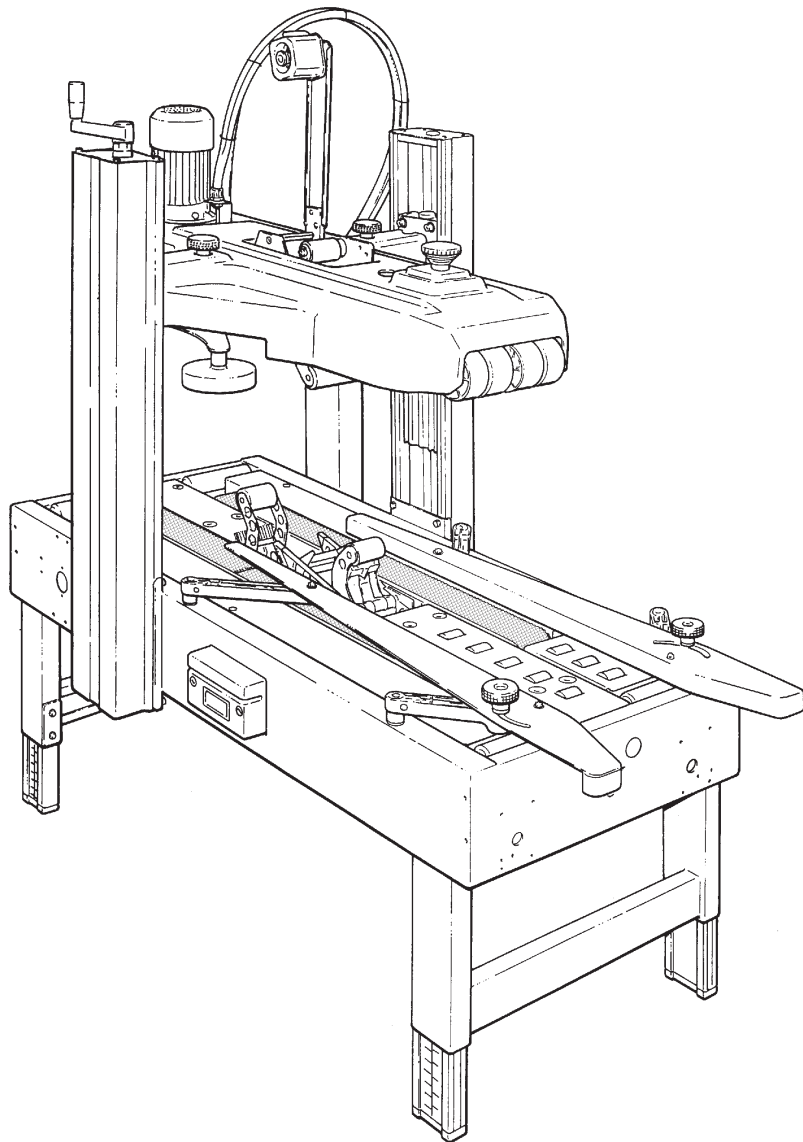


# SIAT

■ M. J. MAILLIS GROUP



**S2-S** Type A

NASTRATRICE AUTOMATICA  
**AUTOMATIC CASE SEALING MACHINE**  
MACHINE ENRUBANNEUSE AUTOMATIQUE  
*AUTOMATISCHE KARTONVERSCHLISSMASCHINE*  
PRECINTADORA AUTOMATICA

MANUALE DI ISTRUZIONI E PARTI DI RICAMBIO  
**INSTRUCTIONS MANUAL AND SPARE PARTS LIST**  
MANUAL D'INSTRUCTIONS ET PIECES DETACHEES  
*BEDIENUNGSANLEITUNG UND ERSTAZTEILLISTE*  
MANUAL DE INSTRUCCIONES Y RECAMBIOS



Instruction manual for the use, safety, maintenance and spare parts concerning the case sealing machine model S2-S Type A.

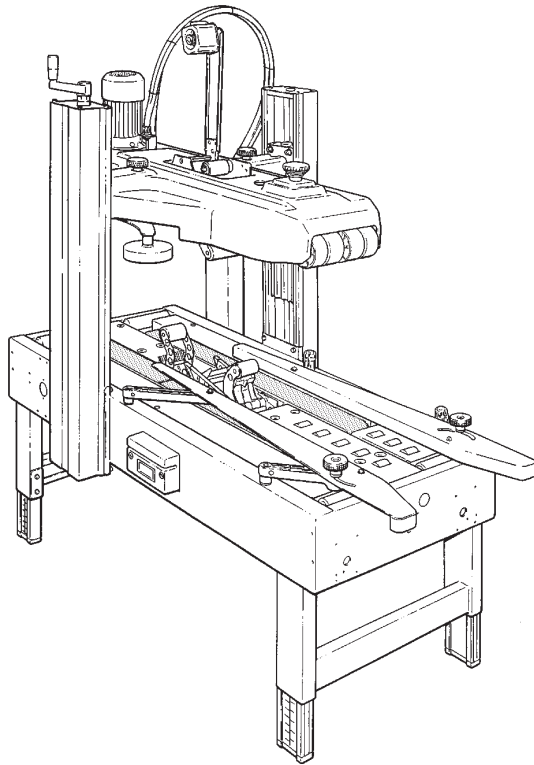
This publication is property of SIAT S.P.A.  
Via Puecher, 22 - 22078 TURATE (CO) - ITALY  
Tel. 02-964951 - Fax. 02-9689727

Edition January 2007

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

Publication n. SMB00050K  
Release I



**S2-S** Type A

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

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

	Section	LIST OF ABBREVIATIONS, ACRONYMS AND UNUSUAL TERMS TO BE FOUND IN THIS MANUAL	
Manufacturing specifications	1.1		
Manual, how to use the	1.2		
Serial Number	2.1		
After-sale service	2.2	Dwg.	= drawing
Warranty	2.3	Encl.	= enclosure
<b>Safety</b>	<b>3</b>	Ex.	= example
Operators' skill levels	3.6	Fig.	= figure showing spare parts
Technical specifications	4	Max.	= maximum
Dimensions and weight	4.2.-4.6	Min.	= minimum
Noise measurement	4.10	Mod.	= machine model
Transportation	5	N.	= number
Unpacking	6	N/A	= not applicable
Installation	7	OFF	= machine stopped
Theory of operation	8	ON	= machine running
Controls	9	OPP	= oriented polypropylene adhesive tape
Safety devices	10	Pict.	= picture
Set-up and adjustments	11	PLC	= Programmable Logic Control
Tape replacement	11.1-11.2	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	13.5	Tav.	= Illustration
Blade replacement	13.9		
Belt replacement	13.10-13.11		
Adjustment of belt tension	13.12	w	= width
Log of maintenance work	13.13	h	= height
Fire emergency	14.2	l	= length
Electric Schematics	16	ol	= overall length
Spare parts	last section	cbh	= conveyor bed height

# INTRODUCTION

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## 1.1 MANUFACTURING SPECIFICATIONS

The automatic case sealing machine Mod. S2-S has been designed and manufactured complying with the legal requirements in force at the date of its manufacture.

THE REFERENCE DOCUMENTS ARE:

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

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

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

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

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

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

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

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

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

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

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

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

## 1.2 HOW TO READ AND USE THE INSTRUCTION MANUAL

### 1.2.1 IMPORTANCE OF THE MANUAL

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

### 1.2.2 MANUAL MAINTENANCE

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

Use the manual without damaging it.

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

### 1.2.3 CONSULTING THE MANUAL

The manual is composed of:

- pages which identify the document and the machine;
- index of the subjects;
- instructions and notes on the machine: sections **2÷14**
- enclosures, drawings and diagrams: sections **15÷16**
- spare parts: last section.

All pages and diagrams are numbered. The spare parts lists are identified by the figure identification number.

All the notes on safety measures or possible dangers are identified by the symbol:



All the important warning notes related to the operation of the machine are identified by the symbol: 

The parts typed in **bold** refer to technical data or technical notes on a specific subject.

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

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

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


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

The user must use them update this manual.

## 2-GENERAL INFORMATION

---

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

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

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

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

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

## 2-GENERAL INFORMATION

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### 2.3 WARRANTY

Within the limits of what is set forth below, Seller agrees to repair or replace without cost to Buyer any defective goods when such defect occurs within a period of 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

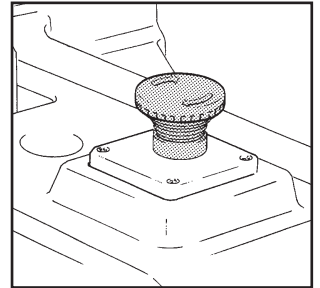
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### 3.1 GENERAL SAFETY INFORMATION

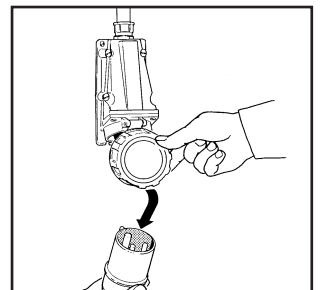
Read all the instructions carefully before starting the work with the machine; please pay particular attention to sections marked by the symbol



The machine is provided with a LOCKABLE EMERGENCY STOP BUTTON placed on the operator side of the machine; when this button is pressed, it stops the machine at any point in the working cycle.



