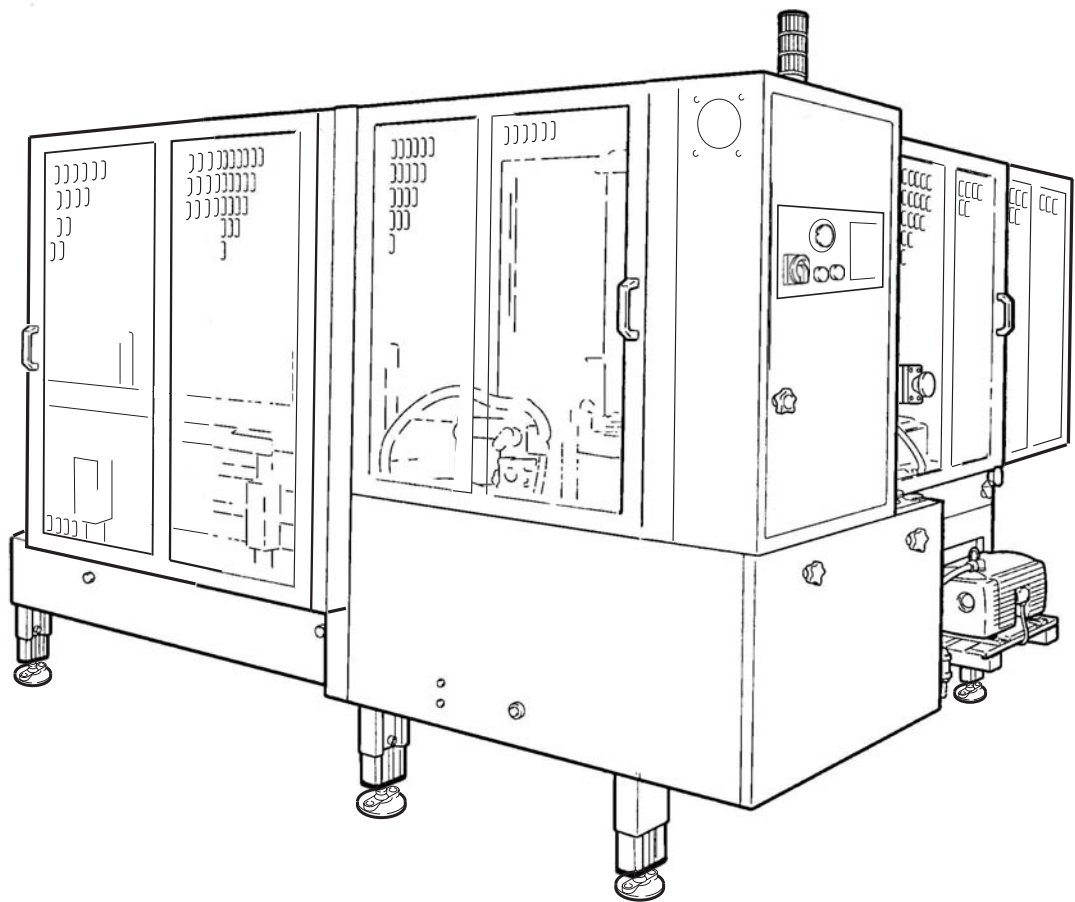


SIAT

■ M. J. MAILLIS GROUP



F344-SX

FORMATORE AUTOMATICO PER CASSE IN CARTONE
AUTOMATIC CASE FORMER

MACHINE AUTOMATIQUE A FORMER DES BOITES EN CARTON
AUTOMATISCHER KARTONFORMER

MOLDEADORA AUTOMATICA PARA CAJAS DE CARTON

MANUALE DI ISTRUZIONI E PARTI DI RICAMBIO

INSTRUCTIONS MANUAL AND SPARE PARTS LIST

MANUAL D'INSTRUCTIONS ET PIECES DETACHEES

BEDIENUNGSANLEITUNG UND ERSTAZTEILLISTE

MANUAL DE INSTRUCCIONES Y RECAMBIOS



Instruction manual for the use, safety, maintenance and spare parts concerning the automatic case former machine Model F344 -SX

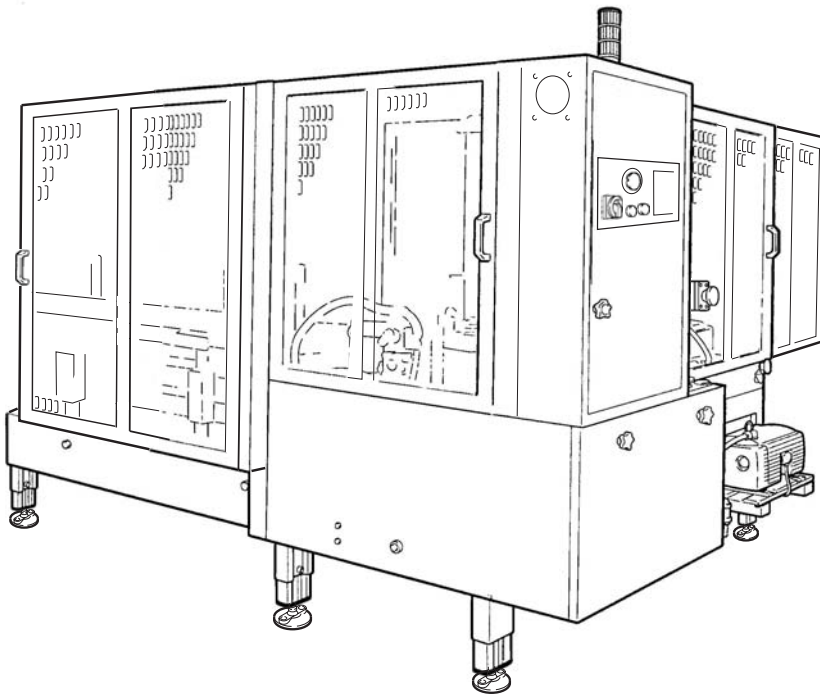
This publication is property of SIAT S.P.A.
Via Puecher, 22 - 22078 TURATE (CO) - ITALY
Tel. 02-964951 - Fax. 02-9689727

Edition April 2007

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

Publication n. SMC00007K
Release I



F344-SX

AUTOMATC CASE FORMER

- Maximum box size: **h.** 500 mm x **w.** 340 mm x **l** 450 mm
- Minimum box size: **h.** 120 mm x **w.** 150 mm x **l** 200 mm
- Adhesive tape 50 mm
- Belt speed: 21 m per minute
- Production: 18 boxes per minute

	Section	LIST OF ABBREVIATIONS, ACRONYMS AND UNSUAL TERMS TO BE FOUND IN THIS MANUAL	
Manufacturing specifications	1.1		
Manual, how to use the	1.2		
Serial Number	2.1	Dwg.	= drawing
After-sale service	2.2	Encl.	= enclosure
Warranty	2.3	Ex.	= example
Safety	3	Fig.	= figure showing spare parts
Operators' skill levels	3.6	Max.	= maximum
Technical specifications	4	Min.	= minimum
Dimensions and weight	4.2.-4.6	Mod.	= machine model
Noise measurement	4.10	N.	= number
Transportation	5	N/A	= not applicable
Unpacking	6	OFF	= machine stopped
Installation	7	ON	= machine running
Theory of operation	8	OPP	= oriented polypropylene adhesive tape
Controls	9	Pict.	= picture
Safety devices	10	PLC	= Programmable Logic Control
Set-up and adjustments	11	PP	= polypropylene
Operation	12	PTFE	= Polytetrafluorethylene
Cleaning	12.5	PVC	= Polyvinylchloride
Trouble shooting	12.8	Ref.	= reference mark
Maintenance	13	SIAT SPA	= Società Internazionale Applicazioni Tecniche (Società per Azioni)
Lubrication	13.4-13.5		
Blade replacement	13.7	Tav.	= Illustration
Belt replacement	13.8		
Adjustment of belt tension	13.9		
Fire emergency	14.2	w	= width
Enclosures	15	h	= height
Pneumatic Schematic	16	l	= length
Spare parts	last section	ol	= overall length
		cbh	= conveyor bed height

1-INTRODUCTION

1.1 MANUFACTURING SPECIFICATIONS

The automatic case FORMER machine Mod. F344-SX 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

2.1 SERIAL NUMBER OF THE MACHINE AND NAME OF THE MANUFACTURER

SIAT ■ 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:

SIAT ■ M. J. MAILLIS GROUP
Via Puecher, 22 22078 TURATE (CO) - ITALY
Tel. 02-964951 Fax. 02-9682239 E-mail siat@siat.com

AGENT/DISTRIBUTOR OR LOCAL AFTER SALE SERVICE:

2-GENERAL INFORMATION

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 six (6) months from the date in which Seller's goods have been put into use, but in no event beyond eight (8) months from the date of shipment.

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

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

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

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

Seller is not responsible for defects resulting from:

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

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

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

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

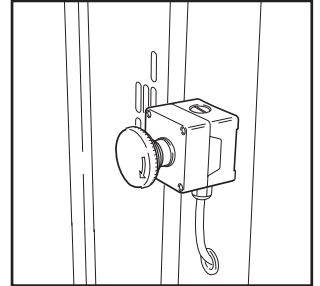
3-SAFETY

3.1 GENERAL SAFETY INFORMATION

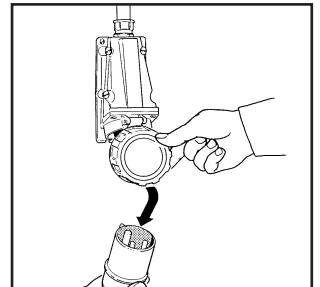
Read all the instructions carefully before starting the work with the machine; please pay particular attention to sections marked by the symbol



The machine is provided with a LOCKABLE EMERGENCY STOP BUTTON placed in the central part of the protection on control side; when this button is pressed, it stops the machine at any point in the working cycle without cutting the pneumatic circuit.



Disconnect the machine from the mains before any maintenance operation.



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

3.2 DEFINITION OF THE OPERATORS' QUALIFICATIONS

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

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

SKILL 1

MACHINE OPERATOR

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

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

3-SAFETY

SKILL 2

MECHANICAL MAINTENANCE TECHNICIAN

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

He is not allowed to work on live electrical components.

SKILL 2a

ELECTRICAL MAINTENANCE TECHNICIAN

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

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

SKILL 3

SPECIALIST FROM THE MANUFACTURER

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

3.3 INSTRUCTIONS FOR A SAFE USE OF THE MACHINE

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

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

3.4 STATE OF THE MACHINE

List of the modes which are possible with this machine:

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

3-SAFETY

3.5 NUMBER OF THE OPERATORS

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

3.6 OPERATORS' SKILL LEVELS

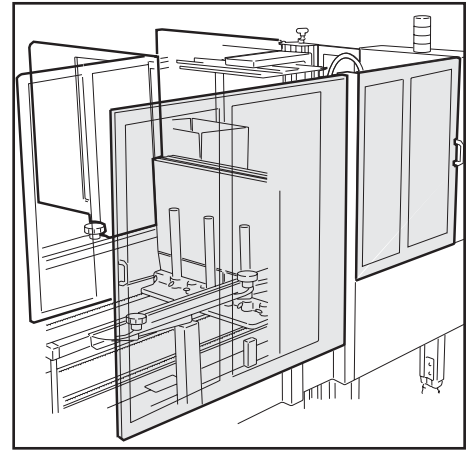
The table below shows the minimum operator's skill for each operation with the machine.

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

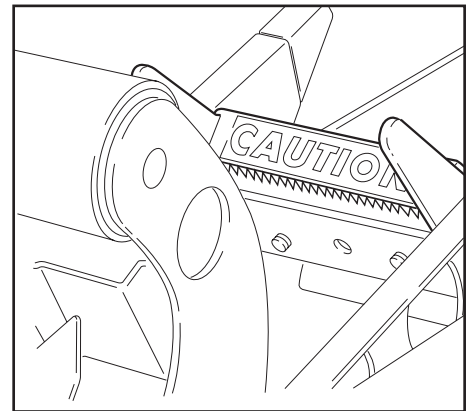
3-SAFETY

3.7 RESIDUAL HAZARDS

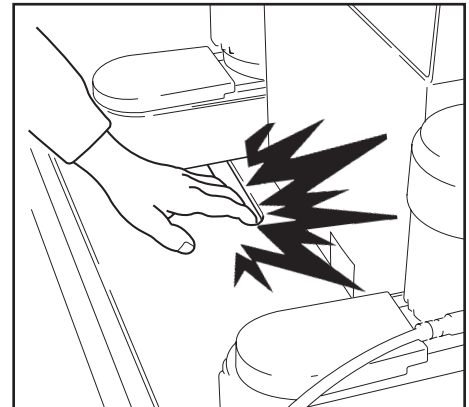
The case former F344-SX has been designed with a safety protection which stops the machine when the operator opens it to access the moving parts. The safety protection should never be removed or disabled. Notwithstanding the safety precautions conceived by the designers of the machine, it is essential that the operator and service personnel be warned that the following uneliminable residual hazards exists.



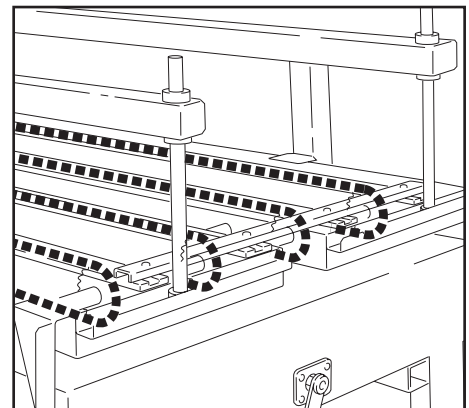
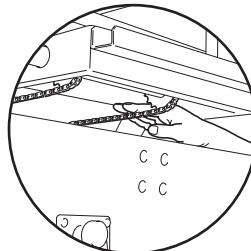
WARNING! Tape cutting blades.
Never remove the safety device which covers the blade on the top and bottom taping units.
Blades are extremely sharp. Any error may cause serious injuries..



WARNING! Cavity in the conveyor bed.
Never put your hands inside any part of the machine while it is working.
Serious injury may occur.

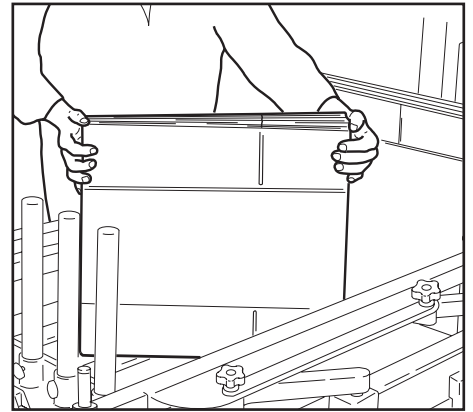


WARNING! Chains and pinions driving the case feeder.
Keep hands away from the lower side of the adjustable feeder bed as they may be trapped between whain and pinion.



3-SAFETY

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



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

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

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

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

3.9 PERSONAL SAFETY MEASURES

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

None is required, except when recommended by the user.

3.10 PREDICTABLE ACTIONS WHICH ARE INCORRECT AND NOT ALLOWED

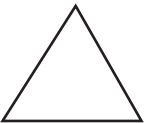
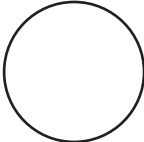
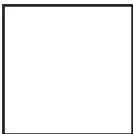
- Never try to stop or hold the box while it is being driven by the belts. Use only the EMERGENCY STOP BUTTON.
- Never work without the safety protections.
- Never remove or disable the safety devices.
- Only authorised personnel should be allowed to carry out the adjustments, repairs or maintenance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

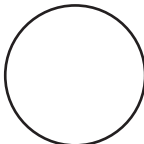


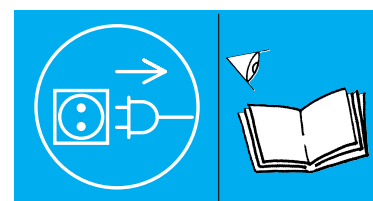
- The cleaning and maintenance operations must be performed after disconnecting the electric power.
- Clean the machine using only dry clothes or light detergents. Do not use solvents, petrols etc.
- Do not modify the machine or any part of it. The manufacturer will not be responsible for any modifications.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

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




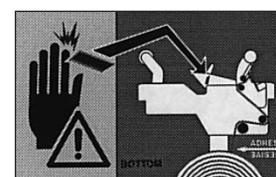
Label code: 3.0.01097.96A

b  Shows the sharp knife on the taping head.



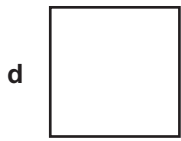
Label code: 3.0.01028.96A

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



Label code: 3.0.01024.96A

3-SAFETY



Shows the running direction of the belts.



Label code:: 3.0.01040.96A



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



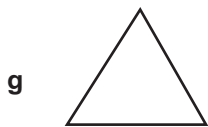
Label code: 3.0.01039.96A



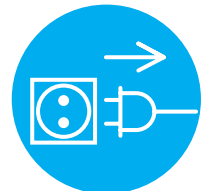
Caution!: High voltage



Label code: 3.0.01100.96A



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



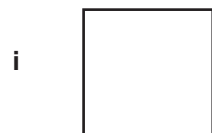
Label code: 3.0.01099.96A



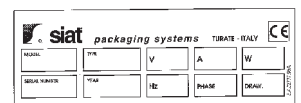
Caution! Turn off the compressed air before each maintenance operation.



Label code: 3.0.01166.97A



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



Label code:S340277700A

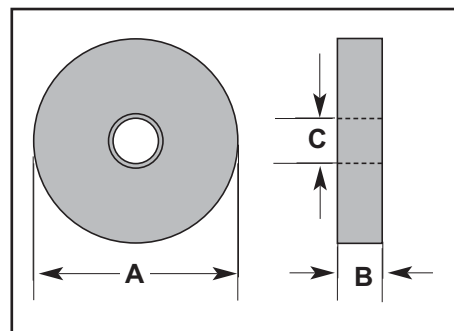
4-PRELIMINARY INFORMATION ON THE MACHINE

4.1 GENERAL DESCRIPTION OF THE MACHINE

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

4.2 TECHNICAL SPECIFICATIONS

- Production = 1000 boxes/hour
- Standard power supply = 230/400 V 50Hz 3Ph
- Power supply: 1, 400 kW
- Taping units K11, tape width 50 mm.
- Weight = 600 kg1
- Belts speed = 22 m per minute
- Compressed air = 6 Bar max.



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

4.3 TAPE DIMENSIONS

Suitable adhesive tapes:

PVC

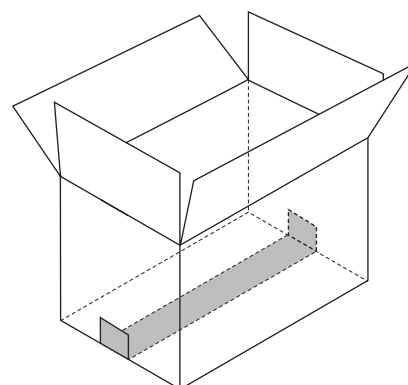
OPP

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.

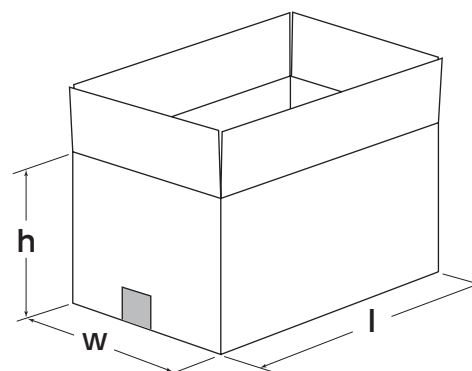
The machine supplied with the standard electric system is not designed for use in atmosphere with risk of deflagration. In such conditions the machine must be equipped with anti-deflagration components and/or air motors.



4.5 BOX-SIZE RANGE

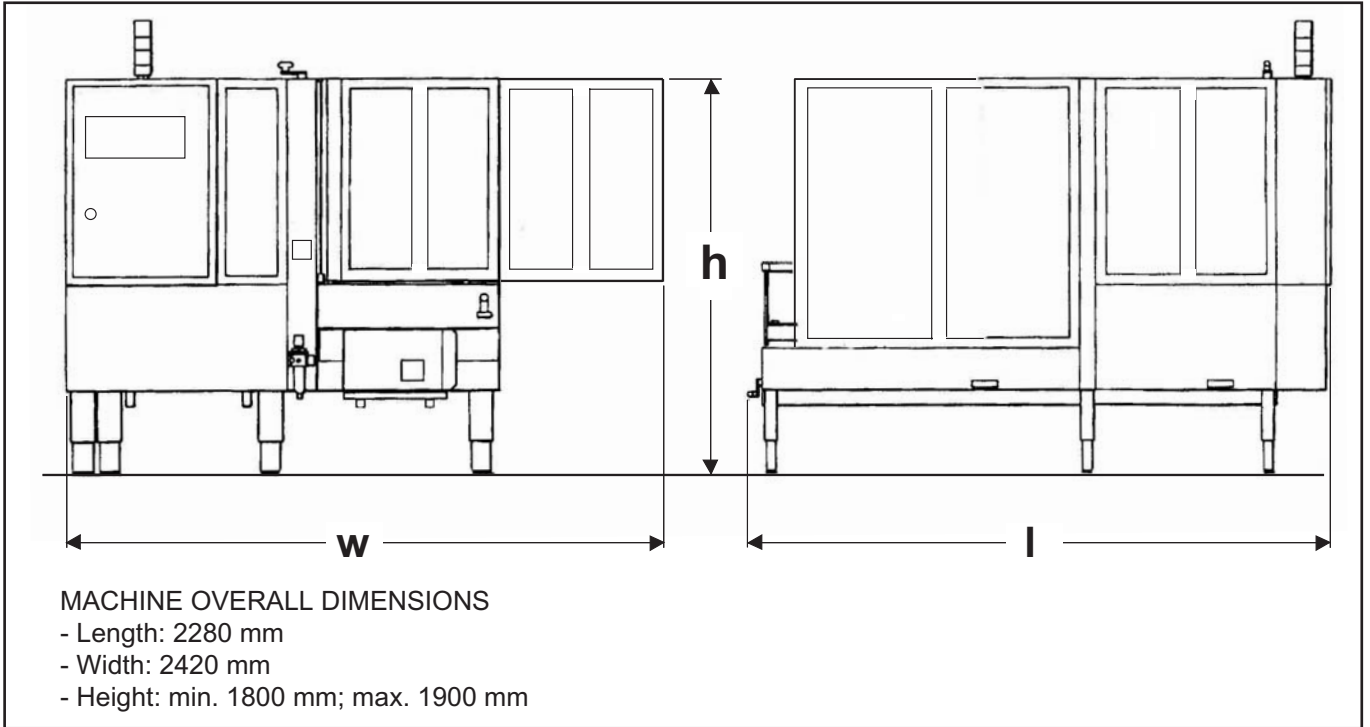
The F344-DX Former is manually adjustable for the forming and sealing of the lower part of the boxes whose dimension are included in the following range.

F344	W	H	L
Min.	150	120	200
Max.	340	500	450



4-PRELIMINARY INFORMATION ON THE MACHINE

4.6 DIMENSIONS



4.7 COVEYOR BED HEIGHT

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

CONVEYOR BED HEIGHT		OVERALL DIMENSIONS		
		MIN	MAX	
MIN	MAX	H	1800	1900
		L	2280	2280
CBH		W	2420	2420

CONVEYOR BED HEIGHT		OVERALL DIMENSIONS		
		MIN	MAX	
MIN	MAX	H	1870	1970
		L	2280	2280
CBH		W	2420	2420

4-PRELIMINARY OPERATION ON THE MACHINE

4.8 MAIN COMPONENTS

The machine is composed of:

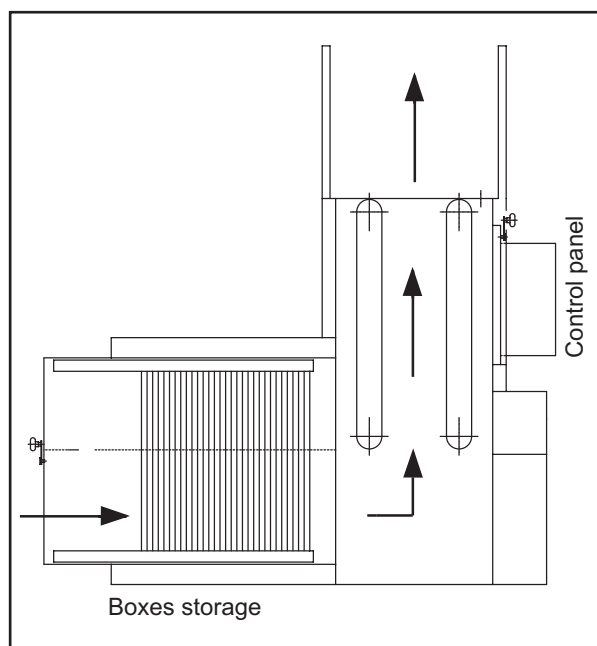
- N. 2 frames
- N. 8 adjustable legs
- N. 1 taping unit
- N. 2 side drive belts assembly
- N. 3 electric motors
- N. 1 emergency stop button
- N. 1 anti-accident protection
- N. 1 control panel
- N. 11 pneumatic cylinders

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

4.9 OPERATIVE FLOW

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

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



4.10 MACHINE NOISE MEASUREMENT

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

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

5-SHIPMENT-HANDLING-STORAGE

5.1 SHIPMENT AND HANDLING OF THE PACKED MACHINE

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

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

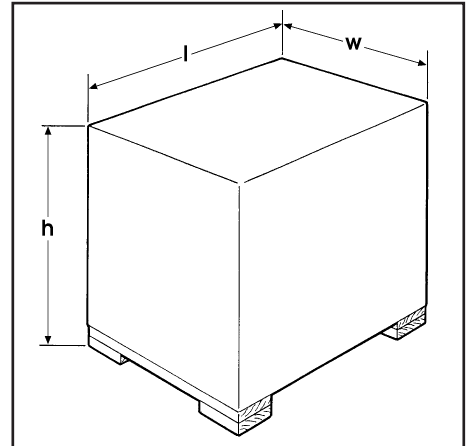
PACKAGING OVERALL DIMENSIONS

l = length 2550 mm

w = width 2250 mm

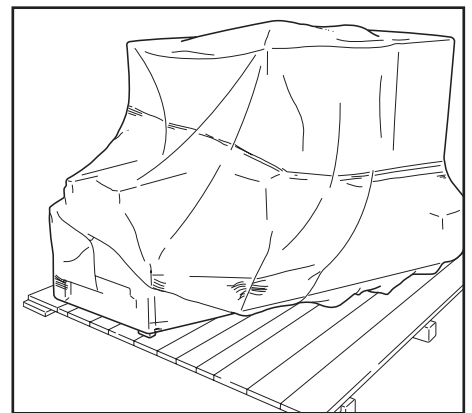
h = height 1950 mm

Weight kg. 750



5.2 PACKAGING FOR OVERSEAS SHIPMENT (OPTIONAL)

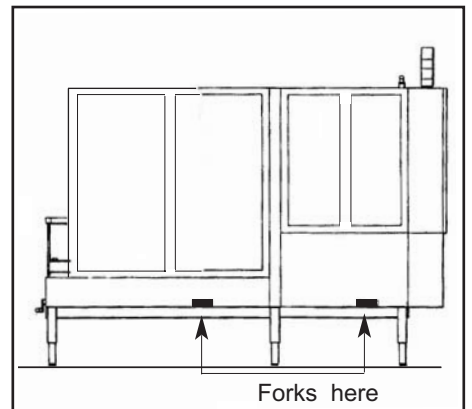
The machines shipped by sea freight are covered by an aluminum/polyester/ polythene bag which contains dehydrating salts.



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 Figure.



MACHINE DIMENSIONS

length: 2280 mm.

width: 1720 mm

height: min. 1800 max. 1900 mm.

weight: kg 600

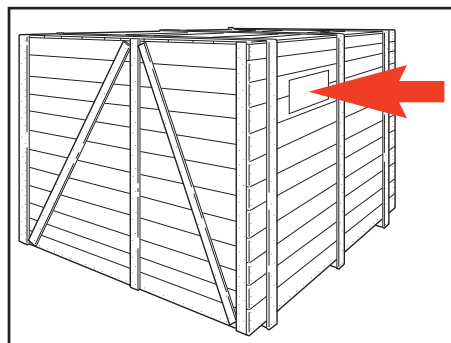
5.4 STORAGE OF THE PACKED OR UNPACKED MACHINE

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

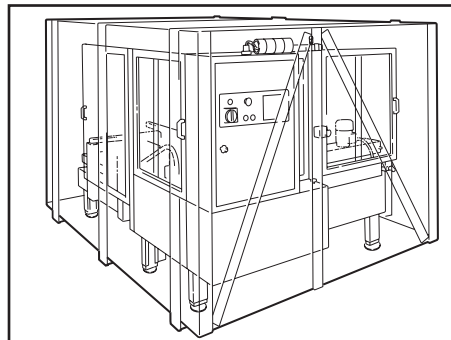
- store the machine in a dry and clean place;
- if the machine is unpacked it is necessary to protect it from the dust and do not stack anything over the machine.

6-UNPACKING

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

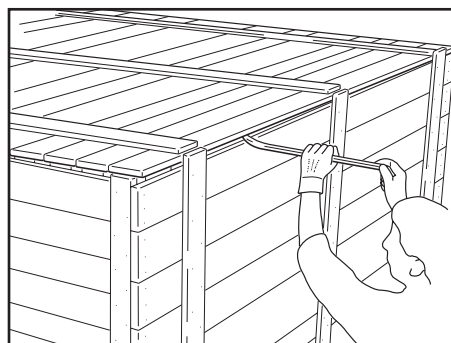


Machine layout inside the packing.

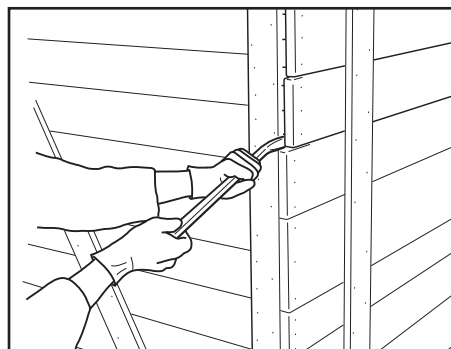


Unnail the top cover and using the proper tools and gloves, take the studs away.

Pay attention to the studs and the wood splinters.

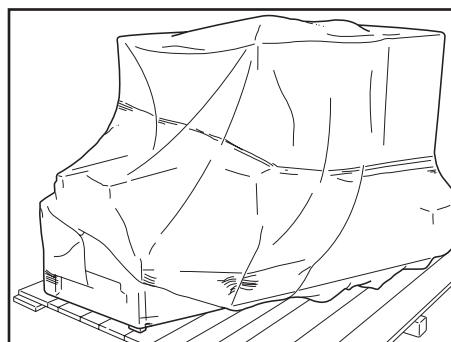


Unnail and remove the four side walls of the case. Take care to hold each wall to avoid that it may fall to the floor causing damages or injuries (minimum 2 persons).



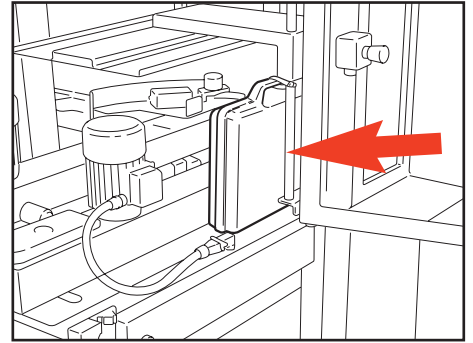
MACHINE PROTECTION

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

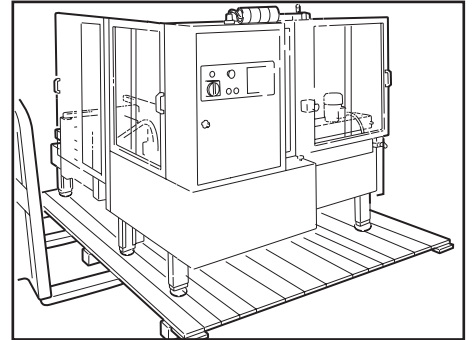


6-UNPACKING

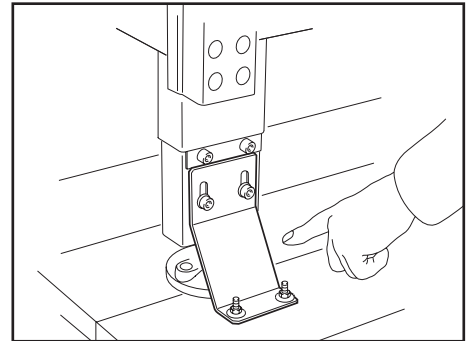
For all the other operations, please follow the instructions contained in the manual.



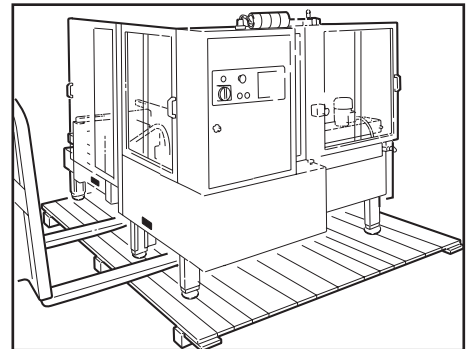
Use a forklift to carry the machine to its working location. (Weight kg **670**)



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



Uplift the machine by using a forklift. Pay attention to place the forks in the points shown in the Picture and remove the wooden pallet (Machine weight Kg. **600**).



6.2 PACKAGING DISPOSAL

The packaging of the machine Mod. F344-DX is composed of:

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

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

7-INSTALLATION

7.0. SAFETY

(Read Section 3 carefully).

7.1. ENVIRONMENTAL CONDITIONS REQUIRED

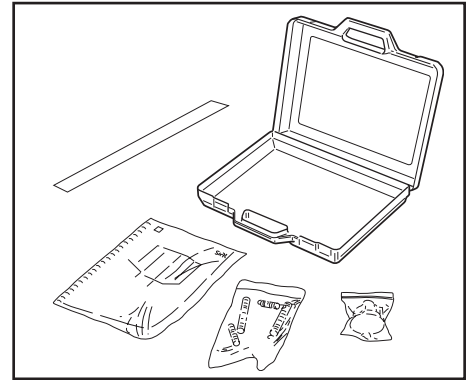
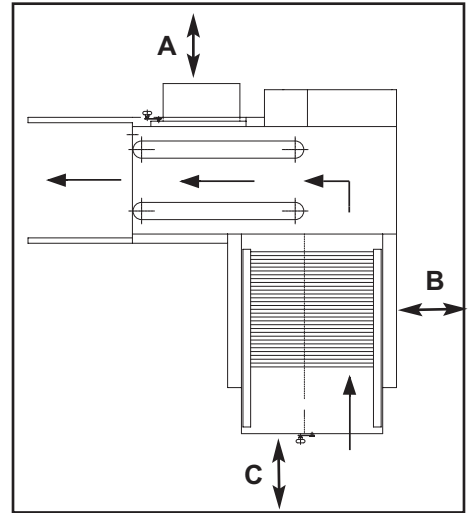
- Min. temperature. = 5 °C; max. 40 °C
- Min. humidity 30%; max. 80%
- Dust free environment.

7.2. SPACE REQUIRED FOR OPERATION AND MAINTENANCE

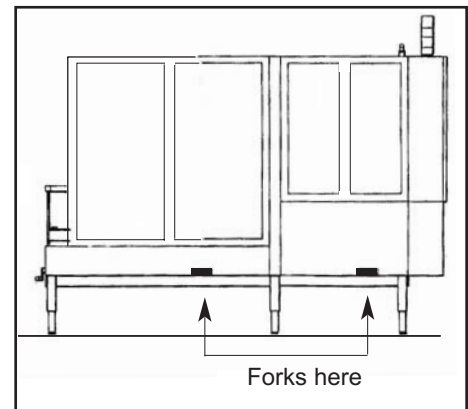
Min. distance from the wall: **A = 1000 mm**; **B = 1000 mm**; **C = 1000 mm**
mm
Min. height= **2500 mm**

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

For a detailed description see section 13.1.

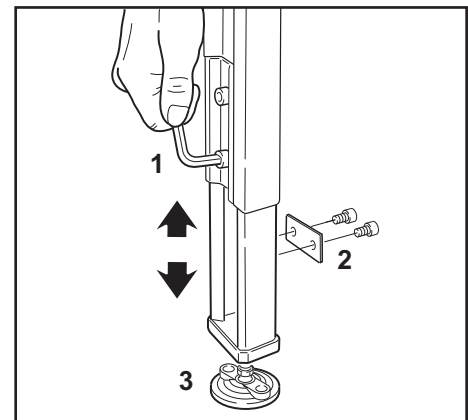


Lift the machine with a fork truck, placing the forks in the indicated points.



Unlock the screws of the clamps **1**, remove the legs according to the graduated rules and then place in position the supporting plates **2** at the desired height as required.

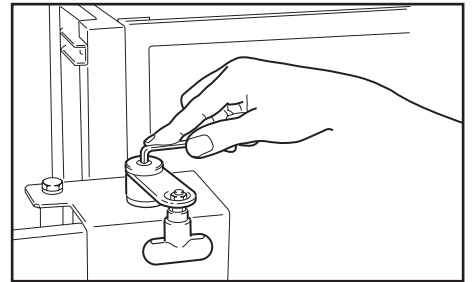
Lock the screws **1** and act on the adjustment feet **3**, as necessary, for correct former weight distribution on the floor.



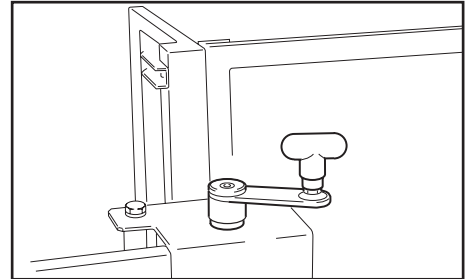
7-INSTALLATION

7.5 CRANKS POSITIONING

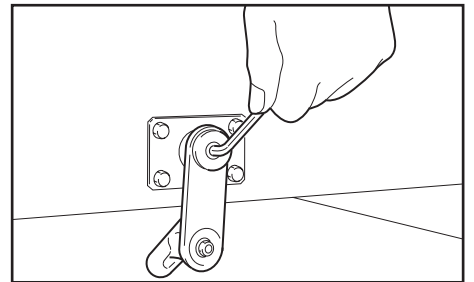
Completely unloose the screw.



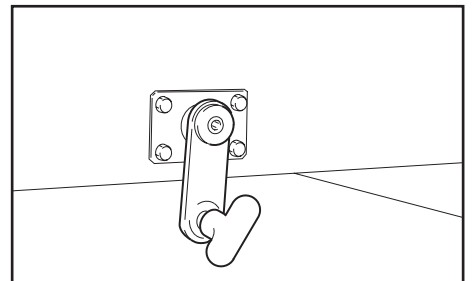
Place the crank for the adjustment of the contrast slide for outcoming boxes.



Completely unloose the screw.

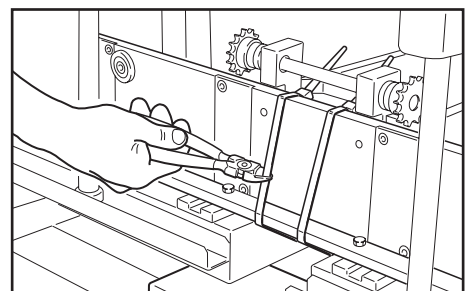


Place the crank for the adjustment of the box-holder carriage. Lift the storage and remove the two polystyrene blocks.

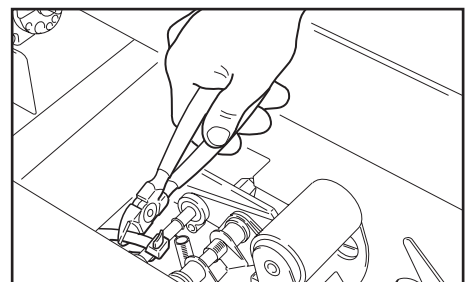


7.6 STRAPS REMOVAL

Remove the plastic straps which lock the pushing carriage and remove the polystyrene blocks.



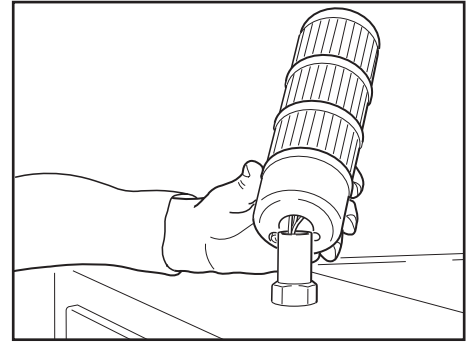
Cut the wrap which blocks the taping unit.



7-INSTALLATION

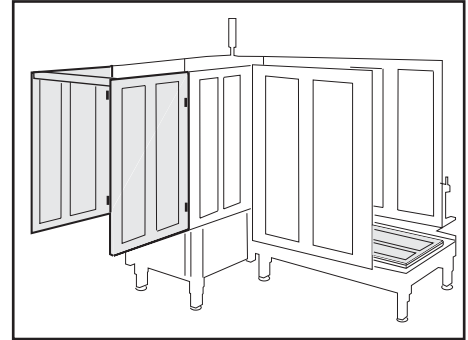
7.7 INSTALLATION OF THE LIGHT

Insert the light into its housing.



