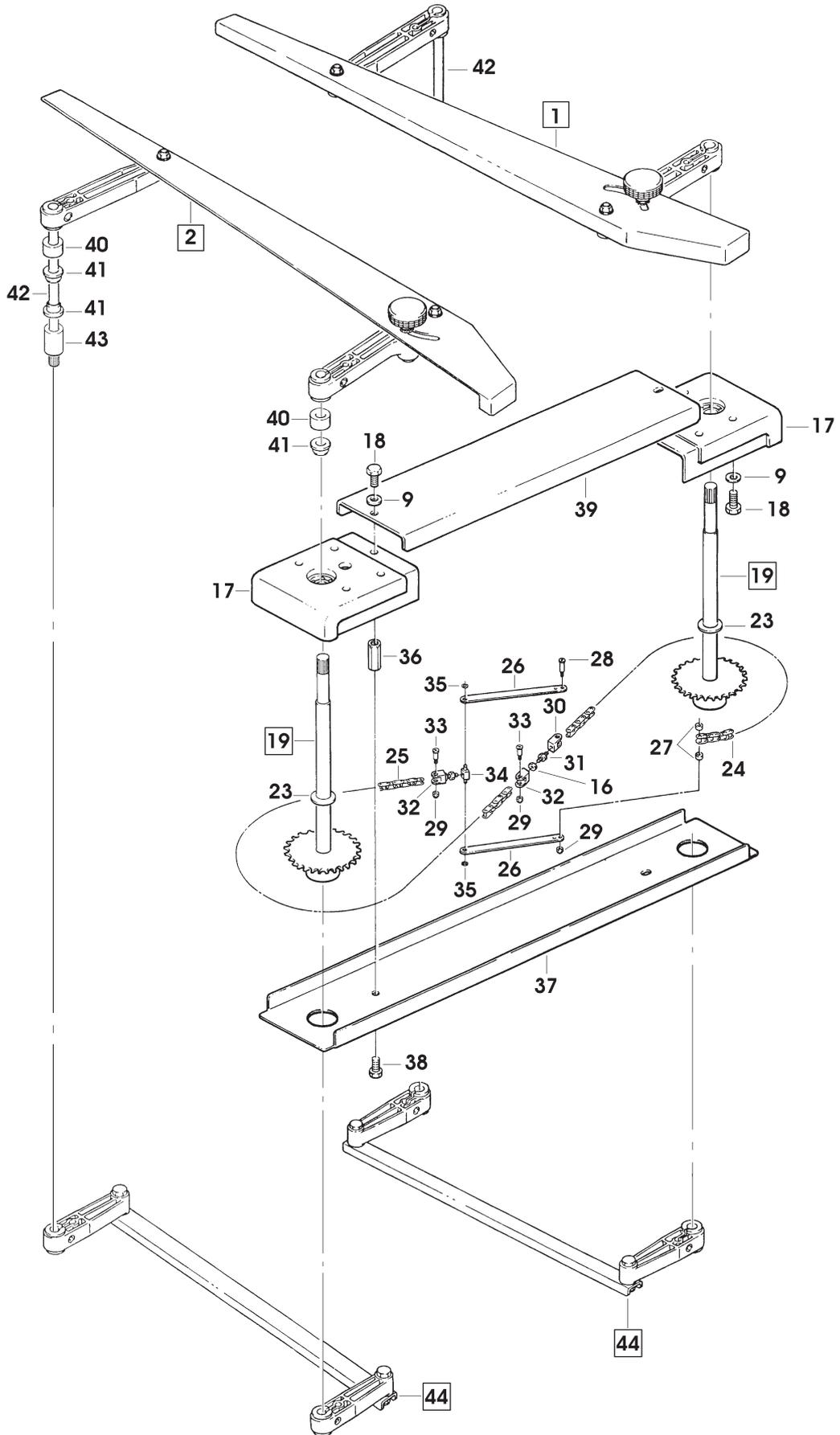
**SIAT s.p.A.** - Via Puecher, 22 - 22078 TURATE (CO) ITALY - P.O. BOX 1  
Tel. 02-964951 - Telefax 02-9689727  
<http://www.siat.com> - E-Mail: [siat@siat.com](mailto:siat@siat.com)