Disconnect the machine from the mains before any maintenance operation.



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

### 3.2 DEFINITION OF THE OPERATORS' QUALIFICATIONS

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

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

#### SKILL 1

##### **MACHINE OPERATOR**

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

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

## 3-SAFETY

---

### SKILL 2

#### **MECHANICAL MAINTENANCE TECHNICIAN**

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

He is not allowed to work on live electrical components.

### SKILL 2a

#### **ELECTRICAL MAINTENANCE TECHNICIAN**

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

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

### SKILL 3

#### **SPECIALIST FROM THE MANUFACTURER**

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

### **3.3 INSTRUCTIONS FOR A SAFE USE OF THE MACHINE**

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

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

### **3.4 STATE OF THE MACHINE**

List of the modes which are possible with this machine:

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



### 3-SAFETY

#### 3.5 NUMBER OF THE OPERATORS

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

#### 3.6 OPERATORS' SKILL LEVELS

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

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

## 3-SAFETY

### 3.7 RESIDUAL HAZARDS

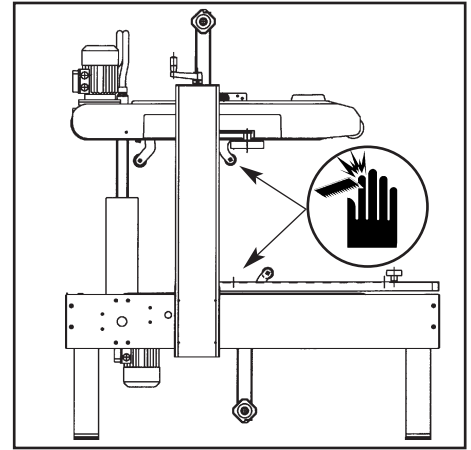
The case sealer SR46-S has been designed following the CE 392 directives, and incorporates various safety protections which should never be removed or disabled.

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

**WARNING!** Tape cutting blades.

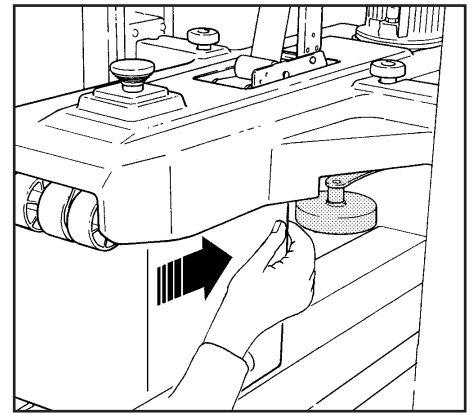
Never remove the safety device which covers the blade on the top and bottom taping units.

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



**WARNING!** Side flap compression rollers.

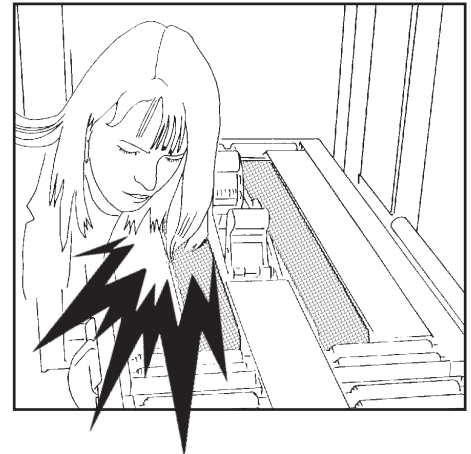
Never keep hands on the box while it is driven by the belts.



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

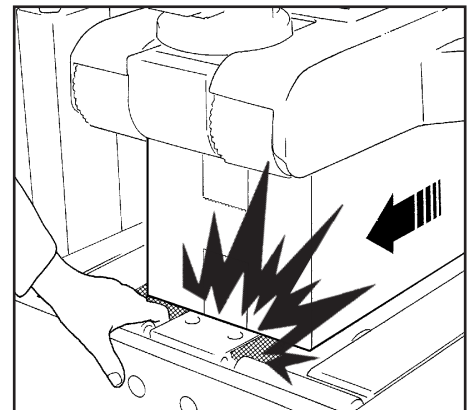
Never work on the machine with loose hair or loose garments such as scarfs, ties or sleeves.

Although protected, the drive belts may be dangerous.



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

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

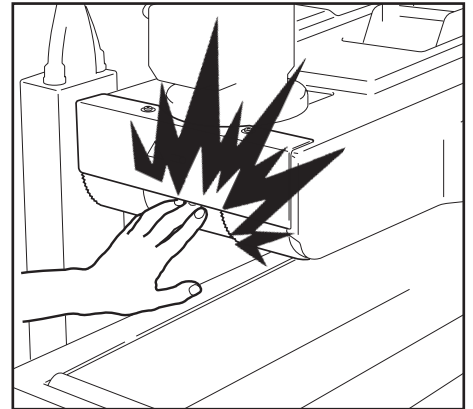


## 3-SAFETY

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**WARNING!** Top driving belts.

Never touch the running belt with your hands.  
Serious injury may occur.



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

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

The box must be fed by keeping the hands in the right position. (see paragraph 4.9)

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

### 3.9 PERSONAL SAFETY MEASURES

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

None is required, except when recommended by the user.

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

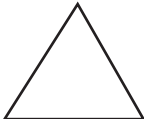
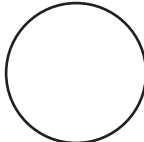

- Never try to stop or hold the box while it is being driven by the belts.  
Use only the EMERGENCY STOP BUTTON.
- Never work without the safety protections.
- Never remove or disable the safety devices.
- Only authorised personnel should be allowed to carry out the adjustments, repairs or maintenance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

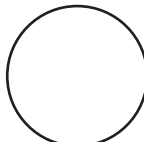


- The cleaning and maintenance operations must be performed after disconnecting the electric power.
- Clean the machine using only dry clothes or light detergents. Do not use solvents, petrols etc.
- Do not modify the machine or any part of it. The manufacturer will not be responsible for any modifications.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

### 3-SAFETY


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

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

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




Label code: 3.0.0103496/A

b  Warns the operator to keep hands away from the side flap compression rollers..



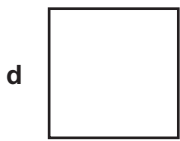
Label code: 3.0.01068.96A

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

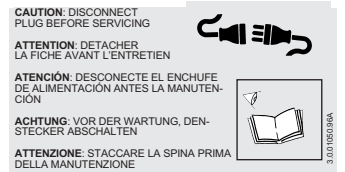


Label code: 3.0.01045.96A

### 3-SAFETY



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



Label code: 3.0.01050.96A



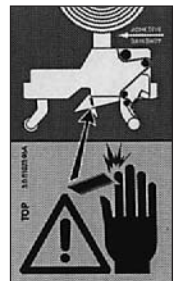
Shows the sharp knife on the taping head.



Label code: 3.0.01028.96A



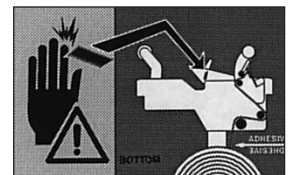
Tape threading path for top taping unit, and position of the sharp knife.



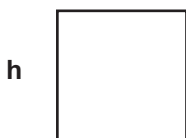
Label code: 3.0.01023.96A



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



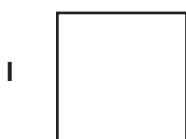
Label code: 3.0.01024.96A



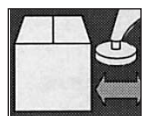
Shows the running direction of the belts.



Label code: 3.0.01040.96A

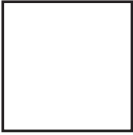



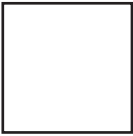

Shows the knob to adjust the right side flap compression roller.







Label code: 3.0.0103.96A

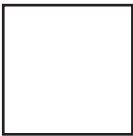

### 3-SAFETY

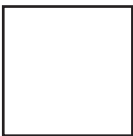

**l**  Shows the knob to adjust the left side flap compression roller.  Label code: 3.0.01044.96A

**m**  Shows the start / stop controls and that inside the circuit breaker box there is electric current.  Label code: 3.0.01090.96A

**n**  Shows the danger of the upper drive belts when running.  Label code: 3.0.01030.96A

**o**  Shows the danger of the bottom drive belts when running.  Label code: 3.0.01031.96A

**p**  Shows the point for earth wire connection on the machine frame  Label code: 3.0.01039.96A

**q**  Identification data of the machine model, serial number and manufacturer  Label code: 3.0.01103.95

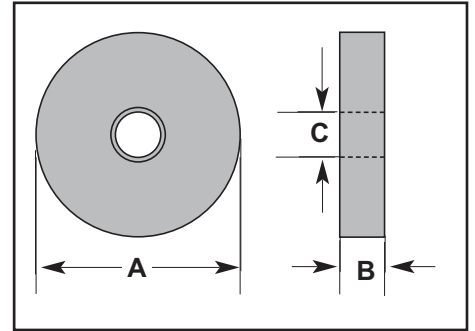
## 4-PRELIMINARY INFORMATION ON THE MACHINE

### 4.1 GENERAL DESCRIPTION OF THE MACHINE

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

### 4.2 TECHNICAL SPECIFICATIONS

- Production = 650 boxes/hour (average)
- Standard power supply = 230/400 V 50Hz 3Ph
- N.2 motors (HP 0,18) KW 0,12
- Taping units K11, tape width 50 mm.
- Weight = 137,5 kg.
- 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:

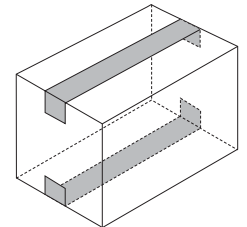
PVC

OPP

ADHESIVE PAPER

### 4.4 PURPOSE OF THE MACHINE

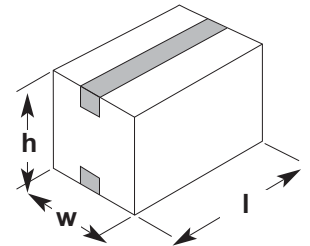
The machine is designed to seal with adhesive tape cases having the dimensions (in millimeters) shown in section 4.5, by applying two tape stripes on their top and bottom flaps simultaneously.