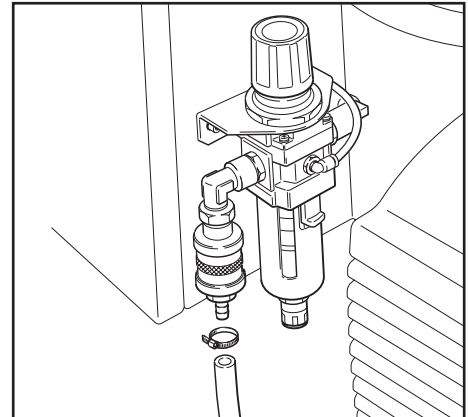
7.8 SAFETY PROTECTIONS ASSEMBLY

Assemble the safety protections (fixed panels) on tapping unit side as in figure, with angle plates and upper rigid profile supplied with the former.



7.9 PNEUMATIC CONNECTION

Connect a 8 mm diameter hose to the plug and fix it by the supplied clamp.



7.10 PRELIMINARY ELECTRIC CHECK-OUT

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

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

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

7.10.3 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.

7.11 MACHINE CONNECTION TO THE MAINS AND CHECK-OUT

Power supply = kW 1.400

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

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

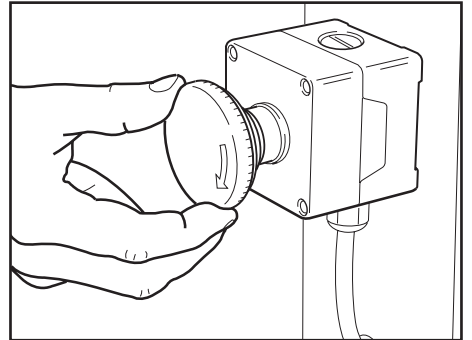
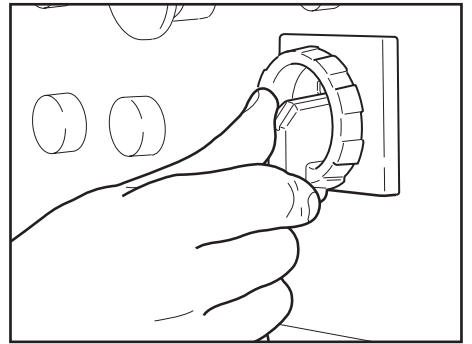
- Push the LOCKABLE EMERGENCY STOP BUTTON
- The magnetothermic main switch is normally turned OFF.
- Connect the cable supplied with the machine to a plug which complies with the safety regulations of your country.

7-INSTALLATION

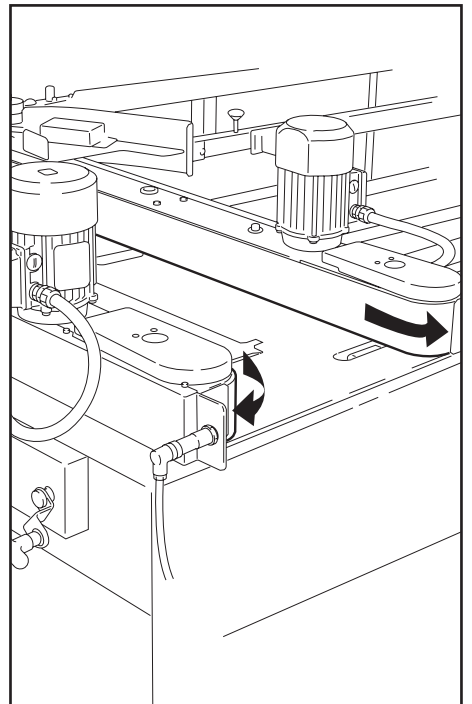
7.12 CHECK-OUT OF PHASES (FOR THREE-PHASE MAINS ONLY)

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.
- Move the main switch on the ON position.
- Check the rotation direction of the side drive belts; to start the motor units see paragraph 11.10 '**Note: Check-out of phases at first starting**'
- In case they rotate in the wrong way, please reverse 2 phases on the plug.



Correct rotation direction of the side drive belts..

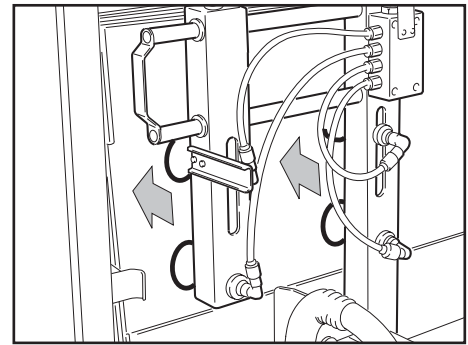


8-OPERATION

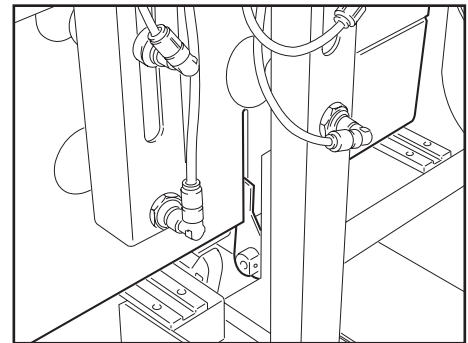
8.1 DESCRIPTION OF THE WORKING CYCLE

The operator, after filling the box storage with boxes and having adjusted the machine, presses the start button.

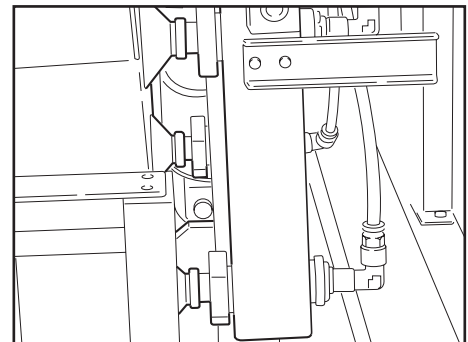
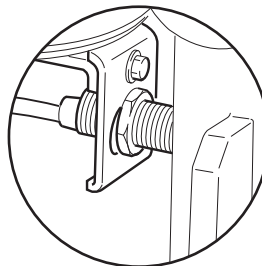
After pressing the START button, the suckers-holder carriage approaches the box holder storage.



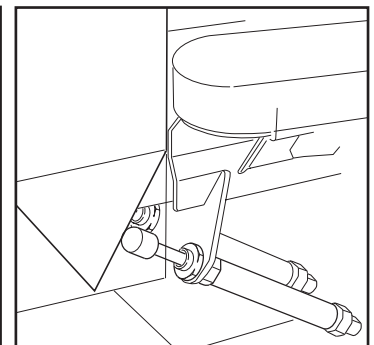
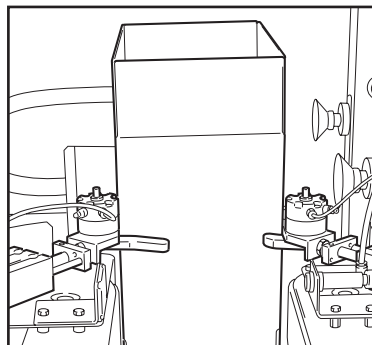
The suckers suck the first box. The carriage goes back dragging the box which is automatically opened by the box-opener levers.



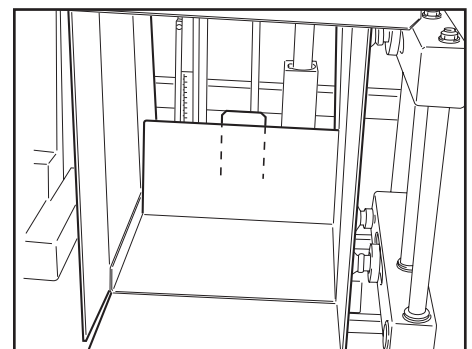
The suckers-holder carriage with the open box stops at the sensor..



The two pneumatic cylinders mounted on the side motor devices position correctly the box. The two lower pneumatic cylinders mounted on the contrast lever close partially the box front lap.

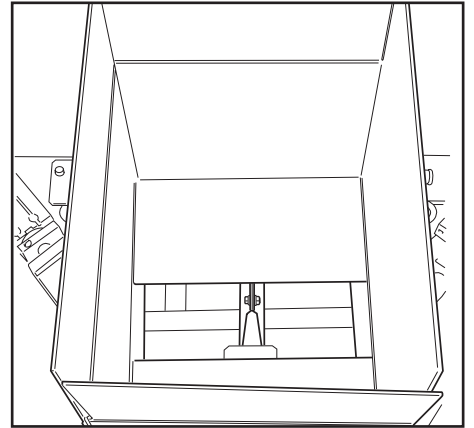


At the same time the lower paddle on the pushing carriage close the back lap of the box.

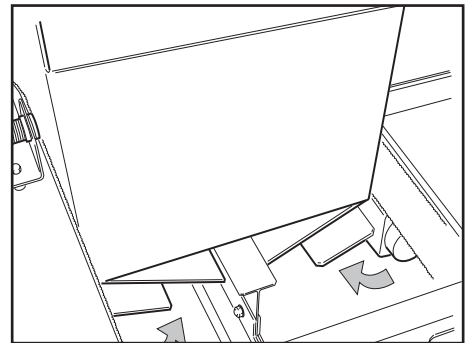


8-OPERATION

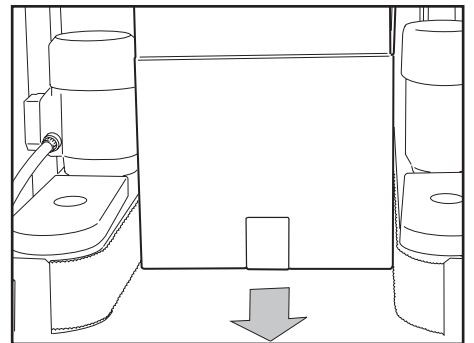
The carriage pushes the box among the driving belts while the contrast lever closes the front lap of the box.



The box, by shading the photocell located above the driving belts, starts the side lap-closing devices which fold the laps.



The formed box goes through the taping group which seals the lower part with adhesive tape.



8.2 OPERATING MODES

The case sealer Mod. F344-DX has only one automatic working mode, with:

- The EMERGENCY STOP BUTTON unlocked
- The start button pushed ON
- Pneumatic circuit activated.

8.3 HOW TO STOP THE MACHINE

8.3.1 NORMAL STOP PROCEDURE

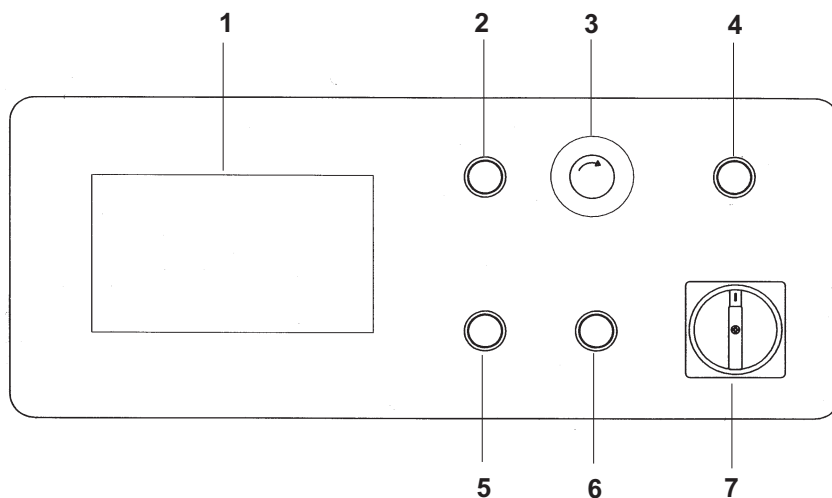
When the main switch is turned OFF, the machine stops immediately at any point of the working cycle. The same thing happens in case of electric black-out or when the machine is disconnected from the mains. Air pressure remains ON.

8.3.2 EMERGENCY STOP

The lockable button for emergency stop.

9-CONTROLS IN BRIEF

9.1 CONTROL PANEL

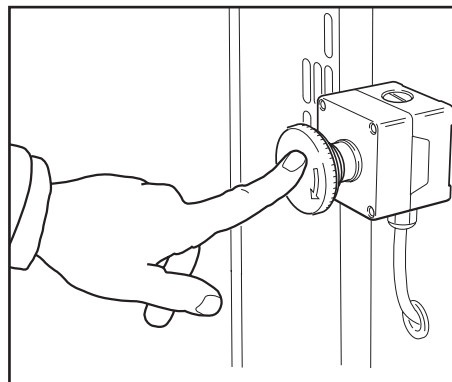


- 1. 'Touch Screen' display
- 2. Working cycle stop button
- 3. Emergency stop button
- 4. Voltage lamp

- 5. Start button
- 6. Set-up button (panel enabling)
- 7. Main switch

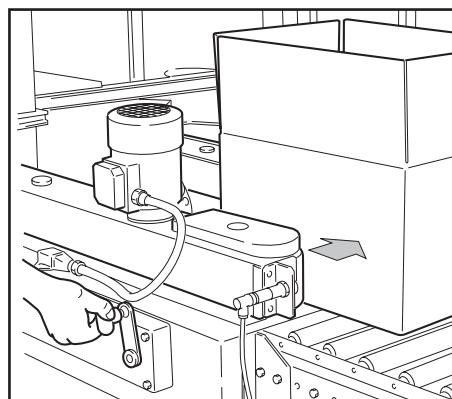
9.2 EMERGENCY STOP BUTTON

It is located on the machine controls side; if it is pressed it stops the machine at any point of the cycle closing also the pneumatic circuit.



9.3 DRIVING BELTS ADJUSTMENT CRANK

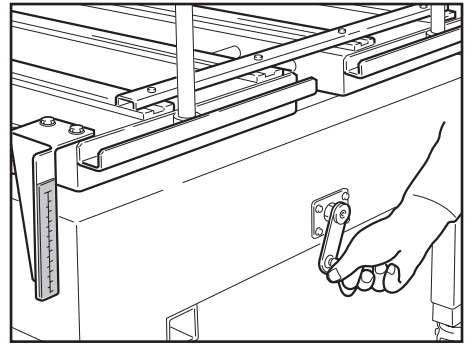
It adjusts the width of the belts according to the width of the box to be taped.



9-CONTROLS IN BRIEF

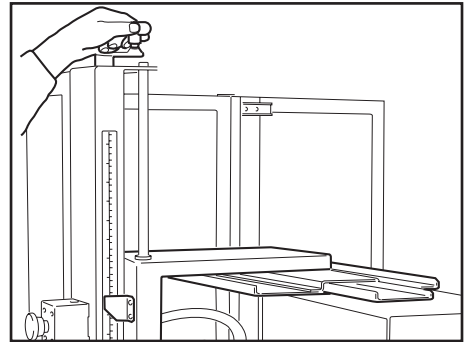
9.4 CRANK FOR THE ADJUSTMENT OF THE HEIGHT OF THE BOX STORAGE

It adjusts the position of the box storage according to the width of the box to be formed.



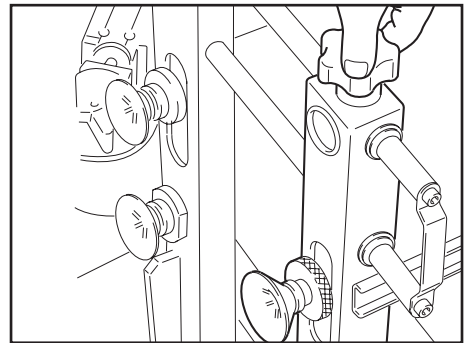
9.5 CRANK FOR THE ADJUSTMENT OF THE CONTRAST SLIDE

It adjusts the height of the contrast slide so that the box remains with the lower laps lowered during the taping..



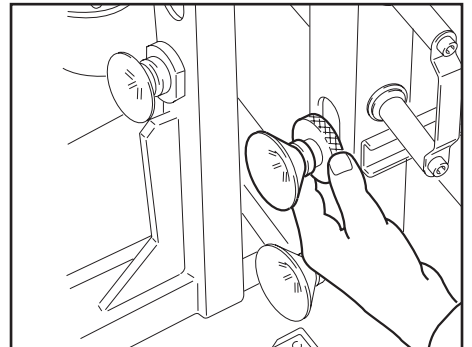
9.6 SUCKERS CARRIAGE LOCK

By loosening the lock knob, it is possible to adjust in a horizontal sense the position of the suckers according to the length of the box.



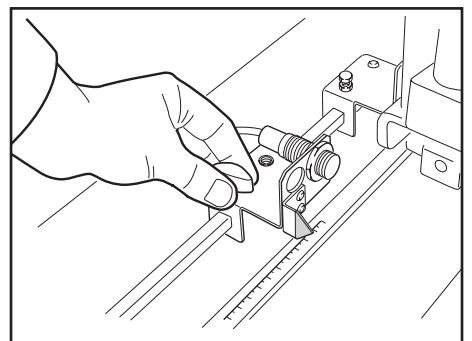
9.7 LOCK RING NUT FOR THE VERTICAL ADJUSTMENT OF THE SUCKER

By loosening it, it allows the adjustment of the single sucker in a vertical sense according to the height of the box..



9.8 PUSHING CARRIAGE SENSOR

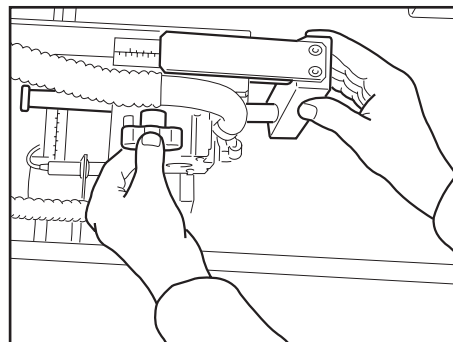
It adjusts the stop position of the carriage according to the preset length.



9-CONTROL IN BRIEF

9.9 LOCK KNOB ON BACK PUSHER

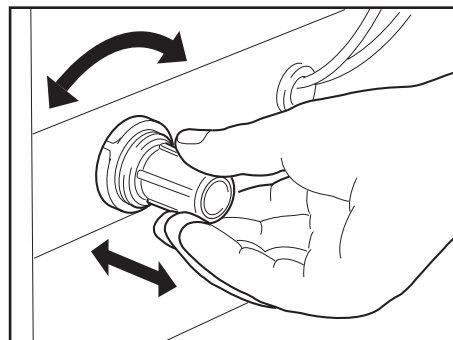
By loosening it, it is possible to adjust the position of the pusher according to the width of the box.



9.10 BOX STORAGE PRESSURE REGULATOR

It adjusts the feed strength of the chain and of the pusher on the box storage.

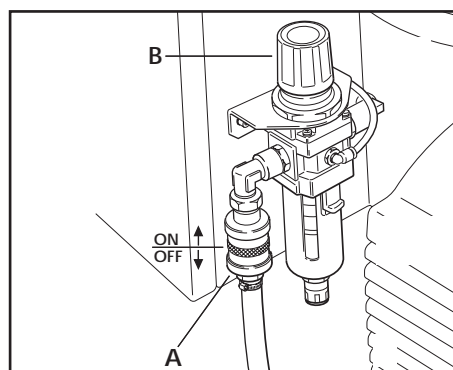
Unlock the knob and turn clock-wise to increase the pressure; counter-clock wise to decrease it.



9.11 PNEUMATIC SYSTEM CONTROLS

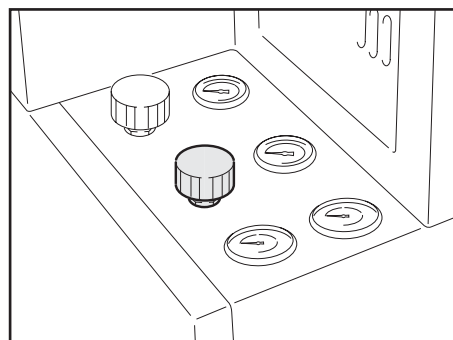
Compressed air ON/OFF valve (A).

Main pressure regulator at the entrance of the circuit (B).



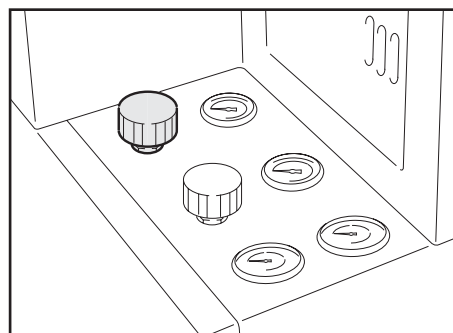
9.12 KNOB FOR THE REGULATION OF THE PRESSURE OF THE LEVER FOR THE RIGHT BOX SUPPORT

- By turning it clock-wise the turning strength of the lever is increased.
- By turning it counter-clock wise the turning strength of the lever is decreased.



9.13 KNOB FOR THE REGULATION OF THE PRESSURE OF THE LEVER FOR THE LEFT BOX SUPPORT

- By turning it clock-wise the turning strength of the lever is increased.
- By turning it counter-clock wise the turning strength of the lever is decreased.



10-SAFETY DEVICES OF THE MACHINE

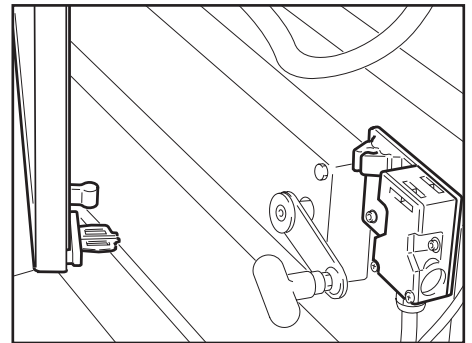
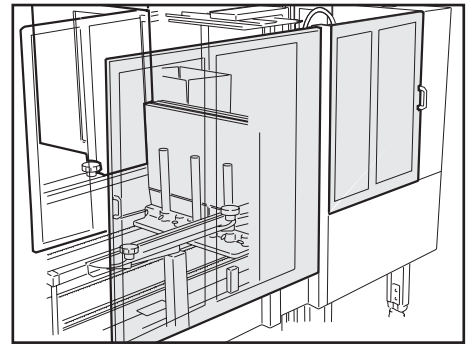
10.1 ANTI-ACCIDENT GUARD

The automatic former F344-SX is equipped with a total anti-accident guard.

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

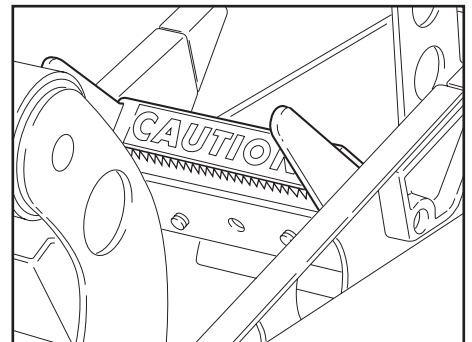
If this interruption takes place during the work cycle, interrupting the machine program half-way, before resuming the cycle the following operations are necessary:

- 1) Remove the box inside the machine;
- 2) Close the protection door;
- 3) Press the set-up button on the control panel;
- 4) Press the 'reset' button on the 'touch screen' display;
- 5) Press the START button on the panel, see also parag. 12.2.



10.2 BLADE GUARDS

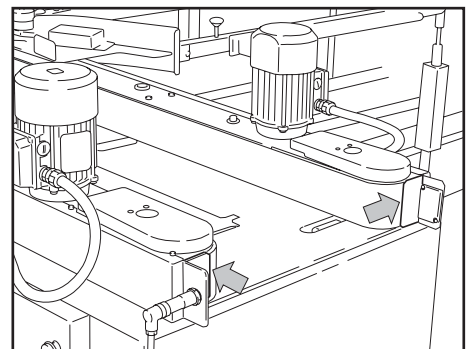
Both the top and bottom taping units have a blade guard.



10.3 BELT GUARDS

The drive belts are protected by safety covers on their external sides and by flexible elements on the exit side.

These protections must be immediately replaced if damaged.



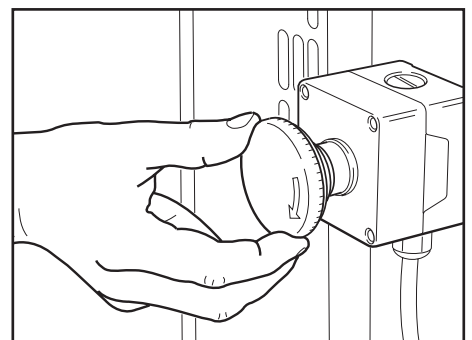
10.4 EMERGENCY STOP BUTTON

The lockable emergency stop button is placed in handy position.

10.5 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

11.0 SAFETY

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

11.1 TAPE LOADING ON THE BOTTOM UNIT

By means of the crank lift the box contrast slide so that the removal of the bottom unit is easier.

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

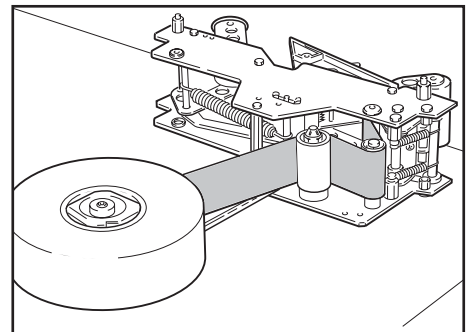
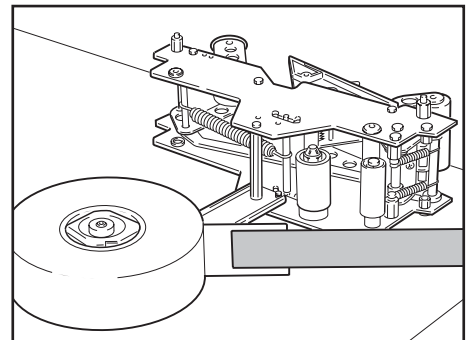
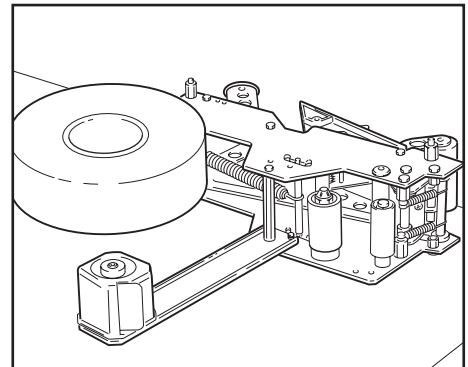
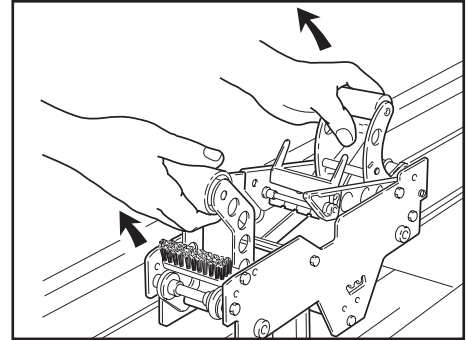
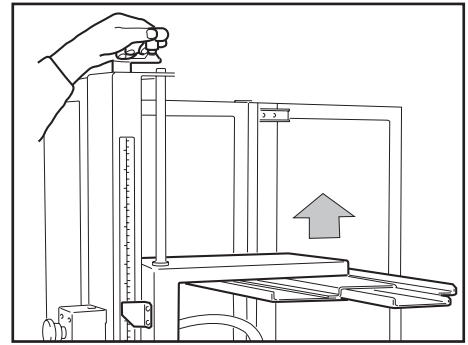
Put a tape roll on the drum.

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



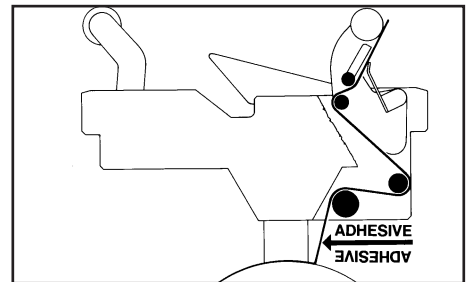
Attach the tape leg to the threading tool (supplied with the tools kit)

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



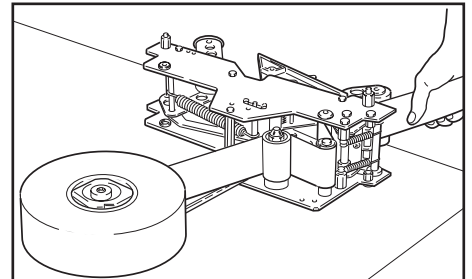
11-SET-UP AND ADJUSTMENTS

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



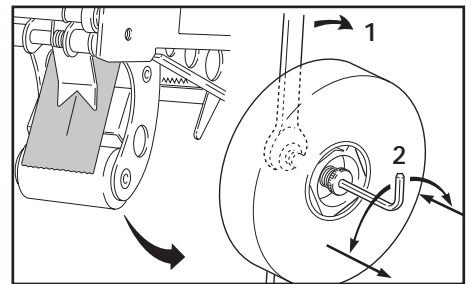
Pull and cut off the excess tape.

Put again the taping head into its seat..



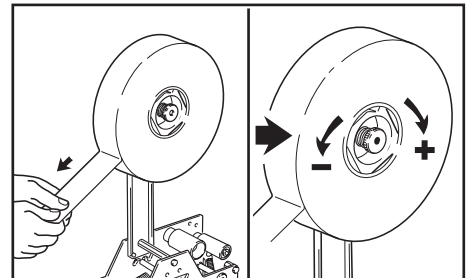
11.2 TAPE DRUM ALIGNMENT

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



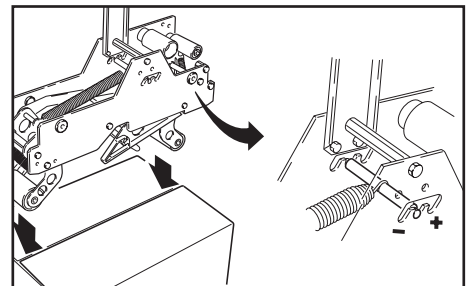
11.3 TAPE DRUM FRICTION BRAKE ADJUSTMENT

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



11.4 ADJUSTMENT OF TAPING UNITS ACCORDING TO THE TYPE OF BOXES

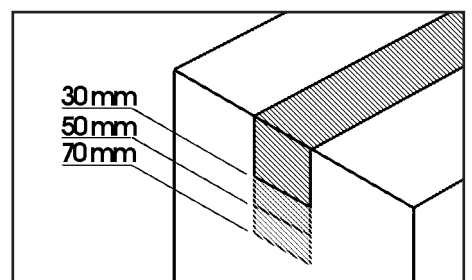
☞ Adjust the main spring:
- decrease the spring load for light cardboard cases;
- increase the spring load for robust cardboard cases.



SPECIAL ADJUSTMENTS

11.5 CHANGE OF THE TAPE LEG LENGTH

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



11-SET-UP AND ADJUSTMENTS

11.6 ADJUSTMENTS TO THE CASE LENGTH, WIDTH AND HEIGHT

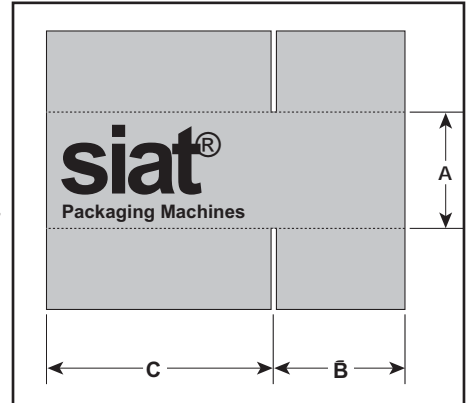
Example of adjustment of the machine using a box with the following dimensions:

A = 250 mm

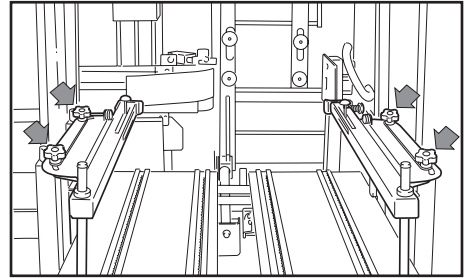
B = 300 mm

C = 400 mm

NOTE: If you are to use boxes with personalized printings and/or wordings, to prevent the boxes from coming out of the former with the printings upside-down, it is necessary to print them as shown in the drawing (side **C** on the left hand).

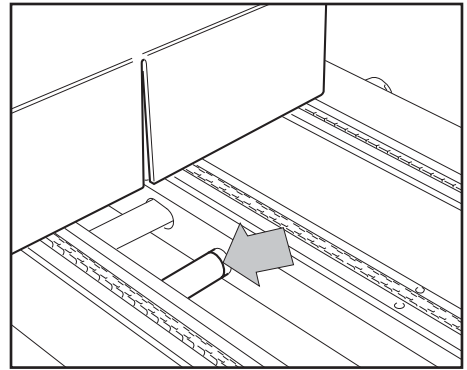


Loosen the 4 top knobs and open the driveways on the box storage carriage.

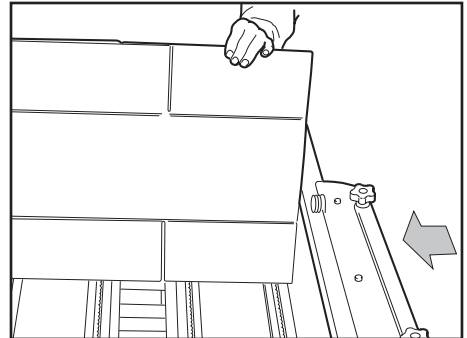


11.6.1 BOX STORAGE ADJUSTMENT

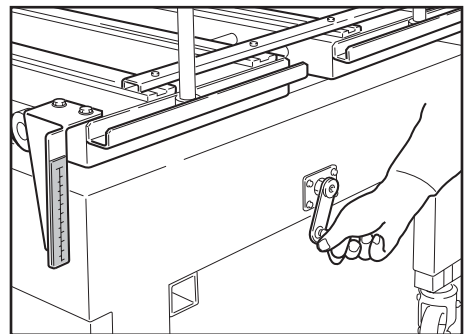
Place the box cut on the red line silk-screen printed on the roller.



By keeping the box in place, bring the side driveways to the carton and lock the knobs.

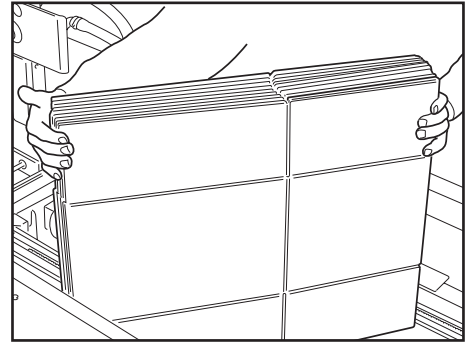


By means of the crank, adjust the height of the conveyor bed of the boxes-holder carriage, taking as a reference the width of the box (eg. 300 mm) and bringing it on the millimetric rod fixed on the side of the carriage.

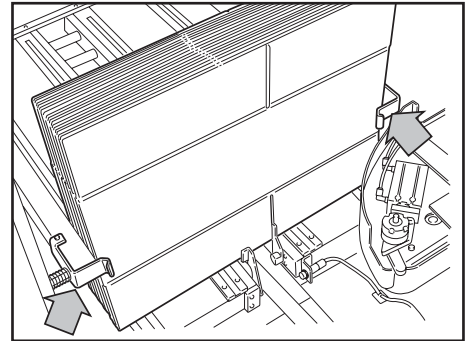


11-SET-UP AND ADJUSTMENTS

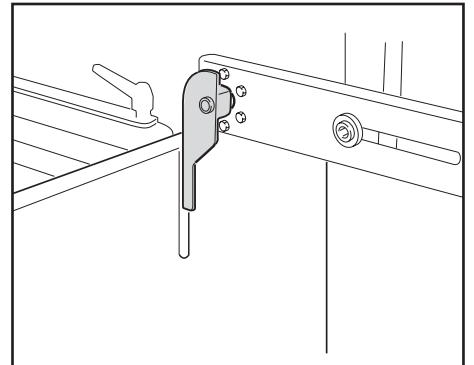
Insert the box package obliquely in the box storage.



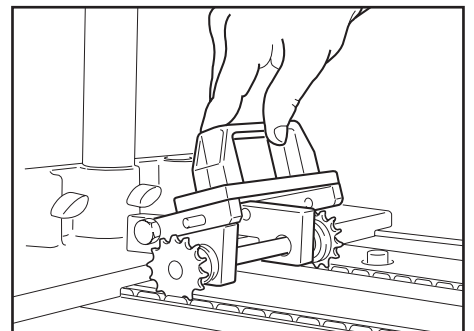
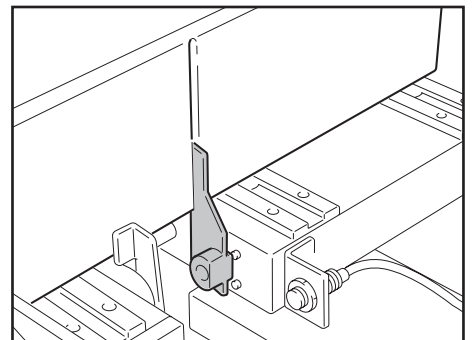
Push the boxes against the two box locking devices.



Make sure that the cut between the laps in the lower part of the box is in line with the box upper and lower opening levers.

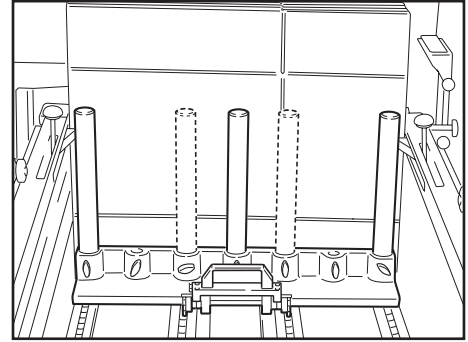


Remove the pinions from the chain with the handle.
Place the pushing device on the back of the boxes.
Place the pinions into the chain.



11-SET-UP AND ADJUSTMENTS

Place the shafts of the pushing device according to the dimension of the box.

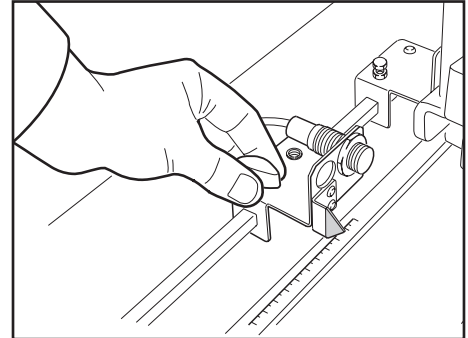


11.6.2 BOX LENGHT ADJUSTMENT

Open the anti-accident guard.

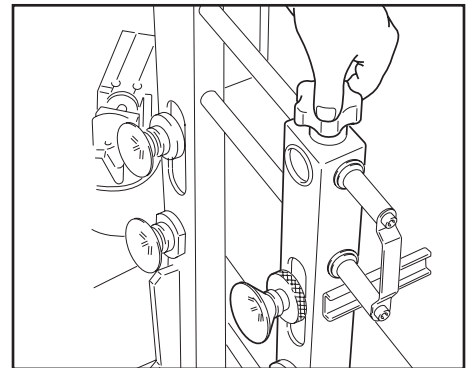
Adjust the position of the photocell (pushing carriage) according to the length of the box (eg. 400 mm).

- Loosen the knob
- Slide the photocell along the millimetric rod on the measurement to be set;
- Lock the knob

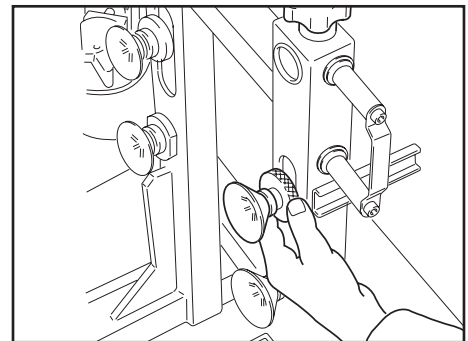


11.6.3 SUCKERS ADJUSTMENT

- Loosen the knob,
- Adjust the position of the suckers horizontally (eg. box length: 400 mm - suckers max. 370 mm);
- Lock the knob

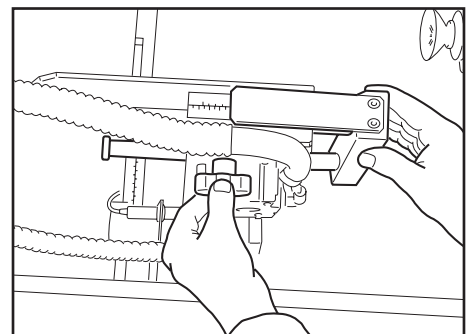
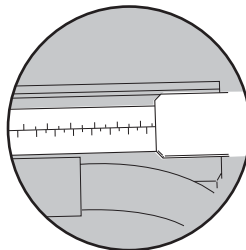


- Loosen the ring nuts;
- Adjust the position of the suckers vertically;
- Lock the ring nuts;



11.6.4 PUSHING CARRIAGE BAR ADJUSTMENT

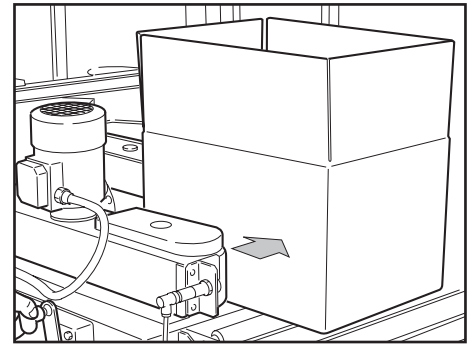
- Loosen the knob
- Adjust the length of the pushing carriage according to the width of the box (eg. 300 mm);
- Lock the knob



11-SET-UP AND ADJUSTMENTS

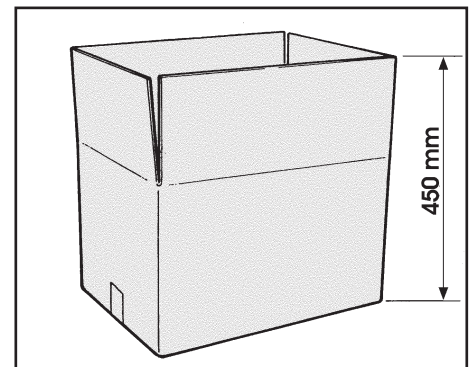
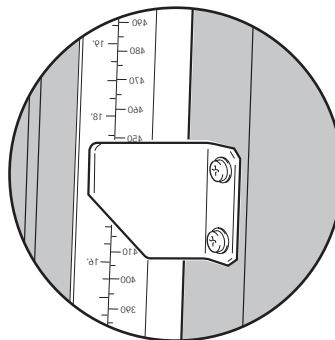
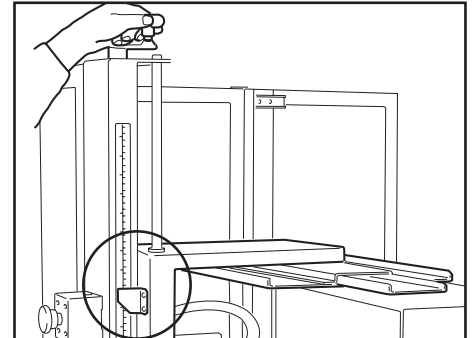
11.6.5 ADJUSTMENT OF THE WIDTH OF THE BOX DRIVING BELTS

Insert a box and bring together the driving belts by means of the crank.