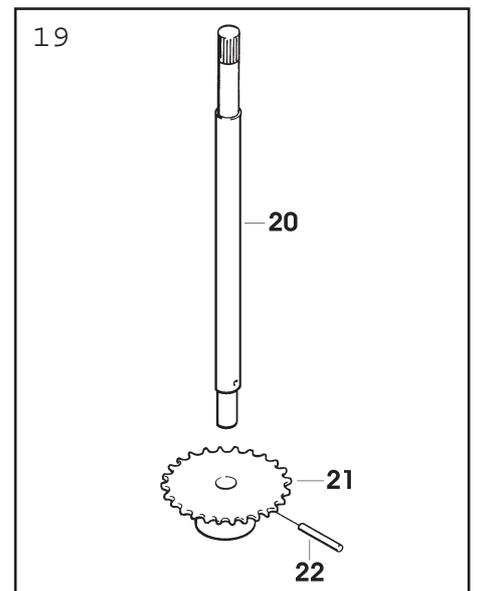
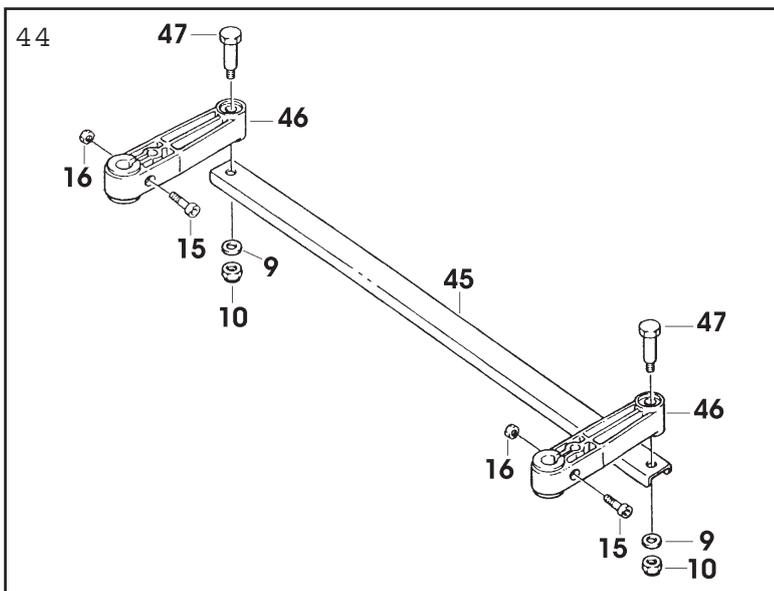
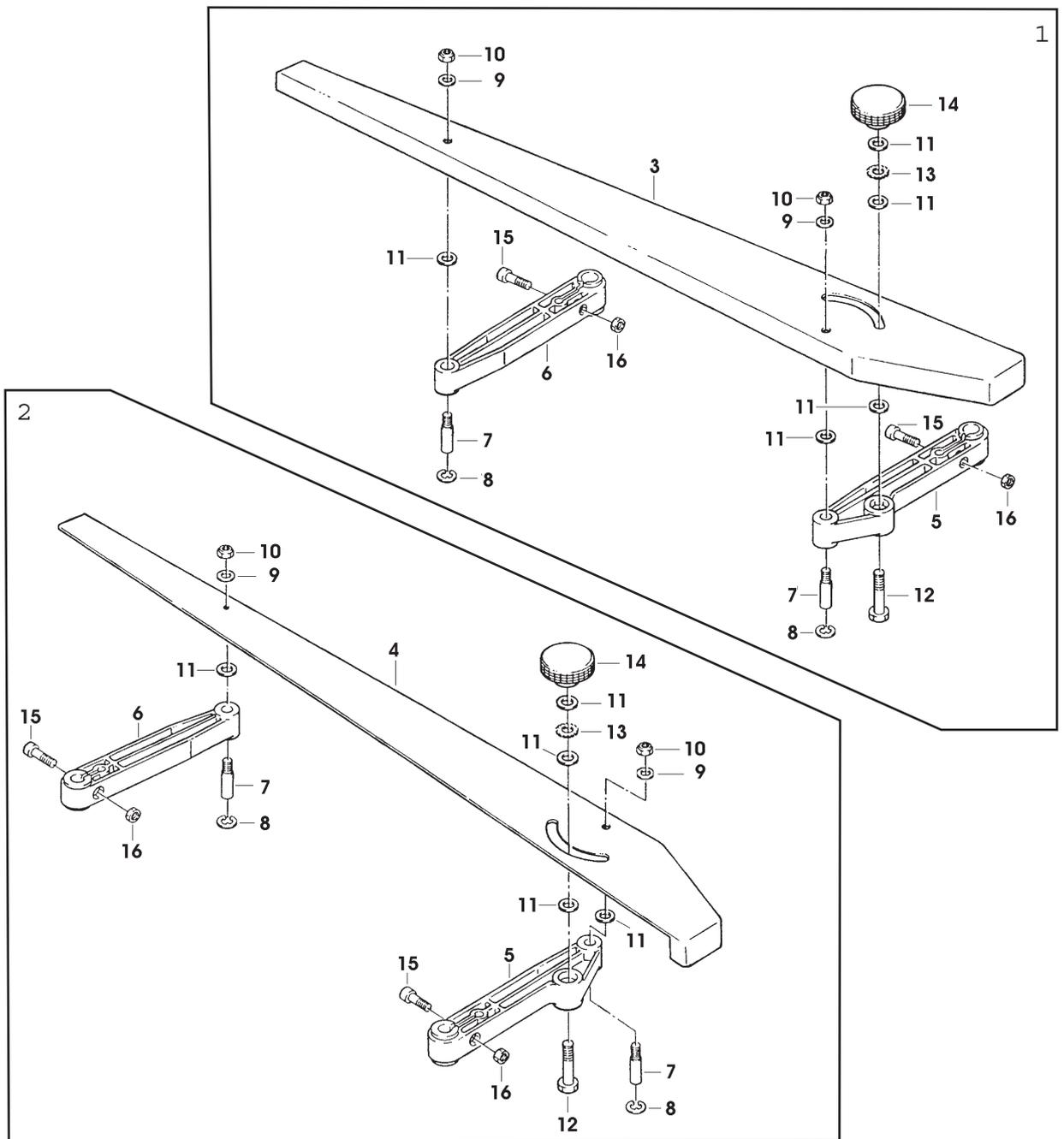
<b>Fig. 10142</b>		<b>BANCALE</b>		<b>SEB0000536</b>		<b>SK1-S NASTRATRICE</b>	
Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione		
1	1,0000	PZ		SBA0000489	BANCALE CON INSERTI SK2		
2	4,0000	PZ	4.3.04737	S4304737ZZZ	GAMBA CON PIEDINO SA2 SR4		
3	4,0000	PZ	3.1.01498	M3101498ZZZ	tappo di chiusura x mont. fot.		
4	4,0000	PZ	3.0.00982.95A	S300098295A	RIGHELLA MILLIMETRATA PER GAMBA H=440		
5	4,0000	PZ	3.2.05671.93A	M320567193A	Muting piastrina fiss. gamba muting Siat		
6	4,0000	PZ	3.2.05898.93A	S320589893A	STAFFA PER GAMBE E TRAVERSE		
7	8,0000	PZ	3.4.00584.93	S340058493Z	VITE TCEI M8X16 ZINCATA		
8	8,0000	PZ	3.4.00123.93	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.		
9	1,0000	PZ	3.2.05876.47B	S320587647B	PIASTRA FISSAGGIO INTERRUETTORE VERN.		
10	4,0000	PZ	3.4.00318.93	S340031893Z	VITE TCEI M5X12 ZINCATA		
11	6,0000	PZ	3.4.00061.93	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.		
12	1,0000	PZ	3.2.05888.47A	S320588847A	PIASTRA CHIUSURA VANO INT.		
13	4,0000	PZ	3.4.00830.93	S340083093Z	VITE TCBCR AUTOF.7SPX8 ZINCATA		
14	4,0000	PZ	3.4.00043.93	S340004393Z	RONDELLA PIANA X VITE M4 ZINC.		
15	4,0000	PZ	4.7.08522.00A	S470852200A	RULLO TIPO "G" ASS.SA2		
16	2,0000	PZ	3.2.05907.17A	S320590717A	PIANO SCORRIMENTO LATERALE		
17	6,0000	PZ	3.1.00981.05	S310098105Z	BUSSOLA 200A		
18	6,0000	PZ	3.4.00015.93	S340001593Z	VITE TCEI M6X25 ZINCATA		
19	1,0000	PZ	3.4.00045.93	S340004593Z	VITE TE M5X20 ZINCATA		
20	2,0000	PZ	3.4.00745.92	S340074592Z	RONDELLA DENT. X VITE M5 BRUN.		
21	2,0000	PZ	3.4.00023.93	S340002393Z	DADO M5 ZINCATO		
22	1,0000	PZ	3.4.02573	S3402573ZZZ	TAPPO DP 1250 (PER FORO /32)		
23	6,0000	PZ	3.8.03667	S3803667ZZZ	TAPPO DP-875 SIAT-2000		
24	2,0000	PZ	3.4.02661	S3402661ZZZ	PASSACAVO SB1250-15 "Heyco"		
25	2,0000	PZ	3.4.02703	S3402703ZZZ	TAPPO DP 1187 "Heyco"		
26	1,0000	PZ	7.8.04337.00B	S780433700B	AS77 SET RUOTE /80 SIAT 2000		
27	4,0000	PZ	3.4.01501	S3401501ZZZ	RUOTA /80 POLIDERNYL		
28	4,0000	PZ	3.2.02455.93	S320245593Z	DISTANZIALE PER RUOTE SM481		
29	4,0000	PZ	3.2.07244.93A	S320724493A	ATTACCO RUOTA AS77		
30	4,0000	PZ	3.4.00062.93	S340006293Z	RONDELLA PIANA X VITE M12 ZINC		
31	4,0000	PZ	3.4.00735.93	S340073593Z	DADO AUTOBLOCCANTE M12 ZINCATO		
32	8,0000	PZ	3.4.00415.92	S340041592Z	GRANO EIPP M8X8 BR.		
33	1,0000	PZ	7.8.04413.00A	S780441300A	AS80-SET GAMBE SPECIALI		
34	4,0000	PZ	3.0.01051.96A	S300105196A	ETICHETTA RIGHELLA MILLIMET.H=600 X GAMBA		