### 4.5 BOX-SIZE RANGE

The case sealer S2-S is automatically adjustable to any box sizes included in the range shown below (part 1).

To seal boxes higher than 750 mm, it is possible to modify the position of the outer columns as shown in the drawing below (part 2).



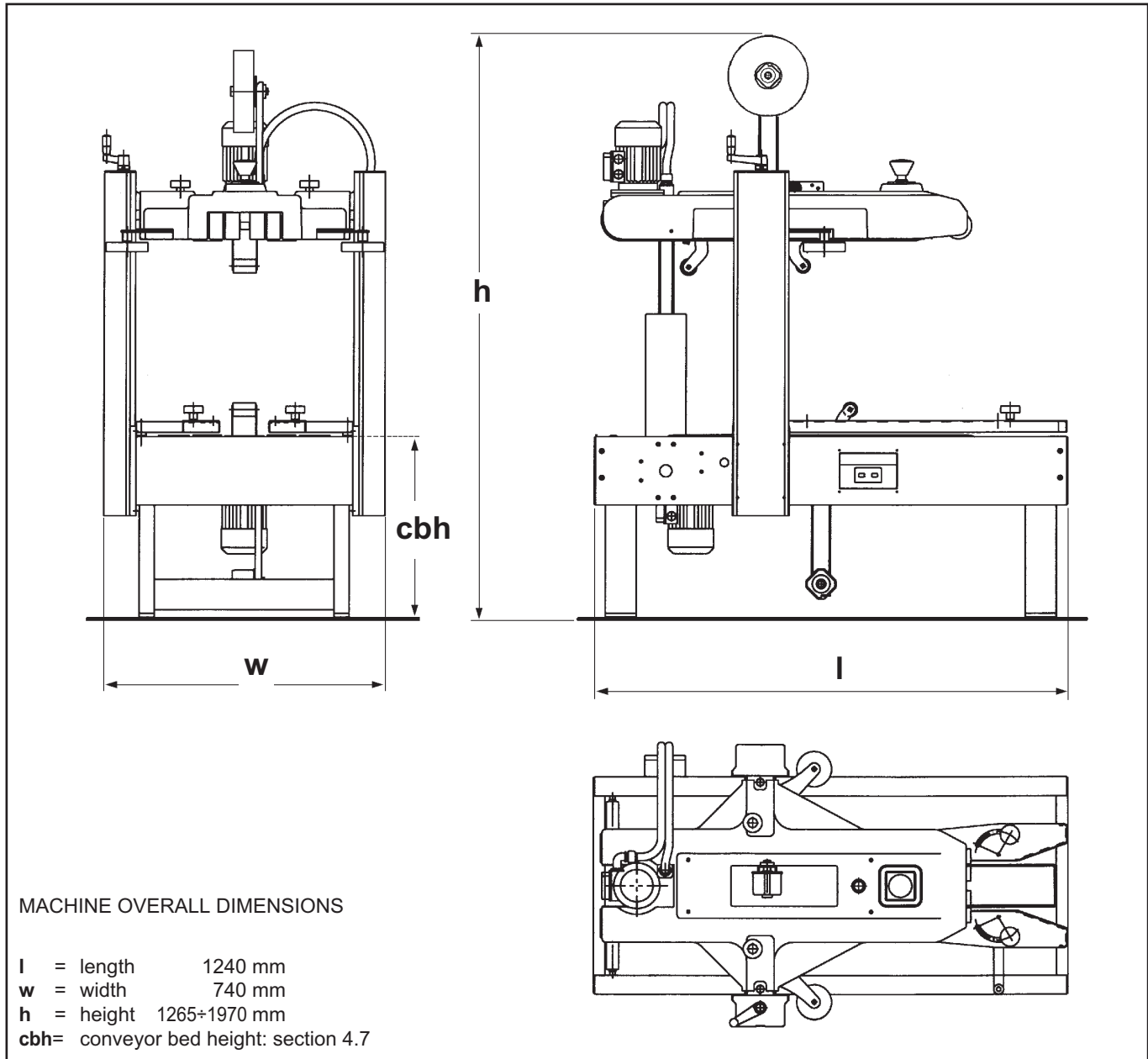
		<b>1 OUTER COLUMNS IN LOW POSITION</b>		
		BOX SIZE	MIN	MAX
	L	150		
	W	140	500	
	H	110	500	
		<b>2 OUTER COLUMN IN HIGH POSITION</b>		
		BOX SIZE	MIN	MAX
	L	150		
	W	140	500	
	H	115	700	

#### NOTES

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

## 4-PRELIMINARY INFORMATION ON THE MACHINE

### 4.6 DIMENSIONS

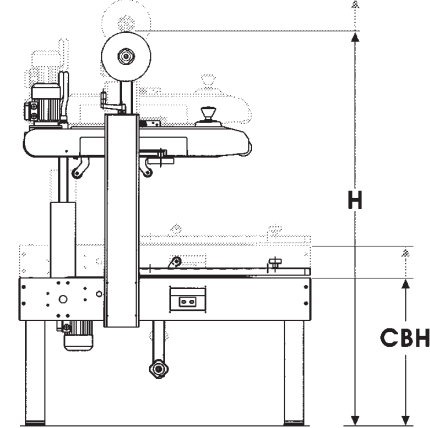
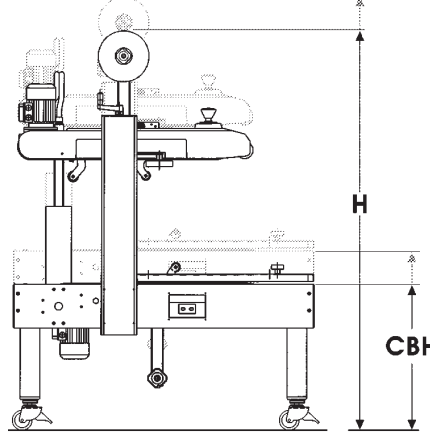
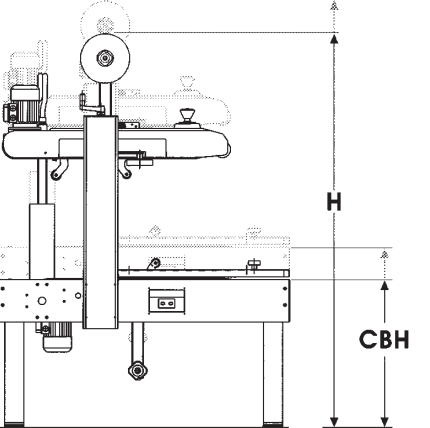
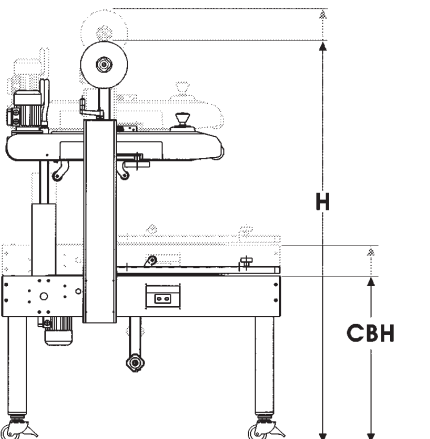


### 4.7 CONVEYOR BED HEIGHT

The case sealer S2-S allows for a wide range of conveyor bed height. Various combinations are possible with the use of the optional accessories AS77 (casters) and AS80 (legs), as shown in the following page.