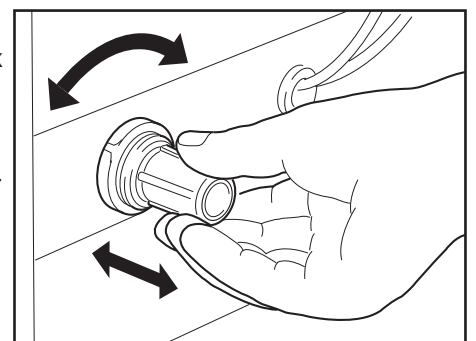
11.6.6 BOX HEIGHT ADJUSTMENT

By means of the crank place the slide which prevents the coming out of the boxes in line with the box with the bottom laps folded (eg. 450 mm).



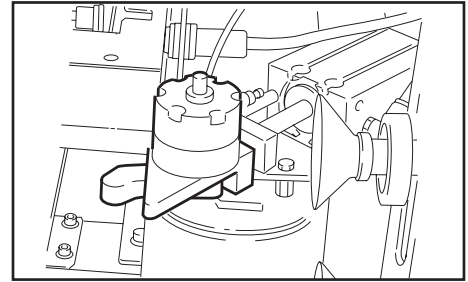
11.7 PNEUMATIC ADJUSTMENTS OF BOX STORAGE

- Adjust the pressure of the pushing carriage on the boxes in the box storage;
- Increase the pressure when the boxes in the storage remain too loose (not close-packed);
- Decrease the pressure when the boxes are pushed beyond the containment levers.

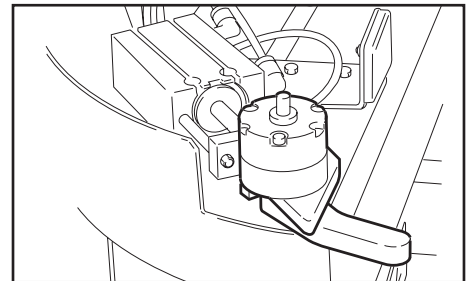
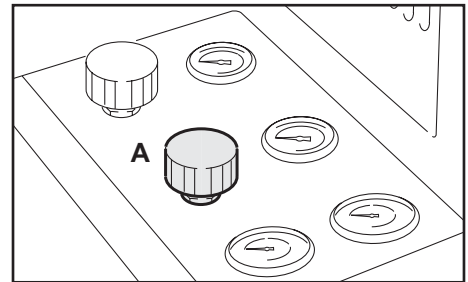


11-SET-UP AND ADJUSTMENTS

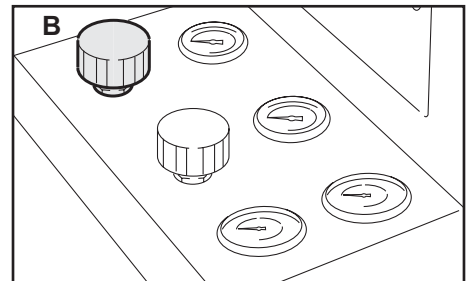
11.8 ADJUSTMENT OF THE PRESSURE OF THE BOXES-SUPPORT LEVERS



- Adjust the pressure of the right box support lever with regulator **A**.



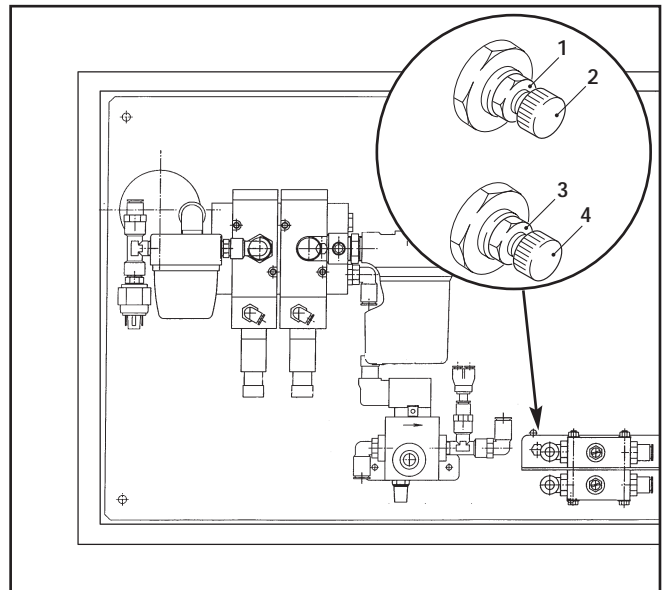
- Adjust the pressure of the left box support lever with regulator **B**.



11.9. ADJUSTMENT OF THE SPEED OF THE OPENING/CLOSING OF THE SIDE LAPS CLOSING DEVICES

Adjust the speed of the cylinders according to the thickness of the cardboard (if the cardboard is strong - eg. two-three corrugations card board - increase the speed of the cylinders).

- 1) Loosen lock nut **1**;
- 2) Turn knob **2** clock-wise to decrease the closing speed; counter clock-wise to increase the speed;
- 3) Lock nut **1**;
- 4) Loosen nut **3**;
- 5) Turn knob **4** clock-wise to decrease the opening speed; counter clock-wise to increase it;
- 6) Lock nut **3**.



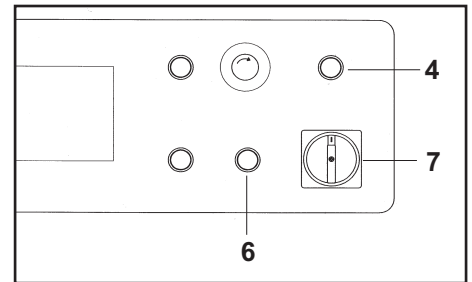
11-SET-UP AND ADJUSTMENTS

11.10 OPERATOR CONTROL PANEL PRELIMINARY OPERATION:

Check that the doors protection are closed.

Check also that the buttons for the emergency stop aren't activate, in the case of activation turn it in clockwise position.

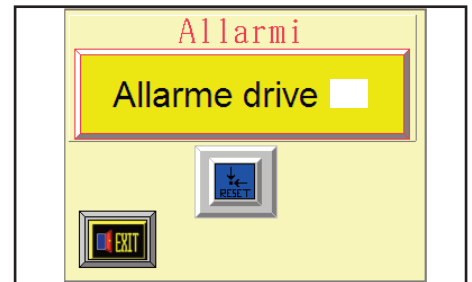
Move the main switch **7** in the position "I" and check that the light **4** is on; press the auxiliary button **6**.



See the page "alarms" in the start phase of the machine.

See if necessary the index of the alarms in the following paragraphs and the instructions for the elimination of the trouble that the display signal has done.

Push the button "reset" and wait that the suckers-pushing carriages are correctly positioned then press 'exit' button.



Visualization of the page "main menu"

Push the button "language".



Select the language by pushing the flag as required.

Press 'exit'.



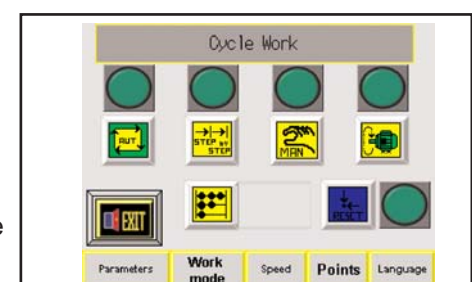
Push 'Work Mode' to access on the page "Cycle work"



Check the phases of power supply at the first start of the machine (see parag. 7.12) by pushing the button for starting the motorizations and the empty pump; push another time for stop the check executed.



Push "Man" and "points" for approaching at the following pages for the strokes definition of the suckers-pushing carriages.



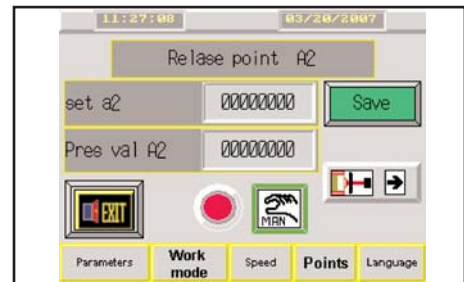
11-SET-UP AND ADJUSTMENTS

Release point A2: pushing carriage running end forward.

Push the button to run  ← forward the carriage

Note: The button is active with yellow light on, when is pressed the light is off.

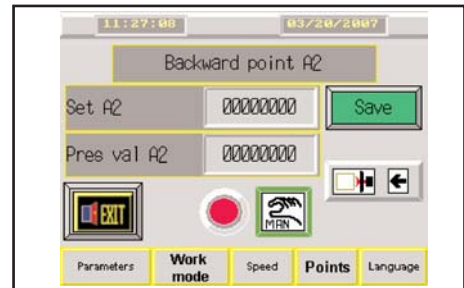
Push the button “save” then “exit” for passing the value done to the following point.



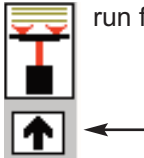
Backward point A2: pushing carriage running end back

Push the button to  → run back the carriage

Push the button “save” then “exit” for passing the value done to the following point.



Taken point A1: suckers carriage running end forward

Push the button to  run forward the carriage

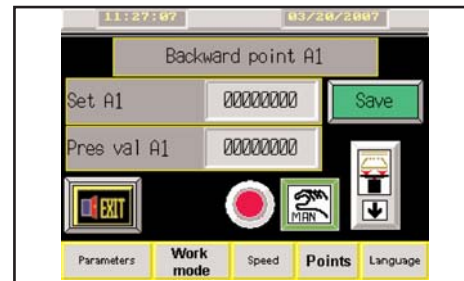
Push the button “save” then “exit” for passing the value done to the following point.



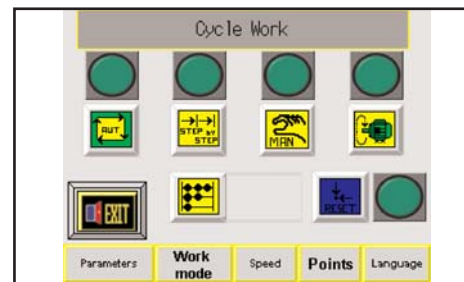
Backward point A1: suckers carriage running end back

Push the button to  → run back the carriage.

Push ‘save’ then “exit” to access on the page ‘Work mode’



Push again ‘exit’ to access to page ‘Main menu’.



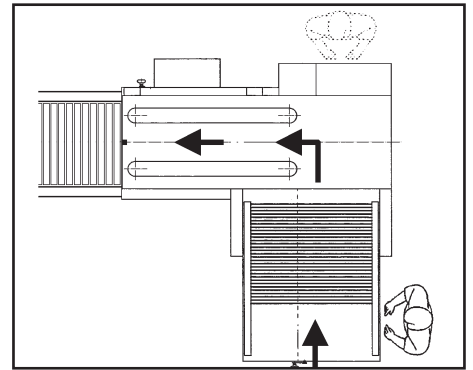
If you want to start immediately the production see the parag. 12.



12-OPERATION

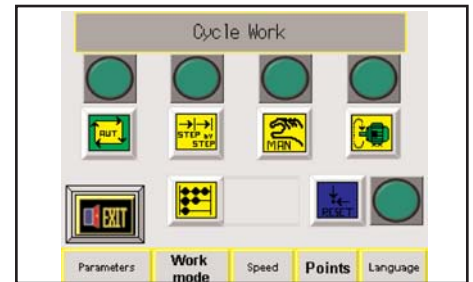
12 OPERATION

12.1 OPERATOR'S CORRECT WORK POSITION



12.2 RUNNING PHASE

Close the doors.
 Release EMERGENCY STOP buttons.
 Give air to the circuit.
 Execute all the preliminary matters for the first start operation that we show you in the paragraph 11.10 until the visualization on the display of the control panel of the page "Cycle work"

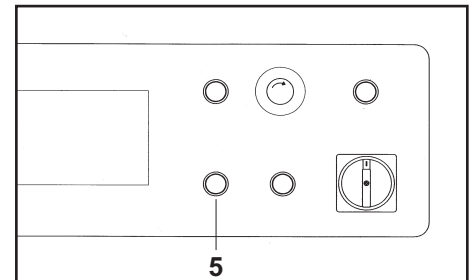


Chose the working cycle
 1)Step by step 2)Manual 3)Automatic

Activation Step by Step cycle:
 Push the button 'reset';
 Push the button 'Step by step'



Push the button 'running motors';

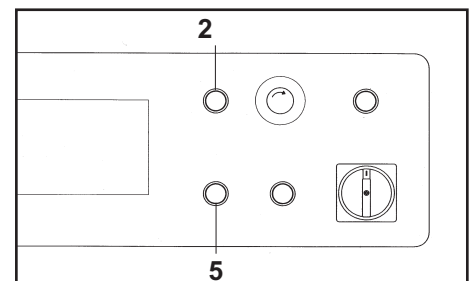


Push the button 'run' 5 on the panel; at every activation of the button is executed a "step" of work cycle (n. 1 complete working cycle = n. 8 steps)

Activation Manual cycle:
 Push the button 'reset';
 Push the button 'Man'



Push the button 'running motors';



By pushing 'run' 5 on the panel ; at every activation of the button the machine will done a complete working cycle; for stopping the machine push the button 2.

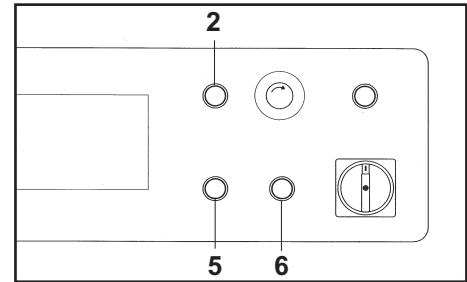
12-OPERATION

Activation of the Automatic cycle:

Push the button 'R eset';
Push the button 'Aut'



Press the button 'run' 5 on the panel, the machine will be in a forming preparation continuously, for stop this phase press the button 2.

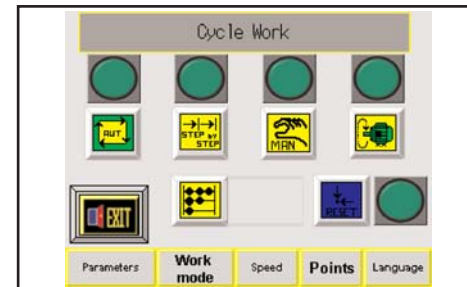


Note : Before every former starting, is necessary, after removed the box, press the button "reset"

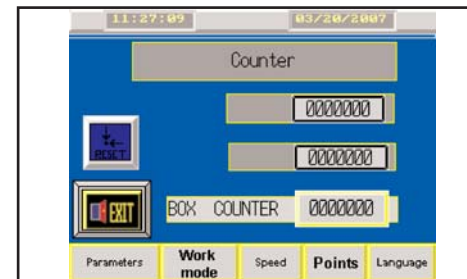
To re-start after a emergency stop (by pressing a red mushroom or by opening a protection door) is also necessary to push the 'set up' button 6 on the control panel.

Programming the counter

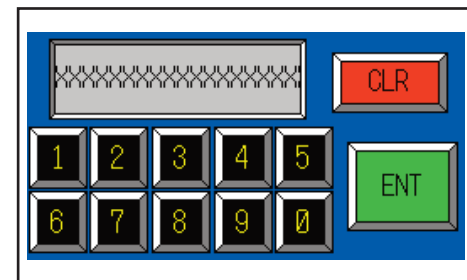
Push the button 'Parameters'.



Push the button 'Counter'.

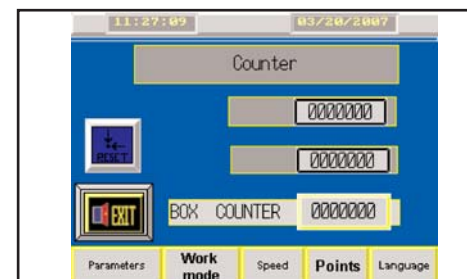


Push the button 'Box counter'.



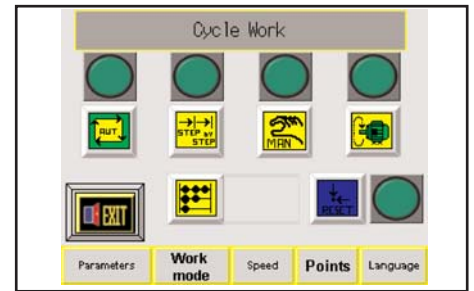
Set the number as required and confirm with 'Ent'.

Push the button 'Exit' to return at the page 'Cycle work'



12-OPERATION

Push the button



Former operation speed

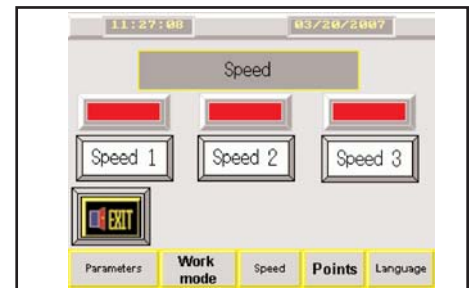
In the page 'Cycle work' push the button 'Parameters'.

Select the operation speed desired considering also the box quality.

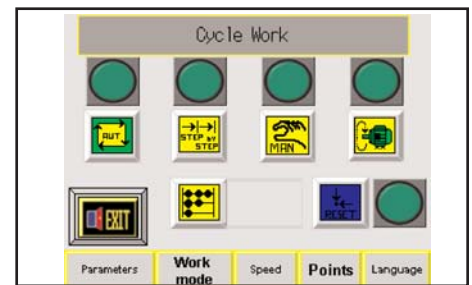
Speed. 1: 14 boxes max. per minute for light boxes or poor quality.

Speed. 2: 16 boxes max. per minute for medium quality boxes.

Speed. 3: 18 boxes max. per minute for sturdy boxes.



Push the button 'Exit'



12-OPERATION

12.3 PRODUCTION STARTING

Before starting, check the main functions of the machine.

- 1 Entry air pressure 6 BAR, if pressure is below 5,5 the machine functions are not safe.
- 2 Press the START button and check that Emergency Stops are working properly.
- 3 Press the START button and check that machine stops if side guards are opened.

Alarms visualized on the control panel display with red flashing and stop machine.

Alarm on the display	Cause	Solution
Film broken.	Breakdown of the film in the taping unit	Check the taping unit.
No air.	Air low pressure (less than 4,5 bar)	Check pressure value.
Box not taken	The box is not sucked by the suckers carriage.	Remove the box and check as required.
Full line (the red light does not goes on)	Temporary stop of the case former. The line photocell is interrupted. The cycle restart in the time when the photocell is reactivated.	Check the exit rollers on taping unit outlet side .
Max. cycle time.	The machine will stop when the cycle of forming boxes is not done just in time as preselected (PLC parameters).	Remove the box, reset and re-start the machine.
Termic overload motor	Thermal protection device intervention.	Check.
Time out orig. A1	Research of the position '0' of the axis n. 1 (suckers carriage)	Wait that the research is finished.
Time out orig. A2	Research of the position '0' of the axis n. 2 (pushing carriage)	Wait that the research is finished.
Allarm drive A1	Carriage axe n. 1 overload.	Made the research of the A1 axis origin point by pressing the 'reset' button on the control panel display.
Allarm drive A2	Carriage axe n. 2 overload	Made the research of the A2 axis origin point by pressing the 'reset' button on the control panel display.

12-OPERATION

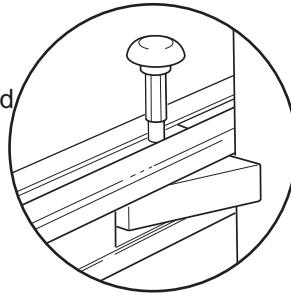
Alarm on the display	Cause	Solution
Emergency	Stop emergency button (red mushroom) activation. Interlocking device activation (a safety door has been opened).	Check and act as necessary. In this case to restart press also the 'set up' button on the control panel.

Alarms visualized on the control panel display with yellow flashing only (the former doesn't stop).

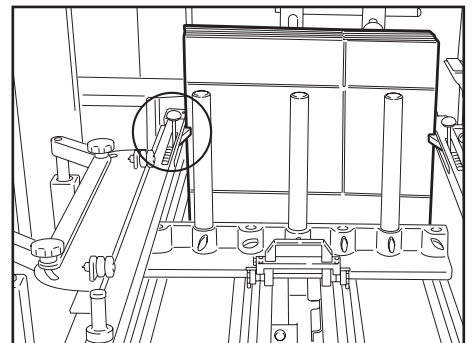
- Ending box;
- End of film.

12.4 FILLING OF THE BOX STORAGE WHEN THE MACHINE IS MOVING

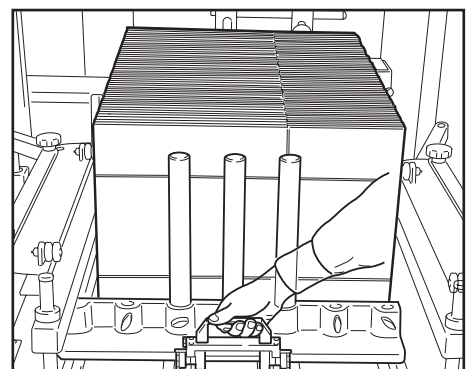
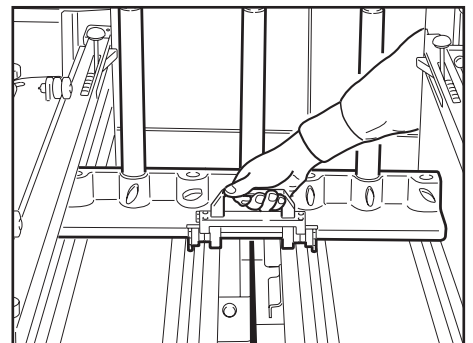
Position the two boxes-fasteners, mounted on the side drives, behind the boxes.



Slide the pushing carriage at the beginning of the box storage.



Fill the box storage and lay the pushing carriage on the boxes, reinserting the pinions of the handle into the chain.



12-OPERATION

12.5 TAPE REPLACEMENT

Operator Skill 1

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

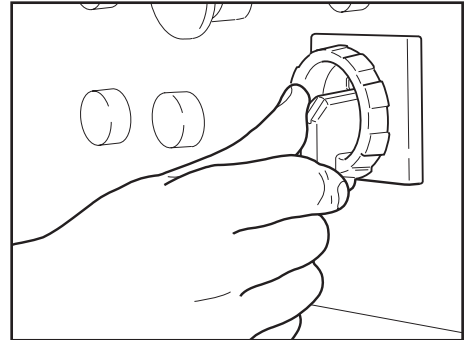
- Press the E-stop;
- Set the main switch in OFF position;
- Open the safety guard;
- Do all the operations under points 11.1 and 11.2

Pay attention to the cutting blades.



12.6 CLEANING

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

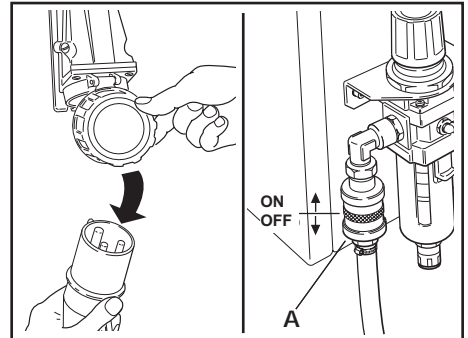


Disconnect the electric power and disconnect pneumatic circuit through valve **A**.

CLEANING - Skill 1 operator

Use dry clothes or light detergents.

Do not use solvents or water jets.



12-OPERATION

12.6 ADJUSTMENTS TABLE

OPERATIONS	OPERATOR'S SKILL	SECTIONS
Tape loading	1	11.1
Tape alignment	1	11.2
Checkout of the safety devices	1	12.7
Adjustment of tape drum friction brake	1	11.3
Adjustment of tape applying spring	1	11.4
Box size adjustment	1	11.6
Box storage pneumatic adjustments	1	11.7
Pressure adjustments of the boxes support levers	1	11.8
Cylinders adjustments	1	11.9
Box storage filling	1	11.10
Conveyor bed height adjustment	1	7.4
Special adjustment: Tape leg	2	11.5

12.7 SAFETY DEVICES CHECKOUT

- 1) Taping units blade guard (Par. 10.2);
- 2) Lockable emergency stop button (Par. 10.4)
- 3) Belt guards (Par. 10.3)

12.8 TROUBLESHOOTING

SITUATION	CAUSE	SOLUTION
Turning the main switch on ON the voltage lamp does not light up.	Emergency stop button pressed.	Check
	Anti-accident guard opened	Check.
	Magnetothermal protection.	Check.
The vacuum pump does not work.	Thermal switch intervention.	Check and reset.
Pressing 'RUN' button on the control panel the motors do not turn.	Thermal switch intervention.	Check and reset.
The suckers do not take the cardboard.	Vacuum pump failure.	Check.
The box is not opened by the suckers-holder carriage.	Box opener cylinder in a wrong position.	Adjust the position of the boxes in the storage.
The machine stops without pushing the box in the driving belts and the box falls down.	Wrong position of the sensor that adjusts the position of the pushing carriage.	Adjust the position of the pushing carriage (the best distance between the slide and the pushing carriage must be about 5 mm higher than the length of the box to be formed).
	Uncorrect calibration of the sensor of the vacuum pump.	Adjust as necessary
The blade does not cut or grays the tape.	Blade dirty of adhesive tape	Clean or replace.
	Cut levers springs not strong enough.	Replace
	Insufficient tape tensioning	Increase the friction brake.

12-OPERATION

SITUATION	CAUSE	SOLUTION
The tape is not properly put on the back part of the box.	Blade does not cut the tape properly.	Replace/clean.
	Insufficient taping unit main spring tension.	Adjust the tensioning of the spring.
	Adhesive clotting on the tape refeeding rollers of the taping unit.	Clean and lubricate the rollers.
	Rubber coated roller at the exit.	Replace.
The belts do not drive the box.	Too low pressure.	Adjust.
	Smooth ring on the pulley.	Replace.
	Excessive unrolling tensioning of the tape.	Decrease friction on the drum.
	Excessive tensioning of the taping unit spring.	Adjust.
	Excessive pressure on the head of the box.	Adjust.
The tape is not centered on the box.	The driving guides are not correctly positioned.	Check driving belts position.
	The laps are not positioned at the centre of the taping unit.	make sure that the laps are centered.
	The tape is not positioned at the centre of the taping unit.	Adjust the tape position.
The box, although not open at the driving belts, is pushed by the pushing carriage.	Uncorrect calibration of the vacuum pump sensor.	Adjust the sensor sensitivity.

12-MAINTENANCE AND REPAIRS

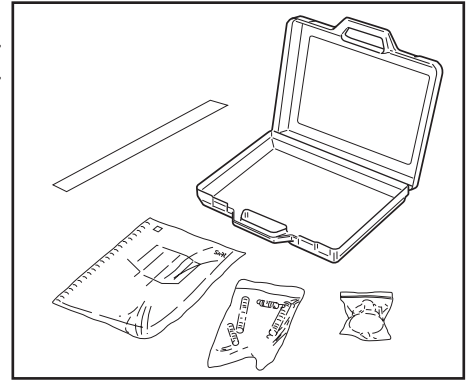
13.0 SAFETY MEASURES

(see section 3)

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

13.1 SPARE PARTS SUPPLIED WITH THE MACHINE

- N.1 Instructions and spare parts manual (SMC00007K)
- N. 2 Suckers
- N. 1 2" spare blade
- N. 1 K11 main spring
- N. 2 Blade-holder spring
- N. 1 Plastic threading leader

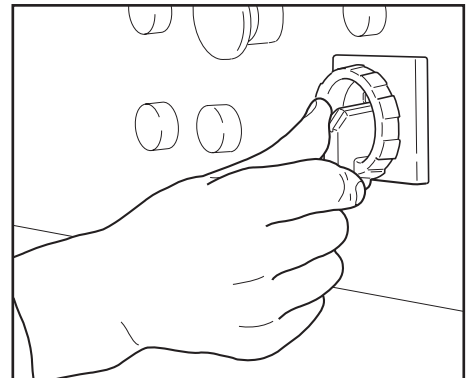


13.2 RECOMMENDED FREQUENCY OF CHECK-OUTS AND MAINTENANCE OPERATIONS

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

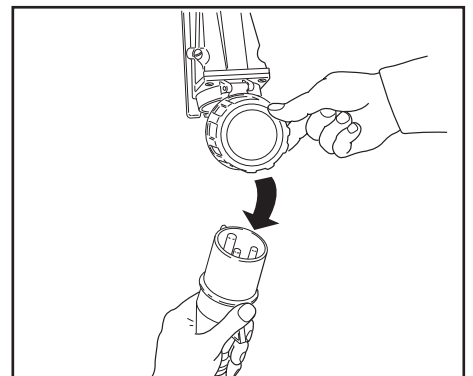
13.3 CHECK-OUT TO BE PERFORMED BEFORE AND AFTER EVERY MAINTENANCE OPERATION

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



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

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



13-MAINTENANCE AND REPAIRS

13.4 SUGGESTED PRODUCTS FOR LUBRICATION

GREASE TYPE:

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

METAL/PLASTIC: PLATE MASTER M+L

(molybdenum grease and PTFE for plastic and metallic materials)

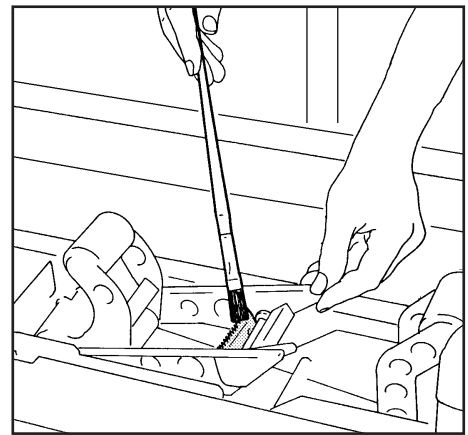
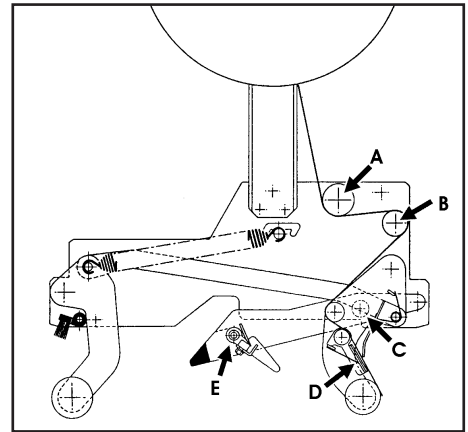
OIL TYPE:

regular lubricating oil or general purpose spray lubricant.

13.5 LUBRICATION OF THE TAPING UNIT

Lubricate monthly with oil the points shown on Picture.

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



13.6 BLADE CLEANING

 Skill 2 operator

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

13.7 BLADE REPLACEMENT

Skill 2 operator

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

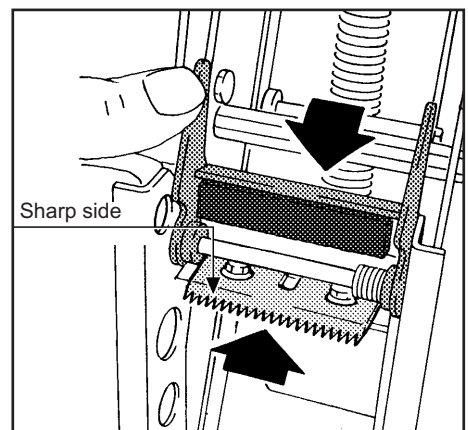
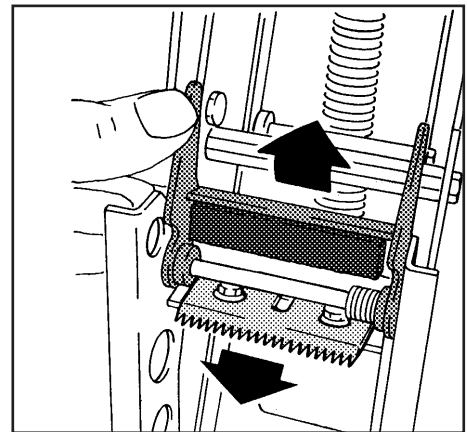
WARNING!

Very sharp blade.

Any error may lead to bad injuries.

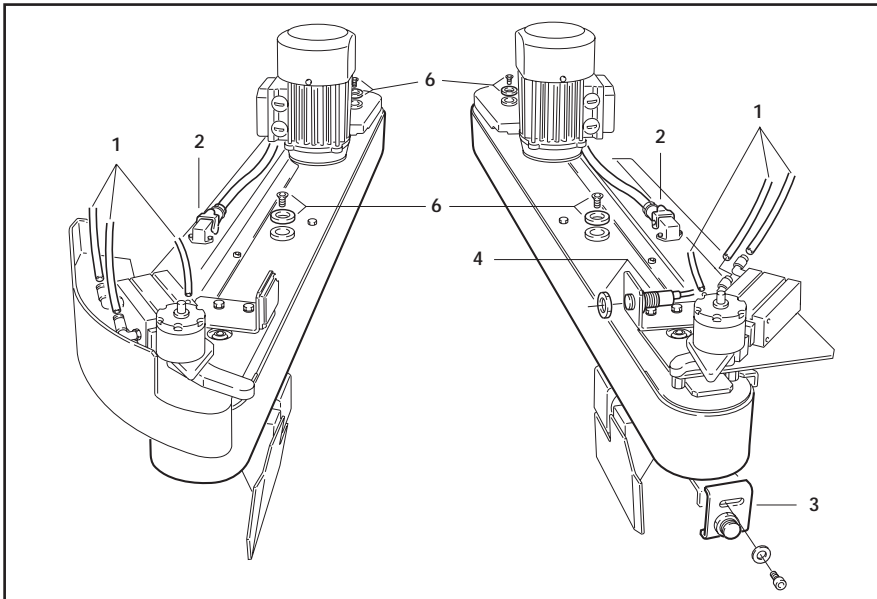


- Insert the new blade paying attention to the position of its sharp side.
- Fix the screws.
- Release the guard..

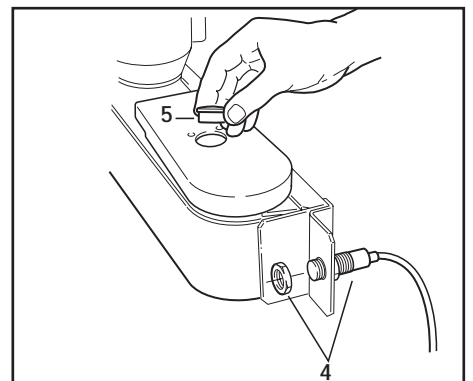
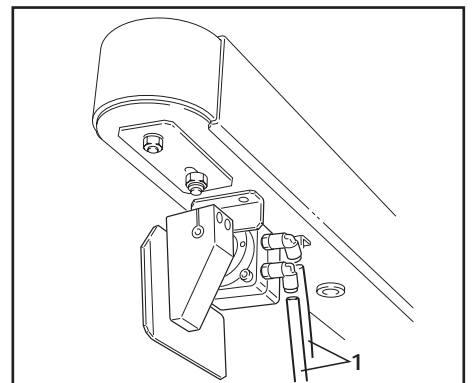
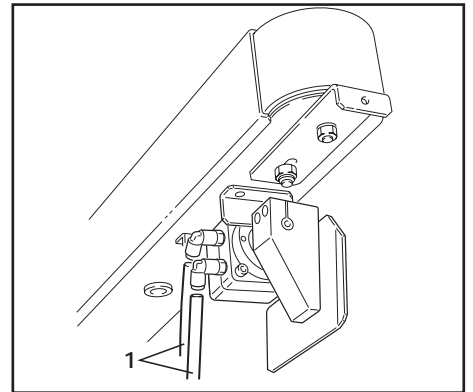


13-MAINTENANCE AND REPAIRS

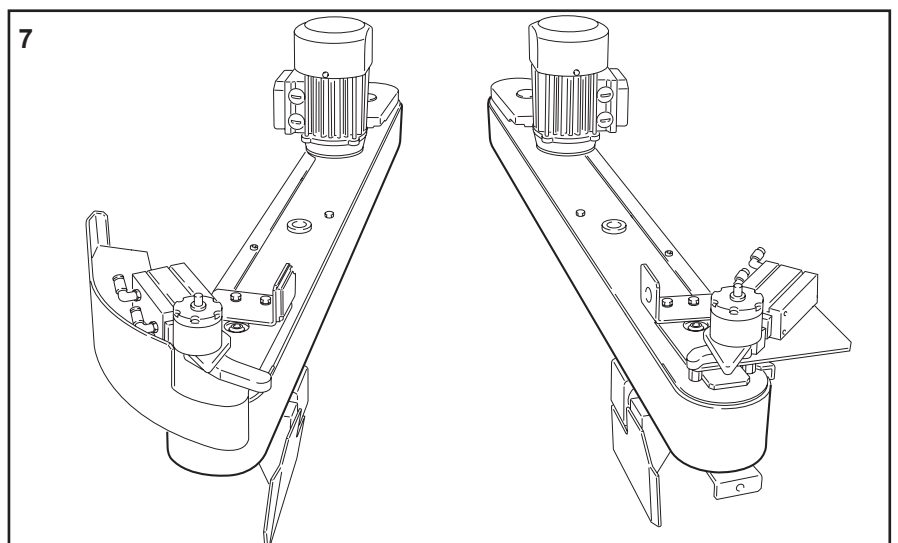
13.8 DRIVE BELTS REPLACEMENT



Remove the pipes 1), remove plugs 2), remove sensor 3), remove photocells 4), remove caps 5), unscrew and remove the screws and the washers which secure the motor devices 6).

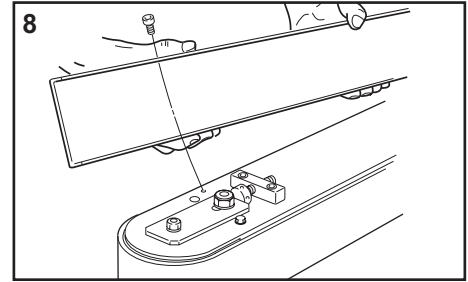


Remove the motorization units 7).

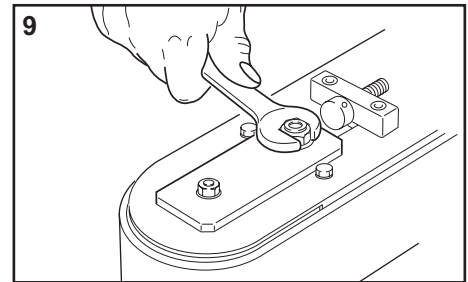


13-MAINTENANCE AND REPAIRS

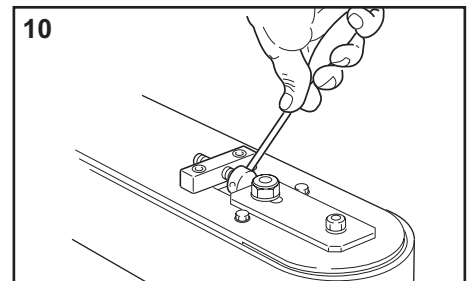
Remove the guards **8**).



Loosen the nuts which secure the belt tensioning board **9**).

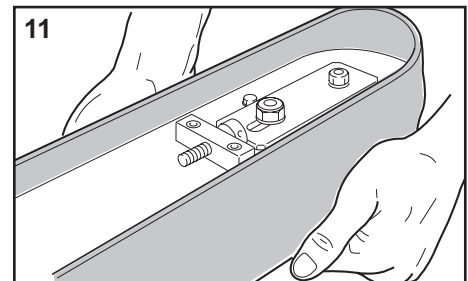


Loosen the tensioning screws **10**).



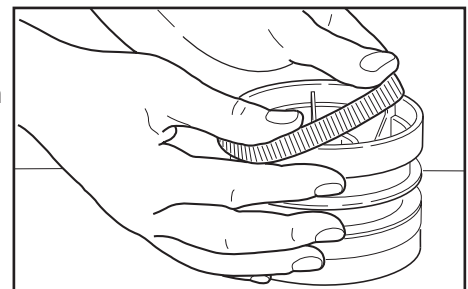
Remove and replace the belts **11**).

Remounting: proceed in the reverse way.



WARNING!

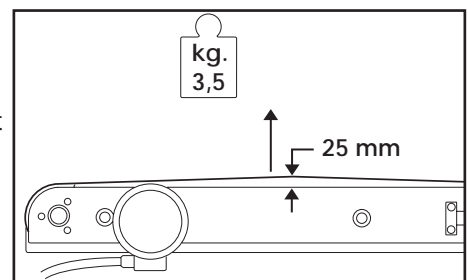
Before setting the new belt, check the wear of the orange plastic rings on the drive pulleys: replace them if they are worn out.