<b>Fig. 10144</b>		<b>GUIDE LATERALI</b>		<b>SEB0000536</b>		<b>SK1-S NASTRATRICE</b>	
Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione		
1	1,0000	PZ	4.7.09506.00B	S470950600B	GUIDA DX ASS.SK2		
2	1,0000	PZ	4.7.09507.00B	S470950700B	GUIDA SX ASS.SK2		
3	1,0000	PZ	3.2.06950.40A	S320695040A	GUIDA DX SK2		
4	1,0000	PZ	3.2.06951.40A	S320695140A	GUIDA SX SK2		
5	2,0000	PZ	3.1.00571.05	S310057105Z	(P) LEVA BLOCCAGGIO L=194		
6	2,0000	PZ	3.1.00569.05	S310056905Z	(P )LEVA L=194		
7	4,0000	PZ	3.3.05330.93	S330533093Z	PERNO /10X41		
8	4,0000	PZ	3.4.00837.92	S340083792Z	ANELLO ARRESTO 10SP220		
9	18,000	PZ	3.4.00175.93	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.		
10	8,0000	PZ	3.4.00258.93	S340025893Z	DADO AUTOBLOCCANTE BASSO M6		
11	10,000	PZ	3.4.00219.93	S340021993Z	RONDELLA PIANA X VITE M10 ZINC		
12	2,0000	PZ	3.4.00499.93	S340049993A	VITE TE M10X35 ZINCATA		
13	2,0000	PZ	3.4.01170.92	S340117092Z	RONDELLA DENT.EST./10 BRUNITA		
14	2,0000	PZ	3.4.02706.05	S340270605Z	MANOPOLA "ELESA" MBT-50 B-M10		
15	8,0000	PZ	3.4.00160.93	S340016093Z	VITE TCEI M6X20 ZINCATA		
16	10,000	PZ	3.4.00002.93	S340000293Z	DADO M6 ZINCATO		
17	2,0000	PZ	4.6.04220	S4604220ZZZ	(P) SCATOLA RINVIO CON CUSCINE		
18	10,000	PZ	3.3.07876.93	S330787693Z	VITE TE M6X16 SPEC.		
19	2,0000	PZ		SBA0000491	PERNO ANTERIORE GUIDE CON PIGN		
20	2,0000	PZ	3.3.29774.93A	S332977493A	PERNO ANTERIORE LEVE GUIDE		
21	2,0000	PZ	3.3.17732.92A	S331773292A	PIGNONE Z=24 3/8" SK2		
22	2,0000	PZ	3.4.00136.92	S340013692Z	SPINA ELASTICA /5X35 BRUNITA		
23	2,0000	PZ	3.3.17733.93A	S331773393A	DISTANZIALE PER PIGNONE SK2		
24	1,0000	PZ	3.4.00201	S3400201ZZZ	SPEZZONE CATENA 3/8" L=65 PASSI P=9,525 "CM"		
25	1,0000	PZ	3.4.02972	S3402972ZZZ	SPEZZONE CATENA P=3/8" L=45 PASSI "CM"		
26	2,0000	PZ	3.2.01037.93	S320103793Z	TIRANTE X CATENA SM/XL/3M		
27	2,0000	PZ	3.3.05605.93	S330560593Z	RONDELLA /3/10X3 ZINCATA		
28	1,0000	PZ	3.3.06185.92	S330618592Z	VITE SPEC.TC M3X25		

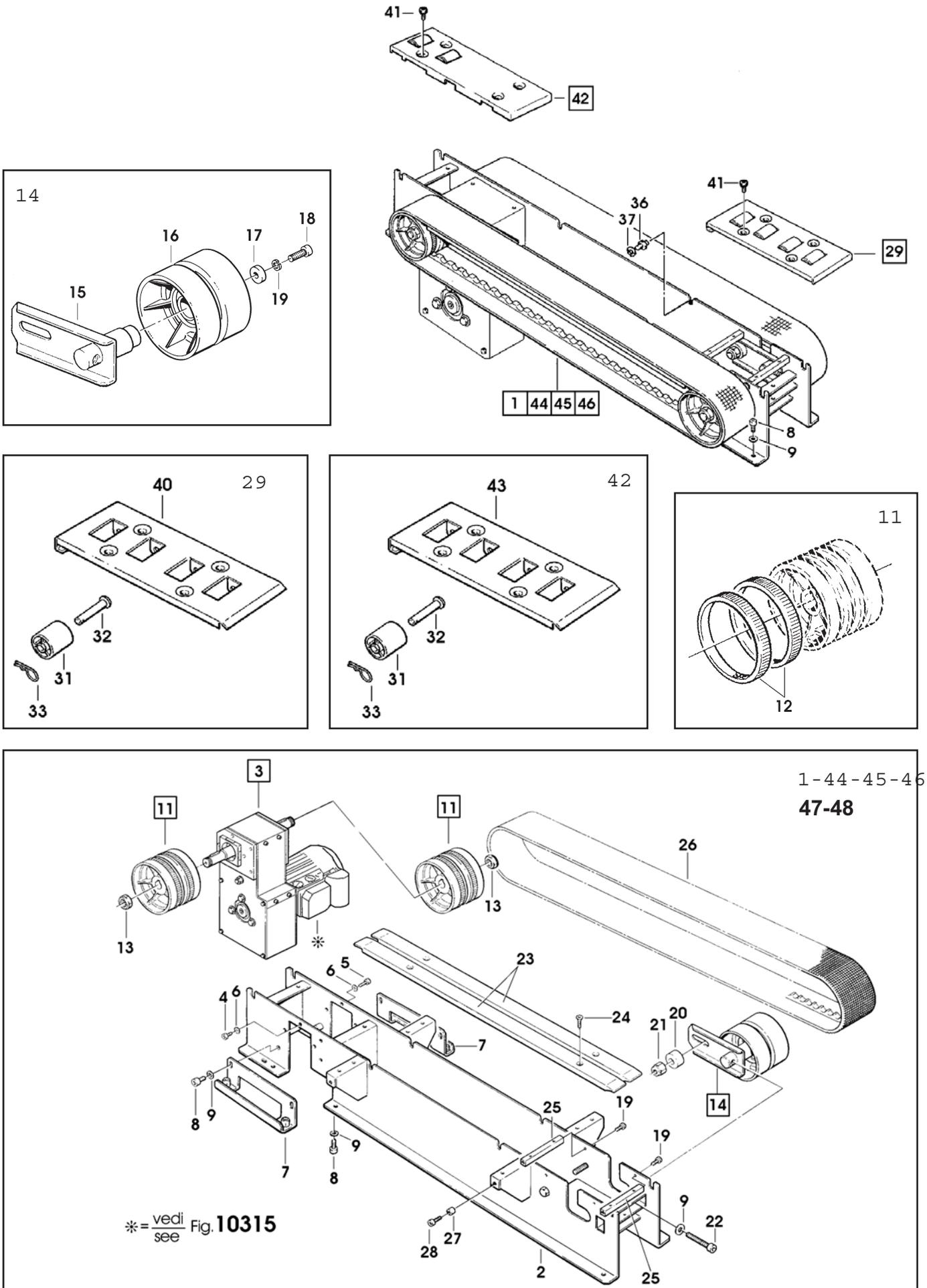


<b>Fig. 10144</b>		<b>GUIDE LATERALI</b>		<b>SEB0000536</b>	<b>SK1-S NASTRATRICE</b>
Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
29	3,0000	PZ	3.4.01014.93	S340101493Z	DADO AUTOBLOCCANTE M3 ZINCATO
30	1,0000	PZ	3.3.05899.93	S330589993Z	FORCELLA DESTRORSA SM4/F-104
31	2,0000	PZ	3.3.05602.93	S330560293Z	VITE TENDICAT.DX/SX SM4/F-104
32	2,0000	PZ	3.3.05603.93	S330560393Z	FORCELLA SINISTROSA F-104
33	3,0000	PZ	3.3.06184.92	S330618492Z	VITE SPEC.TC M3X20
34	1,0000	PZ	3.3.05604.93	S330560493Z	BLOCCHETTO FISS.CATENA
35	2,0000	PZ	3.4.00905.92	S340090592Z	ANELLO SICUREZZA 3,2 DIN 6799
36	2,0000	PZ	3.3.17731.93A	S331773193A	DISTANZIALE PER CARTER SK2
37	1,0000	PZ	3.2.06955.47A	S320695547A	CARTER INF.PER GR.GUIDE SK2
38	2,0000	PZ	3.3.05356.93	S330535693Z	VITE TE M6X12 SPEC.
39	1,0000	PZ	3.2.06954.47A	S320695447A	CARTER SUP.PER GR.GUIDE SK2
40	4,0000	PZ	3.1.00573.05	S310057305Z	(P) DISTANZIALE /24X15
41	6,0000	PZ	3.1.00574	S3100574ZZZ	BUSSOLA DI GUIDA
42	2,0000	PZ	3.3.29775.93A	S332977593A	PERNO POSTERIORE LEVE GUIDE SK2-S
43	2,0000	PZ	3.1.01698.05A	S310169805A	(P) DISTANZIALE PER GUIDE SK2
44	2,0000	PZ	4.7.09526.00A	S470952600A	BARRA ACCOPPIAMENTO LEVE ASS.SK2
45	2,0000	PZ	3.2.06972.93A	S320697293A	BARRA ACCOPP.GUIDE SK2
46	4,0000	PZ	3.1.00568.05	S310056805Z	(P) LEVA L=115
47	4,0000	PZ	3.3.08317.93	S330831793Z	PERNO RULLINI TENDICAT.12A-S2