#### 4-PRELIMINARY INFORMATION ON THE MACHINE

	<h3>A WITH STANDARD LEGS</h3>				
	<h3>B WITH AS77 CASTERS (OPTIONAL)</h3>				
	<h3>C WITH AS80 LEGS (OPTIONAL)</h3>				
	<h3>D WITH AS80 LEGS AND AS77 CASTERS (OPTIONAL)</h3>				
<p>CONVEYOR BED HEIGHT</p> <p>MIN      MAX</p> <p>CBH    <b>485</b>    <b>825</b></p>	<p>OVERALL DIMENSIONS</p> <p>MIN      MAX</p> <p>H        <b>1265</b>    <b>1970</b></p> <p>L        <b>1240</b>    <b>1240</b></p> <p>W        <b>740</b>     <b>740</b></p>				
<p>CONVEYOR BED HEIGHT</p> <p>MIN      MAX</p> <p>CBH    <b>585</b>    <b>925</b></p>	<p>OVERALL DIMENSIONS</p> <p>MIN      MAX</p> <p>H        <b>1365</b>    <b>2070</b></p> <p>L        <b>1240</b>    <b>1240</b></p> <p>W        <b>740</b>     <b>740</b></p>				
<p>CONVEYOR BED HEIGHT</p> <p>MIN      MAX</p> <p>CBH    <b>645</b>    <b>1135</b></p>	<p>OVERALL DIMENSIONS</p> <p>MIN      MAX</p> <p>H        <b>1425</b>    <b>2280</b></p> <p>L        <b>1240</b>    <b>1240</b></p> <p>W        <b>740</b>     <b>740</b></p>				
<p>CONVEYOR BED HEIGHT</p> <p>MIN      MAX</p> <p>CBH    <b>745</b>    <b>1235</b></p>	<p>OVERALL DIMENSIONS</p> <p>MIN      MAX</p> <p>H        <b>1525</b>    <b>2380</b></p> <p>L        <b>1240</b>    <b>1240</b></p> <p>W        <b>740</b>     <b>740</b></p>				

## 4-PRELIMINARY INFORMATION ON THE MACHINE

### 4.8 MAIN COMPONENTS

The machine is composed of:

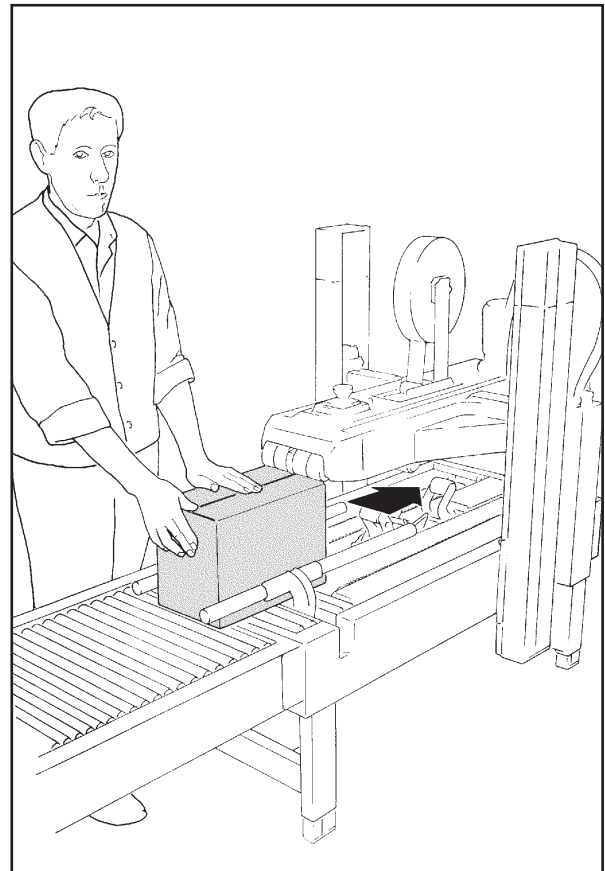
- N. 1 frame
- N. 4 adjustable legs
- N. 2 columns
- N. 2 taping units
- N. 1 top head support
- N. 1 top drive belts assembly
- N. 1 bottom drive belts assembly
- N. 2 electric motors
- N. 1 emergency stop button
- N. 1 main switch ON/OFF

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

### 4.9 OPERATIVE FLOW

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

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



### 4.10 MACHINE NOISE MEASUREMENT

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

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

## 5-SHIPPING-HANDLING-PACKAGE

### 5.1 SHIPMENT AND HANDLING OF THE PACKED MACHINE

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

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

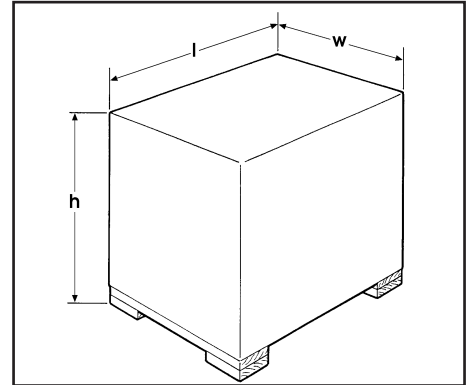
#### PACKAGING OVERALL DIMENSIONS

**l** = length 1300 mm

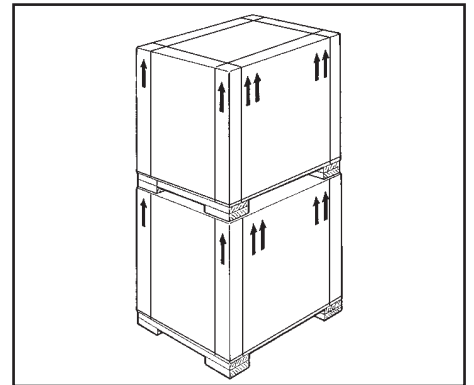
**w** = width 800 mm

**h** = height 1100 mm

Weight kg. 162



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



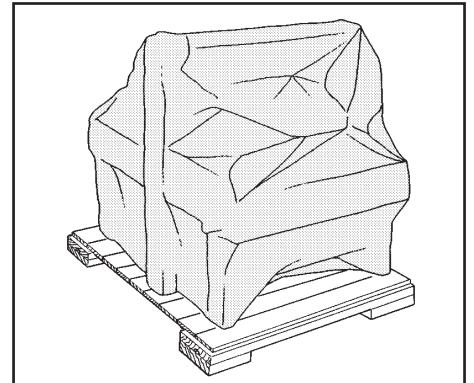
### 5.2 PACKAGING FOR OVERSEAS SHIPMENT (OPTIONAL)

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

### 5.3 SHIPMENT AND HANDLING OF THE UNPACKED MACHINE

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

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



#### MACHINE OVERALL DIMENSIONS

length 1450 mm.

width 740 mm.

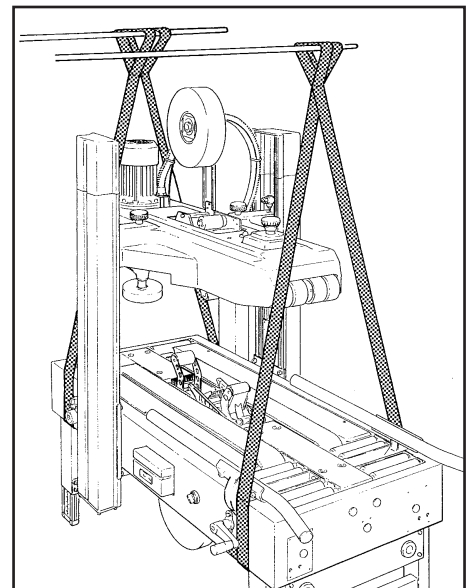
height min. 1265; max. 1970 mm.

Weight kg 137,5

### 5.4 STORAGE OF THE PACKED OR UNPACKED MACHINE

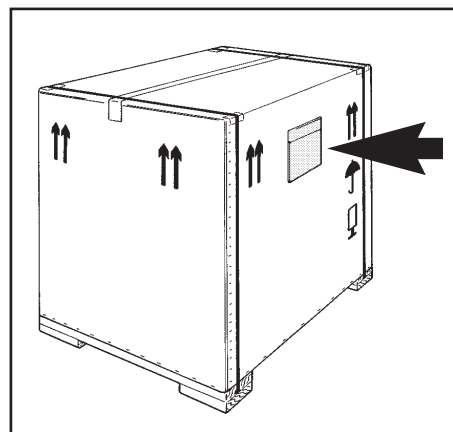
If the machine is left inactive for a long period, please take the following precautions:

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

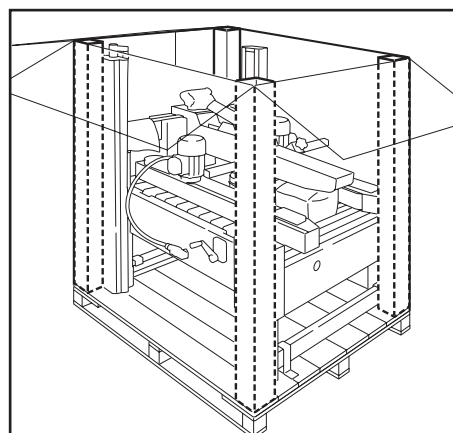


## 6-UNPACKING

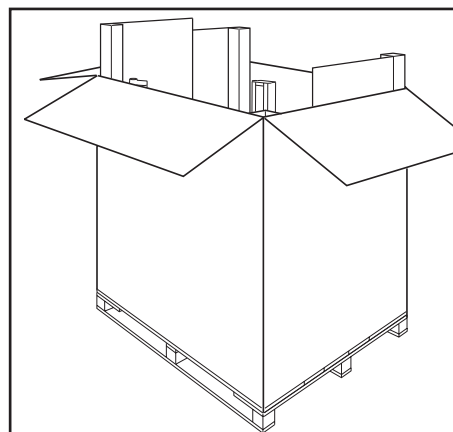
- 6.1 The envelope attached to the external side of the packing case contains the instructions concerning the unpacking of the machine.