13.9 ADJUSTMENT OF THE BELTS TENSION

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

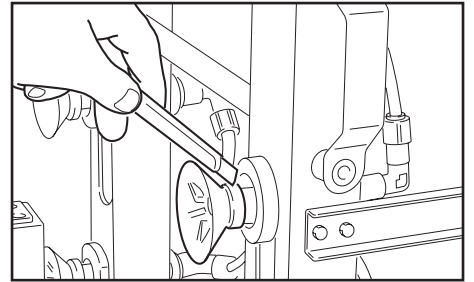
A force of 3,5 kg should produce a gap of 25 mm (1 inch) between the belt and the frame



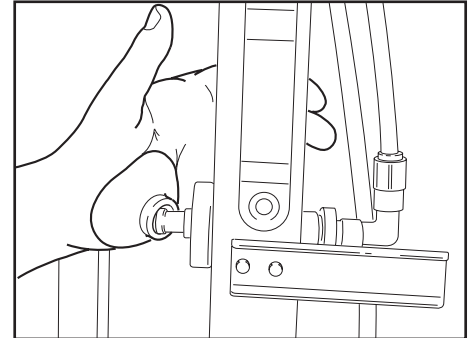
13-MAINTENANCE AND REPAIRS

13.10 SUCKERS REPLACEMENT

Cut with a cutter the sucker to be replaced.
Remove the sucker cut out of its housing.



Grease the hole of the new sucker and remount it.

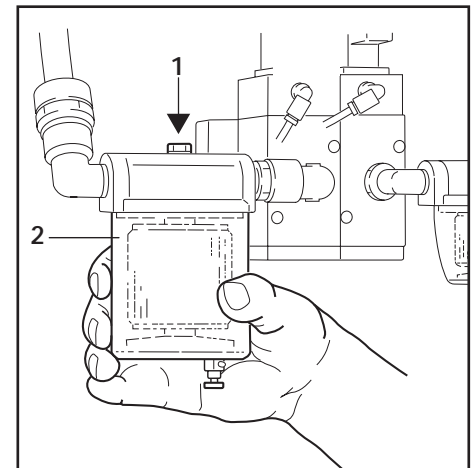


13.11 SUCTION FILTERS

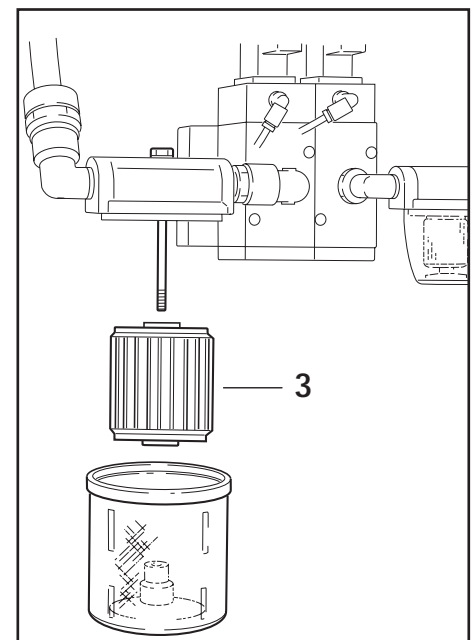
Preventing impurities from reaching the vacuum pump is fundamental to guarantee the best functioning and a long duration. The filters of this series, located on the line pipings of the systems and on the suction intakes of the vacuum pump, require regular cleaning and maintenance interventions.

FILTERS FOR THE SUCKERS ON THE MAIN CARRIAGE

- Completely loosen screw 1)
- Remove plastic cup 2)).



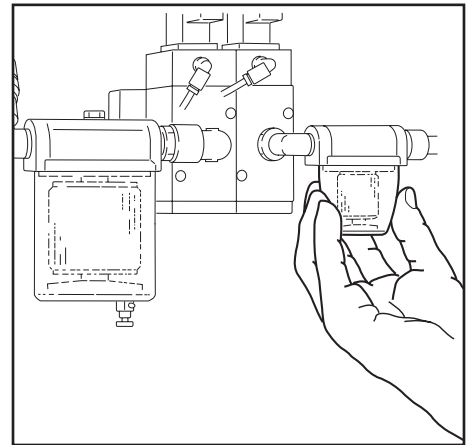
- Remove filter 3) and clean it with compressed air.



13-MAINTENANCE AND REPAIRS

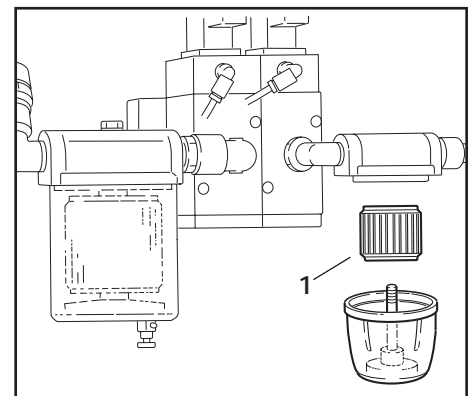
FILTER FOR THE SUCKER ON THE PUSHING CARRIAGE

- Unscrew the plastic cup turning it clockwise.



- Remove the filter 1) and clean it with compressed air.

NOTE: clean the filters every 200 work hours

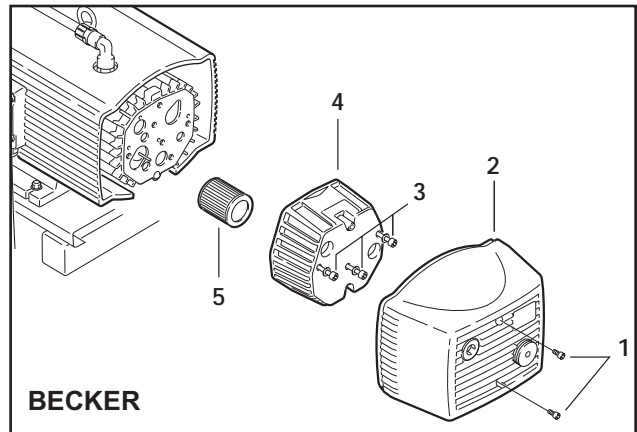


13.12 CLEANING OF VACUUM PUMP FILTER

A regular maintenance of the pump guarantees a perfect operation. The maintenance intervals depend on the type of application and on the operational conditions. Before starting any maintenance operation, disconnect the plug to avoid non intentional startings.

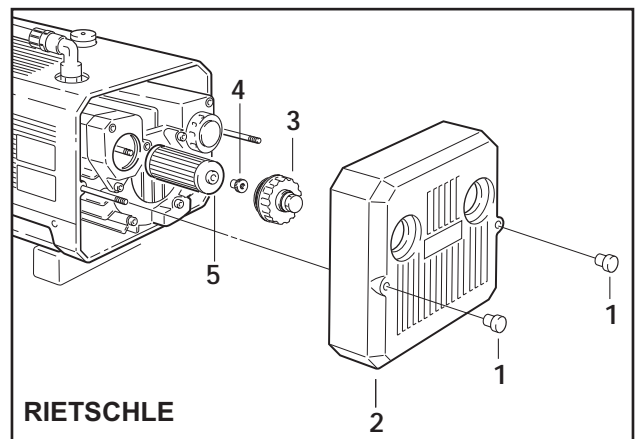
BECKER VACUUM PUMP

- Loosen screws 1
- Remove grid 2
- Loosen screws 3
- Remove cover 4
- Remove filter 5 and clean it with compressed air



RIETSCHLE VACUUM PUMP

- Loosen knobs 1
- Remove cover 2
- Completely unscrew cap 3
- Remove knob 4
- Remove filter 5 and clean it with compressed air

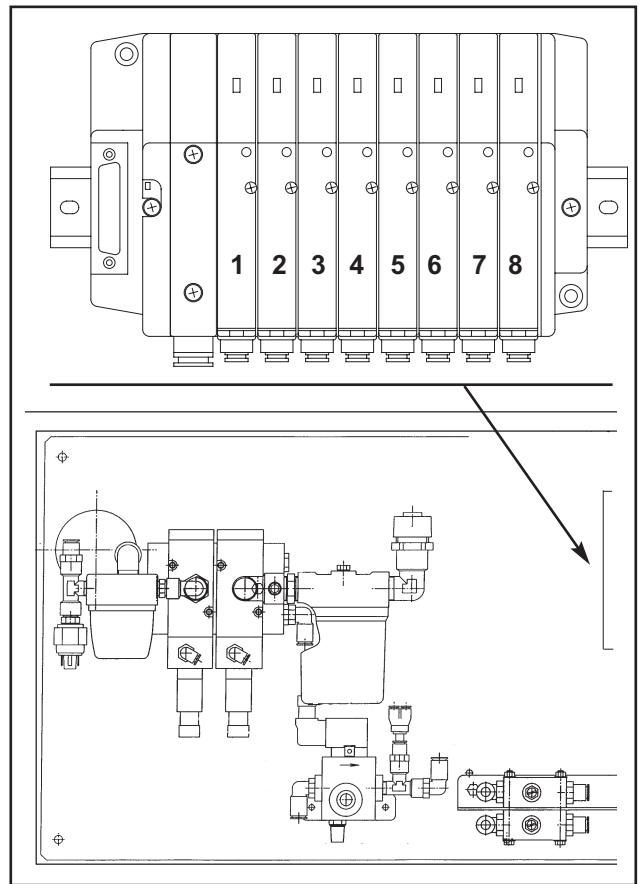


The filter must be cleaned every month and must be replaced every year.

13-MAINTENANCE AND REPAIRS

13.13 FUNCTIONS OF THE SOLENOID VALVES

1. Boxes fastener
2. Boxes feeder
3. Box opener lever
4. Back-laps closer
5. Sicker holder
6. Side-laps closer
7. Box support
8. Box support



13.15 FUNCTIONS OF THE PHOTOCELLS AND OF THE SENSORS

SENSOR N. 1

It adjusts the stop position of the suckers-holder carriage on its back trip in line with the driving belts.

SENSOR N. 2

It adjusts the stop position of the suckers-holder carriage on its forward trip.

SENSOR N. 3

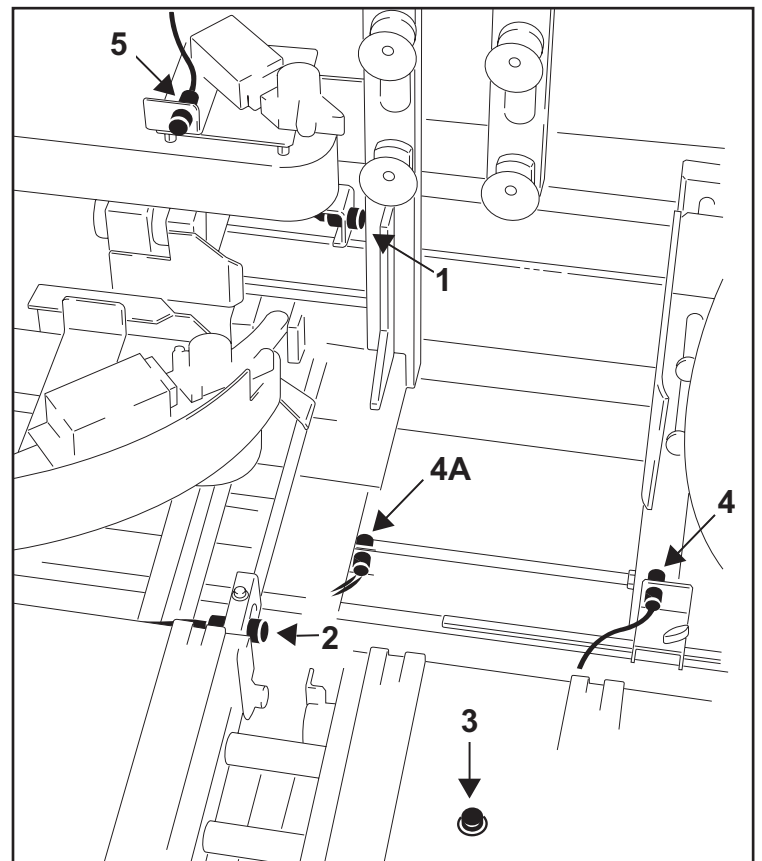
It detects the presence of boxes in the box storage.

SENSORS N. 4, 4A

It adjusts the position of the pushing carriage.

PHOTOCELL N. 5

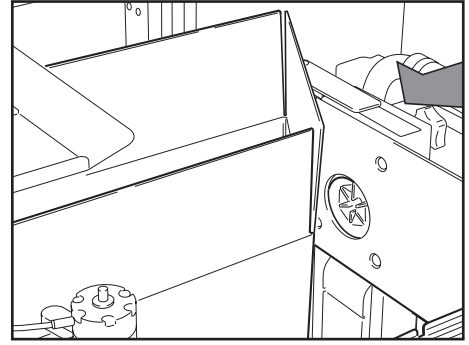
Shadowed by the box, it controls the starting of the side lap-closers.



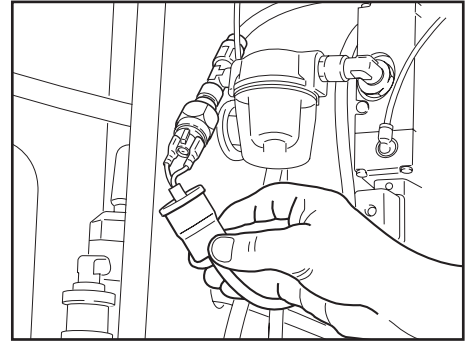
13-MAINTENANCE AND REPAIRS

13.15 CALIBRATION OF THE VACUUM PUMP SENSOR

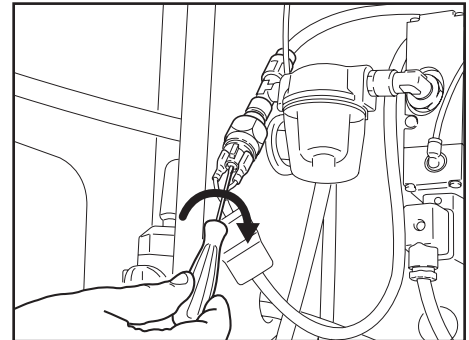
This calibration is necessary when the box at the driving belts falls down and the machine stops..



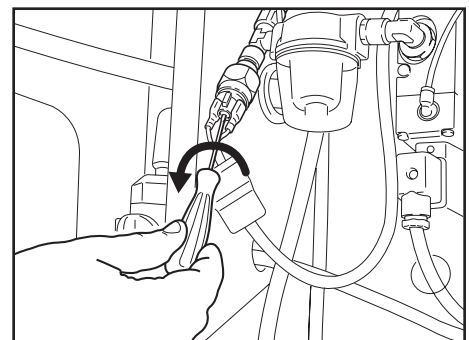
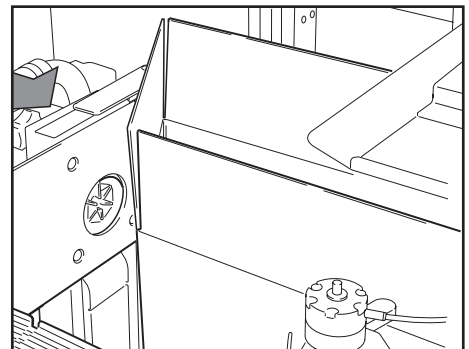
Open the door of the pneumatic supply board and remove the cap which covers the vacuum pump sensor.



With a screw driver turn the screw clockwise to decrease sensitivity.



Turn the screw counter clock-wise (to increase the sensitivity of the sensor) when the box, although not open at the driving belts, is pushed by the pushing carriage..



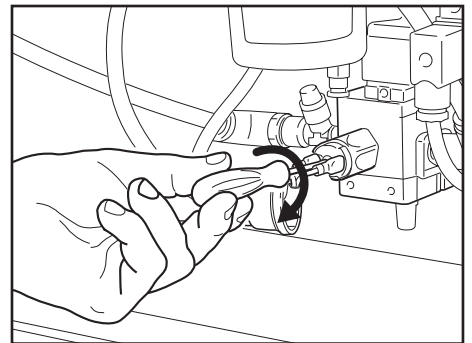
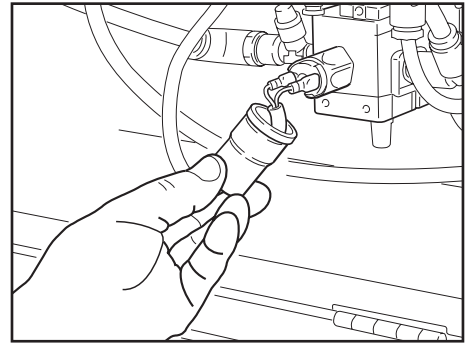
13-MAINTENANCE AND REPAIRS

13.16 ADJUSTMENT AND CALIBRATION OF THE PRESSURE SWITCH

This calibration is necessary when the control panel display show 'no air' alarm (low pressure: less than 4,5 bar).

Open the door of the pneumatic supply panel and remove the cap which covers the regulator of the pressure switch.

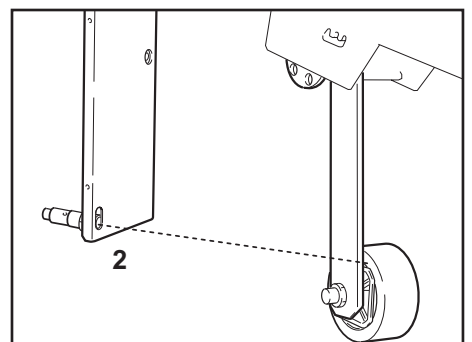
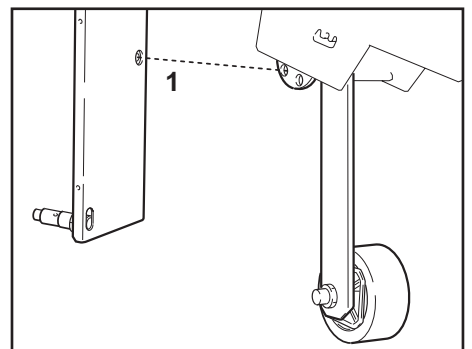
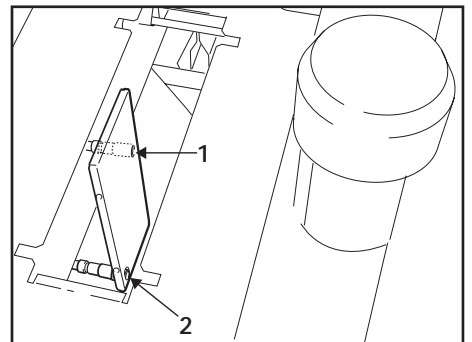
Turn clockwise the screw.



13.17 PHOTOCELL FOR THE CONTROL OF THE TAPE END/BREAKAGE

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

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



14-ADDITIONAL INSTRUCTIONS

14.1 INSTRUCTIONS FOR SCRAPPING AND DISPOSAL OF THE MACHINE

The machine is made of the following materials:

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

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

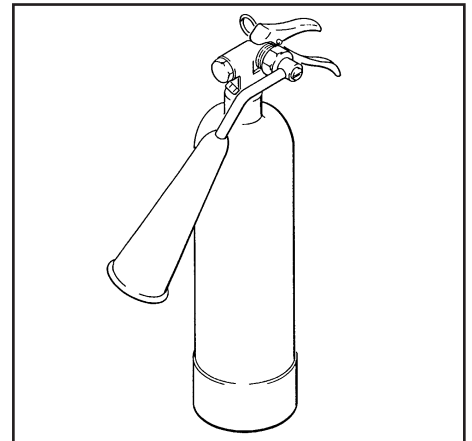
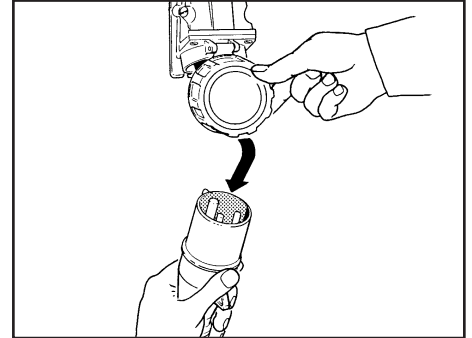
14.2 INSTRUCTIONS ON EMERGENCY SITUATIONS

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

FIRE

In case of fire use an extinguisher containing CO₂.

DO NOT use water.



15-ENCLOSURES

15.1 STATEMENT OF CONFORMITY

to the Directives on Machinery EEC 98/37, 91/368, 93/44 and 93/68.

15.2 SAFETY LABELS

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

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

15.3 EMISSIONS OF RADIATIONS, GAS, VAPOURS AND DUST

Nothing to report

15.4 ELECTRIC TESTS

Electric tests:

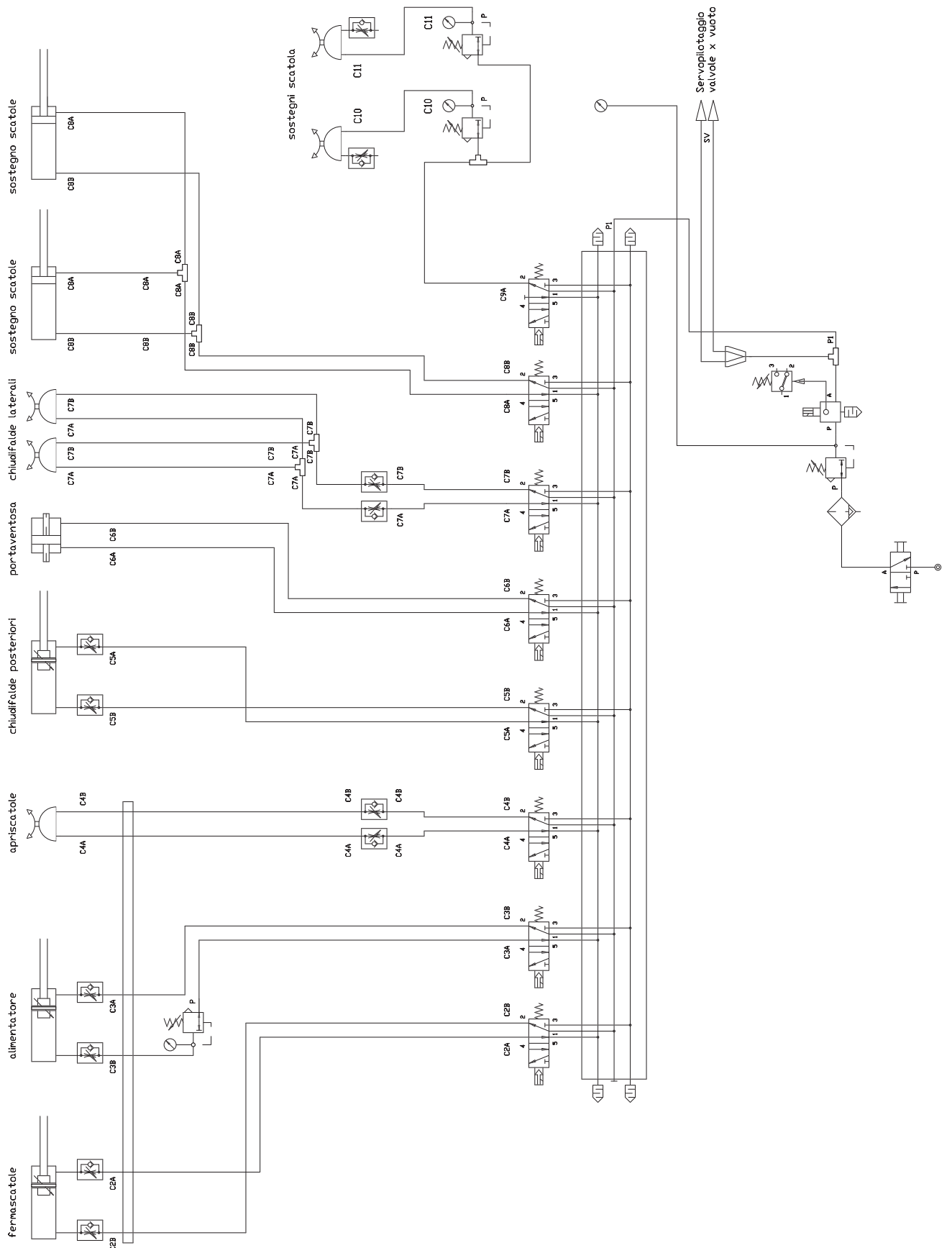
1 - Continuity of the ground circuit

2 - Insulation resistance

3 - High voltage insulation

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

16-DRAWINGS AND SCHEMATICS



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 projecteurs, 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:

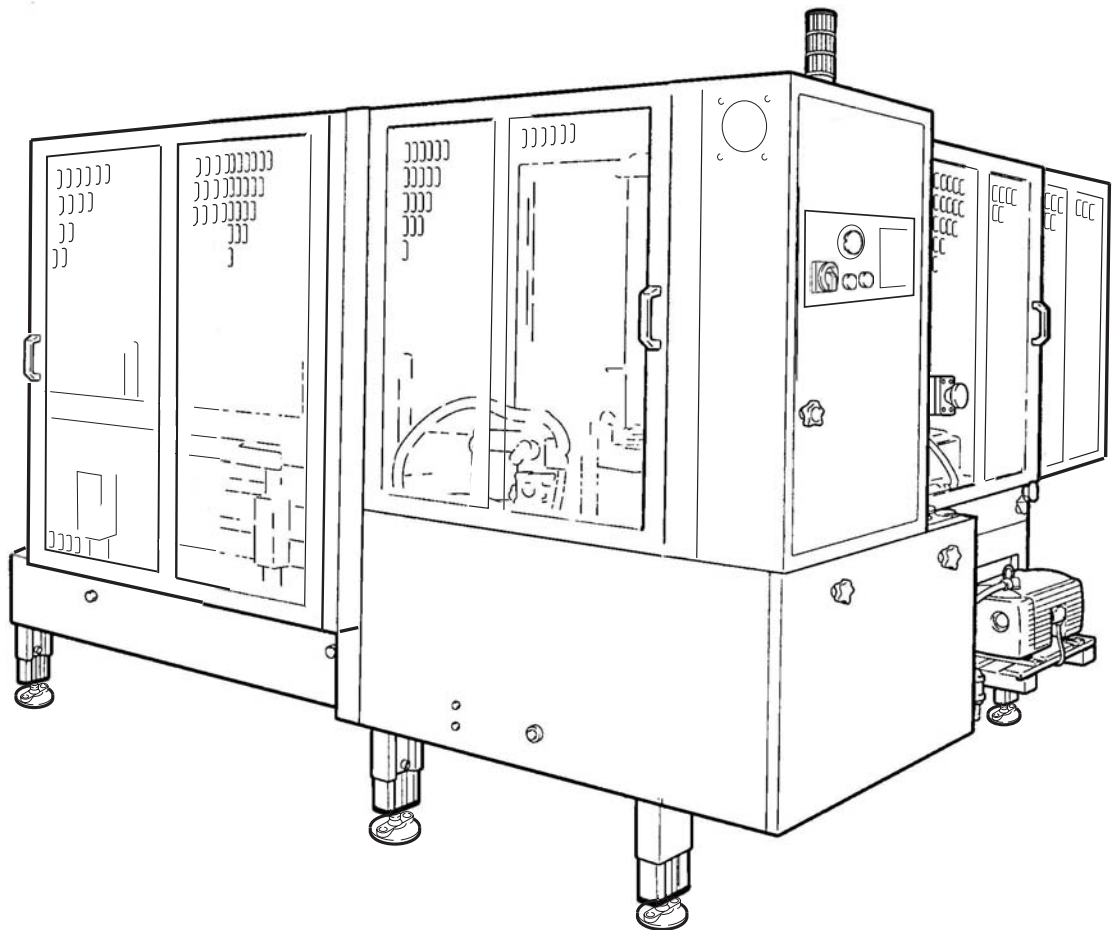
MODELO EXACTO DE LA MÁQUINA/ NÚMERO DE MATRÍCULA DE LA MÁQUINA/NÚMERO DE LA FIGURA DEL CATÁLOGO

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

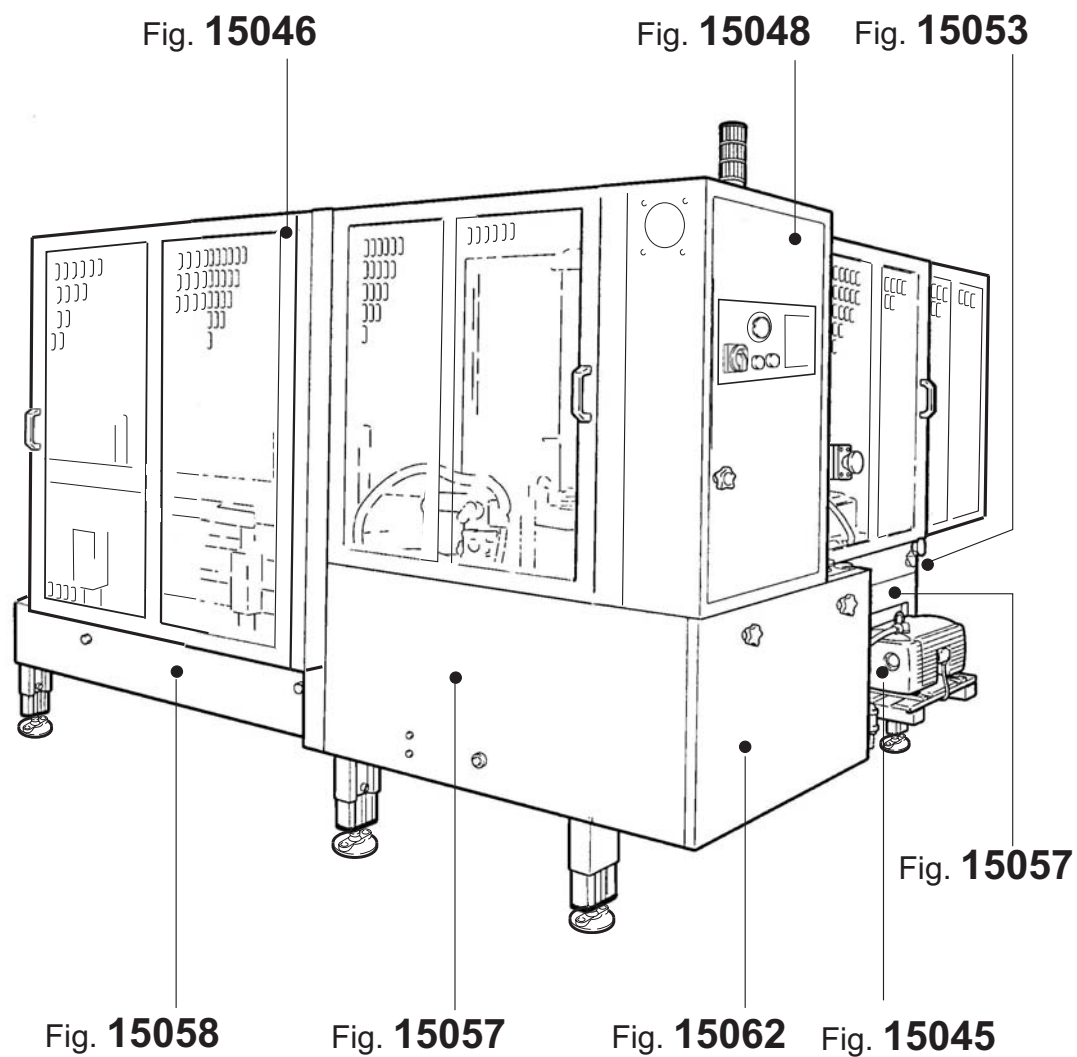
ATENCIÓN! LA MÁQUINA ES CONSTANTEMENTE MEJORADA POR LOS PROYECTISTAS, POR LO QUE EL CATÁLOGO DE RECABIOS ES ACTUALIZADO PERIÓDICAMENTE. ES INDISPENSABLE QUE TODOS LOS PEDIDOS DE PIEZAS DE RECAMBIO HAGAN MENCION DEL NÚMERO DE MATRÍCULA DE LA MÁQUINA, LEGIBLE EN LA PLACA METÁLICA DE IDENTIFICACIÓN DE LA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

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

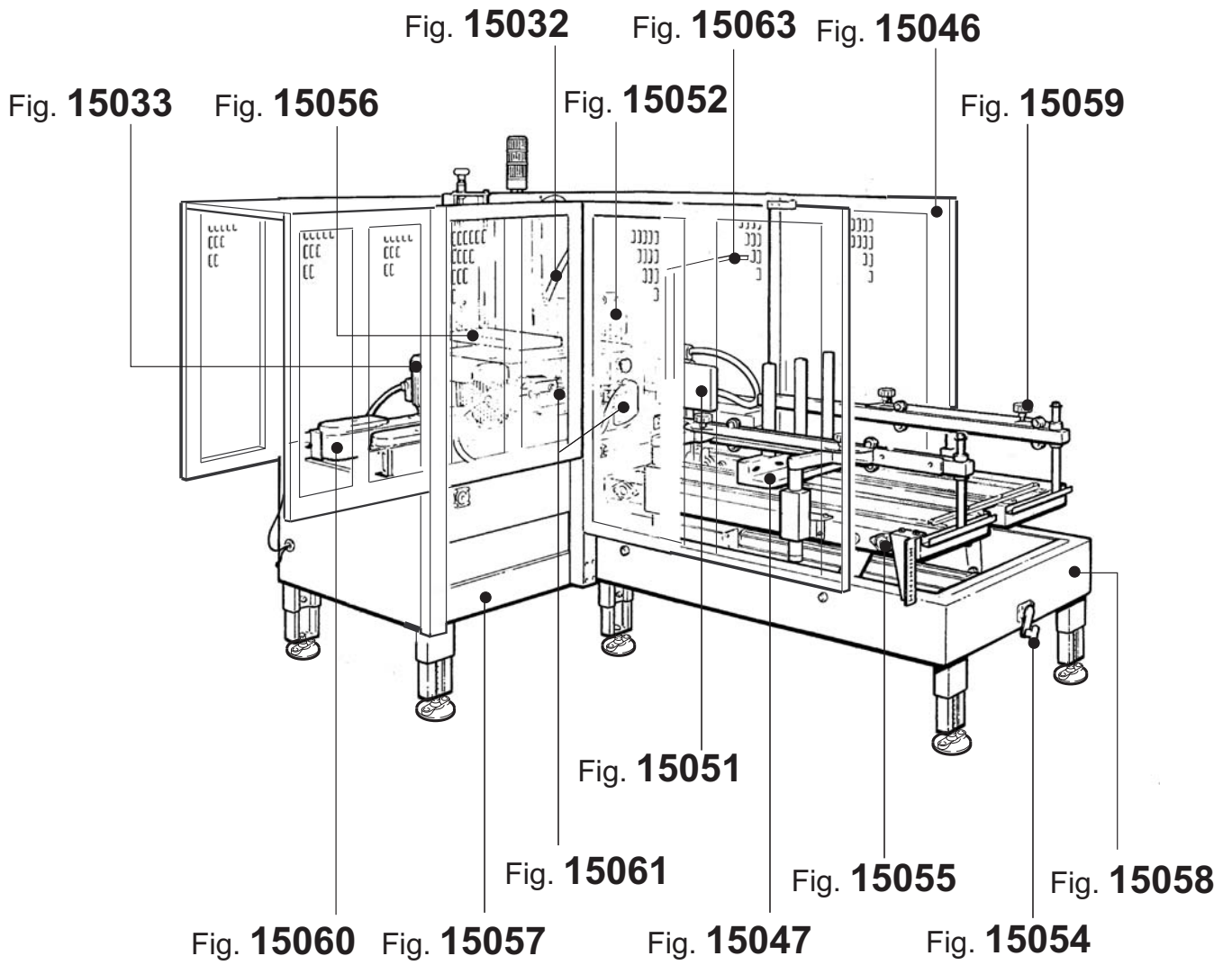


F344-SX

CATALOGO PARTI DI RICAMBIO
SPARE PARTS LIST



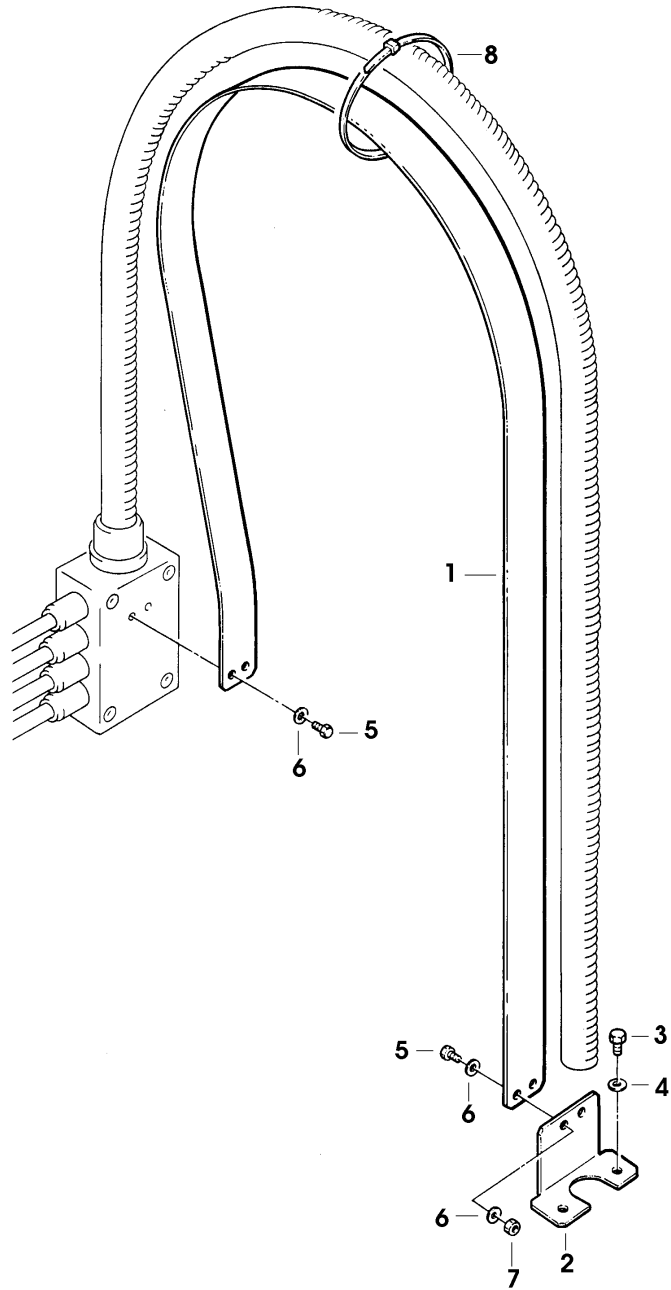
VISTA LATO COMANDI
VIEW CONTROL BOX SIDE



VISTA LATO ALIMENTATORE
FEEDING SIDE VIEW

15032 BANDELLA SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	1,0000	PZ	3.7.00172.47	S370017247Z	MOLLA BANDELLA SM481 GRIGIO A.
2	1,0000	PZ	3.2.04213.93	S320421393Z	SQUADRETTA ATTACCO BANDELLA
3	2,0000	PZ	3.4.00026.93	S340002693Z	VITE TE M6X16 ZINCATA
4	2,0000	PZ	3.4.00175.93	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
5	4,0000	PZ	3.4.00056.93	S340005693Z	VITE TE M5X10 ZINCATA
6	6,0000	PZ	3.4.00061.93	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
7	2,0000	PZ	3.4.00023.93	S340002393Z	DADO M5 ZINCATO
8	7,0000	PZ	3.8.00876	S3800876ZZZ	FASCETTA BIANCA 140X3,6