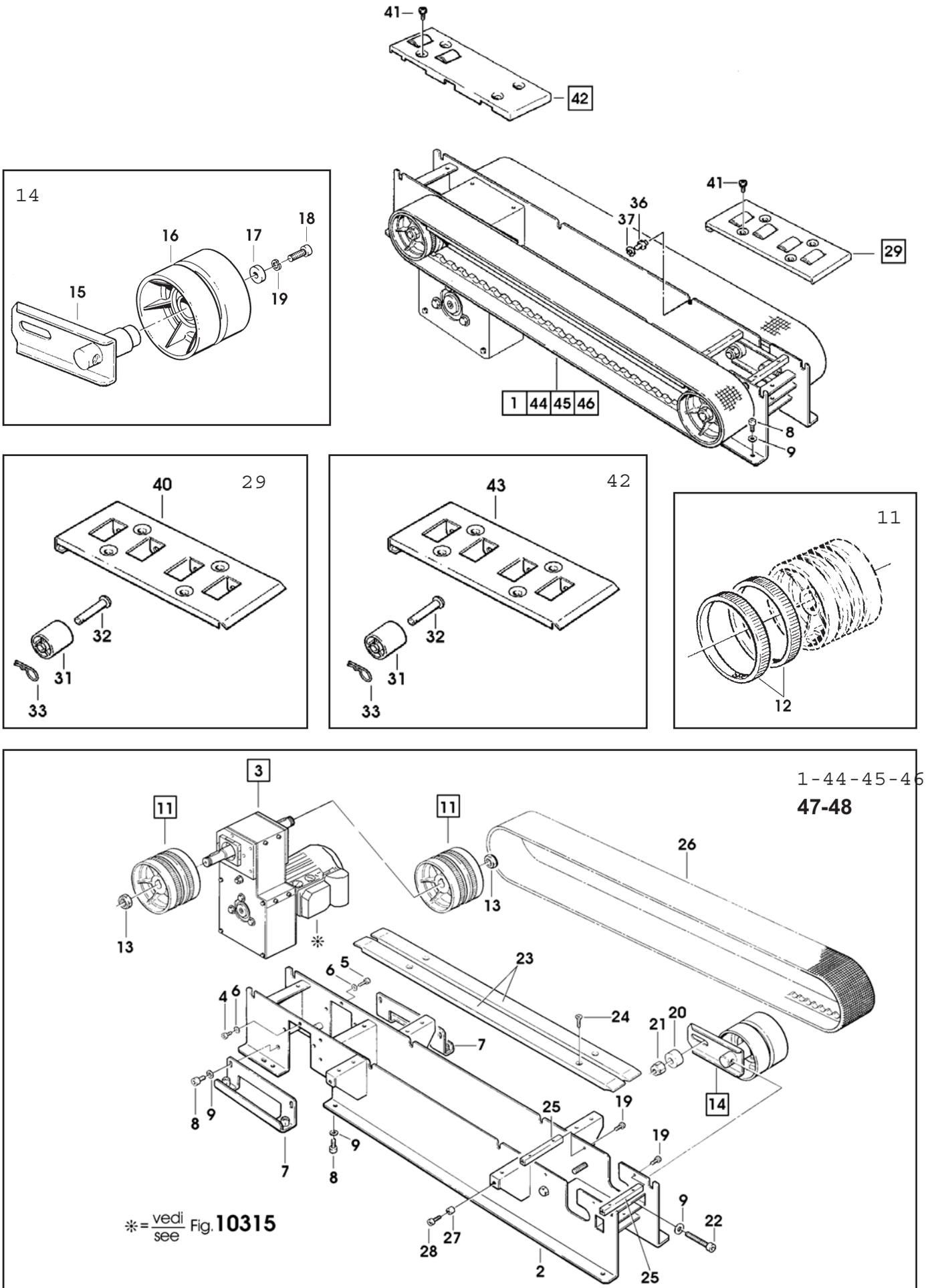
**Fig. 10313    MOTORIZZAZIONE INFERIORE****SEB0000536    SK1-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	1,0000	PZ		SBA0008192	MOT. INF.SK1/SK2 220/240V-50-MF
2	1,0000	PZ		SBA0002144	Struttura motorizzazione inf. c/ins.
3	1,0000	PZ		SBA0002259	RIDUTTORE INFERIORE ASSIEMATO
4	3,0000	PZ	3.4.00318.93	S340031893Z	VITE TCEI M5X12 ZINCATA
5	3,0000	PZ	3.4.00112.93	S340011293Z	VITE TCEI M5X16 ZINCATA
6	6,0000	PZ	3.4.00061.93	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
7	2,0000	PZ	4.5.04912.47	S450491247Z	SQUADRETTA RINFORZO SPALLE S2
8	12,000	PZ	3.4.00584.93	S340058493Z	VITE TCEI M8X16 ZINCATA
9	14,000	PZ	3.4.00123.93	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
11	2,0000	PZ	4.7.05876	S4705876ZZZ	PULEGGIA MOTRICE ASS.C/ANELLI
12	4,0000	PZ	3.1.00540.48	S310054048Z	ANELLO PER PULEGGIA
13	2,0000	PZ	3.5.00515.93	S350051593Z	DADO SPEC.AUTOBLOCC.M20X1 ZINC
14	2,0000	PZ	4.7.08528.00B	S470852800B	CARRELLO TENDICINGHIA ASS.SA2
15	2,0000	PZ	4.4.05687.93C	S440568793C	CARRELLO TENDICINGHIA ASS.
16	2,0000	PZ	4.6.01730	S4601730ZZZ	(P) PULEGGIA FOLLE COMP.
17	2,0000	PZ	3.3.04916.93	S330491693Z	RONDELLA /6,5/30X5
18	2,0000	PZ	3.4.00024.92	S340002492Z	RONDELLA ELAST.X VITE M6 BRUN.
19	6,0000	PZ	3.3.05356.93	S330535693Z	VITE TE M6X12 SPEC.
20	2,0000	PZ	3.5.01802.93	S350180293Z	DIST.PERNO MOTORIZZAZ.INF.
21	2,0000	PZ	3.4.00438.93	S340043893Z	DADO AUTOBLOCCANTE M10 BASSO
22	2,0000	PZ	3.4.01703.93	S340170393Z	VITE TCEI M8X70 TUTTO FILETTO
23	4,0000	PZ	3.2.02909.93	S320290993Z	GUIDA SCORRIM.CINGHIA 200A
24	8,0000	PZ	3.4.00055.93	S340005593Z	VITE TSVEI M5X20 ZINCATA
25	2,0000	PZ	3.5.01757.93	S350175793Z	DISTANZIALE FISS.CARTER
26	2,0000	PZ	3.4.01771	S3401771ZZZ	CINGHIA TRASCINAM.C/GIUNZIONE 75X1823 +-2,5 S2000-3M
27	4,0000	PZ	3.5.01852.93	S350185293Z	DIST.X CARTER LAT.200A-700A
28	4,0000	PZ	3.4.00045.93	S340004593Z	VITE TE M5X20 ZINCATA