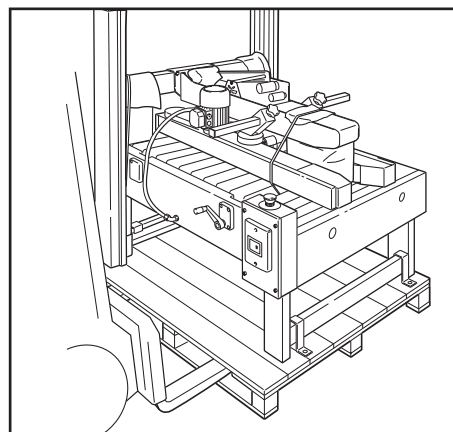
Machine layout inside the packing.



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

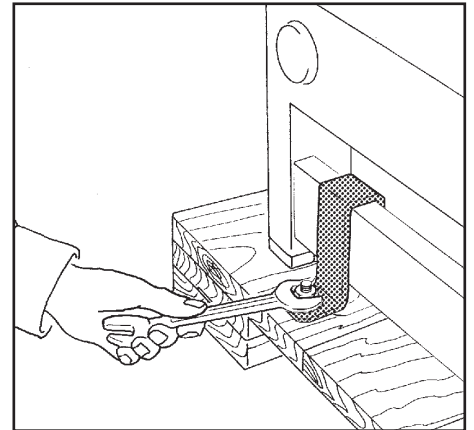


Use a forklift to carry the machine to its working location.  
(Weight of machine + pallet = Kg. 152)



## 6-UNPACKING

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



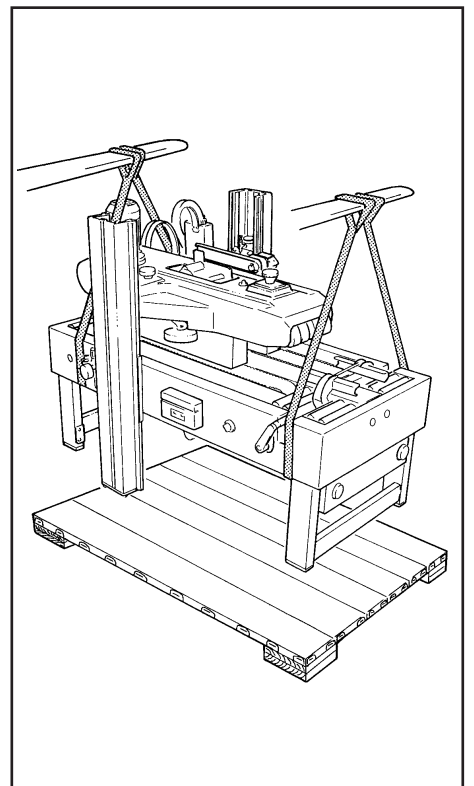
Uplift the machine by using belts or ropes. Pay attention to place the belts in the points shown in Picture and remove the wooden pallet.  
(Machine weight 137,5 kg).

### 6.2 PACKAGING DISPOSAL

The packaging of the machine Mod. SR46-S is composed of:

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

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



## 7-INSTALLATION

### 7.0 SAFETY MEASURES

(Read section 3 carefully).

### 7.1 ENVIRONMENTAL CONDITIONS REQUIRED

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

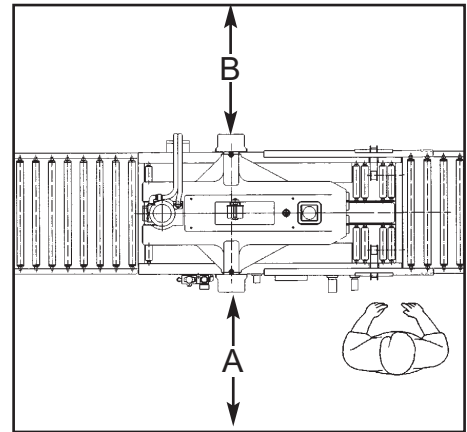
### 7.2 SPACE REQUIRED FOR OPERATION AND MAINTENANCE

Min. distance from the wall:

**A = 1000 mm.**

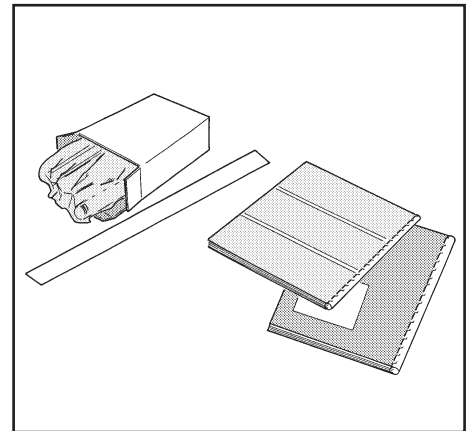
**B = 700 mm.**

Min. height = **2500 mm.**



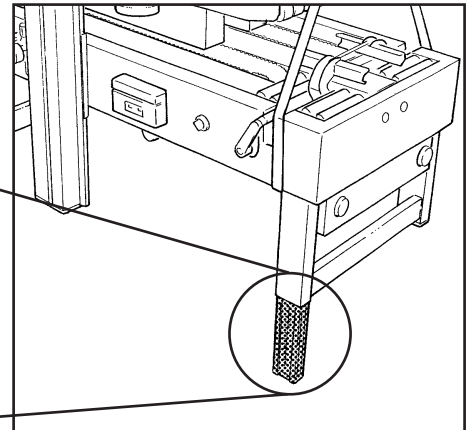
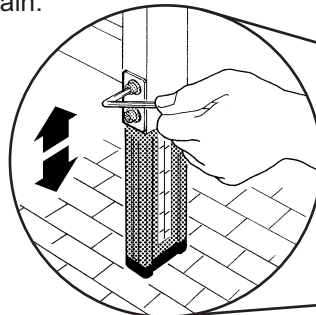
### 7.3 SPARE PARTS AND THREADING TOOL FOR TAPING HEADS SUPPLIED WITH THE MACHINE

For a detailed description see section 13.1.



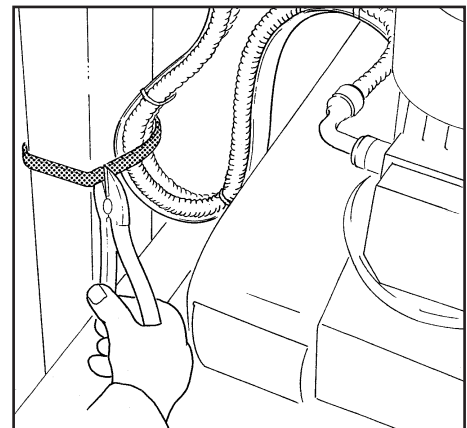
### 7.4 MACHINE POSITIONING

Lift the machine as shown in Picture Unlock the screws and take the legs out looking for the desired conveyor bed height on the graduated label. Then lock the screws again.



### 7.5 LOCKS REMOVAL

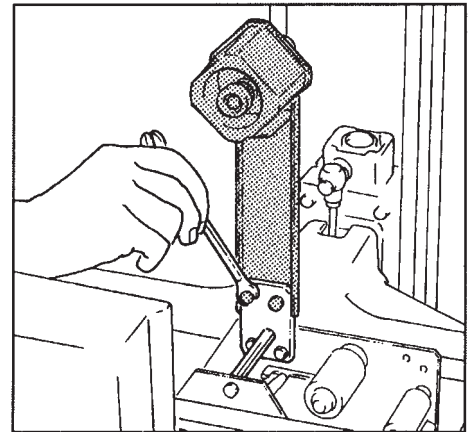
Cut the strap that keeps the wires flexible conduits.



## 7-INSTALLATION

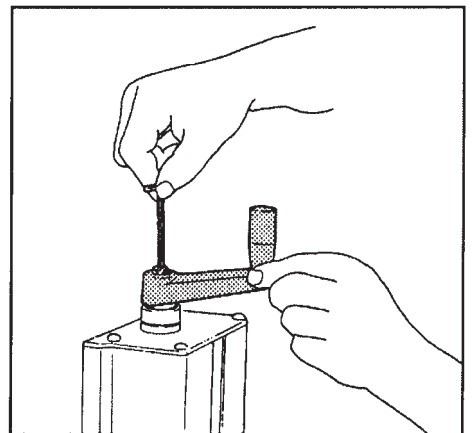
### 7.6 POSITIONING OF THE TOP UNIT TAPE HOLDER

Take away the screws that hold the core holder bracket to the machine. Position the bracket as shown on Picture and lock the screws previously removed.