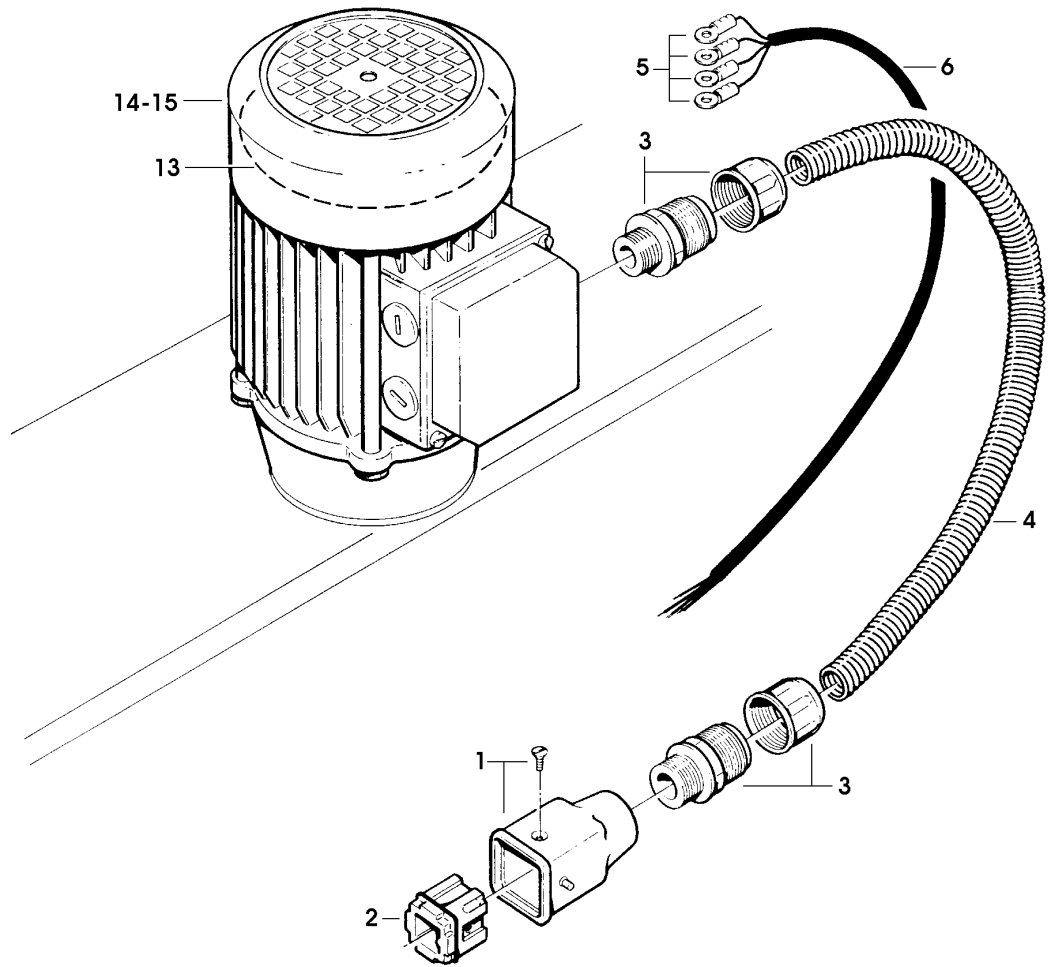


15033 MOTORI SEC0000087

F344-SX

FORMATORE AUTOMATICO

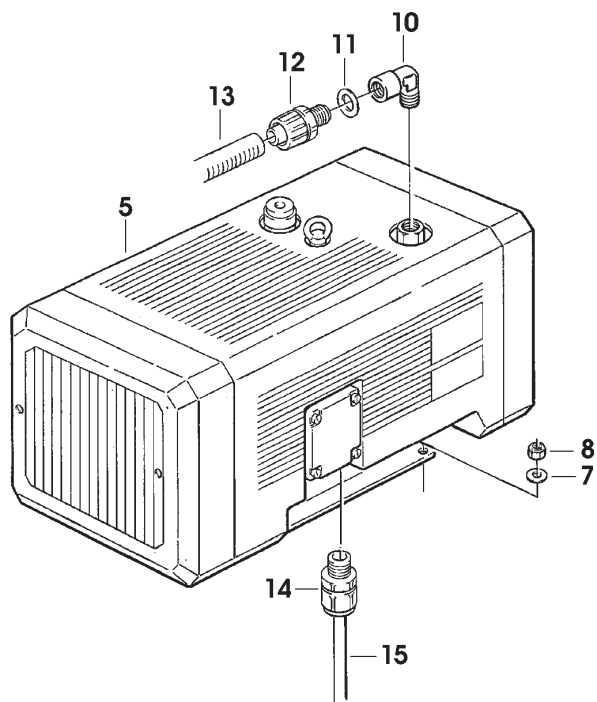
Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	2,0000	PZ	3.8.01458	S3801458ZZZ	CUSTODIA VOL.USCITA VERTI.PG11 105121
2	2,0000	PZ	3.8.01455	S3801455ZZZ	INSERTO MASCHIO 4 POLI 3P+T
3	4,0000	PZ	3.8.00936	S3800936A	RACCORDO PG11 PER GUAINA /12
4	2,0000	PZ	3.8.01758	S3801758ZZZ	GUAINA FLESSIBILE MM550 /12
5	8,0000	PZ	3.8.00145	S3800145ZZZ	TERMINALE A OCCHIELLO/4 ROSSO
6	1,0000	PZ	3.8.01703	S3801703ZZZ	CAVO VIN.4X1,5 MT.5 X 3F
13	2,0000	PZ	3.8.01885	S3801885ZZZ	VENTOLA X MOTORE SFACC.F.63
14	2,0000	PZ	3.8.03443	S3803443ZZZ	MOT MULTITENS H63 A4 KW0,12 B14 TIPO 2 "SM"
15	2,0000	PZ	3.8.03441	S3803441ZZZ	MOT MULTITENS H63 A4 KW0,12 B14 TIPO 1 "SM"



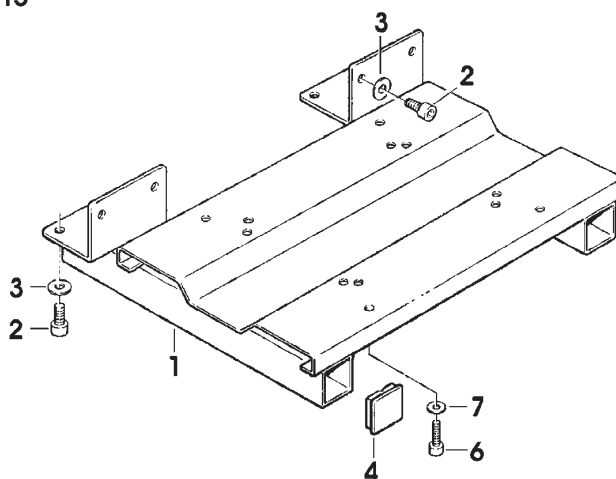
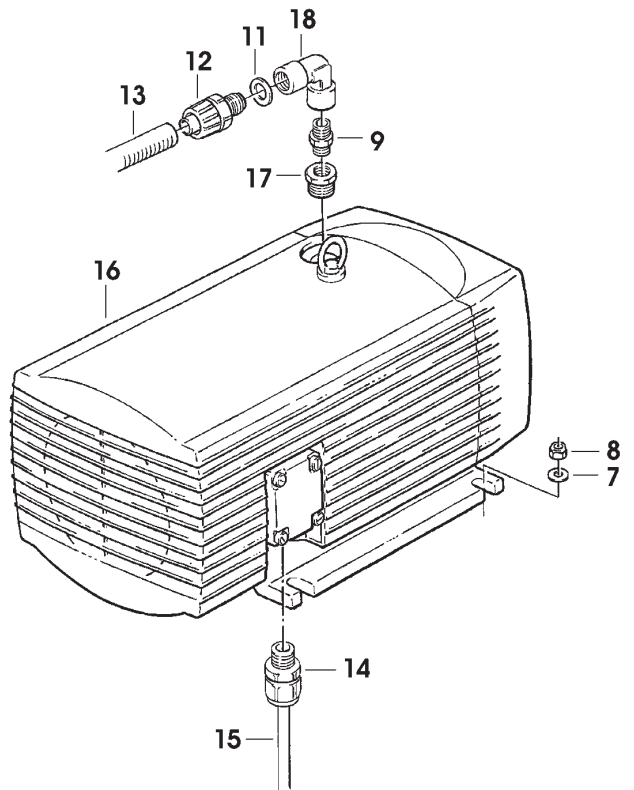
15045 POMPA VUOTO SEC0000087 F344-X FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	1,0000	PZ	4.4.06223.47A	S440622347A	SUPPORTO PER POMPA VUOTO ASS.
2	8,0000	PZ	3.4.00122.93	S340012293Z	VITE TCEI M8X20 ZINCATA
3	12,000	PZ	3.4.00655.93	S340065593Z	RONDELLA TRIPLA X VITE M8 ZINC
4	2,0000	PZ	3.4.01355.05	S340135505Z	PUNTALE QUADRO 40X40
5	1,0000	PZ	3.8.03434	S3803434ZZZ	POMPA X VUOTO VLT25 RIETSCHLE
6	4,0000	PZ	3.4.00015.93	S340001593Z	VITE TCEI M6X25 ZINCATA
7	8,0000	PZ	3.4.00033.93	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINC
8	4,0000	PZ	3.4.00258.93	S340025893Z	DADO AUTOBLOCCANTE M6 ZINC.
9	1,0000	PZ	3.8.02882	S3802882ZZZ	NIPPLO CONICO RA 012 1/2"-1/2"
10	1,0000	PZ	3.8.02883	S3802883ZZZ	RACC A GOMITO RA 022 1/2" - 1/2"
11	1,0000	PZ	3.8.01424	S3801424ZZZ	GUARNIZIONE 1/2"
12	1,0000	PZ	3.8.02872	S3802872ZZZ	RACCORDO RTPR-1/2" F144
13	1,0000	PZ	3.8.03067	S3803067ZZZ	ALPHA TUBO D.I. 16 METRI 1,8
14	1,0000	PZ	3.8.00854	S3800854ZZZ	BOCCHETTONE SKINTOP ST 16
15	1,0000	PZ	3.8.01703	S3801703ZZZ	CAVO VIN.4X1,5 MT.5 X 3F
16	1,0000	PZ	3.8.04274	S3804274ZZZ	POMPA PER VUOTO BECKER VT 4.25
17	1,0000	PZ	3.8.03198	S3803198ZZZ	RIDUZIONE RA O14 3/4 1/2
18	1,0000	PZ	3.8.04495	S3804495ZZZ	RACCORDO GOMITO RA 021-1/2-1/2

RIETSCHLE

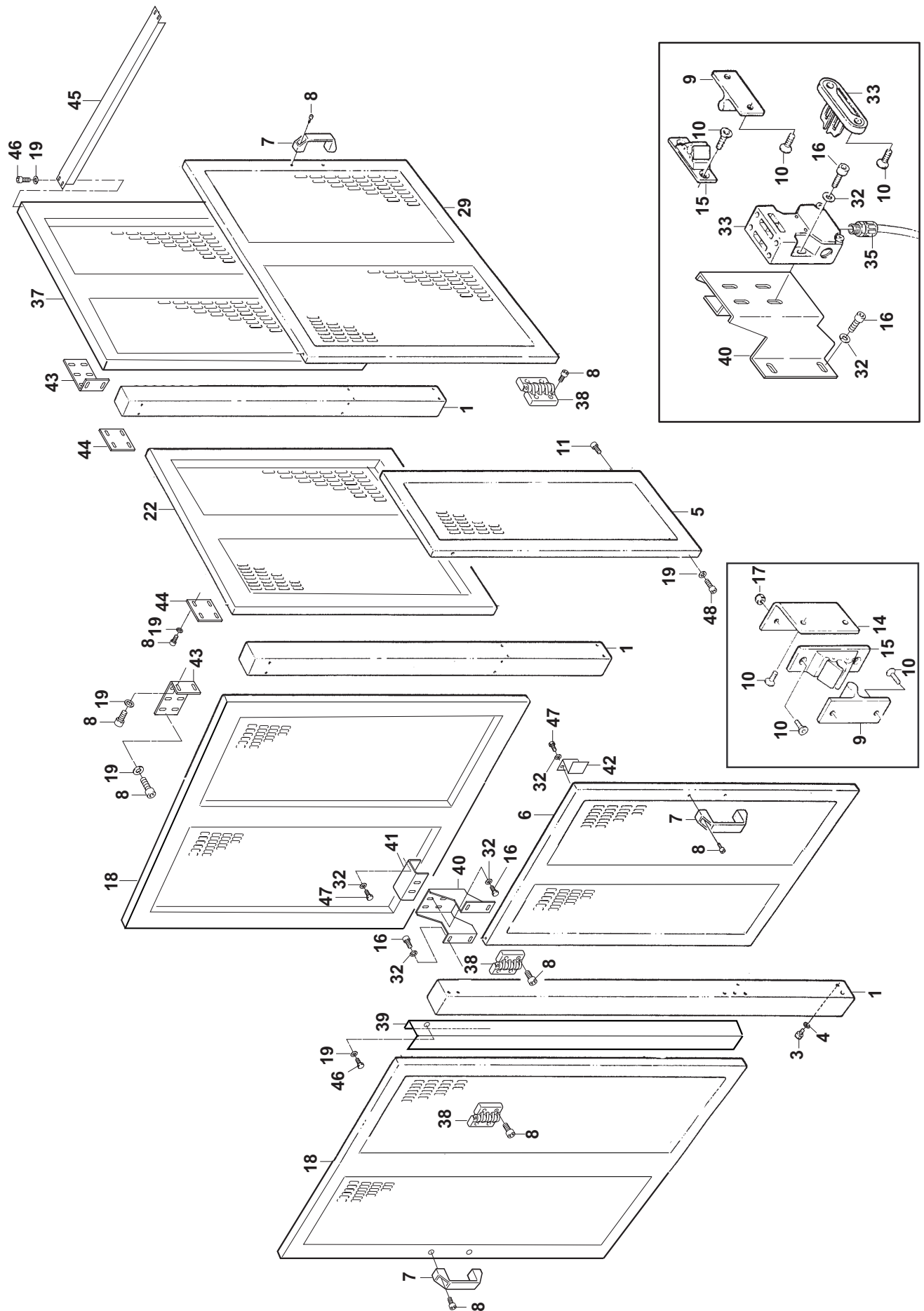


BECKER



15046 PROTEZIONE ANTINFORTUNISTICA SEC0000087 F144-SX FORMATORE AUTOMATICO

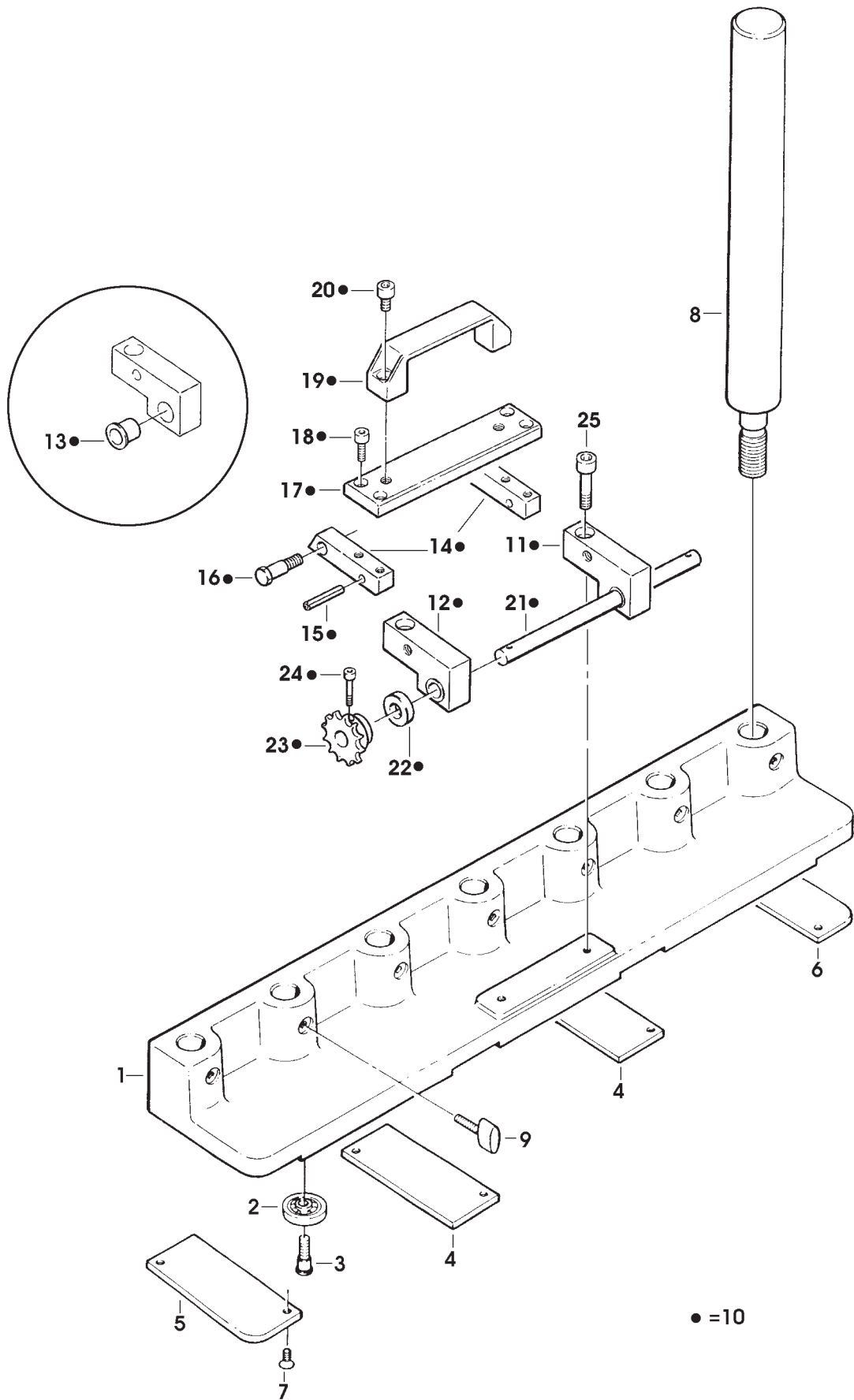
Pos.	Q.tà	UM	Codice	Descrizione
1	4	PZ	SBA0001499	ASSIEME MONTANTE C/INS.
3	16	PZ	S340058493Z	VITE TCEI M8X16 ZINCATA
4	16	PZ	S340220592Z	RANELLA DI SAFETY "S" (SCHNORR) /8 F144
5	1	PZ	SBA0001486	PROTEZIONE LATERALE C/INS.
6	1	PZ	SBA0001488	SPORTELLLO PROTEZIONE ANTERIORE C/INS.
7	3	PZ	S3801095ZZZ	MANIGLIA M443/110
8	82	PZ	S340016093Z	VITE TCEI M6X20 ZINCATA
9	2	PZ	S3401707ZZZ	AGGANCIO X BLOCCO A SCATTO T330
10	20	PZ	S340040393Z	VITE TSVEI M5X16 ZINCATA
11	2	PZ	S340005193Z	VITE TCEI M6X12 ZINCATA
14	1	PZ	S320424693Z	SQUADRETTA PER BLOCCAPORTA F144 ZINC.
15	2	PZ	S3401601ZZZ	BLOCCO A SCATTO SPEC.F144
16	12	PZ	S340010893Z	VITE TCEI M5X20 ZINCATA
17	2	PZ	S340025993Z	DADO AUTOBLOCCANTE M5 ZINCATO
18	2	PZ	SBA0004959	Protezione laterale aliment. c/ins.
19	91	PZ	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINC
22	1	PZ	SBA0004692	PROTEZIONE INTERNA FORMATORE C/INS
29	1	PZ	SBA0004693	PROTEZIONE USCITA FORMATORE C/INS
32	18	PZ	S340046893Z	RONDELLA TRIPLA X VITE M5 ZINC
33	2	PZ	S3802388ZZZ	FINECOR DI SAFETY CON STAF PER 800af
35	1	PZ	S3802139ZZZ	BOCCHETTONE SKINTOP ST11
37	2	PZ	SBA0004693	PROTEZIONE USCITA FORMATORE C/INS
38	6	PZ	S340398000A	CERN -ELESA- CFA.65 CH-6 COD.422232 SM1
39	1	PZ	SBA0004957	Distanziale protezione aliment. c/ins.
40	2	PZ	SBC0007493V	Supporto micro sportello alimentatore
41	1	PZ	SBA0004958	Spessore fiss. protez. laterale c/ins
42	1	PZ	SBC0007075V	SQUADRETTA ARRESTO PORTA
43	6	PZ	SBC0007080V	SQUADRETTA X PROTEZIONI
44	4	PZ	SBC0007078V	CERNIERA FISSA
45	1	PZ	SBC0007070V	TRAVERSINO PROTEZIONI FORMATORE F144
46	8	PZ	S340005793Z	VITE TE M6X20 ZINCATA
47	4	PZ	S340032993Z	VITE TE M5X16 ZINCATA
48	3	PZ	S340002693Z	VITE TE M6X16 ZINCATA



15047 SPINTORE SEC0000087 F344-SX

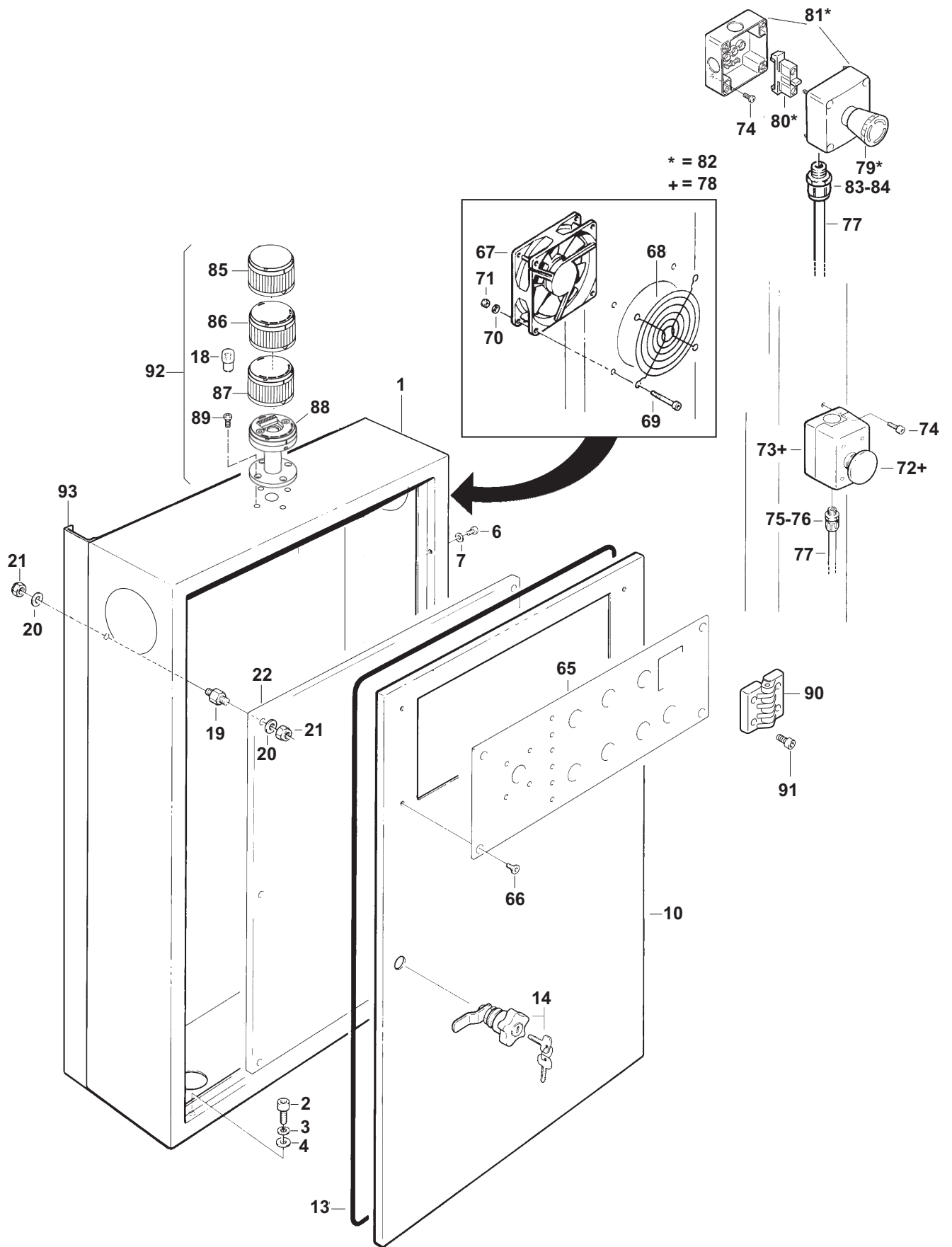
FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	1,0000	PZ	3.5.02527.17	S350252717Z	SPINTORE F144 VERN.
2	4,0000	PZ	3.4.00750	S3400750ZZZ	CUSCINETTO /33 RIVESTITO
3	4,0000	PZ	3.3.00069.93	S330006993Z	VITE CUSCINETTO /33 K SP.ZINC.
4	2,0000	PZ	3.1.01320.05	S310132005Z	INSERTO PER SPINTORE CENTRALE F144
5	1,0000	PZ	3.1.01321.05	S310132105Z	INSERTO PER SPINTORE DX F144
6	1,0000	PZ	3.1.01322.05	S310132205Z	INSERTO PER SPINTORE SX F144
7	8,0000	PZ	3.4.00223.93	S340022393Z	VITE TSVEI M6X10 ZINCATA
8	3,0000	PZ	3.3.11757.95	S331175795Z	COLONNA X SPINTORE F144
9	7,0000	PZ	3.4.01853	S3401853ZZZ	CHIAVETTA DI SERRAGGIO "ELESA" CT476/30 M6X20
10	1,0000	PZ	4.7.09624.00A	S470962400A	TRASCINAMENTO SPINTORE ASS.F144 DX
11	1,0000	PZ	4.3.04825	S4304825ZZZ	STAF DX ATTACCO SPINTORE ASS.F144 "Type C"
12	1,0000	PZ	4.3.04826	S4304826ZZZ	STAF SX ATTACCO SPINTORE ASS.F144 "Type C"
13	2,0000	PZ	3.4.01241	S3401241ZZZ	BRONZINA SINT. 12X16X20X2X12
14	2,0000	PZ	3.3.13329.93B	S331332993B	CERNIERA MOBILE SPINTORE F144 ZINCAT.
15	2,0000	PZ	3.4.02971	S3402971ZZZ	SPINA CILINDRICA RET 6X36
16	2,0000	PZ	3.3.13332.93	S331333293Z	PERNO CERNIERA F144 ZINCATO
17	1,0000	PZ	3.3.17625.93A	S331762593A	TRAVERSA PER STAFFE F144
18	4,0000	PZ	3.4.00577.93	S340057793Z	VITE TCEI M6X16 ZINCATA
19	1,0000	PZ	3.4.01864	S3401864ZZZ	MANIGLIA ELESA M443/140 N
20	2,0000	PZ	3.4.00584.93	S340058493Z	VITE TCEI M8X16
21	1,0000	PZ	3.3.17629.92A	S331762992A	ALBERO PER PIGNONI F144
22	2,0000	PZ	3.3.17627.93A	S331762793A	DISTANZIALE PER PIGNONI F144
23	2,0000	PZ	3.3.17628.93A	S331762893A	PIGNONE Z=14 3/8" F144
24	2,0000	PZ	3.4.00142.93	S340014293Z	VITE TCEI M4X25 ZINCATA
25	2,0000	PZ	3.4.00515.93	S340051593Z	VITE TCEI M8X35 ZINCATA
999	1,0000	PZ	4.7.06406	S4706406ZZZ	SPINTORE ASS.F144



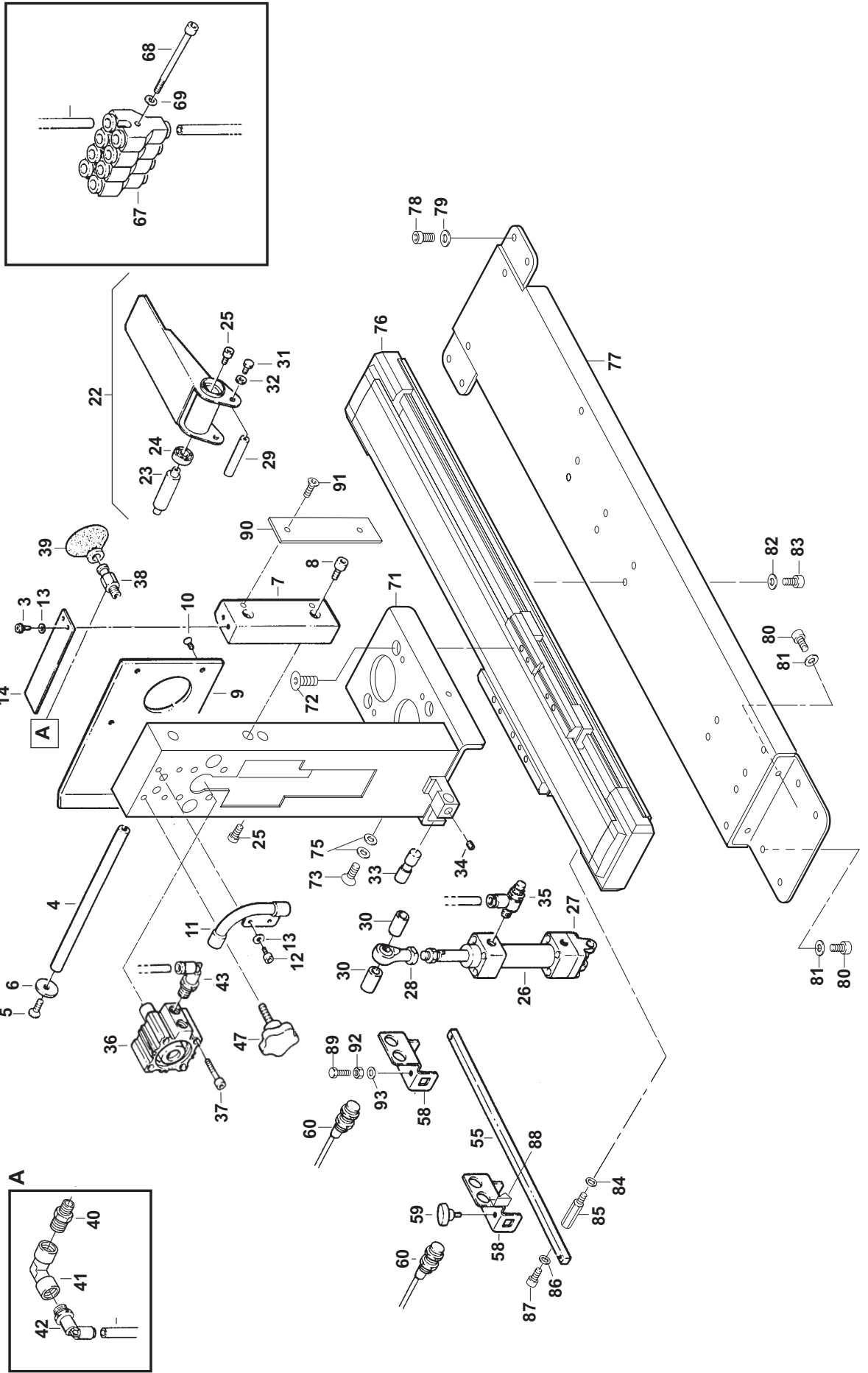
15048 QUADRO ELETTRICO SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
1	1	PZ	SBA0004975	Cassetta impianto elettrico c/ins.
2	4	PZ	S340012293Z	VITE TCEI M8X20 ZINCATA
3	4	PZ	S340006392Z	ROND ELAST.GROWER DIN 7980 (SEZ.QUADRATA
4	4	PZ	S340065593Z	RONDELLA TRIPLA X VITE M8 ZINC
6	4	PZ	S340174993Z	VITE TBEI M6X12 ZINC.
7	4	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
10	1	PZ	SBA0005242	Sportello cassetta imp.eletr.ass. F344
13	3	M	S340215405Z	3.4.02154.05 GOMMA SPUGNA F144
14	1	PZ	S3402130ZZZ	68123VC.309/40-UD SERRATURA PER PORTELL
18	3	PZ	S3800874ZZZ	LAMPADINA BA15D 5W 30V
19	4	PZ	S331164893Z	3.3.11648.93 DISTANZIALE PER Q.E. F144
20	8	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
21	8	PZ	S340028393Z	DADO AUTOBLOCCANTE M8 BASSO ZINCATO
22	1	PZ	S3204210LZZ	3.2.04210.LZ PANNELLO Q.E. F144 LAMIERA
65	1	PZ	SBC0008020V	Pannello pulsantiera F344
66	4	PZ	S340040393Z	VITE TSVEI M5X16 ZINCATA
67	2	PZ	S3803607ZZZ	VENTILATORE ASSIALE 92X92X25 24VDC F144
68	2	PZ	S3803608ZZZ	GRIGLIA DI PROTEZIONE MOD.92 F144
69	8	PZ	S340031593Z	VITE TCEI M4X35 ZINCATA
70	8	PZ	S340004393Z	RONDELLA PIANA X VITE M4 ZINC.
71	8	PZ	S340000193Z	DADO M4 ZINCATO
72	1	PZ	S3802110ZZZ	CUSTODIA IN PLASTICA GIALLA 800E-1PY, E-
73	1	PZ	S3803648ZZZ	PULSANTE EMERGENZA /60 800EP-
74	2	PZ	S340010893Z	VITE TCEI M5X20 ZINCATA
75	1	PZ	S3802139ZZZ	BOCCHETTONE SKINTOP ST11
76	1	PZ	S3802143ZZZ	CONTRODADO GMP11
77	1	PZ	S3802310ZZZ	CAVO FROR 07 2X1 (5 M)
78	1	PZ	S471169000A	PULSANTE EMERGENZA ASS.SM/XL "ALLEN BRA
79	1	PZ	S3805198ZZZ	PULSANTE EMERG. 3SB3000-1HA20
80	1	PZ	S3805197ZZZ	CONTATTO NC 3SB3420-0C
81	1	PZ	S3805196ZZZ	SCATOLA GIALLA 3SB3801-0AC
82	1	PZ	S471168900A	PULSANTE EMERGENZA ASS.SM/XL "SIEMENS"
83	1	PZ	S3802141ZZZ	BOCCHETTONE SKINTOP ST13,5
84	1	PZ	S3802144ZZZ	CONTRODADO GMP13,5
85	1	PZ	S3804914A	MODULO LUM.ROSSO 855T-B00XN4
86	1	PZ	S3804915A	MODULO LUM.ARANCIO 855T-B00XN5
87	1	PZ	S3804913ZZZ	MODULO LUM.VERDE 855T-B00XN3
88	1	PZ	S380620800A	BASE+COPERCHIO SU ASTA 855T-BPM10C A.B.
89	4	PZ	S340011293Z	VITE TCEI M5X16 ZINCATA
90	2	PZ	S340398000A	CERN -ELESA- CFA.65 CH-6 COD.422232 SM1
91	8	PZ	S340057793Z	VITE TCEI M6X16 ZINCATA
92	1	PZ	S470970900A	COLONNA LUMINOSA ASS.CON LAMP. F144/F145
93	1	PZ	SBC0007627V	Montante cassetta impianto elettrico



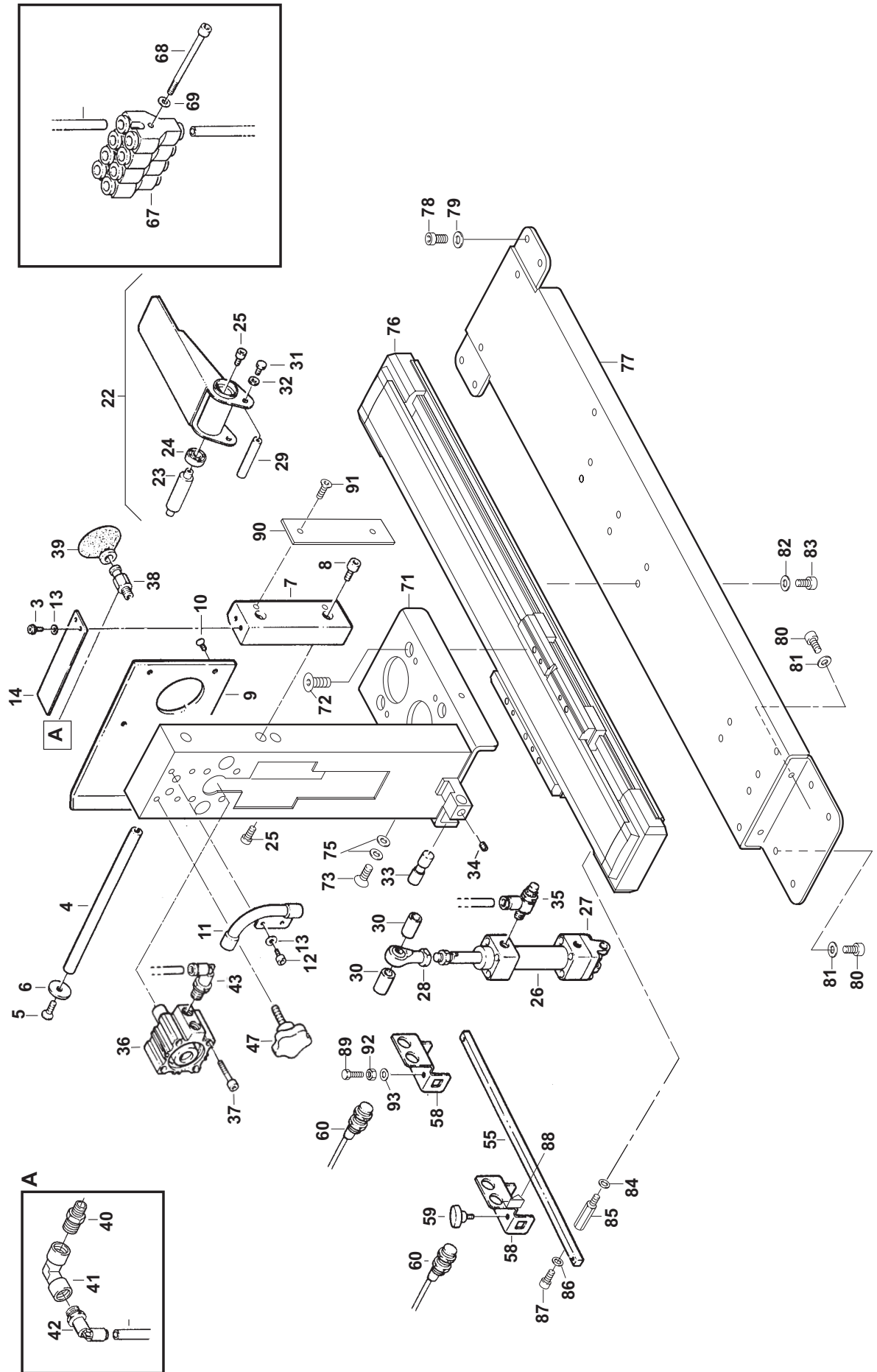
15051 SPINTORE CHIUDIFALDA POST. SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
4	2	PZ	S331166683Z	ASTA X CARRELLO /16X250 F144
5	2	PZ	S340004893Z	VITE TSVEI M8X16 ZINCATA
6	2	PZ	S331169193Z	RONDELLA SVASATA /8,5-25-5 F144
7	1	PZ	S332540295A	SPINTORE F144
8	2	PZ	S340048693Z	VITE TCEI M8X25 ZINCATA
9	1	PZ	S320454195Z	PIASTRA PER CARRELLO POSTER. F144-DX
10	4	PZ	S340005393Z	VITE TSVEI M6X16 ZINCATA
11	1	PZ	S440486347B	CURVA CON STAFFA F144 SX
12	2	PZ	S340011293Z	VITE TCEI M5X16 ZINCATA
13	2	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
14	1	PZ	S320440195B	PIASTRINA X RIGHELLA MILLIM. F144
15	2	PZ	S340037193Z	VITE TE M5X12 ZINCATA
22	1	PZ	S4304519ZZZ	CHIUDIFALDA POST.C/CUSCINETTI F144
23	1	PZ	S331166092Z	PERNO X CHIUDIFALDA POST.F144
24	2	PZ	S3400166ZZZ	CUSCINETTO 6001-2RS
25	2	PZ	S340005193Z	VITE TCEI M6X12 ZINCATA
26	1	PZ	S3802851ZZZ	CILINDRO C65 D 32-60 C F144 CON CERNIERA
27	1	PZ	S3802853ZZZ	CERNIERA C65 D32 F144
28	1	PZ	S340101093Z	TESTA A SNODO M10X1,25 ZINCATA
29	1	PZ	S330004190Z	PERNO /10X66 FOSFATATO
30	2	PZ	S331169393Z	DISTANZIALE /10,2-16-26 F144
31	2	PZ	S340002193Z	VITE TE M6X12 ZINCATA
33	1	PZ	S331165892Z	PERNO ATTACCO CILINDRO F144
34	1	PZ	S340179492Z	GRANO EIPC M6X8
35	2	PZ	S3802929ZZZ	REGOLAT.DI FLUSSO AS 2201F 01-06S F144
36	1	PZ	S3802402ZZZ	CILINDRO DN-50C ECQ 2B 50-10D SM44/S
37	6	PZ	S340013793Z	VITE TCEI M6X50 ZINCATA
38	1	PZ	S332377300A	PORTAVENTOSA POSTERIORE FORMATORI
39	1	PZ	S3802869ZZZ	VENTOSA 01.65.28 F144
40	1	PZ	S3802186ZZZ	NIPPLO CONICO 1/4"-1/8" 700R
41	1	PZ	S3801107ZZZ	RACCORDO RA 021 1/4"-1/4"
42	1	PZ	S3802358ZZZ	RACCORDO GOMITO KQL08-02S 800af
43	2	PZ	S3802357ZZZ	RACCORDO GOMITO KQL06-02S 800af
47	1	PZ	S340268205Z	VOLANTINO "ELESA"VC.192-50-M8X 25 F144 K
55	1	PZ	S331166893Z	GUIDA X SENSORE F144
58	2	PZ	S321257093A	SUPPORTO SENSORE F144
59	1	PZ	S3401853ZZZ	CHIAVETTA DI SERRAGGIO "ELESA" CT476/30
60	2	PZ	S3802411ZZZ	INTER DI PROSSIMITA` E2ELX5F12MBYOMG-L
67	4	PZ	S3801683ZZZ	RACCORDO Y FEMM.LEGRIS31400600
68	1	PZ	S340140793Z	VITE TCEI M4X55 ZINCATA
69	2	PZ	S340004393Z	RONDELLA PIANA X VITE M4 ZINC.
71	1	PZ	SBA0005180	CARRELLO POSTERIORE ASSEMBLATO
72	4	PZ	S340004893Z	VITE TSVEI M8X16 ZINCATA
73	1	PZ	S340004893Z	VITE TSVEI M8X16 ZINCATA
75	2	PZ	S330595193Z	RONDELLA 5,5X/20X4
76	1	PZ	SCC0001065	ATTUATORE ELET. LG1H21Y20PC-500-FW-X2
77	1	PZ	SBA0005137	PIASTRA ASSE POSTERIORE ASSEMBLATA
78	4	PZ	S340048693Z	VITE TCEI M8X25 ZINCATA
79	4	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
80	6	PZ	S340012293Z	VITE TCEI M8X20 ZINCATA
81	6	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
82	8	PZ	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINC
83	8	PZ	S340060193Z	VITE TCEI M6X18 ZINCATA
84	2	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.