**Fig. 10313    MOTORIZZAZIONE INFERIORE****SEB0000536    SK1-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
29	1,0000	PZ	4.7.09509.00A	S470950900A	CARTER ANT.ASS.SK2
31	6,0000	PZ	3.1.00564	S3100564ZZZ	(P)RULLINO /32X38
32	6,0000	PZ	3.3.10702.93	S331070293Z	PERNO X RULLINI BANCALE 800a3M
33	6,0000	PZ	3.7.00012.96	S370001296Z	MOLLETTA H75/H100 800a/800ab
36	4,0000	PZ	3.5.01794.93	S350179493Z	PERNO ATTACCO UNITA'SUP.-INF.
37	4,0000	PZ	3.2.03876.98	S320387698Z	RONDELLA INOX X CUSCINETTO GR.ENTRATA K13
40	1,0000	PZ	3.2.10169.17A	S321016917A	PIANETTO A RULLI ANTERIORE SK2
41	8,0000	PZ	3.4.01708.93	S340170893Z	VITE TESTA MEZZA TONDA CROCE M5X16 PER 700R
42	1,0000	PZ	4.7.10822.00A	S471082200A	CARTER POST.MOTORIZZ.C/RULLINI SA2-SR4
43	1,0000	PZ	3.2.05911.17D	S320591117D	CARTER POSTERIORE MOTORIZZAZ.INF. SA2 SR4 VERN.
44	1,0000	PZ		SBA0002266	MOT.INF.SK2 S KYOWA 200V 50/60HZ 3F
45	1,0000	PZ		SBA0002268	MOT.INF.SK2 S KY 220/240V 50HZ 400/415V
46	1,0000	PZ		SBA0002270	MOT.INF.SK2 S KYOWA 440V 50HZ 3F
47	1,0000	PZ		SBA0009082	MOT.INF.SK1-S 110V/60HZ/MF UL
48	1,0000	PZ		SBA0009147	MOT. INF.SK1/SK2 110V-60HZ-MF



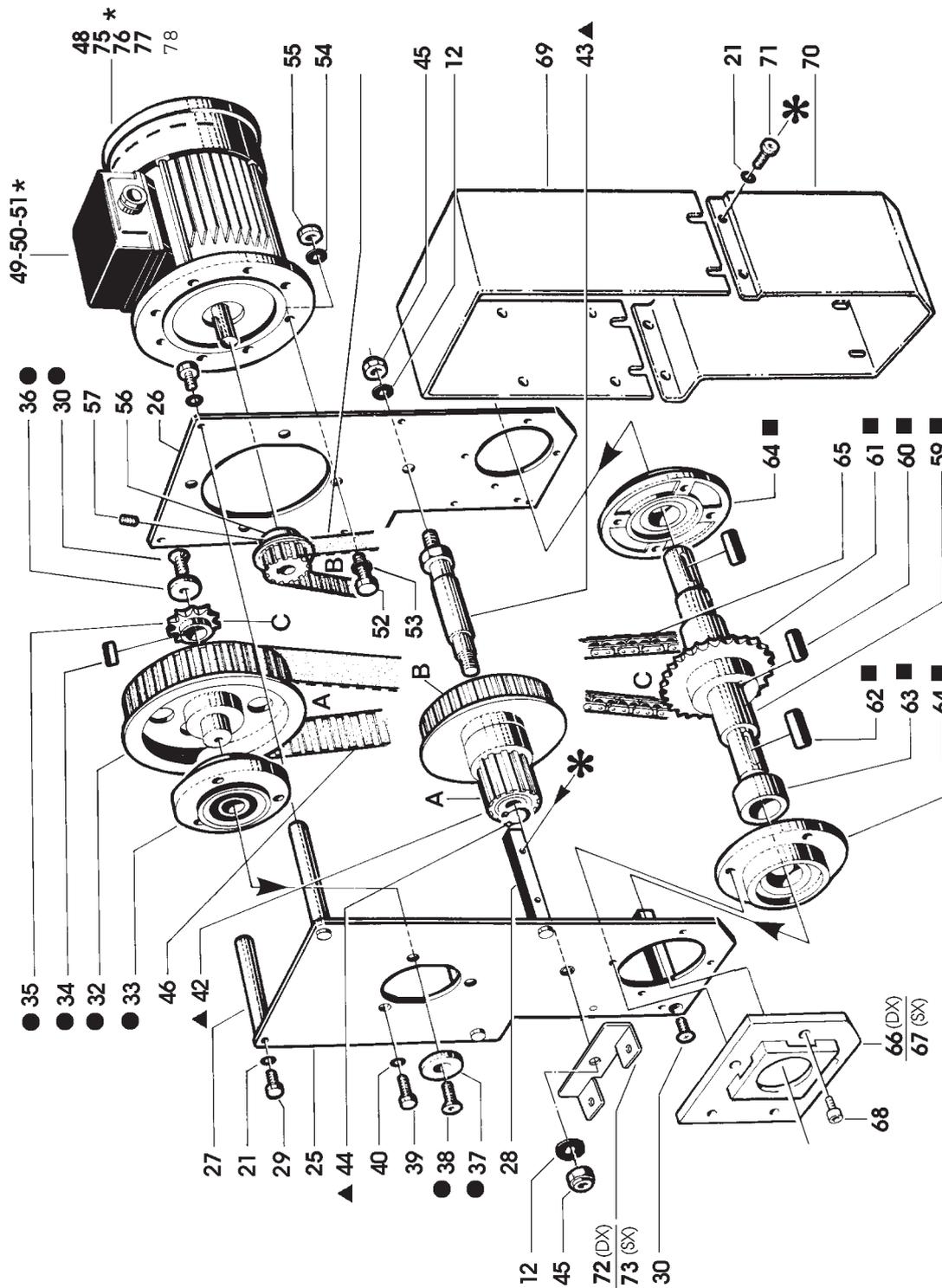
**Fig. 10315 RIDUTTORE ASSIEMATO****SEB0000536 SK1-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
12	12,0000	PZ	3.4.00123.93		RONDELLA PIANA X VITE M8 ZINC.
21	42,0000	PZ	3.4.00061.93		RONDELLA PIANA X VITE M5 ZINC.
25	1,0000	PZ		SBC0002652V	SPALLA SX PER RIDUTTORE SPECIALE
26	1,0000	PZ		SBC0002651V	SPALLA DX PER RIDUTTORE SPECIALE
27	2,0000	PZ	3.3.06830.93		DISTANZIALE /10X81,6
28	3,0000	PZ	3.3.06829.93		DISTANZIALE 10X10X81,6
29	8,0000	PZ	3.4.00371.93		VITE TE M5X12 ZINCATA
30	3,0000	PZ	3.4.00516.93		VITE TSVEI M5X12 ZINCATA
31	1,0000	PZ	4.7.04241		PULEGGIA X RIDUTTORE ASS.SM1/2
32	1,0000	PZ	4.6.02390		PULEGGIA
33	1,0000	PZ	4.6.04157		SUPPORTO PULEGGIA COMP.
34	1,0000	PZ	3.4.00741		LINGUETTA 4X4X10
35	1,0000	PZ	3.3.06826.92		PIGNONE Z=11 P=3/8"
36	1,0000	PZ	3.3.05951.93		RONDELLA /5,5X/20X4
37	1,0000	PZ	3.3.02215.93		RONDELLA /6,5/30X5
38	1,0000	PZ	3.4.00053.93		VITE TSVEI M6X16 ZINCATA
39	4,0000	PZ	3.4.00057.93		VITE TE M6X20 ZINCATA
40	3,0000	PZ	3.4.00033.93		RONDELLA TRIPLA X VITE M6 ZIC
41	1,0000	PZ	4.7.04242		PULEGGIA DOPPIA ASSIEMATA SM1
42	1,0000	PZ	4.3.04355		PULEGGIA DOPPIA C/CUSCINETTO X RIDUTT.SM
43	1,0000	PZ	3.3.06827.92		PERNO ECC.ES.20X116
44	1,0000	PZ	3.4.00187.92		ANELLO ARRESTO 10 DIN 471 BRUN
45	2,0000	PZ	3.4.00283.93		DADO AUTOBLOCCANTE M8 BASSO
46	1,0000	PZ	3.4.01111		CINGHIA DENTATA 187L100
47	1,0000	PZ	3.4.00140		CINGHIA DENTATA 187L050
48	1,0000	PZ	3.8.03446		MOTORE MULTITENSIONE MH63 C4 KW0,12 B5 TIPO 5 .
49	1,0000	PZ	3.8.02615		VENTOLA X MOTORE F.63
50	1,0000	PZ	3.8.04788		PORTA CONDENSATORE MH63