### 7.7 POSITIONING OF THE CRANK

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

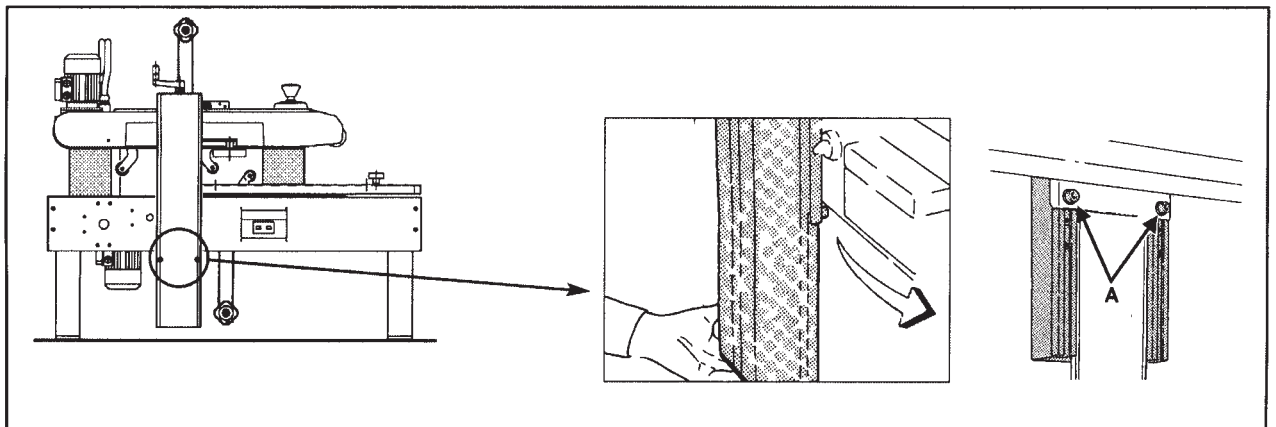
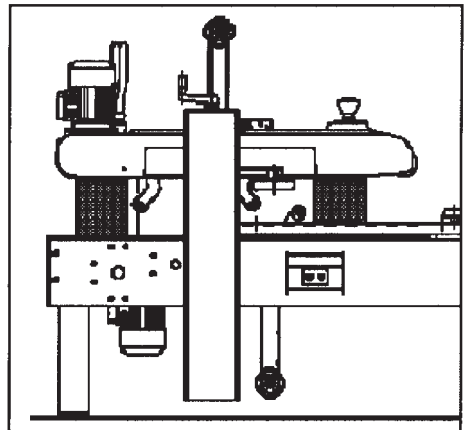


### 7.8 POSITIONING OF THE COLUMNS

With the handle raise the upper head.

Insert enough rigid supports, 25 mm height, on the bottom driving belts and always with the handle lean the upper head on the supports.

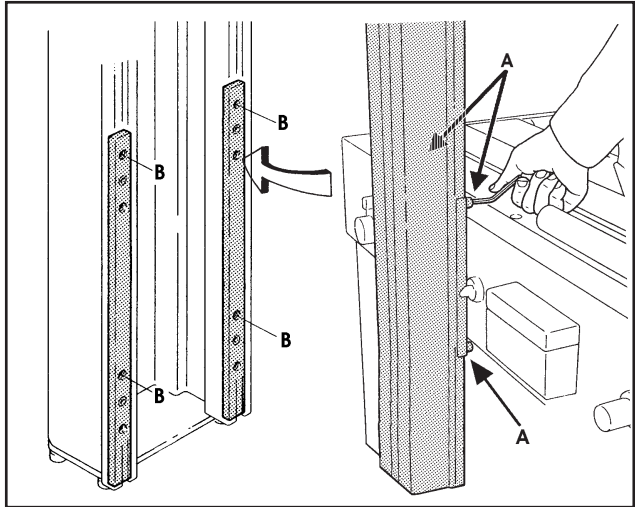
Remove the two screws **A** that fasten the column (with the handle) to the bench of the machine.



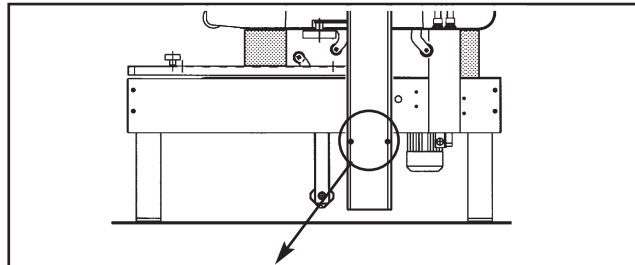
## 7-INSTALLATION

Turn the handle anticlockwise in order to raise the column until it is positioned in correspondence of holes **B**.

Take the other two screws in the spare parts kit and fasten the column (four screws for column **A**).

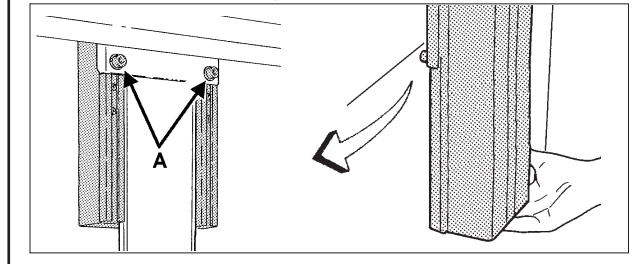


Keep with one hand the column without the handle and remove the two screws **A**.



Push up the column until positioning it in correspondence of the holes **B**.

Take the other two screws in the spare parts kit and fasten the column (four screws each column).



Raise the upper head turning the handle clockwise and remove the supports.

### 7.9 PRELIMINARY ELECTRIC CHECK-OUT

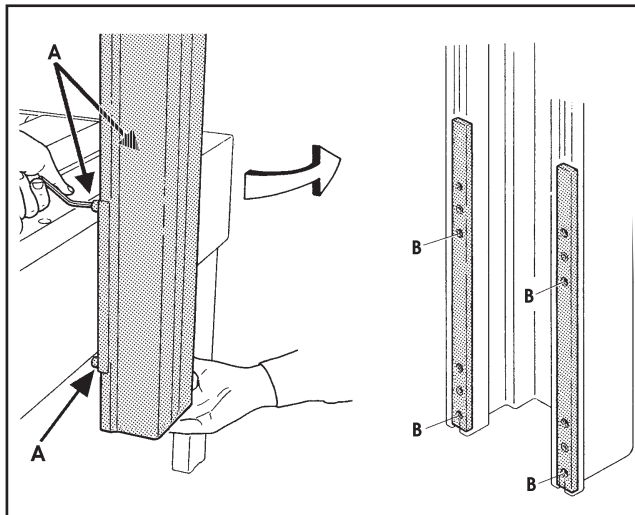
Before connecting the machine to the mains please carry out the following operations:

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

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

**7.9.3** The machine is fitted with a main switch having a maximum breaking power of 6 kA and a short-circuit breaker pre-set at 120 A.

The user will be responsible of testing the short-circuit current in its facility and should check that the short-circuit amperage setting on the main switch of the machine is compatible with all the components of the mains system.





## 7-INSTALLATION

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

Power supply = 0,240 kW

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

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

-Push the LOCKABLE EMERGENCY STOP BUTTON

-The magnetothermic main switch is normally turned OFF.

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

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

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

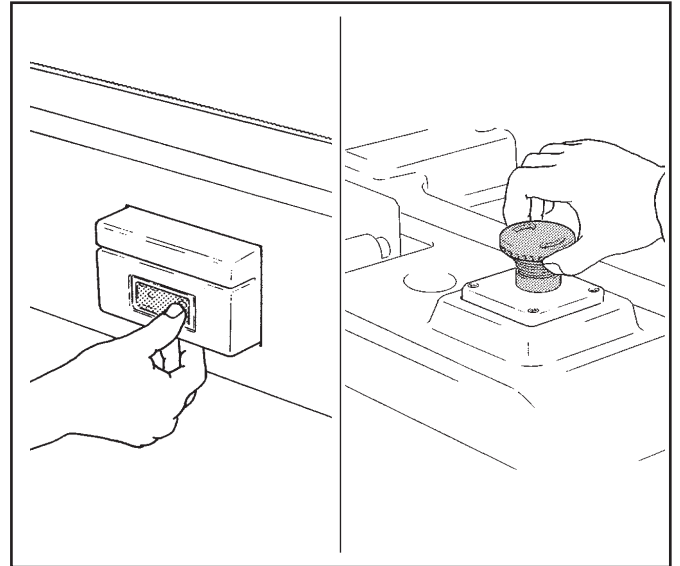
-Remove any tools from the conveyor bed.

-Release the lockable emergency stop button turning it clockwise.

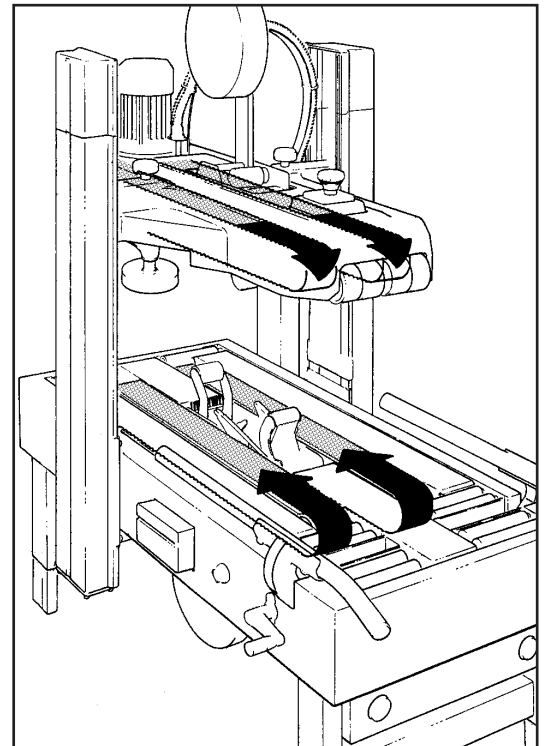
-Push button ON of the main switch.