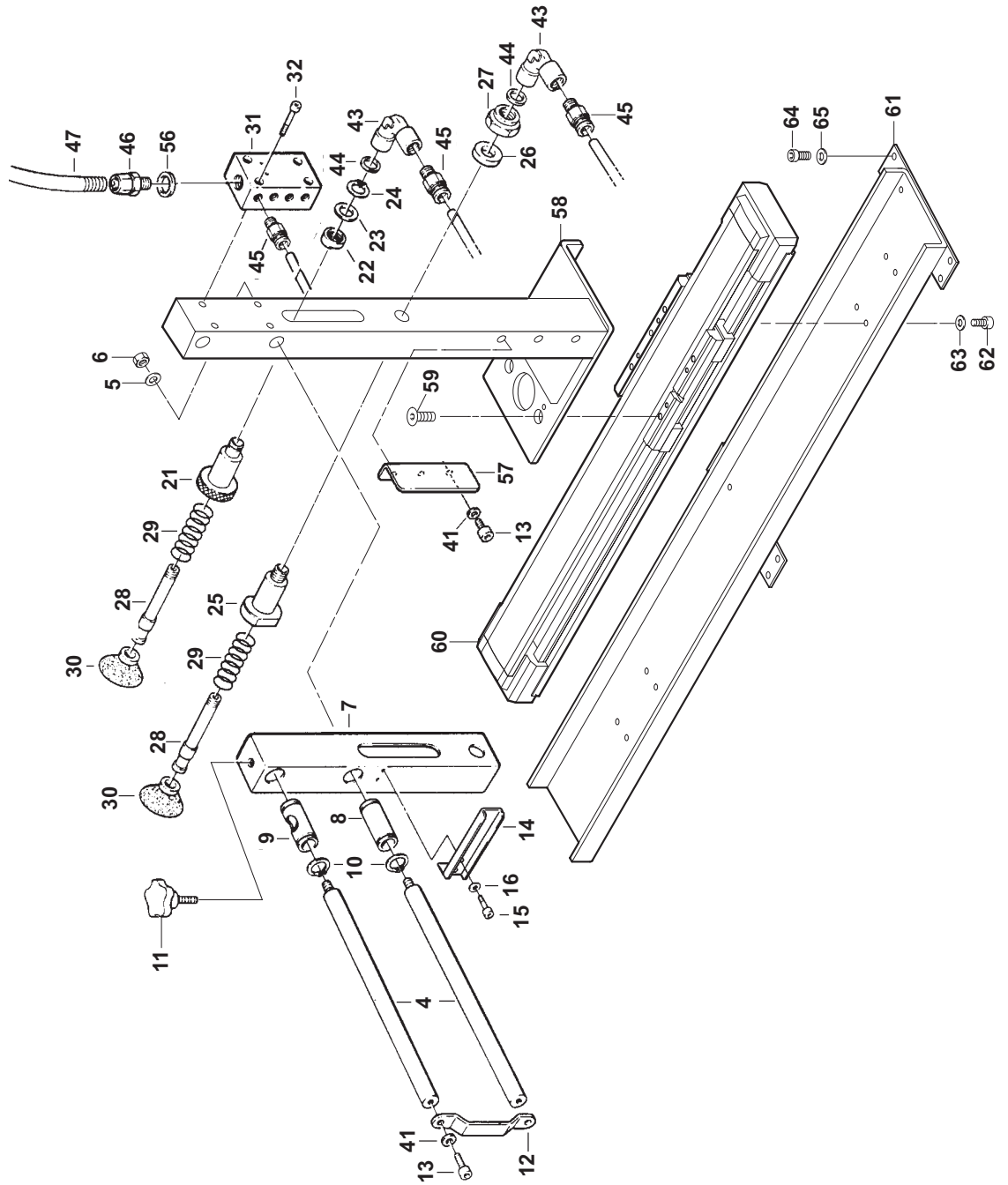
15051 SPINTORE CHIUDIFALDA POST. SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
85	2	PZ	SBC0008292T	Perno fissaggio guida sensore F344
86	2	PZ	S340220392Z	RANELLA DI SAFETY "S" (SCHNORR) /5 F144
87	2	PZ	S340010893Z	VITE TCEI M5X20 ZINCATA
88	1	PZ	SBC0008583	Indicatore righella carrello post. F344
89	1	PZ	S340027093Z	VITE TE M6X25 ZINCATA
90	1	PZ	SBC0008298	Piastrina per spintore F344
91	2	PZ	S340051693Z	VITE TSVEI M5X12 ZINCATA
92	1	PZ	S340000293Z	DADO M6 ZINCATO
93	1	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.



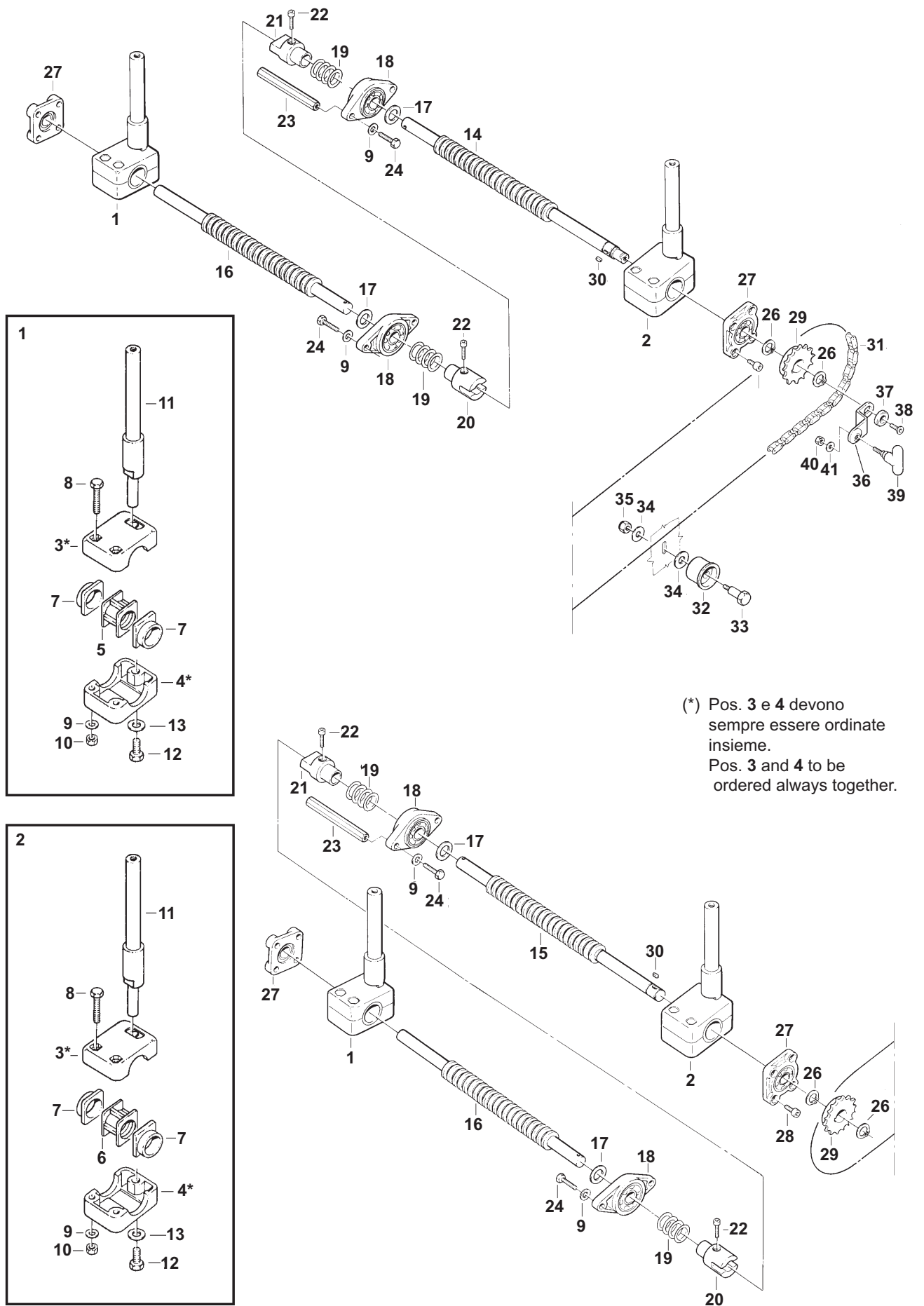
15052 CARRELLO PORTAVENTOSE SEC0000087 F344-S X FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
4	2	PZ	S331167483B	ASTA /20X400 F144
5	4	PZ	S340021993Z	RONDELLA PIANA X VITE M10 ZINC
6	2	PZ	S340043893Z	DADO AUTOBLOCCANTE M10 BASSO
7	1	PZ	S450452217Z	PORTAVENTOSA MOBILE C/INS.F144
8	1	PZ	S3101205ZZZ	BUSSOLA PASSANTE F144 PER PORTAVENTOSA
9	1	PZ	S3101237ZZZ	BUSS INF.PER CARR PORTAVEN F144
10	4	PZ	S340039992Z	ANELLO ARRESTO PER ALBERO /28
11	1	PZ	S340268205Z	VOLANTINO "ELESA"VC.192-50-M8X 25 F144 K
12	1	PZ	S320442117Z	FERMO X CARRELLO PORTAVENTOSE F144
13	5	PZ	S340012293Z	VITE TCEI M8X20 ZINCATA
14	1	PZ	S320918693A	PIASTR FERMACAVI PER CARR F144 ZINC.
15	2	PZ	S340011993Z	VITE TCEI M5X10 ZINCATA
16	2	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
21	2	PZ	S331167092Z	SUPPORTO PORTAVENTOSA REGOL. F144
22	2	PZ	S331167292Z	DADO FISSAGGIO VENTOSE F144
23	6	PZ	S320429898Z	RONDELLA /20-30-1 X PORTAVENT. F144
24	2	PZ	S340003792Z	ANELLO ARRESTO X ALBERO /18 BR
25	2	PZ	S331167192Z	SUPPORTO PORTAVENTOSA FISSO F144
26	2	PZ	S330439893Z	RONDELLA /20,5/30X5
27	2	PZ	S350051593Z	DADO SPEC.AUTOBLOCC.M20X1 ZINC
28	4	PZ	S3311669ZZZ	PORTAVENTOSA F144
29	4	PZ	S370026592Z	MOLLA X VENTOSE F144
30	4	PZ	S3802869ZZZ	VENTOSA 01.65.28 F144
31	1	PZ	S331243095Z	DISTRIBUTORE PER VUOTO F144-DX
41	13	PZ	S340220592Z	RANELLA DI SAFETY "S" (SCHNORR) /8 F144
43	4	PZ	S3801107ZZZ	RACCORDO RA 021 1/4"-1/4"
44	4	PZ	S3800884ZZZ	GUARNIZIONE 1/4"
45	8	PZ	S3801393ZZZ	RACCORDO DIRITTO 31010813 CF13
46	1	PZ	S380565400A	PORTAGOMMA 454 - /16 - 1/2" F144
47	1	PZ	S3803068ZZZ	ALPHA TUBO D.I. 16 METRI 1,5 r1
56	1	PZ	S3801424ZZZ	GUARNIZIONE 1/2"
57	1	PZ	S320707793A	SQUADRETTA CONTRASTO DECELERATORE F145
58	1	PZ	SBA0005178	CARRELLO PORTAVENTOSE ASSEMBLATO
59	4	PZ	S340004893Z	VITE TSVEI M8X16 ZINCATA
60	1	PZ	SCC0001066	ATTUATORE ELET. LG1H21Y20NC-800-FW-X10
61	1	PZ	SBA0005133	PIASTRA ASSE PORTAVENTOSE ASSEMBLATA
62	8	PZ	S340060193Z	VITE TCEI M6X18 ZINCATA
63	8	PZ	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINC
64	8	PZ	S340012293Z	VITE TCEI M8X20 ZINCATA
65	8	PZ	S340065593Z	RONDELLA TRIPLA X VITE M8 ZINC



15053 REGOLAZIONE GUIDE MOTORIZZ. SEC0000087 F344-SX FORMATORE AUTOMATICO

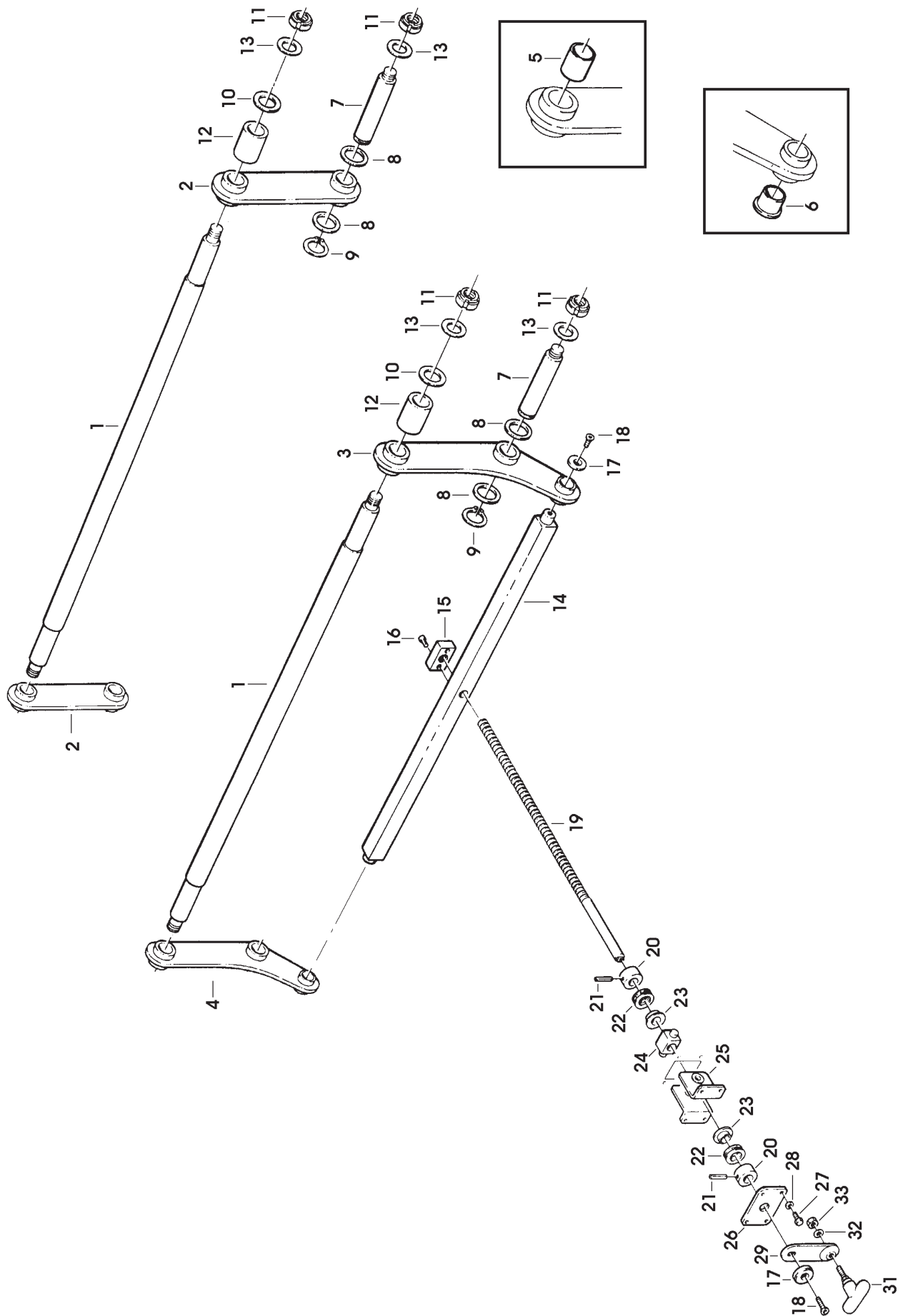
Pos.	Q.tà	UM	Codice	Descrizione
1	2	PZ	S4706397ZZZ	BLOCCHETTO DX COMANDO MOTORIZZ ASS.F144
2	2	PZ	S4706398ZZZ	BLOCCHETTO SX COMANDO MOTORIZZ ASS.F144
3	4	PZ	S3502484ZZZ	(C) SEMICORPO SUP.BLOC VITE 800a/3M
4	4	PZ	S3502483ZZZ	(C) SEMICORPO INF.BLOC VITE 800a/3M
5	2	PZ	S3101103ZZZ	CHIOCCIOLA X BLOCCH.VITI DX 800a/3M
6	2	PZ	S3101107ZZZ	CHIOCCIOLA X BLOCCH.VITI SX 800a/3M
7	8	PZ	S3502485ZZZ	BUSSOLA X BLOCCHETTI VITI 800a/3M
8	8	PZ	S340032593Z	VITE TE M6X50 ZINC.
9	16	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
10	8	PZ	S340025893Z	DADO AUTOBLOCCANTE M6 ZINC.
11	4	PZ	S331172393Z	PERNO FISSAGGIO MOTORIZZ.F144
12	4	PZ	S340028093Z	VITE TE M8X20 ZINCATA
13	4	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
14	1	PZ	S332189490A	VITE CONDOTTA CENTR GUIDE F145 W=400 FOS
15	1	PZ	S332188890A	VITE CON ATTACCO MANOV F145 W=400 FOSFAT
16	2	PZ	S332189590A	VITE CENTRATURA GUIDE FOSFAT. F145 W=400
17	4	PZ	S331074693Z	DISTANZIALE VITE/CUSCINETTO 800a/3M
18	4	PZ	S4304359ZZZ	FLANGIA CENTRALE C/CUSCINETTO 800a/3M
19	4	PZ	S370024793Z	MOLLA /20,5X30X2,8 800a/3M
20	2	PZ	S331027393Z	INNESTO X VITE CENTRATURA 800a/3M
21	2	PZ	S331075493Z	INNESTO MASCHIO X VITE CEN 800a/3M
22	4	PZ	S340014293Z	VITE TCEI M4X25 ZINCATA
23	4	PZ	S331178793Z	DISTANZIALE ES.10X116 F144
24	8	PZ	S340026793Z	VITE TE M6X30 ZINCATA
26	4	PZ	S340006792Z	ANELLO ELASTICO X ALBERO D.15
27	4	PZ	S430435800A	SUPPORTO EST.VITE C/CUSCINETTO 800a/3M
28	16	PZ	S340011293Z	VITE TCEI M5X16 ZINCATA
29	2	PZ	S331023393Z	(C) PIGNONE 3/8" Z=16 800a/3M
30	2	PZ	S3400700ZZZ	LINGUETTA 5X5X10.
31	1	PZ	S3401927ZZZ	SPEZZONE CAT 133 PASSI RING CHIUS.3/8"9
32	1	PZ	S3101035ZZZ	RULLINO TENDICATENA 200A-3M
33	1	PZ	S330831793Z	PERNO RULLINI TENDICAT.12A-S2
34	2	PZ	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINC
35	1	PZ	S340025893Z	DADO AUTOBLOCCANTE M6 ZINC.
36	1	PZ	S320710093A	LEVA PER MANOVELLA SPEC.F145
37	1	PZ	S330221593A	RONDELLA /6,5/30X5
38	1	PZ	S340005393Z	VITE TSVEI M6X16 ZINCATA
39	1	PZ	S470173200A	MANOPOLA ASS.GIALLO RAL 1018 SERIE "SM"
40	1	PZ	S340000293Z	DADO M6 ZINCATO
41	1	PZ	S340220492Z	RANELLA DI SAFETY "S" (SCHNORR) /6 F144



(*) Pos. 3 e 4 devono sempre essere ordinate insieme.
 Pos. 3 and 4 to be ordered always together.

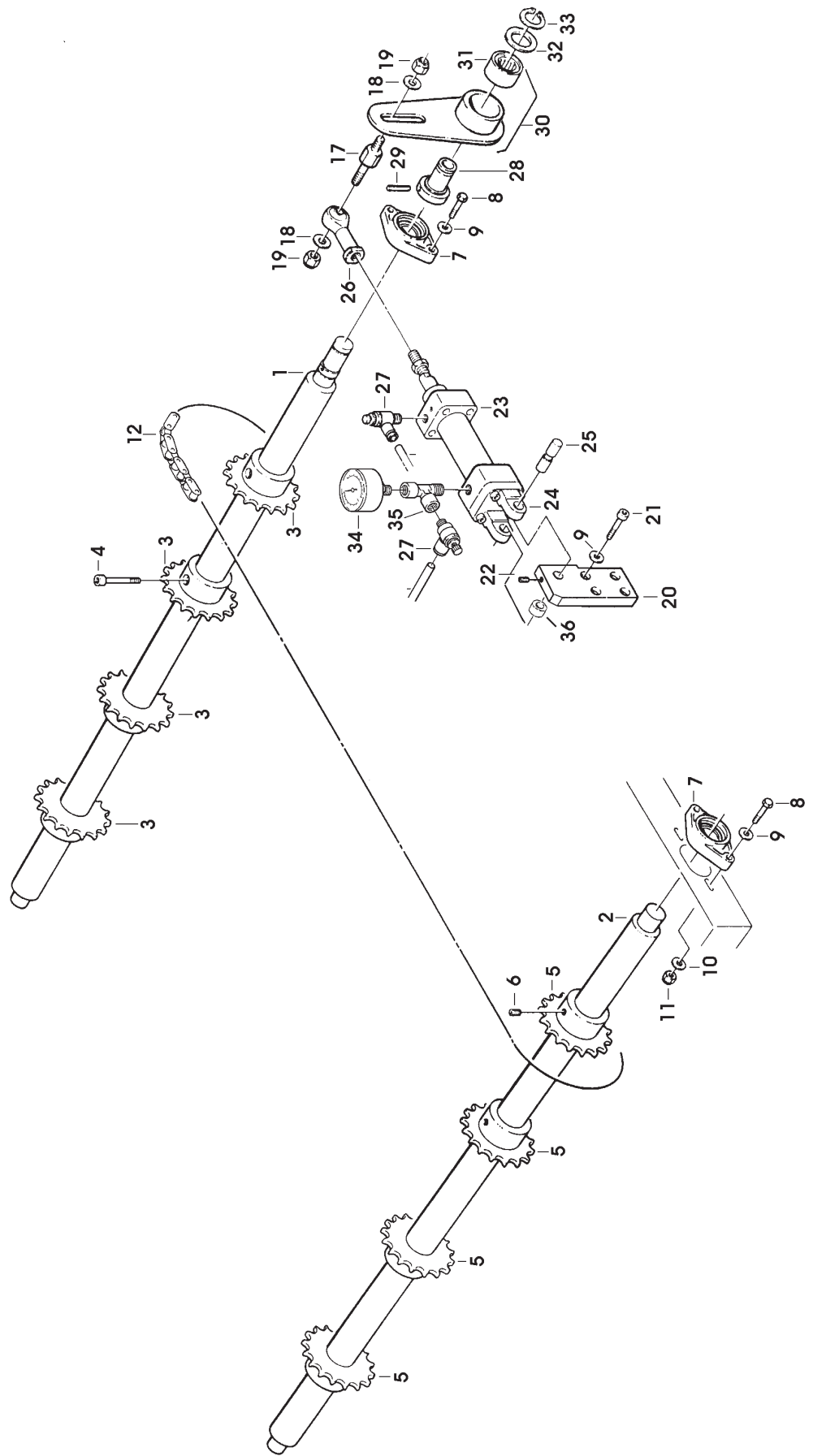
15054 SOLLEVAM.PIANO ALIMENTATORE SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
1	2	PZ	S331175890C	PERNO PER ALIMENTATORE F144 FOSFAT.
2	2	PZ	S4304522ZZZ	LEVA CON BUSSOLE F144
3	1	PZ	S4304524ZZZ	LEVA SX CON BUSSOLE F144
4	1	PZ	S4304523ZZZ	LEVA DX CON BUSSOLE F144
5	8	PZ	S3402149ZZZ	BUSSOLA KU /25/28X30 F144
6	2	PZ	S3402150ZZZ	BUSSOLA FLANGIATA KU /18/20/26 X 17 F144
7	4	PZ	S331175292Z	PERNO X LEVE ALIMENT.F144
8	8	PZ	S331175593Z	RONDELLA X PERNI LEVE ALIMENT. F144
9	4	PZ	S340010492Z	ANELLO ARRESTO X ALBERO /25 BR
10	4	PZ	S331175393Z	RONDELLA X PIANO ALIMENT.F144
11	8	PZ	S350051593Z	DADO SPEC.AUTOBLOCC.M20X1 ZINC
12	4	PZ	S331175493Z	DISTANZ.X LEVE PIANO F144
13	8	PZ	S330871493Z	RONDELLA SPEC.20,5X35X5 F144
14	1	PZ	S331176493Z	TIRANTE X VITE SOLLEV.F144
15	1	PZ	S3311762ZZZ	CHIOCCIOLA F144
16	2	PZ	S340010893Z	VITE TCEI M5X20 ZINCATA
17	3	PZ	S330221593A	RONDELLA /6,5/30X5
18	3	PZ	S340005393Z	VITE TSVEI M6X16 ZINCATA
19	1	PZ	S331176093Z	VITE X SOLLEVATORE F144
20	2	PZ	S330873693Z	BUSSOLA SPINATA
21	2	PZ	S3400273ZZZ	SPINA ELASTICA / 4X28
22	2	PZ	S3400247ZZZ	CUSCINETTO REGGISPINTA 51103
23	2	PZ	S3101228ZZZ	BUSSOLA X REGGISPINTA F144
24	1	PZ	S3500780ZZZ	BLOCCHETTO PER VITE
25	2	PZ	S450421393Z	SQUAD CON BUSS SM11 12AF/XL33/35/36
26	1	PZ	S320185247Z	PIASTRINA CON ASOLA SML2-XL33- XL35
27	4	PZ	S330787693Z	VITE TE M6X16 SPEC.
28	4	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
29	1	PZ	S320086793Z	LEVA X MANOPOLA SM/XL/3M
31	1	PZ	S470173200A	MANOPOLA ASS.GIALLO RAL 1018 SERIE "SM"
32	1	PZ	S340220492Z	RANELLA DI SAFETY "S" (SCHNORR) /6 F144
33	1	PZ	S340000293Z	DADO M6 ZINCATO



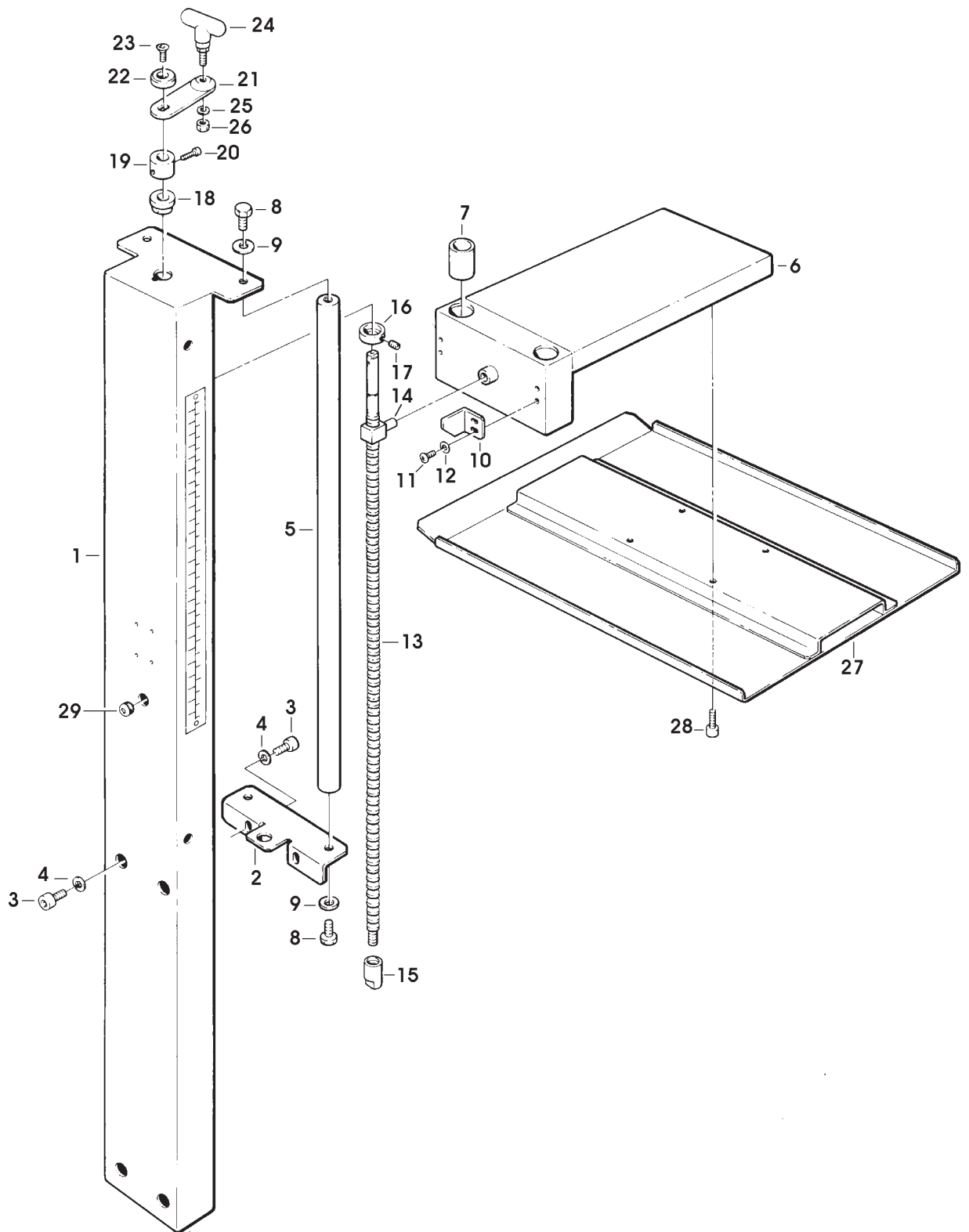
15055 AVANZAMENTO SCATOLE SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
1	1	PZ	S331176390B	ALBERO INGR.CONDUTTORI F144
2	1	PZ	S331176590B	ALBERO INGR.CONDOTTI F144
3	4	PZ	S331173490C	PIGNONE Z=24 3/8" FISS.VITE F144 FOSFATA
4	4	PZ	S340050093Z	VITE TCEI M6X40 ZINCATA
5	4	PZ	S331173590Z	(C) PIGNONE Z=24 3/8" FISS.CON
6	4	PZ	S340179492Z	GRANO EIPC M6X8
7	4	PZ	S4304525ZZZ	FLANGIA CON CUSCINETTO F144
8	8	PZ	S340027093Z	VITE TE M6X25 ZINCATA
9	12	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
10	4	PZ	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINC
11	4	PZ	S340025893Z	DADO AUTOBLOCCANTE M6 ZINC.
12	4	PZ	S340215394Z	CAT RING CHIUSO NIKELATA 3/8" 228 PS.GI
17	1	PZ	S331174793Z	PERNO ATTACCO TESTA A SNODO F144
18	2	PZ	S340021993Z	RONDELLA PIANA X VITE M10 ZINC
19	2	PZ	S340043893Z	DADO AUTOBLOCCANTE M10 BASSO
20	1	PZ	S332601393A	STAFFA ATTACCO CILINDRO F144
21	4	PZ	S340002093Z	VITE TCEI M6X30 ZINCATA
22	1	PZ	S340015492A	GRANO M5X8 BR.
23	1	PZ	S3802850ZZZ	CIL C65 D 32-40 C F144 (CON CERN)
24	1	PZ	S3802853ZZZ	CERNIERA C65 D32 F144
25	1	PZ	S331165892Z	PERNO ATTACCO CILINDRO F144
26	1	PZ	S340101093Z	TESTA A SNODO M10X1,25 ZINCATA
27	2	PZ	S3802929ZZZ	REGOLAT.DI FLUSSO AS 2201F 01-06S F144
28	1	PZ	S331264997Z	BUSSOLA X PERNO TEMPRATA F144
29	1	PZ	S340227392Z	SPINA ELASTICA /5X40 F144
30	1	PZ	S4304615ZZZ	BIELLA CON TORRINGTON F144-SX
31	1	PZ	S3402268ZZZ	TORRINGTON RCB-162117 F144
32	1	PZ	S331265192Z	RONDELLA SPEC.F144 F104
33	1	PZ	S340010492Z	ANELLO ARRESTO X ALBERO /25 BR
34	1	PZ	S3803690ZZZ	MANOM SCALA MPa 0-0.4 SM/XL/3M per JAP
35	1	PZ	S380572000A	RACCORDO A -T- A02518 F144 - F145
36	1	PZ	S331004193Z	DISTANZIALE X TIRANTI LEVE XL45-800AF



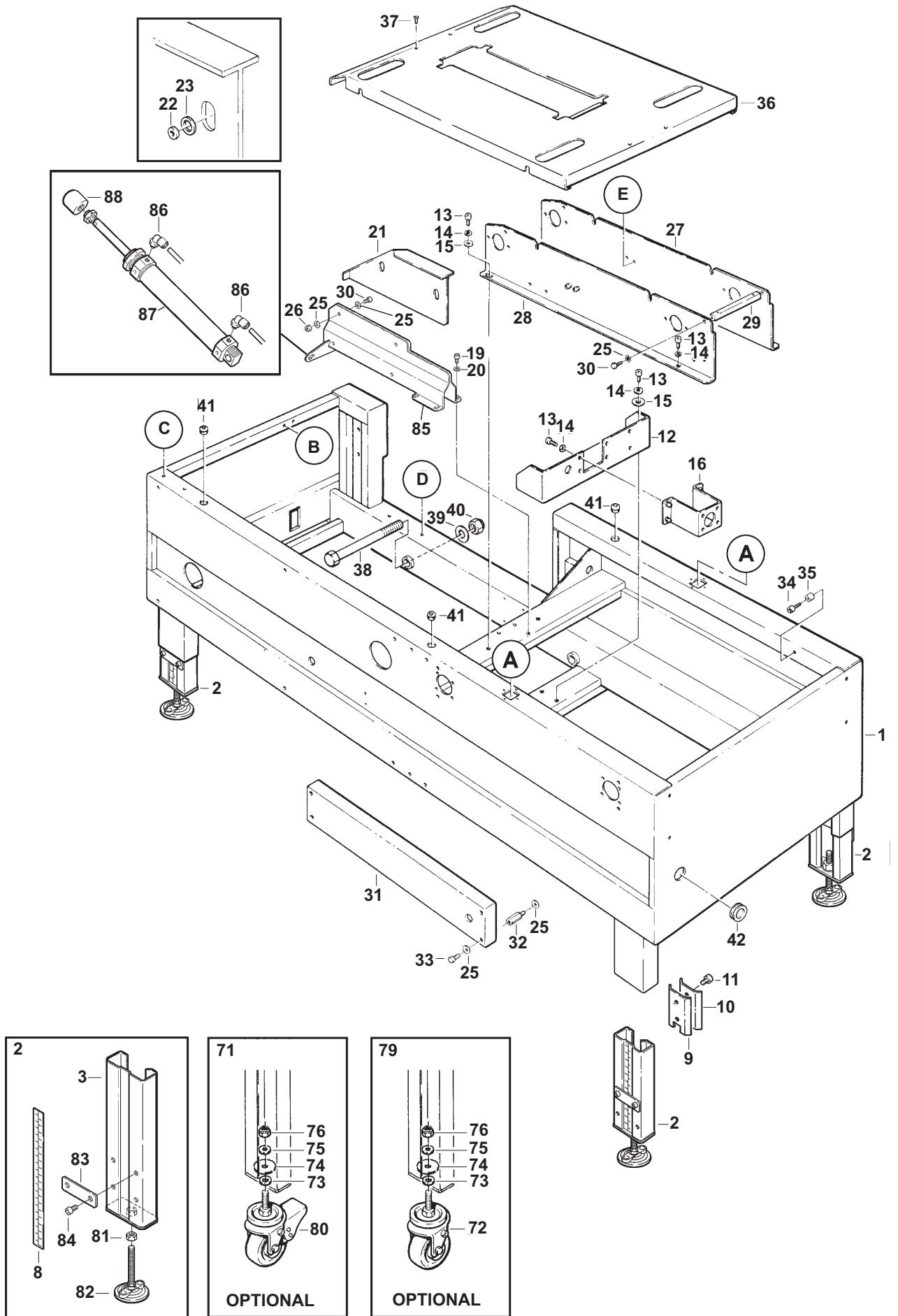
15056 COLONNA/PRESSATORE SUPERIORE SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
1	1	PZ	S450449247Z	COLONNA C/INS.F144
2	1	PZ	S320430847Z	STAFFA INF.COLONNA F144
3	6	PZ	S340012293Z	VITE TCEI M8X20 ZINCATA
4	6	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
5	2	PZ	S332532383A	ASTA Ø25 x 760 PER COLONNA F144 - HM145
6	1	PZ	S4304520ZZZ	CARRELLO X COLONNA C/BUSSOLE F144
7	4	PZ	S3402149ZZZ	BUSSOLA KU /25/28X30 F144
8	4	PZ	S340032193Z	VITE TE M10X20 ZINCATA
9	4	PZ	S340220692Z	RANELLA DI SAFETY "S" (SCHNORR) /10 F144
10	1	PZ	S320461893Z	SQUADRETTA X RIGHELLA MILLIM. F144
11	2	PZ	S340000593Z	VITE TCBCR M4X6 ZINC.
12	2	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
13	1	PZ	S330620193Z	VITE SOLLEVAMENTO
14	1	PZ	S3309572ZZZ	CHIOCCIOLA PER VITE SM11
15	1	PZ	S3311705ZZZ	BUSSOLA DI GUIDA X VITE SOLL. F144
16	1	PZ	S350179193Z	BUSSOLA X VITE SOLLEV. 200A-700A 3M
17	1	PZ	S340059992Z	GRANO EIPP M6 X 8
18	1	PZ	S3100583ZZZ	BUSSOLA
19	1	PZ	S331200993Z	BUSSOLA FISSAGGIO VITE SOLLEV. F144
20	1	PZ	S340014293Z	VITE TCEI M4X25 ZINCATA
21	1	PZ	S320086793Z	LEVA X MANOPOLA SM/XL/3M
22	1	PZ	S330221593A	RONDELLA /6,5/30X5
23	1	PZ	S340005393Z	VITE TSVEI M6X16 ZINCATA
24	1	PZ	S470173200A	MANOPOLA ASS.GIALLO RAL 1018 SERIE "SM"
25	1	PZ	S340220492Z	RANELLA DI SAFETY "S" (SCHNORR) /6 F144
26	1	PZ	S340000293Z	DADO M6 ZINCATO
27	1	PZ	S440726298B	SCIVOLO SUPERIORE ASS.INOX F145 W=400
28	4	PZ	S340057793Z	VITE TCEI M6X16 ZINCATA
29	1	PZ	S3801216ZZZ	PASSACAVO GOMMA PER FORO /16.5