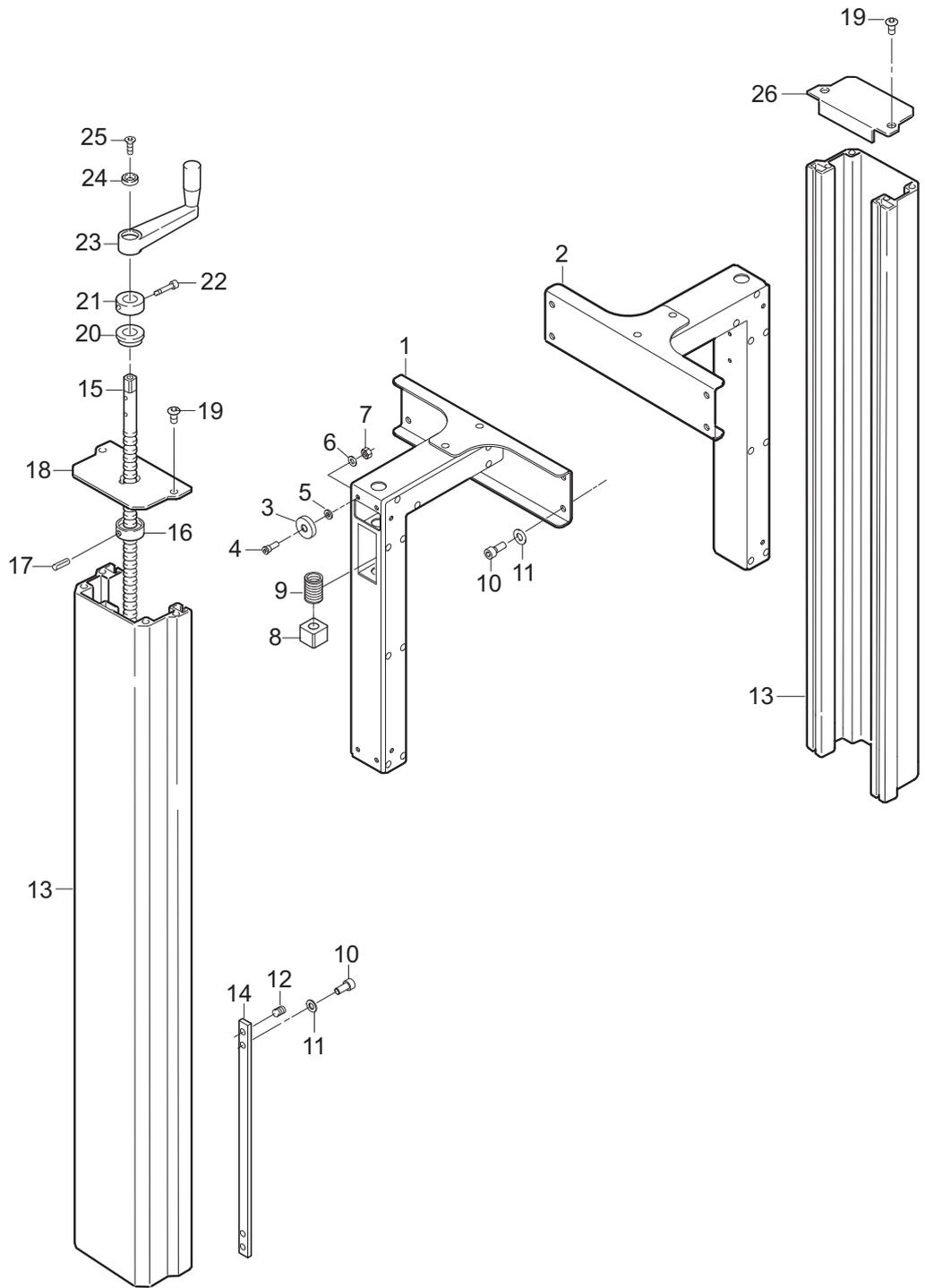
**Fig. 10315 RIDUTTORE ASSIEMATO****SEB0000536 SK1-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
51	1,0000	PZ	3.8.04849		CONDENSATORE 25MF 250V INCASS. x MH63C4 110V 60HZ
52	4,0000	PZ	3.4.00058.93		VITE TE M8X25 ZINCATA
53	4,0000	PZ	3.4.00655.93		RONDELLA TRIPLA X VITE M8 ZINC
54	4,0000	PZ	3.4.00063.92		RONDELLA ELAST.GROWER DIN 7980 X VITE M8
55	4,0000	PZ	3.4.00003.93		DADO M8 ZINCATO
56	1,0000	PZ	3.3.06902.92		PULEGGIA DENTATA PD11 L=050
57	1,0000	PZ	3.4.00388.92		GRANO EIPP PUNTA COPPA ZIGR.M5X6 BRUNITO
58	1,0000	PZ	4.7.05166		ALBERO CON FLANGE ASS. 700A/R
59	1,0000	PZ	3.5.02069.92		ALBERO X RIDUTT.A CINGHIA 3M
60	1,0000	PZ	3.4.00238		LINGUETTA 6X6X20
61	1,0000	PZ	3.3.06824.92		CORONA Z=28 P=3/8"
62	2,0000	PZ	3.4.00183		LINGUETTA 5X5X30
63	1,0000	PZ	3.3.06825.92		BUSSOLA /25/32X22,5 BRUNITA
64	2,0000	PZ	4.6.02391		FLANGIA X ALBERO
65	1,0000	PZ	3.4.01124		CATENA AN.CHIUSO P=3/8 L=57 PS. GIUN.+ FALS.1 RUL.CHIUSO
66	1,0000	PZ	3.1.01043.05		SUPPORTO CUSCINETTO DX 200A
67	1,0000	PZ	3.1.01044.05		SUPPORTO SX CUSCINETTO 200A
68	2,0000	PZ	3.4.00112.93		VITE TCEI M5X16 ZINCATA
69	1,0000	PZ		SBC0002653V	CARTER SUP. PER RIDUTTORE SPECIALE
70	1,0000	PZ	3.2.04140.40		CARTER INF.PER MOTORID.K13 22A
71	6,0000	PZ	3.4.00318.93		VITE TCEI M5X12 ZINCATA
72	1,0000	PZ	4.4.06938.47A		SQUADRETTA DX FISSAGGIO PROT. SUP.S2T/98 VERN.
73	1,0000	PZ	4.4.06939.47A		SQUADRETTA SX FISSAGGIO PROT. SUP.S2T/98 VERN.
74	1,0000	PZ		S3803440ZZZ	MOT H63 A4 B5 220/240V-380/ 415V 50HZ 3F 0.13KW
75	1,0000	PZ		S3800454ZZZ	MOT H63 A4 B5 260V-440V 50HZ 3F 0.13KW
76	1,0000	PZ		S3803442ZZZ	MOT H63 A4 B5 KW0.13 200V 50/60HZ 220V
77	1,0000	PZ		S3803449ZZZ	MOT MH63 C4 B5 220/240V MF 50HZ 0.13KW
78	1,0000	PZ		S3803278ZZZ	MOT 115V 60Hz kW0,12 MH63 C4 B5



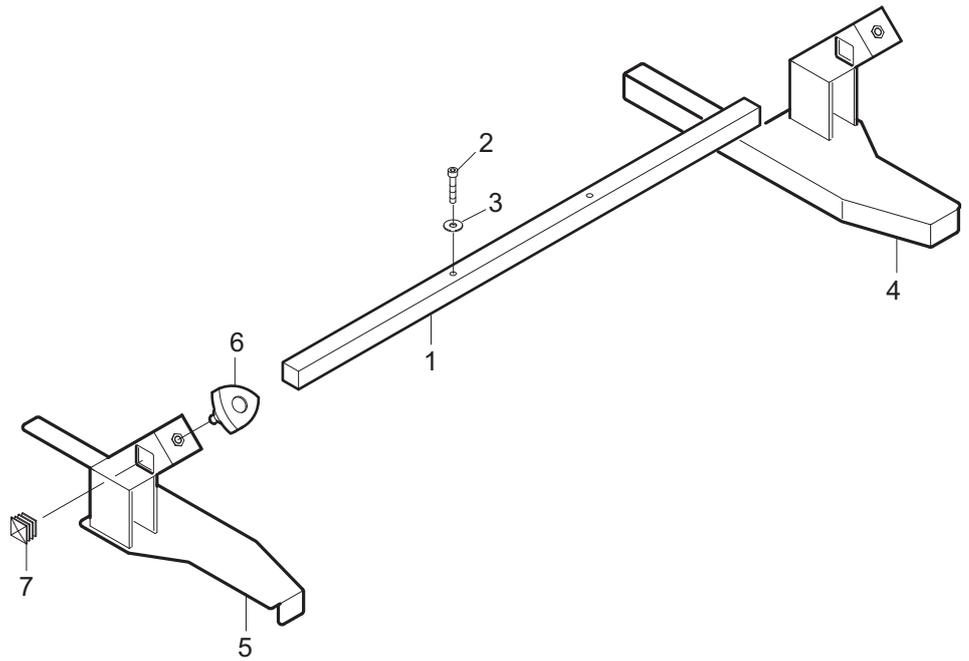
- = 31
- ▲ = 41
- = 58
- \* = non compresi nella Pos. 24  
not included in Pos. 24