-Check the rotation direction of the side drive belts.

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



Correct rotation direction of the side drive belts.



## 8-THEORY OF OPERATION

---

### 8.1 DESCRIPTION OF THE WORKING CYCLE

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

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

Afterwards the case is expelled on the exit conveyor.

### 8.2 OPERATING MODES

The case sealer Mod. S2-S 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 is located on the infeed side of the top head.

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

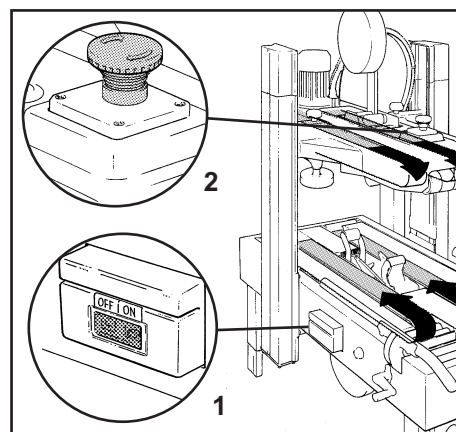
## 9-CONTROLS IN BRIEF

### 9.1 START/STOP BUTTON (2)

It starts/stops the box drive belts.

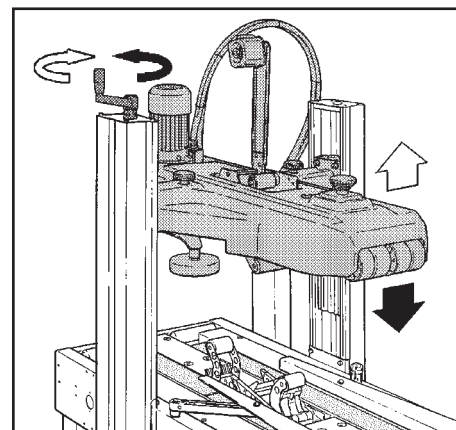
### EMERGENCY STOP BUTTON (1)

It stops the machine cycle.



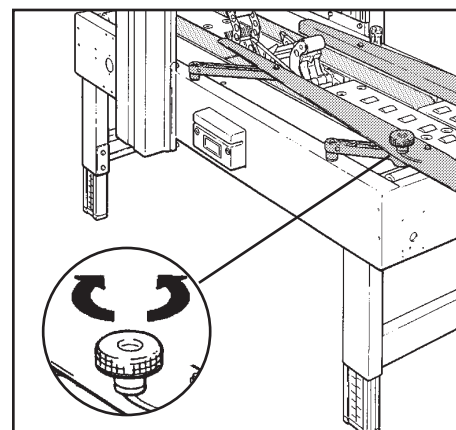
### 9.2 BOX WIDTH ADJUSTMENT CRANK

It adjusts the upper head according to the box height.



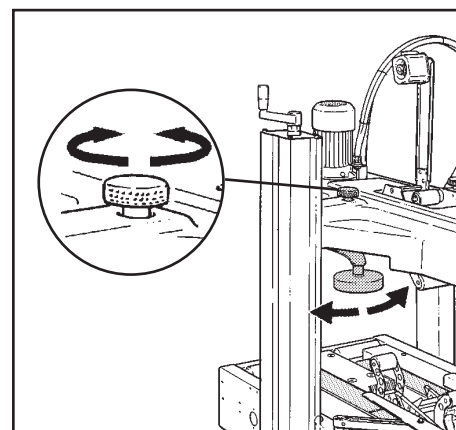
### 9.3 BOX WIDTH ADJUSTMENT KNOBS

It adjusts the side guides according to the box width.



### 9.4 FLAP COMPRESSION ROLLERS LOCKING KNOB

Locks / unlocks the flap compression rollers.

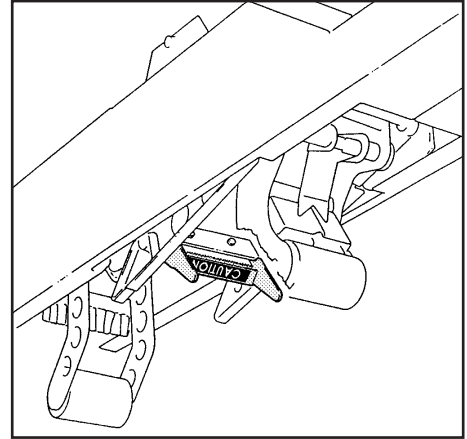


## 10-SAFETY DEVICES OF THE MACHINE

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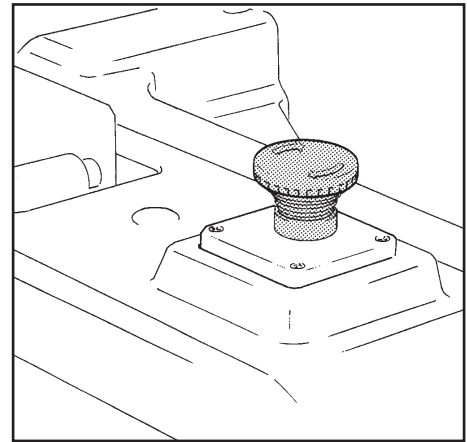
### 10.1 BLADE GUARDS

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



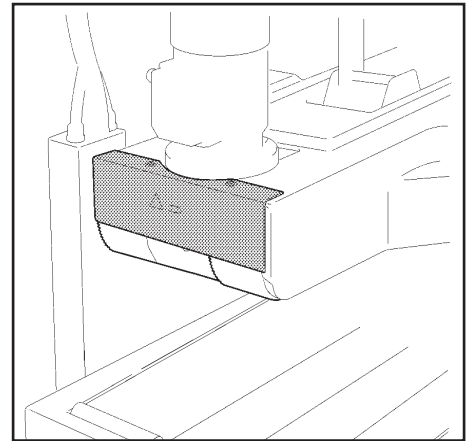
### 10.2 EMERGENCY STOP BUTTON

The lockable emergency stop button is placed in handy position.



### 10.3 METAL SAFETY GUARD

Safety guard of the top driving belts.



### 10.4 ELECTRIC SYSTEM

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

(See section **ENCLOSURES 15.5**)

## 11-SET-UP AND ADJUSTMENTS

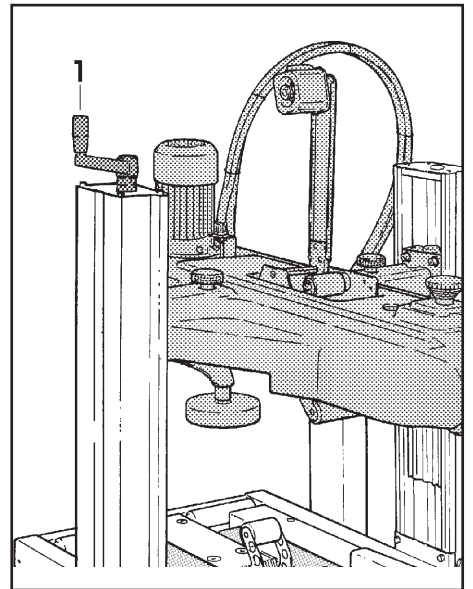
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### 11.0 SAFETY

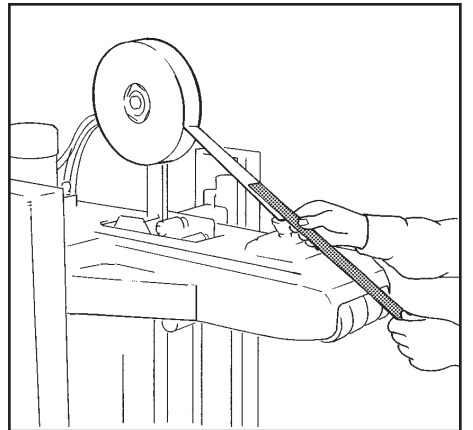
All the set-up operations and adjustments must be carried out when the machine is stopped and the EMERGENCY STOP BUTTON is locked.

### 11.1 TAPE LOADING ON THE TOP UNIT

Turn clockwise the handle 1 to raise the upper head at the desired height.



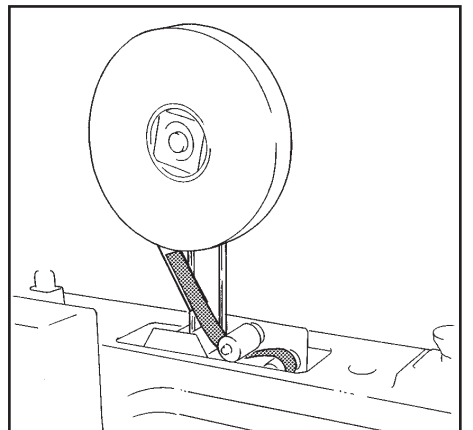
Attach the tape leg to the threading tool (supplied with the tools kit).