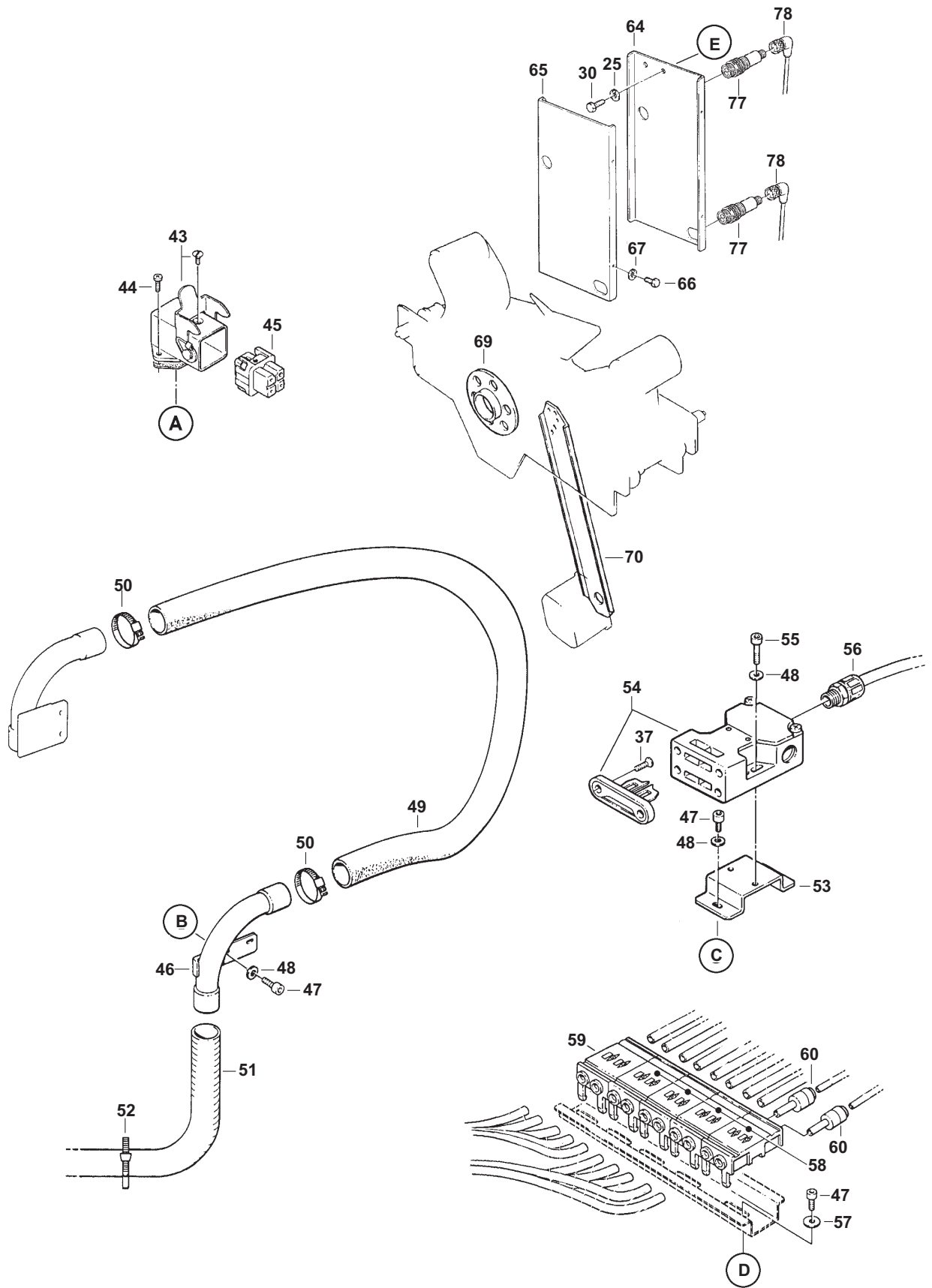
15057 BANCALE FORMATORE SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
1	1	PZ	S450482147Z	BANC FORMAT CON INS. F144A-SX KYOWA
2	4	PZ	S471368700A	GAMBA SCORREVOLE FORMATORE ASS F144 SIAT
3	4	PZ	S450571517Z	GAMBA SCORR.FORMATORE CON RIV. F144/146
8	4	PZ	S300117997A	RIGHELLA MILLIM.F144/145
9	4	PZ	S320485993Z	MORSETTO FILETTATO X GAMBE 3MJ
10	4	PZ	S320085993Z	STAFFA ESTERNA SM/XL/3M
11	8	PZ	S340058493Z	VITE TCEI M8X16 ZINCATA
12	1	PZ	S450493593Z	SUPPORTO ASTE GUIDE C/INSERTI F144 SX
13	12	PZ	S340012293Z	VITE TCEI M8X20 ZINCATA
14	12	PZ	S340220592Z	RANELLA DI SAFETY "S" (SCHNORR) /8 F144
15	6	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
16	1	PZ	S450448793Z	STAFFA ATTACCO CILINDRO C/INS. F144
18	1	PZ	S320432547Z	SUPPORTO SX CHIUDIF.ANT.F144
19	4	PZ	S340057793Z	VITE TCEI M6X16 ZINCATA
20	4	PZ	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINC
22	2	PZ	S331174993Z	DISTANZ.X GUIDASCATOLE F144
23	2	PZ	S3101222ZZZ	RONDELLA VULKOLLAN F144
24	2	PZ	S340005793Z	VITE TE M6X20 ZINCATA
25	18	PZ	S340220492Z	RANELLA DI SAFETY "S" (SCHNORR) /6 F144
26	2	PZ	S340025893Z	DADO AUTOBLOCCANTE M6 ZINC.
27	1	PZ	S320432905Z	SPALLA DX PORTA UNITA' F144
28	1	PZ	S320433005Z	SPALLA SX PORTA UNITA' F144
29	2	PZ	S330913593Z	DISTANZIALE PER SPALLE ZINCATO
30	6	PZ	S340002693Z	VITE TE M6X16 ZINCATA
31	1	PZ	S320433247Z	CARTER CATENA F144
32	4	PZ	S331177393Z	DISTANZ.X CARTER CATENA F144
33	4	PZ	S340002193Z	VITE TE M6X12 ZINCATA
34	4	PZ	S340001593Z	VITE TCEI M6X25 ZINCATA
35	4	PZ	S330721693Z	DISTANZIALE D.6,5/10X10,5 SM8
36	1	PZ	S320917298A	PIANO DI SCORRIMENTO INOX F145-400
37	6	PZ	S340051693Z	VITE TSVEI M5X12 ZINCATA
38	2	PZ	S340216893Z	VITE TE M20X220 F144
39	2	PZ	S330439893Z	RONDELLA /20,5/30X5
40	2	PZ	S340216993Z	DADO AUTOBLOCCANTE M20 NORMALE
41	3	PZ	S3801215ZZZ	PASSACAVO GOMMA CON MEMBR "EZ DG13,5" PE
42	1	PZ	S3802269ZZZ	PASSACAVO GOMMA X FORO /38
43	2	PZ	S3801459ZZZ	CUSTODIA PANNELLO C/USCITA LAT 104235
44	4	PZ	S340001193Z	VITE TC CROCE AUTOFIETT.6PX9 TESTA D.6,
45	2	PZ	S3801456ZZZ	INSERTO FEMMINA 3P+T
46	1	PZ	S440516647Z	SQUADRETTA CON CURVA F144 DX
47	6	PZ	S340031893Z	VITE TCEI M5X12 ZINCATA
48	6	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
49	1	PZ	S340221305Z	TUBO IPDM70 /20/30X1000 F144
50	2	PZ	S3402214ZZZ	FASCETTA STRINGITUBO /24-36
51	1	PZ	S3803069ZZZ	GUAINA FLESSIBILE NERA /22 (CM.67) F144
52	1	PZ	S3801080ZZZ	FASCETTA CABLAGG.NERA 180X4,6
53	1	PZ	S450454193Z	SUPP.INTERRUTT.C/INS.F144
54	1	PZ	S3802388ZZZ	FINECOR DI SAFETY CON STAF PER 800af



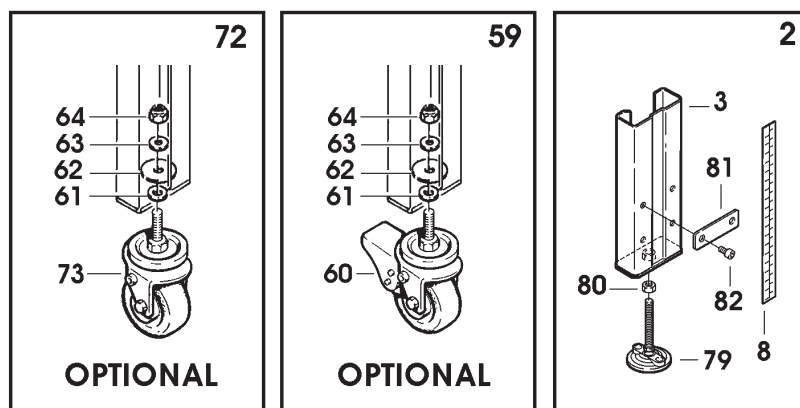
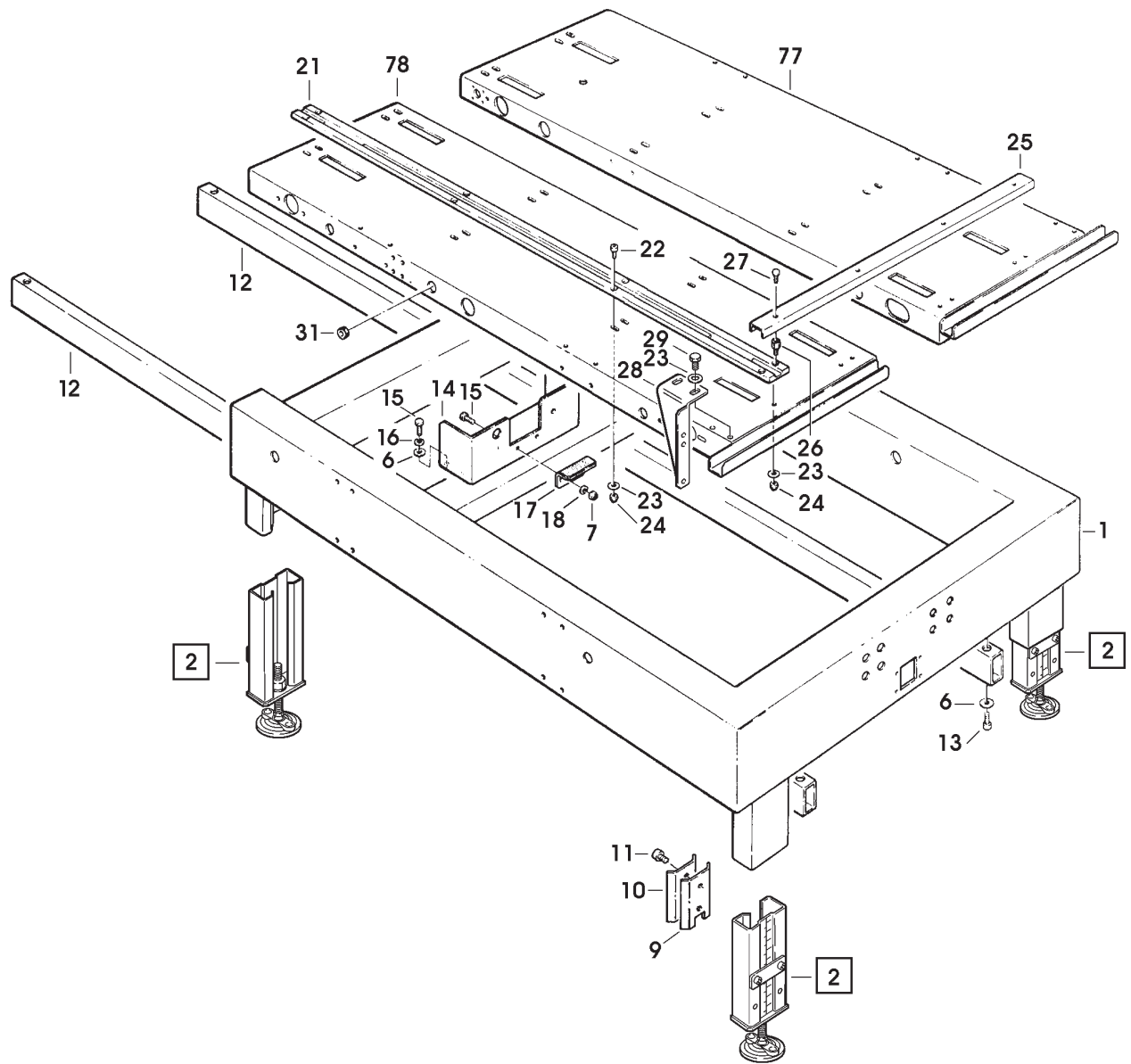
15057 BANCALE FORMATORE SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
55	2	PZ	S340010893Z	VITE TCEI M5X20 ZINCATA
56	1	PZ	S3802139ZZZ	BOCCHETTONE SKINTOP ST11
57	2	PZ	S340046893Z	RONDELLA TRIPLA X VITE M5 ZINC
58	4	PZ	S3802905ZZZ	RACCORDO MULTIPLO 33790600 F144
59	1	PZ	S3802906ZZZ	RACCORDO MULTIPLO 33790800 F144
60	2	PZ	S3800743ZZZ	RIDUZIONE A CODA 31660406
61	1	PZ	S3803070ZZZ	GUAINA FLESSIBILE NERA /22 (CM.78) F144
62	1	PZ	S3803071ZZZ	GUAINA FLESSIBILE NERA /22
63	2	PZ	S3801405ZZZ	FASCETTA BIANCA L=530X8
64	1	PZ	S450493393Z	SUPP FTC INF.CON INSERTI F144
65	1	PZ	S320465693Z	CARTER X SUPP.FOTOCCELLULE F144 KYOWA
66	4	PZ	S340002993Z	VITE TE M4X10 ZINCATA
67	4	PZ	S340220292Z	RANELLA DI SAFETY "S" (SCHNORR) /4 F144
69	1	PZ	S310127205Z	DISCO GENERATORE DI IMPULSI X K11-F144
70	1	PZ	S320468693Z	BRACCIO PORT.SPEC.X K11-F144
71	3	PZ	S4705543ZZZ	RUOTA /100 ASS.800af
72	3	PZ	S3401356ZZZ	RUOTA /100 POLIDERNY (DERBY)
73	4	PZ	S320245593Z	DISTANZIALE PER RUOTE SM481
74	4	PZ	S320145093Z	RONDELLA SPECIALE /12/45,5X4
75	4	PZ	S340006293Z	RONDELLA PIANA X VITE M12 ZINC
76	4	PZ	S340073593Z	DADO M12 AUTOBLOCCANTE
77	2	PZ	S3802449ZZZ	FOTOCCELLULA E3F2-DS10B4-P1 3M
78	2	PZ	S3802450ZZZ	CONNETTORE ELWIKI 4012 PG7
79	1	PZ	S471019000A	RUOTA SENZA FRENO ASS.F144/145
80	1	PZ	S3403097ZZZ	RUOTA /100 IN POLIDERNIL SENZA FRENO
81	4	PZ	S340037293Z	DADO M16 M.A. ZINC.
82	4	PZ	S340382600A	PIEDINO 312525 LV.F-100-24-M16 x98 - F
83	4	PZ	S321153793A	PIASTRINA FISSAGGIO GAMBA
84	8	PZ	S340058493Z	VITE TCEI M8X16 ZINCATA
85	1	PZ	SBA0005619V	Piegafalde anteriore ass. F344
86	2	PZ	S3800660A	RACCORDO GOMITO GIR.31990610
87	1	PZ	S3805302ZZZ	CILINDRO CD85N25-150C-B
88	1	PZ	S310209405A	PUNTALE CILINDRO PIEGAFALDE F146



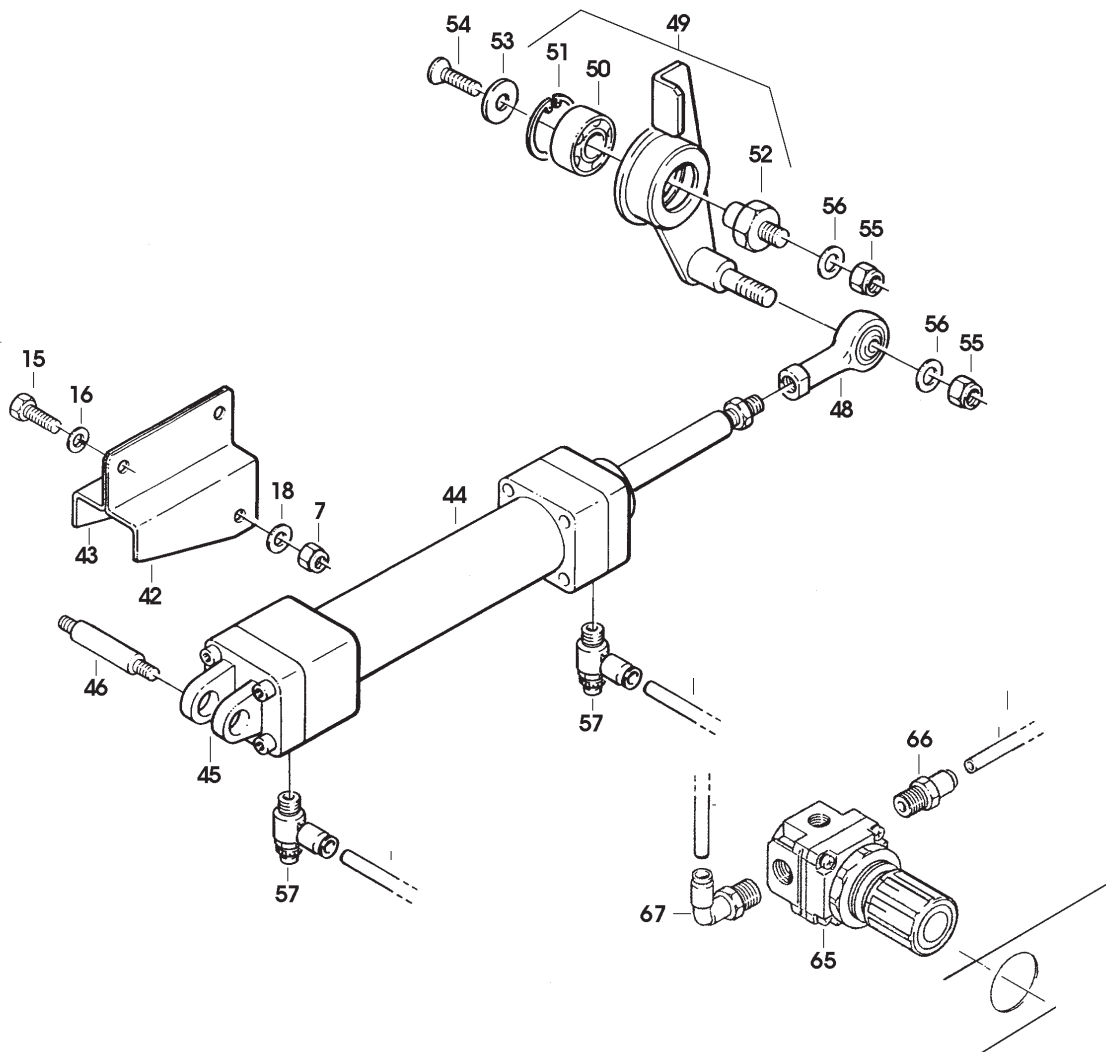
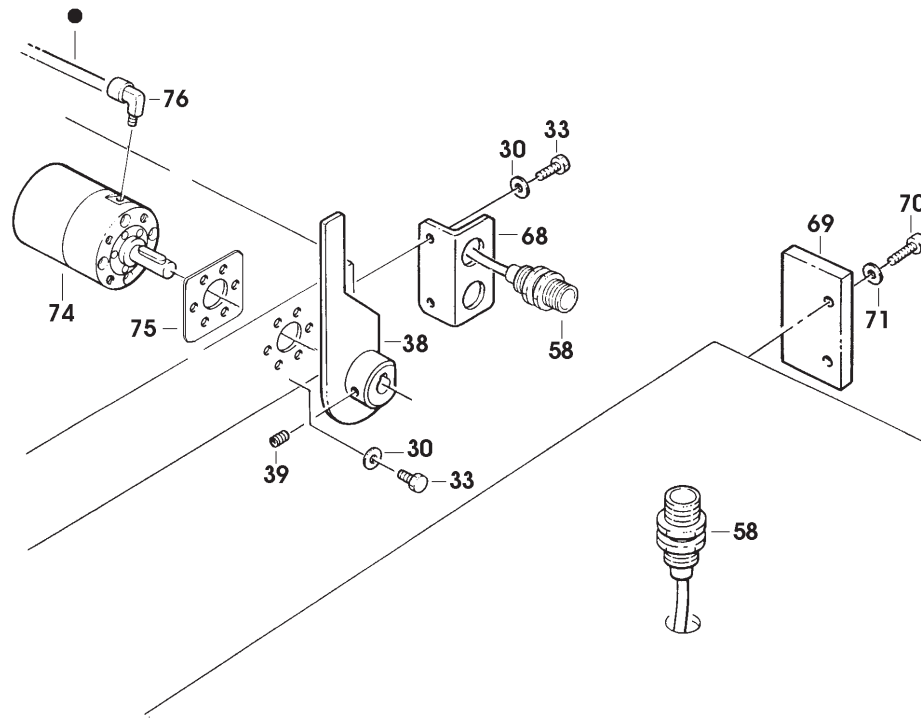
15058 BANCALE ALIMENTATORE SEC0000087 F344-S X FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
1	1	PZ	S450411247Z	BANC ALIM CON INS. F144-DX KYOWA
2	4	PZ	S471368600A	GAMBA SCORR.ALIMENTATORE ASS. F144 SIAT
3	4	PZ	S450571617Z	GAMBA SCORR.FORMATORE CON RIV. F144/146
4	4	PZ	S310086705Z	PIEDINO
5	4	PZ	S340033593Z	VITE TE M8X30 ZINCATA
6	12	PZ	S340065593Z	RONDELLA TRIPLA X VITE M8 ZINC
7	8	PZ	S340028393Z	DADO AUTOBLOCCANTE M8 BASSO ZINCATO
8	4	PZ	S300117997A	RIGHELLA MILLIM.F144/145
9	4	PZ	S320485993Z	MORSETTO FILETTATO X GAMBE 3MJ
10	4	PZ	S320085993Z	STAFFA ESTERNA SM/XL/3M
11	8	PZ	S340058493Z	VITE TCEI M8X16 ZINCATA
12	2	PZ	S331182447Z	TUBOLARE RINFORZO X FORCHE SOLLEV.F144
13	4	PZ	S340012293Z	VITE TCEI M8X20 ZINCATA
14	1	PZ	S320436393B	SUPPORTO ATTACCO ASTE F144
15	8	PZ	S340028093Z	VITE TE M8X20 ZINCATA
16	8	PZ	S340220592Z	RANELLA DI SAFETY "S" (SCHNORR) /8 F144
17	1	PZ	S4204192ZZZ	SQUADRETTA X CILINDRO ASS.F144
18	4	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
21	4	PZ	S310120705Z	(C) PATTINO SCORRIM.CATENE F144
22	28	PZ	S340057793Z	VITE TCEI M6X16 ZINCATA
23	34	PZ	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINC
24	32	PZ	S340025893Z	DADO AUTOBLOCCANTE M6 ZINC.
25	1	PZ	S320437293Z	FERMO X SPINTORE F144
26	4	PZ	S330815193Z	3.3.08151.93 DISTANZIALE SCATOLA ELETTR.
27	4	PZ	S340002193Z	VITE TE M6X12 ZINCATA
28	1	PZ	S320562198Z	INDICATORE ALTEZ PIANO ALIM. F144-SX KYO
29	2	PZ	S340002693Z	VITE TE M6X16 ZINCATA
30	6	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
31	1	PZ	S3801215ZZZ	PASSACAVO GOMMA CON MEMBR "EZ DG13,5" PE
33	6	PZ	S340037193Z	VITE TE M5X12 ZINCATA
38	1	PZ	S440489193Z	APRISCATOLE ASS.F144
39	1	PZ	S340088892Z	GRANO EIPP M5X10 BR,
42	1	PZ	S320434493Z	SUPPORTO DX CILINDRO F144
43	1	PZ	S320434593Z	SUPPORTO SX CILINDRO F144
44	1	PZ	S3802852ZZZ	CILINDRO C65 D 32-70 C F144 CON CERNIERA
45	1	PZ	S3802853ZZZ	CERNIERA C65 D32 F144
46	1	PZ	S331173393Z	PERNO ATTACCO CILINDRO F144
48	1	PZ	S340101093Z	TESTA A SNODO M10X1,25 ZINCATA
49	1	PZ	S4304527ZZZ	FERMASCATOLE CON CUSCINETTO F144
50	1	PZ	S3402146ZZZ	CUSCINETTO 4202 A F144
51	1	PZ	S340019092Z	ANELLO ARRESTO X FORO /35 BRUN
52	1	PZ	S331174892B	PERNO PER FERMO SCATOLE INF. F144
53	1	PZ	S331169193Z	RONDELLA SVASATA /8,5-25-5 F144
54	1	PZ	S340004893Z	VITE TSVEI M8X16 ZINCATA
55	2	PZ	S340043893Z	DADO AUTOBLOCCANTE M10 BASSO
56	2	PZ	S340021993Z	RONDELLA PIANA X VITE M10 ZINC
57	2	PZ	S3802929ZZZ	REGOLAT.DI FLUSSO AS 2201F 01-06S F144
58	2	PZ	S3802411ZZZ	INTER DI PROSSIMITA` E2ELX5F12MBYOMG-L
59	3	PZ	S4705543ZZZ	RUOTA /100 ASS.800af



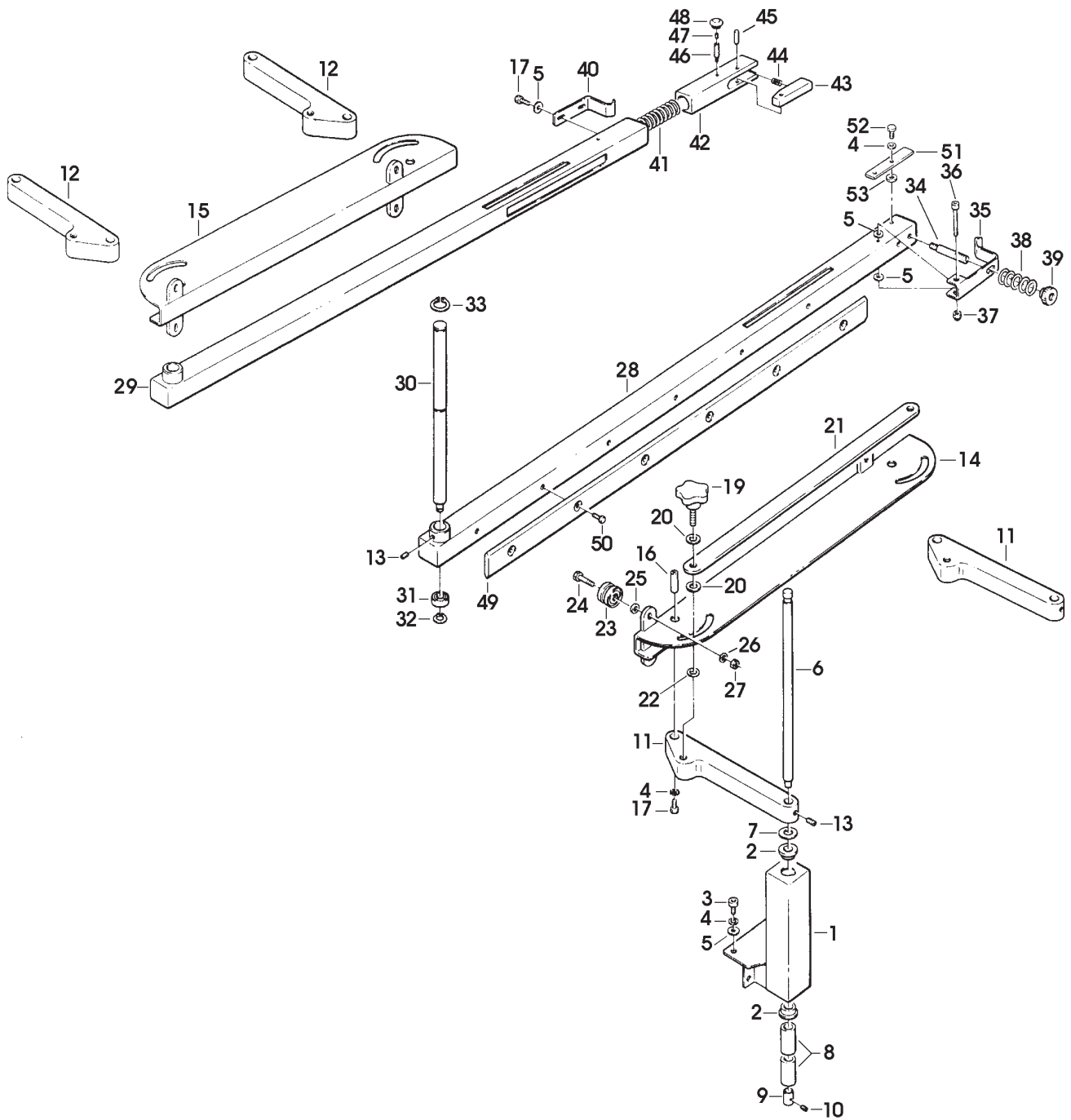
15058 BANCALE ALIMENTATORE SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
60	3	PZ	S3401356ZZZ	RUOTA /100 POLIDERNY (DERBY)
61	4	PZ	S320245593Z	DISTANZIALE PER RUOTE SM481
62	4	PZ	S320145093Z	RONDELLA SPECIALE /12/45,5X4
63	4	PZ	S340006293Z	RONDELLA PIANA X VITE M12 ZINC
64	4	PZ	S340073593Z	DADO M12 AUTOBLOCCANTE
65	1	PZ	S3803389ZZZ	RID MODULARE AR20-F02H 0,5/8,5 bar F144
66	1	PZ	S3800674ZZZ	RACCORDO DIR.M.CIL.31010613
67	1	PZ	S3800617ZZZ	RACCORDO GOMITO GIR.31990613
68	1	PZ	S320994393A	SQUADRETTA PER SENSORE F146 ZINC.
69	1	PZ	S310169200A	TAMPONE DI SICUREZZA F144/145
70	2	PZ	S340010893Z	VITE TCEI M5X20 ZINCATA
71	2	PZ	S340220392Z	RANELLA DI SAFETY "S" (SCHNORR) /5 F144
72	1	PZ	S471019000A	RUOTA SENZA FRENO ASS.F144/145
73	1	PZ	S3403097ZZZ	RUOTA /100 IN POLIDERNIL SENZA FRENO
74	1	PZ	S3805431ZZZ	CIL ROT TIPO "CRB1BW 30-90S-X384 SMC
75	1	PZ	S321006547A	DISTANZIALE CIL.APRISCATOLE F146 VERN.
76	2	PZ	S3800739ZZZ	RACCORDO GOMITO GIR.31990419
77	1	PZ	S450539447Z	PIANO DX ALIMENTATORE F146-DX
78	1	PZ	S450540147Z	PIANO SX ALIMENTATORE F146-SX
79	4	PZ	S340382600A	PIEDINO 312525 LV.F-100-24-M16 x98 - F
80	4	PZ	S340037293Z	DADO M16 M.A. ZINC.
81	4	PZ	S321153793A	PIASTRINA FISSAGGIO GAMBA
82	8	PZ	S340058493Z	VITE TCEI M8X16 ZINCATA



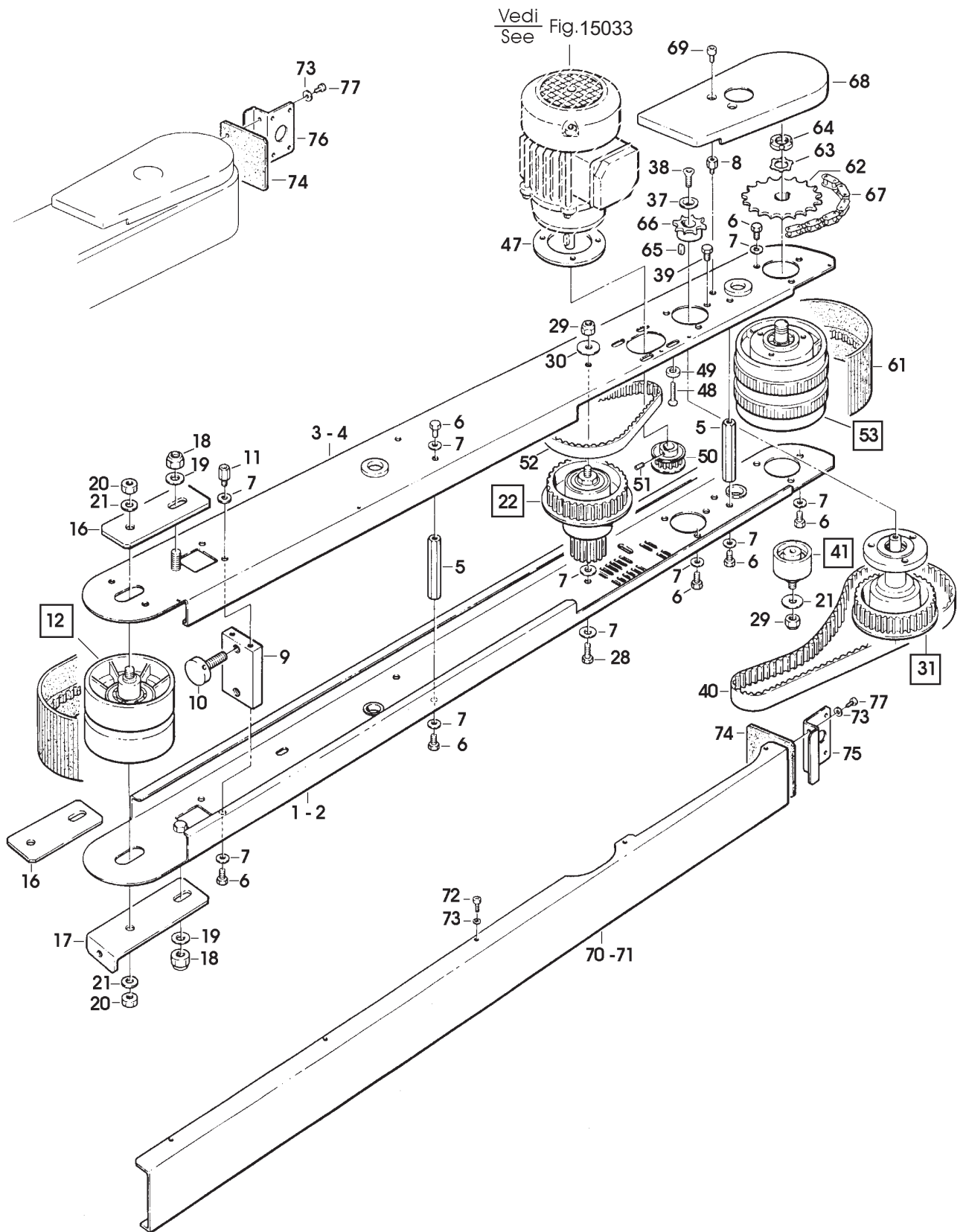
15059 GUIDE ALIMENTATORE SEC0000087 F344-SX FORMATORE AUTOMATICO

1	4 PZ	S440555247B	MONTANTE ASS.ALIMENTATORE F144
2	8 PZ	S3101239ZZZ	BUSSOLA X MONTANTI GUIDE ALIM. F144
3	16 PZ	S340057793Z	VITE TCEI M6X16 ZINCATA
4	22 PZ	S340220492Z	RANELLA DI SAFETY "S" (SCHNORR) /6 F144
5	20 PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
6	4 PZ	S331444693Z	PERNO PER LEVE GUIDE L=390 F144 KYOWA
7	4 PZ	S330595398Z	RONDELLA /15,2/26X1 INOX
8	8 PZ	S331444793Z	DISTANZIALE POSIZIONAM.LEVE F144 KYOWA
9	4 PZ	S330764593Z	GHIERA FISS.PERNI /12-25X12
10	4 PZ	S340026492Z	GRANO EIPP M6X6 BR.
11	2 PZ	S350257105B	(C) LEVA 45* L=300 F144
12	2 PZ	S350257205C	(C) LEVA 45* L=260 F144
13	6 PZ	S340136592Z	GRANO EIPC DENTELLATO M8X10 BR
14	1 PZ	S440552340B	PORTA GUIDA DX ASS.F144
15	1 PZ	S440552440B	PORTA GUIDA SX ASS.F144
16	4 PZ	S331175093Z	PERNO X LEVE ALIMENT.F144
17	8 PZ	S340002693Z	VITE TE M6X16 ZINCATA
19	4 PZ	S3403386ZZZ	MANIGLIA A RIPRESA MR-80p M10X30 (ELESA)
20	10 PZ	S340021993Z	RONDELLA PIANA X VITE M10 ZINC
21	2 PZ	S320556640Z	BRETELLA COLLEGAMENTO LEVE F144
22	4 PZ	S3100079ZZZ	RONDELLA NYLON /10,5/18X1
23	8 PZ	S4304691ZZZ	RULLINO CON CUSCINETTI ASS. F144 KYOWA
24	8 PZ	S340044293Z	VITE TE M8X45 ZINCATA
25	8 PZ	S331442993Z	DISTANZIALE PER RULLINO GUIDE F144 KYOWA
26	15 PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
27	10 PZ	S340028393Z	DADO AUTOBLOCCANTE M8 BASSO ZINCATO
28	1 PZ	S450525993Z	GUIDA DX ALIMENTATORE FORMAT.
29	1 PZ	S450526093Z	GUIDA SX ALIMENTATORE FORMAT.
30	2 PZ	S331442593Z	PERNO CON BEARING PER GUIDE F144 KYOWA
31	2 PZ	S3400166ZZZ	CUSCINETTO 6001-2RS
32	2 PZ	S340013592Z	ANELLO ARRESTO X ALBERO BR.
33	2 PZ	S340006892Z	ANELLO ARRESTO X ALBERO 20 BR.
34	1 PZ	S331176793Z	PERNO X MOLLA FERMASCATOLE F144
35	1 PZ	S320690198B	FERMASCATOLA CON MOLLEGGIO F144 INOX
36	2 PZ	S340184793Z	VITE TE M8X80 F144 ZINC.
37	1 PZ	S340025893Z	DADO AUTOBLOCCANTE M6 ZINC.
38	1 PZ	S370034693A	MOLLA PER FERMASCATOLE F144/F145
39	1 PZ	S330443893Z	GHIERA REGOLAZ.PORTAR.K ZINC.
40	1 PZ	S320435398B	FERMASCATOLE FISSO F144/145
41	2 PZ	S370027393Z	MOLLA /30 X GUIDE F144
42	2 PZ	S310149400B	BLOCCHETTO PER SALTARELLO F144 KYOWA
43	2 PZ	S3101252ZZZ	SALTERELLO F144
44	2 PZ	S370027493Z	MOLLA X SALTERELLO F144
45	2 PZ	S340068793Z	SPINA CILINDRICA /6X30 ZINC.
46	2 PZ	S331206193Z	PERNO X BLOCCHETTO F144
47	2 PZ	S340022592Z	GRANO EIPP M6X20 BRUNITO
48	2 PZ	S460197940Z	POMOLO COMP.
49	2 PZ	S331617995A	GUIDA A DOPPIA "V" F145
50	12 PZ	S330535693Z	VITE TE M6X12 SPEC.
51	1 PZ	S320708593A	PROLUNGA PER GUIDE F145
52	2 PZ	S340005793Z	VITE TE M6X20 ZINCATA
53	2 PZ	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINC
54	2 PZ	S340000393Z	DADO M8 ZINCATO
55	2 PZ	S3403387ZZZ	MANIGLIA A RIPRESA MR.80A-M10 (ELESA)
56	2 PZ	S332162500A	ASTA FIX GUIDE L=350 F145-ML "PAC-TEC"
57	2 PZ	S332160992A	PERNO FIX ASTA F145-ML "PAC-TEC" BRUN.
58	2 PZ	S332162392A	BUSS PER PERNO FIX ASTA F145-ML "PAC-TEC"
59	2 PZ	S3403281ZZZ	TESTA A SNODO KA8 (ASKUBAL)