Pos.	Q.tà	Codice	Descrizione
1	1	SBA0006988	CARRELLO SCORR. C/SUPP. CHIOCC.
2	1	SBA0007070	CARRELLO SCORREVOLE ASS.
3	16	S3402623ZZZ	CUSCINETTO A SFERE SIAT 2000
4	16	S330006993Z	VITE CUSCINETTO /33K SP. ZINC.
5	16	S330635893Z	DISTANZIALE D6/12X2 ZINCATO
6	16	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
7	16	S340000293Z	DADO M6 ZINCATO
8	1	S310157200A	CHIOCCIOLA PER COLONNA S2
9	1	S370014793Z	MOLLA PER COLONNE 22A ZINC.
10	16	S340028093Z	VITE TE M8X20 ZINCATA
11	16	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
12	8	S340136592Z	GRANO EIPC M8X10 BR.
13	2	SBC0011458V	COLONNA FISSA
14	4	SBC0011695T	PIASTRINA FISSAGGIO COLONNA
15	1	S331634093A	VITE SOLLEVAMENTO PER S2 CON AS82
16	1	S331579293A	BUSSOLA PER VITE SOLLEVAMENTO S2
17	1	S340102292Z	SPINA ELASTICA D4X30 BRUNITA
18	1	S321192061A	TESTATA C/FORO COLONNA FISSA S8 CE
19	4	S340344893Z	TVITE TBEI UNI 7380 M8X16
20	1	S3100583ZZZ	BUSSOLA
21	1	S331579193A	GHIERA X VITE SOLLEVAMENTO S2
22	1	S340014293Z	VITE TCEI M4X25 ZINCATA
23	1	S3402700ZZZ	MANOV. 'ELESA' MT. 80 AS 10X10 SIAT 2000
24	1	S350050693Z	RONDELLA FISSAGGIO MOTORI
25	1	S340051693Z	VITE TSVEI M5X12 ZINCATA
26	1	S321191847A	TESTATA COLONNA FISSA 52A 3M



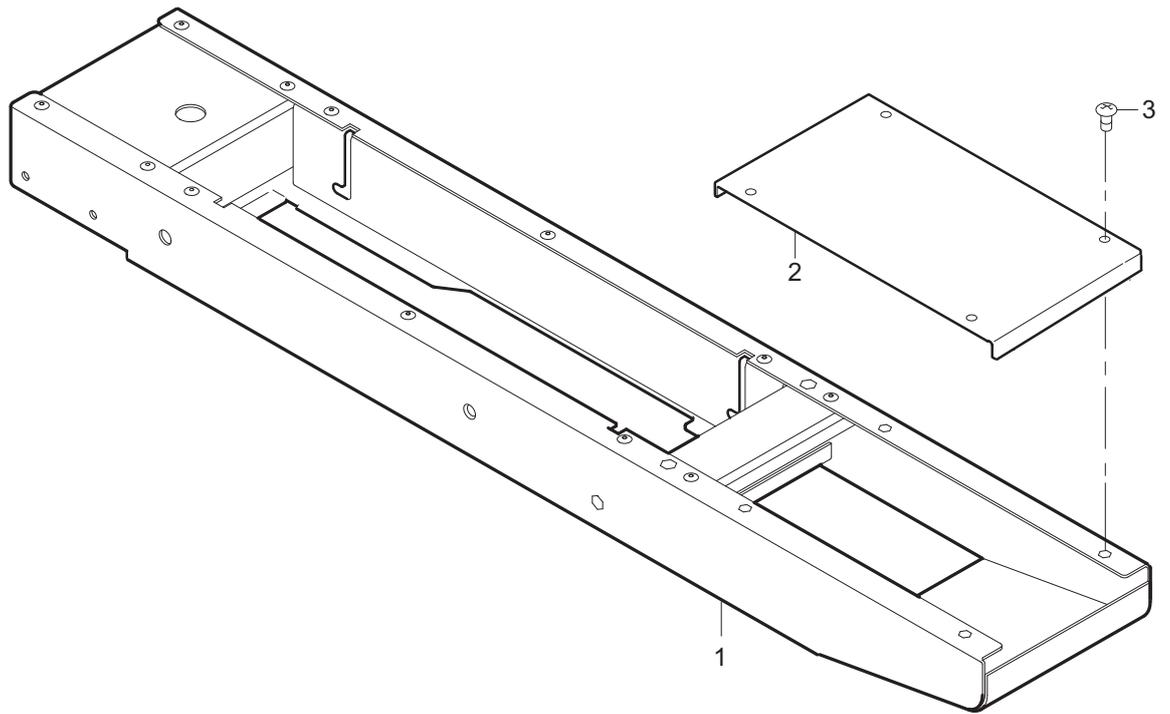
**Fig. 15130 PRESSATORI SEB0000536 SK1-S NASTRATRICE**

1	1	SBC0011111T	TUBO PRESSATORI LATERALI
2	2	S340036793Z	VITE TCEI M6X35 ZINCATA
3	2	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINCATA
4	1	SBA0007063	GUIDA LATERALE DX C/INS.
5	1	SBA0007064	GUIDA LATERALE SX C/INS.
6	2	S3410000400A	MANOPOLA VTR. 50 P-M10X30 (ELESA)
7	2	S340084705Z	TAPPO /25X25



**Fig. 15302 TESTATA SUPERIORE SEB0000536 SK1-S NASTRATRICE**

<b>Pos.</b>	<b>Q.tà</b>	<b>Codice</b>	<b>Descrizione</b>
1	1	SBA0007097	TESTATA SUPERIORE C./INS.
2	1	SBC0013488V	CARTER TESTATA SUPERIORE SK1 VERN.
3	4	S340170893Z	VITE TESTA MEZZA TONDA M5X16