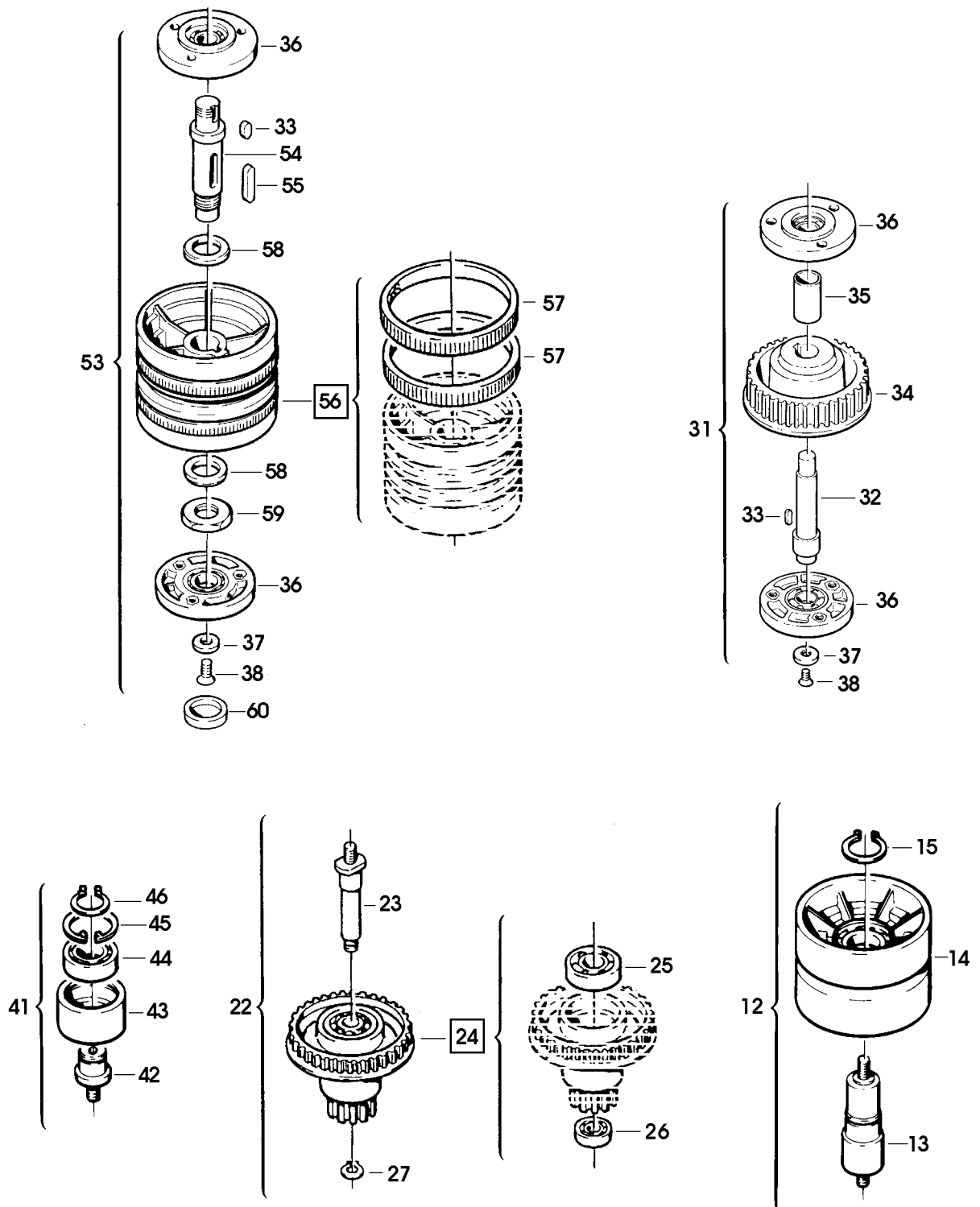
15060 MOTORIZZAZIONI SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
1	1	PZ	S450449047Z	GUIDA INF.DX MOTORIZZ.C/INS. F144
2	1	PZ	S450449147Z	GUIDA INF.SX MOTORIZZ.C/INS. F144
3	1	PZ	S450448847Z	GUIDA SUP.DX MOTORIZZ.C/INS. F144
4	1	PZ	S450448947Z	GUIDA SUP.SX MOTORIZZ.C/INS. F144
5	12	PZ	S330596093Z	DISTANZIALE ES.10X81 SM11 ZINC
6	38	PZ	S340002193Z	VITE TE M6X12 ZINCATA
7	46	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
8	4	PZ	S330627893Z	VITE SPECIALE M6
9	2	PZ	S3311650ZZZ	BLOCCHETTO X MOTORIZZ.F144
10	4	PZ	S331163893Z	VITE SPEC.X TENSIONAMENTO F144
11	8	PZ	S330815193Z	3.3.08151.93 DISTANZIALE SCATOLA ELETTR.
12	2	PZ	S4704053ZZZ	PULEGGIA FOLLE ASS.SM11-48
13	2	PZ	S330596492B	PERNO PER PULEGGIA FOLLE BRUNITO SM
14	2	PZ	S4601730ZZZ	PULEGGIA FOLLE COMP.
15	2	PZ	S340010492Z	ANELLO ARRESTO X ALBERO /25 BR
16	3	PZ	S320132547Z	PIASTRA TENDICINGHIA F144 GRIG
17	1	PZ	S320445647Z	CARRELLO TENDICINGHIA PER SENSORE F144
18	4	PZ	S340043893Z	DADO AUTOBLOCCANTE M10 BASSO
19	4	PZ	S340021993Z	RONDELLA PIANA X VITE M10 ZINC
20	4	PZ	S340000393Z	DADO M8 ZINCATO
21	6	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
22	2	PZ	S4704052ZZZ	PULEGGIA DOPPIA ASS.SM11-48
23	2	PZ	S330596292Z	PERNO PER PULEGGIA RINVIO
24	2	PZ	S4503371ZZZ	PULEGGIA DI RINVIO SM11
25	2	PZ	S3400095A	CUSCINETTO 6203 2RS
26	2	PZ	S3400193ZZZ	CUSCINETTO 6000 2RS
27	2	PZ	S340018792Z	ANELLO ARRESTO 10 DIN 471 BRUN
28	2	PZ	S340002693Z	VITE TE M6X16 ZINCATA
29	4	PZ	S340028393Z	DADO AUTOBLOCCANTE M8 BASSO ZINCATO
30	2	PZ	S340065593Z	RONDELLA TRIPLA X VITE M8 ZINC
31	2	PZ	S4706344ZZZ	PULEGGIA MOTRICE ASS.F144
32	2	PZ	S331089192Z	PERNO X PULEGGIA MOTRICE F144
33	4	PZ	S3400281ZZZ	LINGUETTA 5X5X12
34	2	PZ	S4604184ZZZ	PULEGGIA PD30 L C/INSERTO SPEC FORMATORE
35	2	PZ	S331089292Z	DISTANZIALE X PULEGGIA F144
36	8	PZ	S4603370ZZZ	FLANGIA COMPL.DI CUSCIN.E DADI SM11-
37	6	PZ	S330595193Z	RONDELLA 5,5X/20X4
38	6	PZ	S340051693Z	VITE TSVEI M5X12 ZINCATA
39	6	PZ	S330535693Z	VITE TE M6X12 SPEC.
40	2	PZ	S3402207ZZZ	CINGHIA DENTATA 255 L075 F144
41	2	PZ	S4704051ZZZ	GALOPPINO ASS.SM11 12AF XL
42	2	PZ	S330906892Z	PERNO PER GALOPPINO
43	2	PZ	S330906792Z	GALOPPINO TENDICINGHIA
44	2	PZ	S3400017ZZZ	CUSCINETTO 6004 2RS NTN SKF
45	2	PZ	S340044592Z	ANELLO ARRESTO X FORO 42 BR.
46	2	PZ	S340006892Z	ANELLO ARRESTO X ALBERO 20 BR.
47	2	PZ	S3101491ZZZ	DISTANZIALE X MOTORI SM/XL/3M
48	8	PZ	S340005593Z	VITE TSVEI M5X20 ZINCATA



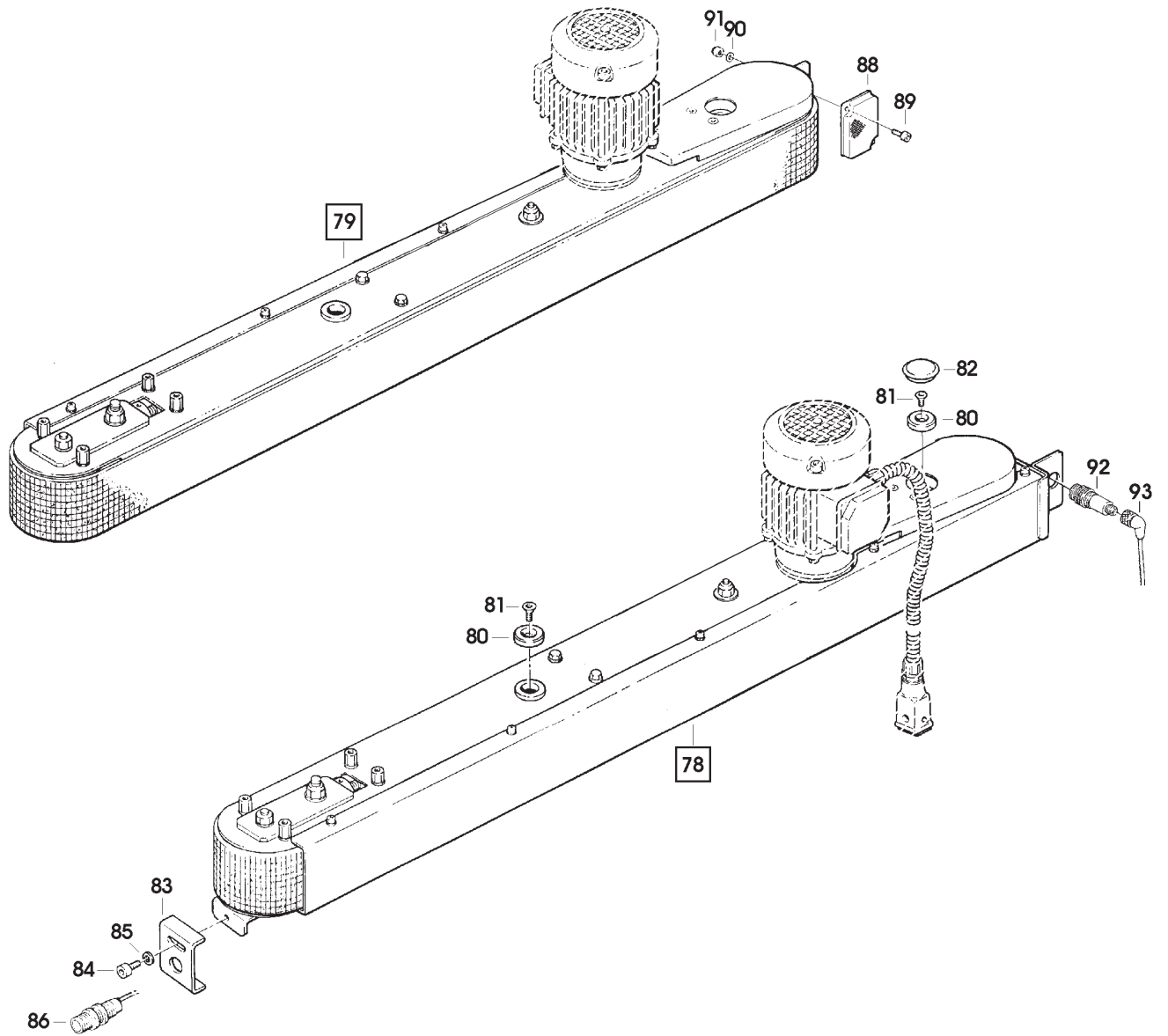
15060 MOTORIZZAZIONI SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
49	8	PZ	S350050693Z	RONDELLA FISSAGGIO MOTORI
50	2	PZ	S330674292Z	(C) PULEGGIA PD14 XL050
51	2	PZ	S340038892Z	GRANO EIPP M5X6 BR.
52	2	PZ	S3401593ZZZ	CINGHIA DENTATA 160XL050
53	2	PZ	S470404900A	PULEGGIA MOTRICE ASS.SM11-48
54	2	PZ	S330595792Z	PERNO PER PULEGGIA MOTRICE
55	2	PZ	S3400183ZZZ	LINGUETTA 5X5X30
56	2	PZ	S4705876ZZZ	PULEGGIA MOTRICE ASS.C/ANELLI
57	4	PZ	S310054048Z	ANELLO PER PULEGGIA
58	4	PZ	S330439893Z	RONDELLA /20,5/30X5
59	2	PZ	S330006893Z	DADO BASSO M18X1 ZINCATO
60	2	PZ	S310076205Z	COPERCHIO PER FLANGIA IN PST NERO
61	2	PZ	S3403259ZZZ	CING TRASC-SR VERDE SV.2306X75 F144 SPEC
62	2	PZ	S330655192Z	(PC) PIGNONE P=3/8" Z=28 SM BRUNITO
63	2	PZ	S3400913ZZZ	ROSETTE DI SICUREZZA MB2
64	2	PZ	S3400094ZZZ	GHIERA KM2
65	2	PZ	S3402142ZZZ	LINGUETTA 4X4X12 SM
66	2	PZ	S330970292Z	(PC) PIGNONE Z=11 P=3/8
67	2	PZ	S3401275ZZZ	CAT.AN.CHIUSO 3/8" L=50 PS. PR.STIR.COM
68	2	PZ	S310112205Z	CARTER X MOTORIZZAZIONI 800af /3M-I
69	4	PZ	S340011993Z	VITE TCEI M5X10 ZINCATA
70	1	PZ	S320445247Z	CARTER X MOTORIZZ.DX F144/93
71	1	PZ	S320445347Z	CARTER X MOTORIZZ.SX F144/93
72	10	PZ	S340083093Z	VITE TCBCR AUTOF.7SPX8 ZINCATA
73	14	PZ	S340004393Z	RONDELLA PIANA X VITE M4 ZINC.
74	2	PZ	S310068005Z	PROTEZIONE CINGHIE
75	1	PZ	S321234347A	SQUADRA FOTOCELL./CATADIOT. F144
76	1	PZ	S321234347A	SQUADRA FOTOCELL./CATADIOT. F144



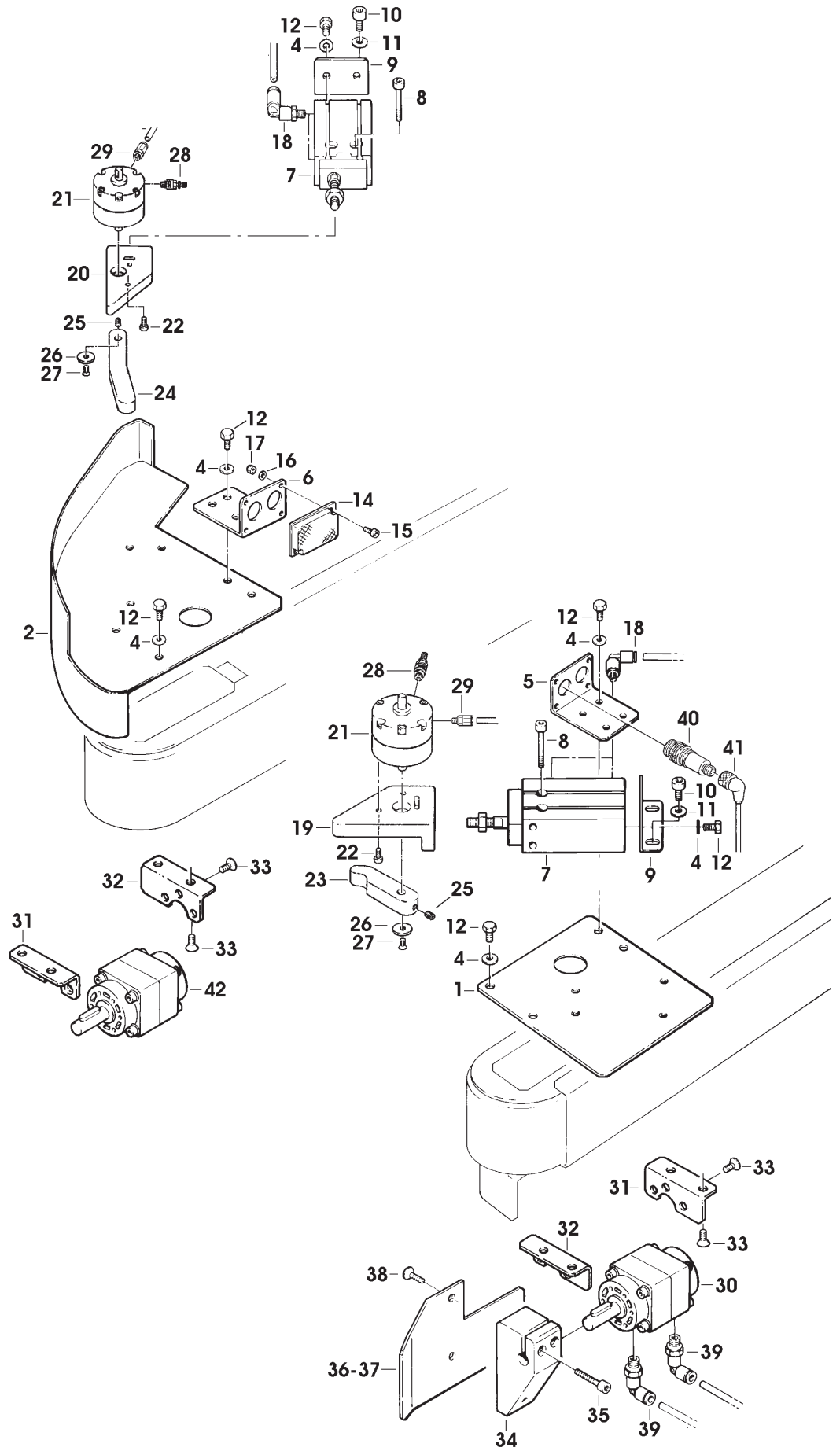
15060 MOTORIZZAZIONI SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
77	4	PZ	S340022893Z	VITE TCBCR AUTOF.8PX13 ZINCATA
78	1	PZ	S470859800A	MOTORIZZ.DX ASS. F144 SX KYOWA - SIAT
79	1	PZ	S470859900A	MOTORIZZ.SX.ASS. F144 SX KYOWA - SIAT
80	4	PZ	S330221593A	RONDELLA /6,5/30X5
81	4	PZ	S340005393Z	VITE TSVEI M6X16 ZINCATA
82	2	PZ	S340119005Z	TAPPO /35X1,5
83	1	PZ	S320445747Z	SCORREVOLE TENDICINGHIA PER
84	1	PZ	S340005193Z	VITE TCEI M6X12 ZINCATA
85	1	PZ	S340000693Z	RONDELLA DENTELLATA X VITE M6
86	1	PZ	S3802411ZZZ	INTER DI PROSSIMITA` E2ELX5F12MBYOMG-L
88	1	PZ	S3802029ZZZ	CATARIFRANGENTE E39-R1 SM44
89	2	PZ	S340029193Z	VITE TCEI M3X10 ZINCATA
90	2	PZ	S340055893Z	RONDELLA PIANA X VITE M3 ZINC.
91	2	PZ	S340101493Z	DADO AUTOBLOCCANTE M3 ZINCATO
92	1	PZ	S3804198ZZZ	FOTOCCELLULA E3F2-R2B4-P1-E SM/XL
93	1	PZ	S3802450ZZZ	CONNETTORE ELWIKI 4012 PG7

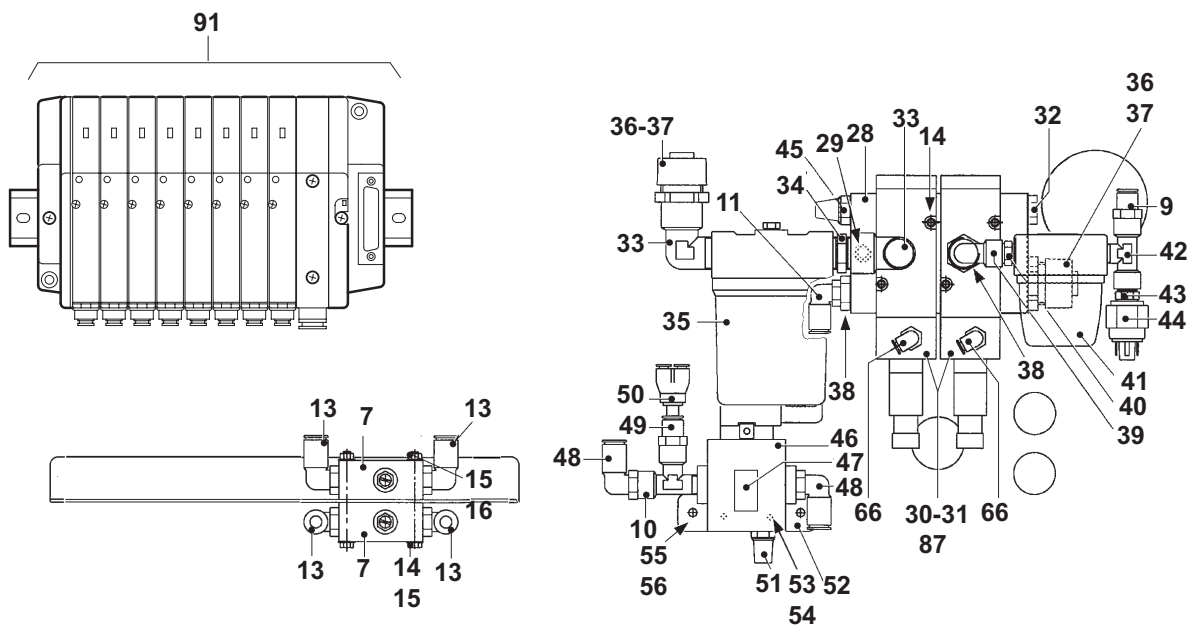
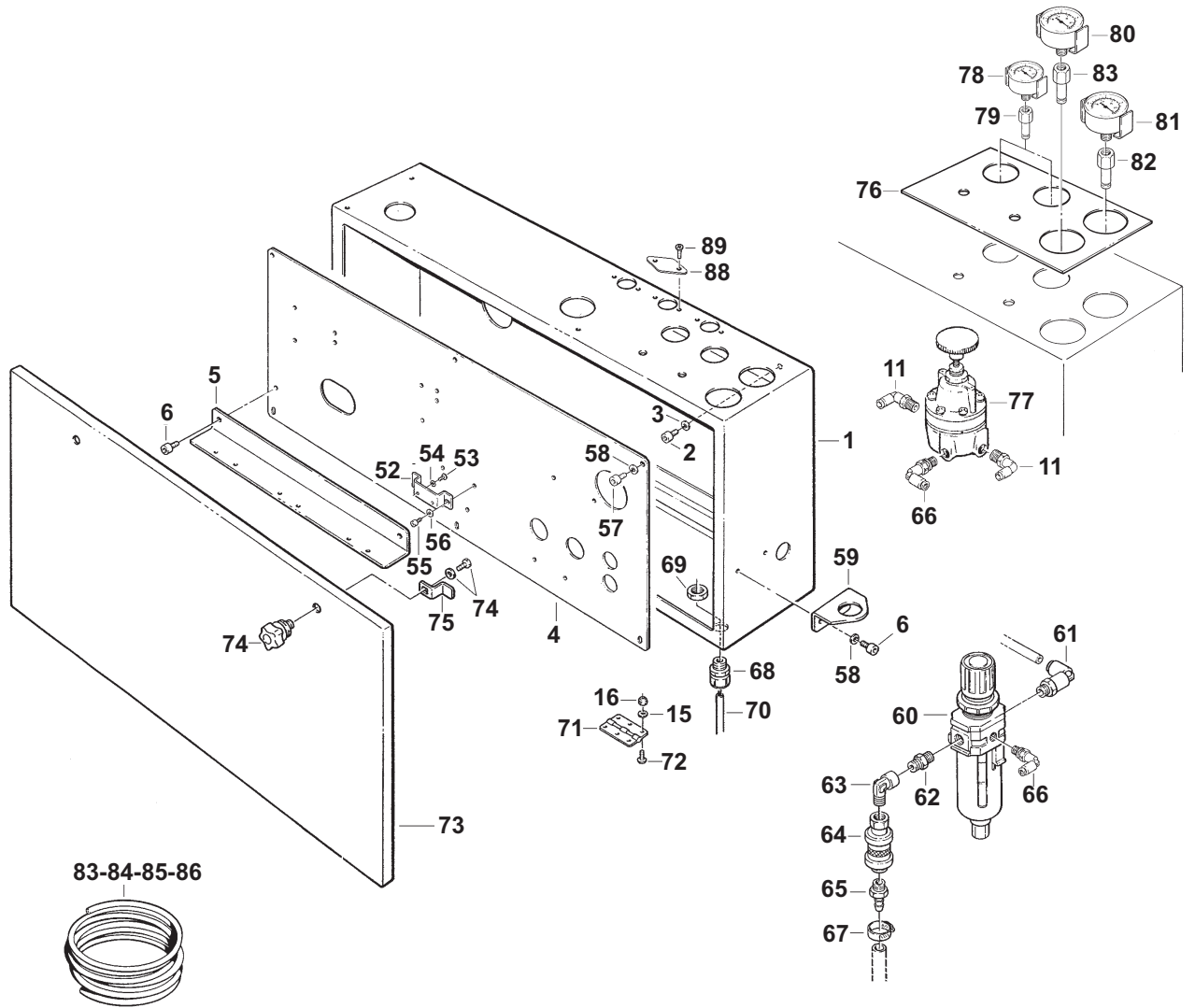


15061 CHIUDIFALDE LAT./SOST.SCATOLE SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
1	1	PZ	S450449593Z	STAFFA X MOTORIZZ.DX C/INS. F144
2	1	PZ	S450449693Z	PIASTRA FORMASCATOLE C/INS. F144
4	12	PZ	S340220492Z	RANELLA DI SAFETY "S" (SCHNORR) /6 F144
5	1	PZ	S321234493A	SQUADRA FOTOCELL. E CATADIOT. F144
6	1	PZ	S321234493A	SQUADRA FOTOCELL. E CATADIOT. F144
7	2	PZ	S3802856ZZZ	CILINDRO CDUK 32-50 D F144
8	4	PZ	S340050093Z	VITE TCEI M6X40 ZINCATA
9	2	PZ	S320444293Z	SQUADRETTA FISSAGGIO CILINDRO F144
10	4	PZ	S340005193Z	VITE TCEI M6X12 ZINCATA
11	4	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
12	12	PZ	S340002193Z	VITE TE M6X12 ZINCATA
14	1	PZ	S3802029ZZZ	CATARIFRANGENTE E39-R1 SM44
15	2	PZ	S340029193Z	VITE TCEI M3X10 ZINCATA
16	2	PZ	S340055893Z	RONDELLA PIANA X VITE M3 ZINC.
17	2	PZ	S340101493Z	DADO AUTOBLOCCANTE M3 ZINCATO
18	4	PZ	S3802354ZZZ	RACCORDO GOMITO KQ2L06-01S
19	1	PZ	S331281495Z	BLOCCA SCATOLE DX CON PALMOLA F144-SX
20	1	PZ	S331281595Z	BLOCCA SCATOLE SX CON PALMOLA F144-SX
21	2	PZ	S380321681Z	ATTUAT ROT CRB1BW30-270 -I003 PER F144
22	4	PZ	S340011293Z	VITE TCEI M5X16 ZINCATA
23	1	PZ	S331274395Z	SOSTEGNO BOX CORTO PER PALMOLA F144-DX
24	1	PZ	S331274295Z	SOSTEGNO BOX LUNGO PER PALMOLA F144-DX
25	2	PZ	S340179492Z	GRANO EIPC M6X8
26	2	PZ	S330595193Z	RONDELLA 5,5X/20X4
27	2	PZ	S340051693Z	VITE TSVEI M5X12 ZINCATA
28	2	PZ	S3803217ZZZ	REGOLATORE DI SCARICO ASN2-M5 F144
29	2	PZ	S3804397ZZZ	RACCORDO DIRITTO 31010419 F144
30	1	PZ	S3803884ZZZ	CILINDRO ROTANTE CRB1BW50-90D XF-F145
31	2	PZ	S320678893B	SQUAD DX FIX ECRB50-90-X65 F145
32	2	PZ	S320678993B	SQUAD SX FIX ECRB50-90X65 F145
33	20	PZ	S340002793Z	VITE TSVEI M6X12 ZINCATA
34	2	PZ	S332424595A	CHIUDIFALDE LATERALI RIBASSATI F144-F145
35	4	PZ	S340017793Z	VITE TCEI M8X40 ZINCATA PARZ. FILETTO
36	1	PZ	S320431798Z	SPATOLA CHIUDIFALDA DX F144
37	1	PZ	S320431898Z	SPATOLA CHIUDIFALDA SX F144
38	4	PZ	S340005393Z	VITE TSVEI M6X16 ZINCATA
39	4	PZ	S3800660A	RACCORDO GOMITO GIR.31990610
40	1	PZ	S3804198ZZZ	FOTOCELLULA E3F2-R2B4-P1-E SM/XL
41	1	PZ	S3804483ZZZ	CONNET X FOTOCEL.CS-A2-02- S-05 X SM/XL
42	1	PZ	S3804778ZZZ	CIL.ROTANTE CRB1BWP50-90D-XC27



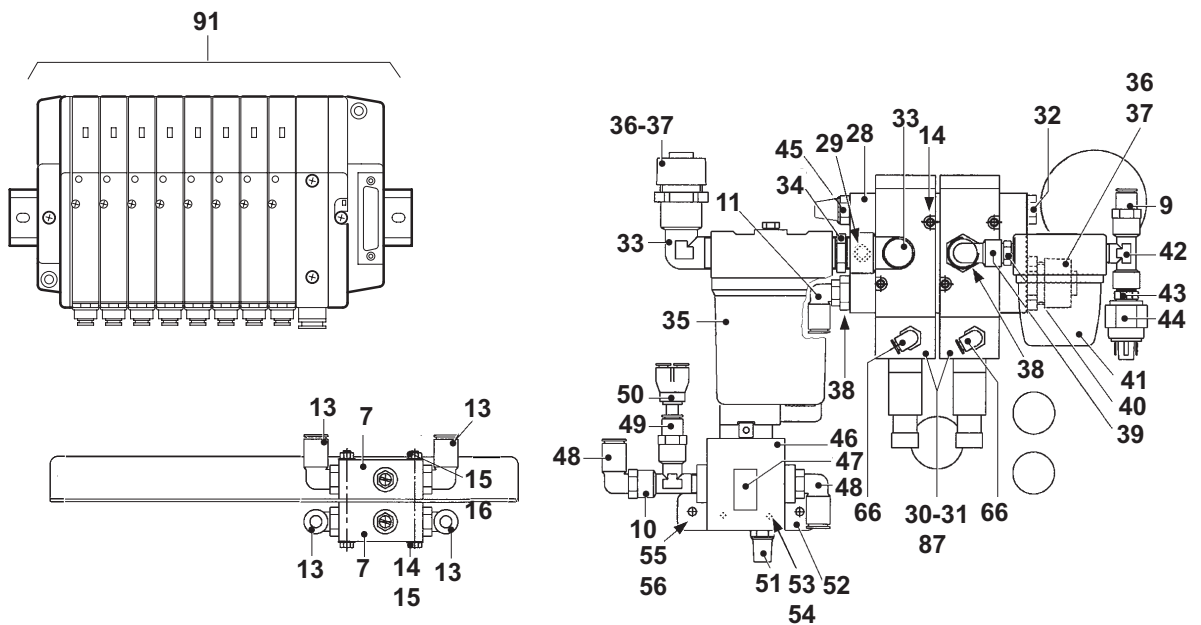
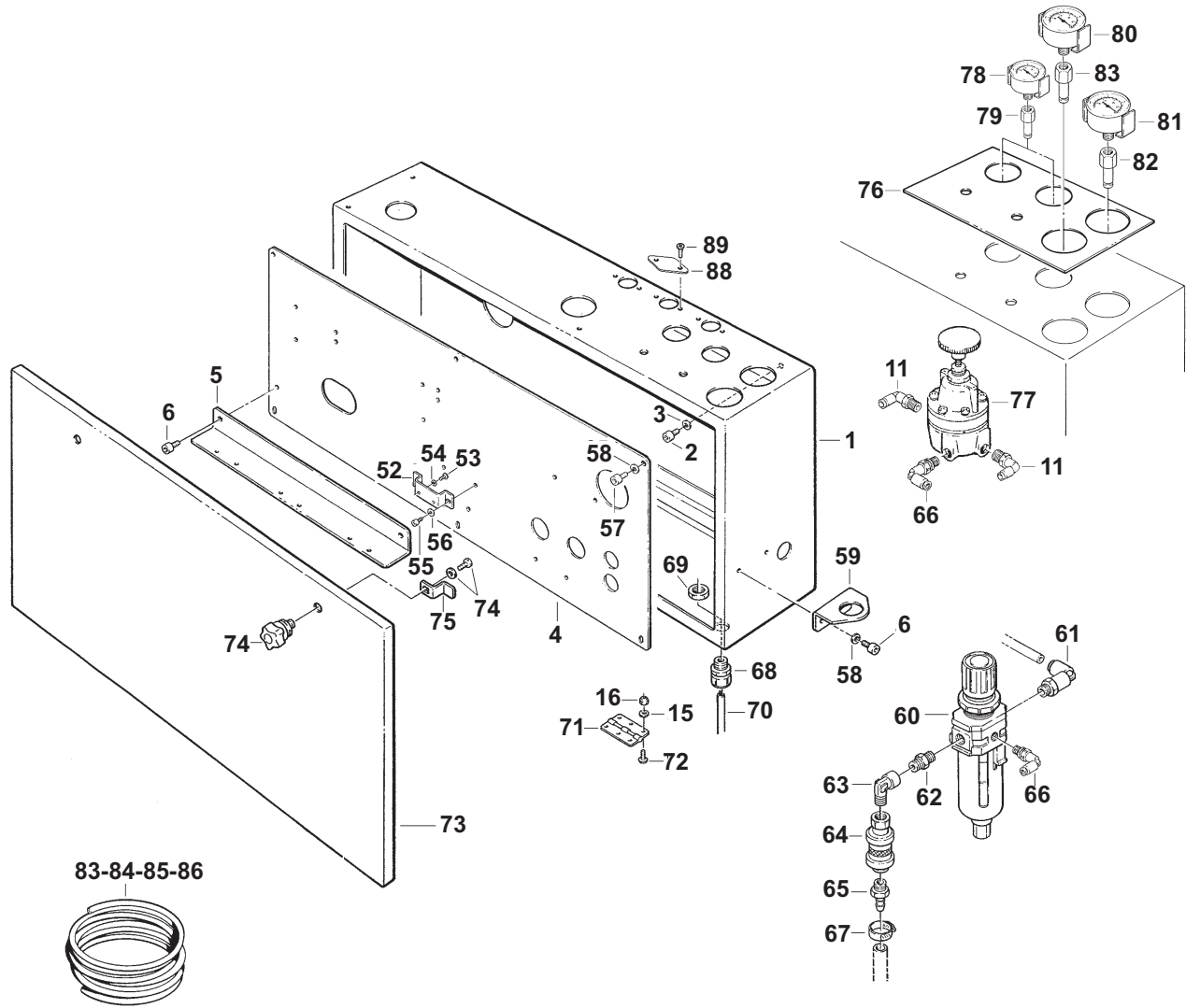
Pos.	Q.tà	UM	Codice	Descrizione
1	1	PZ	S450538347Z	SCATOLA IMP.PNEUM.C/INS. F146-SX
2	6	PZ	S340012293Z	VITE TCEI M8X20 ZINCATA
3	6	PZ	S340220592Z	RANELLA DI SAFETY "S" (SCHNORR) /8 F144
4	1	PZ	S450499447Z	PANN BOX IMP.PNEUM. C/INSERTI F144 DX "T
5	1	PZ	S320425093Z	SQUADRETTA X GR.REGOLATORE F144
6	4	PZ	S340057793Z	VITE TCEI M6X16 ZINCATA
7	6	PZ	S3803972ZZZ	REGOLAT.DI FLUSSO RFU-446-1/4" "CAMOZZI"
8	5	PZ	S3802289ZZZ	RACCORDO GOMITO 31990813
9	4	PZ	S3801393ZZZ	RACCORDO DIRITTO 31010813 CF13
10	2	PZ	S3801040ZZZ	RACCORDO A T M.F.F.1/4"
11	5	PZ	S3804203ZZZ	RACCORDO 31990413 MIGNON F144
12	1	PZ	S3801682A	RACCORDO Y FEMM.LEGRIS31400400
13	4	PZ	S3800617ZZZ	RACCORDO GOMITO GIR.31990613
14	10	PZ	S340224593Z	VITE TCEI M5X65 ZINCATA
28	1	PZ	S331182795B	SOTTOBASE ELETTRIC. EVP742 F144
29	2	PZ	S340013793Z	VITE TCEI M6X50 ZINCATA
30	2	PZ	S3802962ZZZ	ELETTRIC. VALVOLA EVP742 R-BY-04F F144
31	2	PZ	S3101238ZZZ	GUARNIZIONE X EVP742 F144
32	2	PZ	S3800622ZZZ	RACCORDO GOMITO GIR.31990410
33	3	PZ	S3802883ZZZ	RACC A GOMITO RA 022 1/2" - 1/2" F144
34	1	PZ	S3802882ZZZ	NIPPLO CONICO RA 012 1/2"-1/2" F144
35	1	PZ	S3803022ZZZ	FILTRO FB20 1/2" F144 (VUOTOTECNICA)
36	2	PZ	S380565400A	PORTAGOMMA 454 - /16 - 1/2" F144
37	2	PZ	S3801424ZZZ	GUARNIZIONE 1/2"
38	1	PZ	S3802881ZZZ	RIDUZIONE RA 014 1/2" - 1/4" F144
39	1	PZ	S3801108ZZZ	RACCORDO RA 022-1/4-1/4
40	1	PZ	S3800887ZZZ	NIPPLO CONICO RA 012 1/4"-1/4"
41	1	PZ	S3803021ZZZ	FILTRO FB5 1/4" (VUOTOTECNICA) F144
42	1	PZ	S3803020ZZZ	RACCORDO RA 024 1/4 1/4 F144
43	1	PZ	S3800621ZZZ	RIDUZIONE RA 014 1/4"-1/8"
44	1	PZ	S3804360ZZZ	VUOTOSTATO VNC2AP F144
45	1	PZ	S3802876ZZZ	SILENZIATORE SEB-1/2" F144
46	1	PZ	S3804353ZZZ	AVVIATORE PROGRESSIVO EAV2000 -F02-9YO (
47	1	PZ	S3802982ZZZ	PRESSOSTATO IS1000-01-X201-Q SMC
48	2	PZ	S3800921ZZZ	RACCORDO L GIREVOLE 31991013
49	1	PZ	S3800674ZZZ	RACCORDO DIR.M.CIL.31010613
50	1	PZ	S3804399ZZZ	Y SEMPLICE INNESTABILE 31420406 F144
51	1	PZ	S3800448ZZZ	SILENZIATORE 1/4"
52	1	PZ	S320719793A	STAF FIX PER EAV 2000- F02-5Y0 F144
53	2	PZ	S340000593Z	VITE TCBCR M4X6 ZINC.
54	2	PZ	S340220292Z	RANELLA DI SAFETY "S" (SCHNORR) /4 F144
55	2	PZ	S340011293Z	VITE TCEI M5X16 ZINCATA
56	2	PZ	S340046893Z	RONDELLA TRIPLA X VITE M5 ZINC
57	6	PZ	S340016093Z	VITE TCEI M6X20 ZINCATA
58	8	PZ	S340220492Z	RANELLA DI SAFETY "S" (SCHNORR) /6 F144
59	1	PZ	SBC0007657	SQUADRETTA SUPPORTO F.R. AW30-F03D
60	1	PZ	S3802753ZZZ	REGOLATORE PRESS. AW30-F03DH XL300
61	1	PZ	S380582900A	RACC A GOMITO 10 G3/8 TIPO 3169 10 17 LE
62	1	PZ	S3801730ZZZ	NIPPLO CONICO RA012-3/8"-3/8"
63	1	PZ	S3802887ZZZ	RACCORDO A GOMITO RA 022 3/8" -3/8" F144
64	1	PZ	S3802886ZZZ	VALVOLA A MANICOTTO 3/8" F144
65	1	PZ	S3801086ZZZ	PORTAGOMMA RA 030 3/8"X9
66	3	PZ	S3804202ZZZ	RACCORDO 31990410 MIGNON



15062 SCATOLA/IMP.PNEUMATICO

SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
67	1	PZ	S3400653ZZZ	FASCETTA STRINGITUBO /14-24
68	1	PZ	S3800854ZZZ	BOCCHETTONE SKINTOP ST 16
69	1	PZ	S3803846ZZZ	CONTRODADO GMP16
70	1	PZ	S3803072ZZZ	CAVO VINIL.4X2,5 (MT.5) F144
71	2	PZ	S340162993Z	3.4.01629.93 CERNIERA 64X45
72	8	PZ	S340072093Z	VITE TESTA MEZZA TONDA M5X12 CROCE ZINC.
73	1	PZ	S4204247ZZZ	COPERCHIO BOX IMP.PNEUM. C/SPUGNA F144 "
74	2	PZ	S3402898ZZZ	VOLANTINO "ELESA" VC.309/40-SS PER F145
75	2	PZ	S320706693A	CHIAVISTELLO X SCATOLA IMP. PNEUM.F145
76	1	PZ	S320709717A	PANNELLO PER INDICATORI PNEUM. F144/145
77	2	PZ	S3801960ZZZ	REG DI PRECISIONE TIPO IR 2010-F02-X6 SM
78	2	PZ	S3804200ZZZ	MANOM /40 FLANG.CON STAF 0-2,5 bar F144
79	2	PZ	S3801654ZZZ	RACCORDO DIR.FEMM.CIL.31140410
80	1	PZ	S3803689ZZZ	MANOM SCALA MPa 0.2-1.2 SM/XL/3M per JAP
81	1	PZ	S3804199ZZZ	MANOM /50 FLANG.CON STAF 0-12 bar F144
82	2	PZ	S3804204ZZZ	RACCORDO BOSCH (R412005085) F144
83	1	PZ	S3801630ZZZ	TUBO PNEUM.D4/2,5 (5 MT.)
84	6	PZ	S3801631ZZZ	TUBO PNEUM.D6/4 (5 MT.)
85	1	PZ	S3802417ZZZ	TUBO PNEUM.D8X6 NERO (5 MT.)
86	1	PZ	S3803053ZZZ	TUBO PNEUM.D.10X8 NERO (5 MT.)
87	2	PZ	S3804417ZZZ	CONNETTORE DIN (SENZA LED) SMC 2009636
88	2	PZ	S320996147A	PIASTR CHIUSURA FORI BOX IMP.PNEUM.F145
89	4	PZ	S340314393Z	VITE TESTA MEZZA TONDA M6 X 12
90	2	PZ	S3803852ZZZ	RACCORDO GOMITO 31820600
91	1	PZ	SCB0000375	BATTERIA 8 ELETTROVALVOLE SS5Q23



15063 APRISCATOLE SUPERIORE SEC0000087 F344-SX FORMATORE AUTOMATICO

Pos.	Q.tà	UM	Codice	Descrizione
1	1	PZ	S440624347A	TUBO ORIZZONTALE ASS.AS86 VERN.
2	1	PZ	S440624493A	TUBO VERTICALE ASS.AS86
3	1	PZ	S3401022ZZZ	SPINA ELASTICA /4X30
4	1	PZ	S321033193A	SUPPORTO PALMOLA "AS105"
5	1	PZ	S340058493Z	VITE TCEI M8X16 ZINCATA
6	1	PZ	S340065593Z	RONDELLA TRIPLA X VITE M8 ZINC
7	1	PZ	S3805431ZZZ	CIL ROT TIPO "CRB1BW 30-90S-X384 SMC
8	4	PZ	S340037193Z	VITE TE M5X12 ZINCATA
9	4	PZ	S340074592Z	RONDELLA DENT. X VITE M5 BRUN.
10	1	PZ	S3800363ZZZ	RACCORDO A GOMITO MF 1/8"
11	1	PZ	S3801036ZZZ	RACCORDO DIR.M.CIL.31010410
12	7	M	S3804017ZZZ	TUBO PNEUM. POLIUR. TUH0425B-100 SMC
13	1	PZ	S440489193Z	APRISCATOLE ASS.F144
14	1	PZ	S340088892Z	GRANO EIPP M5X10 BR,
15	1	PZ	S331766395B	MORSETTO DOPPIO AS86 ANODIZZ.
16	2	PZ	S331766495A	PIASTRINA FISSAGGIO AS86 ANODIZZATA
17	4	PZ	S340048693Z	VITE TCEI M8X25 ZINCATA
18	4	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
19	4	PZ	S340011293Z	VITE TCEI M5X16 ZINCATA
20	4	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.