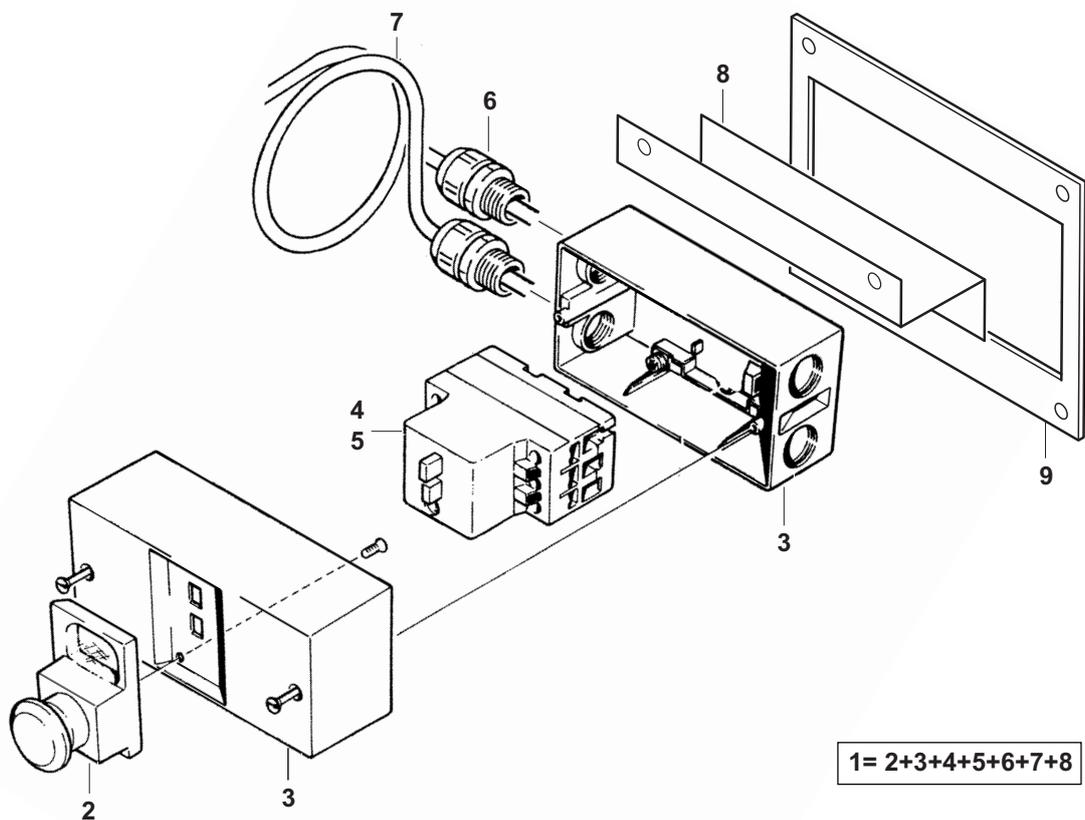


**Fig. 15303    INTERRUTTORE    SEB0000536    SK1-S NASTRATRICE**

## INTERRUTTORE 'AEG'

<b>Pos.</b>	<b>Q.tà</b>	<b>Codice</b>	<b>Descrizione</b>
1	1	SBB0002038	INTERRUTTORE ASS.SK1 380/440V-50HZ/3F
1	1	SBB0002042	INTERRUTTORE ASS.SK1 220V/50/60HZ/3F
1	1	SBB0002043	INTERRUTTORE ASS.SK1 220/240V-50/60HZ-1
1	1	SBB0002227	INTERRUTTORE ASS.SK1 110V 60HZ MF UL
1	1	SBB0002240	INTERRUTTORE ASS.SK1 110V-60HZ-MF
2	1	S3802200ZZZ	PULSANTE A FUNGO X MS25
3	1	S3802199ZZZ	CASSETTA IP55
4	1	S3802193ZZZ	INTERRUTT.MAGNETOTERMICO MS25 0,63-1
4	1	S3802194ZZZ	INTERRUTT.MAGNETOTERMICO MS25 1-1,6
4	1	S3802196ZZZ	INTERRUTT.MAGNETOTERMICO MBS25 2,5-4
5	1	S3802203ZZZ	RELE'DI SGANCIO A MINIMA TENS. 380/415V
5	1	S3802202ZZZ	RELE'DI SGANCIO A MINIMA TENS. 200/240V
5	1	S3802201ZZZ	RELE'DI SGANCIO A MINIMA TENS. 100/125V
6	2	S3800854ZZZ	BOCCHETTONE SKINTOP ST 16
7	6 m	SCC0000396	CAVO FROR 07 4X1,5 GREY CON- DUTT.BROWN
7	6 m	S3801222ZZZ	CAVO FROR 07 3X1,5 MM, GRIGIO
7	6 m	S3802225ZZZ	CAVO USA TRIPOLARE
7	1	S3800733ZZZ	CAVO ALIMENTAZ.USA TIPO SJT
8	2	SBA0008190	STAFFA FISSAGGIO INTERR. SK1 C/ INSERTO
9	1	SBC0013536V	Cornice per interruttore SK1

## INTERRUTTORE 'LOVATO'





**Declaration of Conformity**

Déclaration de conformité  
Declaración de conformidad  
Konformitätserklärung  
Dichiarazione di conformità  
Conformiteitsverklaring  
Försäkran om överensstämmelse  
Declaração de conformidade



**The undersigned** / le fabricant / el que subscribe / der Unterzeichnete / la sottoscritta / Ondergetekende / Untertecknad / os que se subscrivem:

**SIAT SpA – Società Internazionale Applicazioni Tecniche**  
Via Giancarlo Puecher, 22 - 22078 Turate (CO) – ITALY

**hereby certifies that, when leaving our factory, the product indicated below is in accordance with the EEC guidelines, EEC standards of safety and product-specific EEC standards.**

declare que la machine désignée ci-dessous est conforme aux dispositions de la directive "machines modifiées et aux législations nationales la transposant.

declara bajo su propia responsabilidad que la presente mercancía, objeto de la presente declaración, cumple con todas las exigencias de las normas de la Comunidad Europea, en lo que a normas técnicas, de homologación y de seguridad se refiere.

bestätigt, daß das nachfolgend bezeichnete Gerät in der von uns in Verkehr gebrachten Ausführung die Anforderungen EG-Richtlinien, EGSicherheitsstandards und produktspezifischen EG-Standards erfüllt.

certifica che il prodotto qui sotto indicato, nel modello da noi commercializzato, è conforme alle direttive CE nonché agli standard di sicurezza e agli standard relativi ai singoli prodotti.

bevestigt, dat het volgende genoemde apparaat in de door ons in de handel gebrachte uitvoering voldoet aan de eis van, en in overeenstemming zijn met de EG-richtlijnen, de EG-veiligheids-standaard en de voor het produkt specifieke EG-standaard.

försäkrar härmed att nedan nämnda produkter överensstämmer med EEC:s riktlinjer, EEC:s säkerhetsstandard och EEC:s produktspecifikation.

por este meio certificamos que ao sairem da fábrica, o aparelho abaixo mencionado cumprem tanto na execução com as exigências das directrizes harmonizadas da CEE, com os parâmetros de segurança standard da CEE e, com os parâmetros específicos de produção por nós.

**Description of the product**

Description du produit  
Descripción de la mercancía  
Bezeichnung der Gerät  
Descrizione del prodotto  
Omschrijving van het apparaat/de apparaten  
Produkt  
Descrição do aparelho

**Semiautomatic Case Sealer – Box Size Manual Adjust**

**Nastratrice semiautomatica - regolazione manuale formato scatola**

**Model:**

Modèle:  
Modelo:  
Modell:  
Modello:  
Model:  
Modell:  
Modelo:

**SK1**

**Serial Number:**

Numéro de matricule:  
Número de matrícula:  
Matrikel Nummer:  
Numero di matricola:  
Serie nummer:  
Serie nummer:  
Numero de matrícula:

**SEB.....**

**EEC guidelines:**

directives européennes:  
normas CE:  
EG-Richtlinien:  
direttive CE:  
EG-richtlijnen:  
directrizes da CEE:

**2006/42/CE**  
**2004/108/CE**

**Name and address of the person authorized to compile the technical file referred to in Annex VII A of Directive 2006/42/EC**

Nom et adresse de la personne autorisée à constituer le dossier technique visé à l'annexe VII A de la directive 2006/42/CE  
Nombre y dirección de la persona facultada para elaborar el expediente técnico contemplado en el anexo VII A de la Directiva 2006/42/CE  
Name und Anschrift der Person, die bevollmächtigt, die technischen Unterlagen gemäß Anhang VII A der Richtlinie 2006/42/EG zu kompilieren  
Nome e indirizzo della persona autorizzata a costituire il Fascicolo Tecnico di cui all'allegato VII A della Direttiva 2006/42/CE  
Naam en adres van de persoon die gemachtigd is het technisch dossier als bedoeld in bijlage VII A van Richtlijn 2006/42/EG samen te stellen  
Nome e endereço da pessoa autorizada a compilar o processo técnico referido no anexo VII A da Directiva 2006/42/CE

**SIAT SpA – Società Internazionale Applicazioni Tecniche Via Giancarlo Puecher, 22 - 22078 Turate (CO) – ITALY**

**Turate, 26/10/2012**

Stefano Mele  
  
Managing Director