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

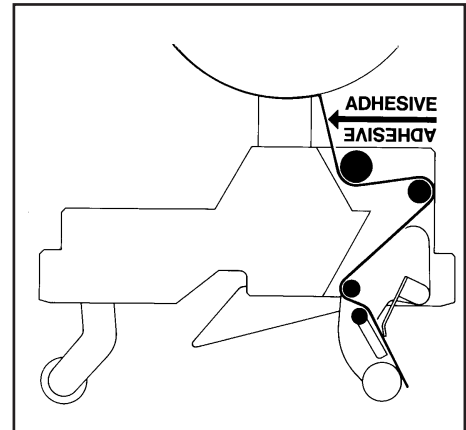


Insert the plastic threading leader through the taping unit. Take care to keep hands away from the tape cutting blades. (see section 3.11-g).

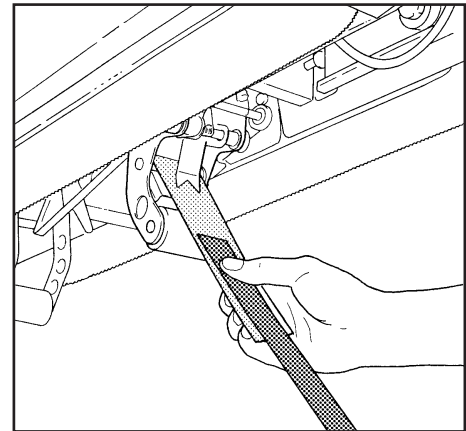
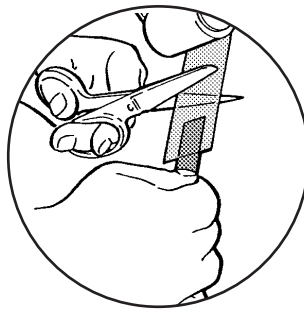


## 11-SET-UP AND ADJUSTMENTS

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

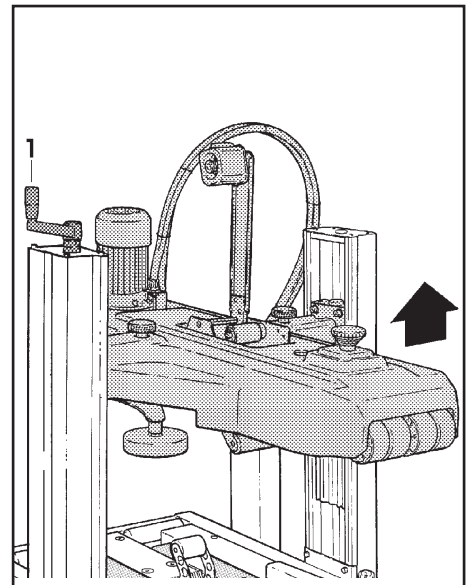


Pull and cut off the tape in excess.



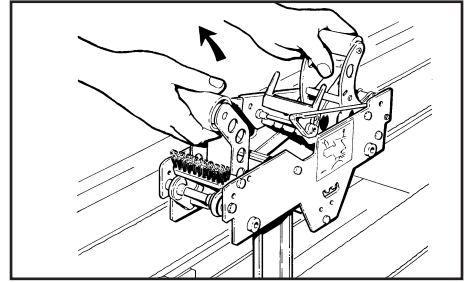
### 11.2 TAPE LOADING ON THE BOTTOM UNIT

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

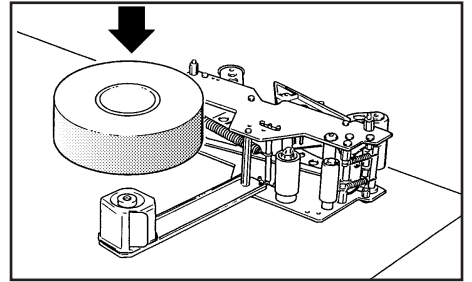


## 11-SET-UP AND ADJUSTMENTS

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



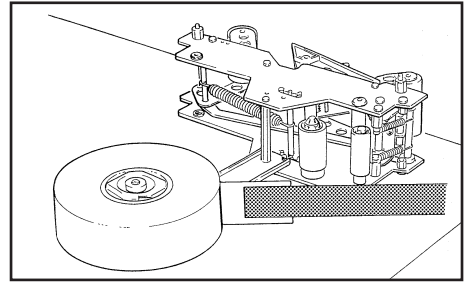
Put a tape roll on the drum.



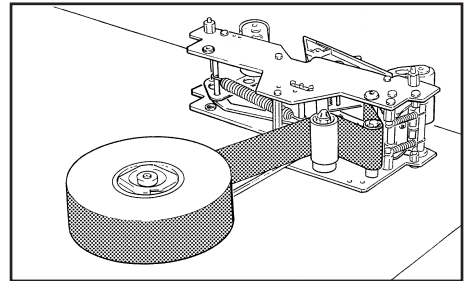
**WARNING! Very sharp blade. It may cause serious injuries.**



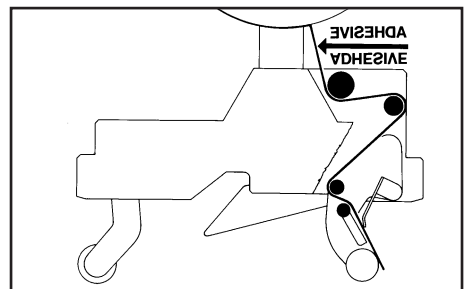
. Attach the tape leg to the threading tool (supplied with the tools kit).



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

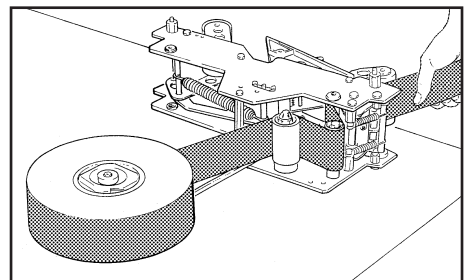
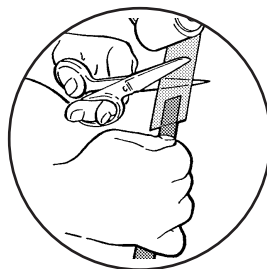


Follow the path through the unit as shown on Picture and make sure that the adhesive side is placed on the correct side.




Pull and cut off the excess tape.

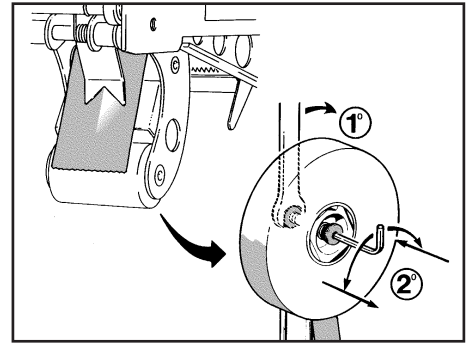
Put again the taping head into its seat..




## 11-SET-UP AND ADJUSTMENTS

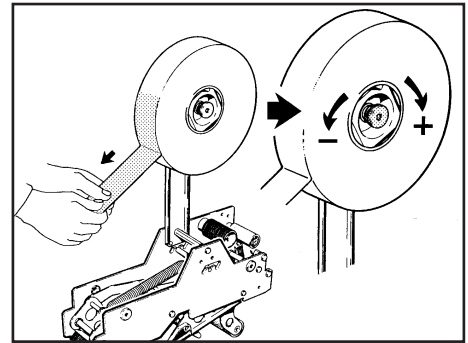
### 11.3 TAPE DRUM ALIGNMENT

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




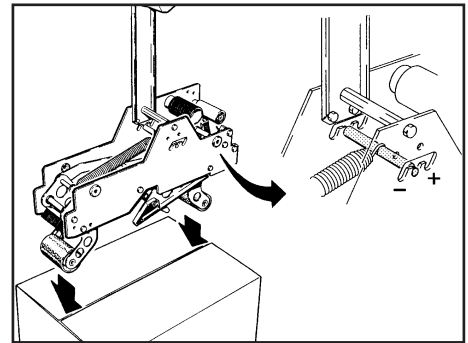
### 11.4 TAPE DRUM FRICTION BRAKE ADJUSTMENT

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




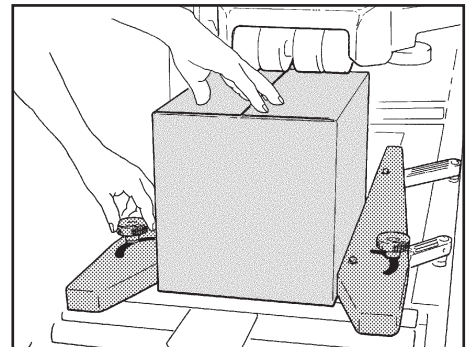
### 11.5 ADJUSTMENT OF TAPING UNITS ACCORDING TO THE TYPE OF BOXES

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




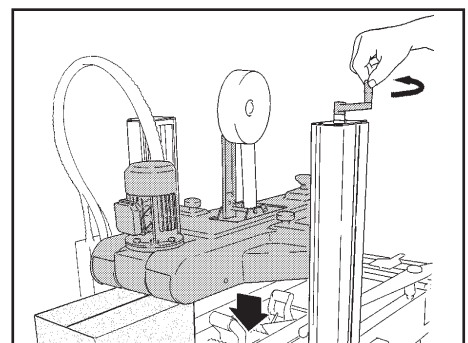
### 11.6 BOX WIDTH ADJUSTMENT

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



### 11.7 BOX HEIGHT ADJUSTMENT


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

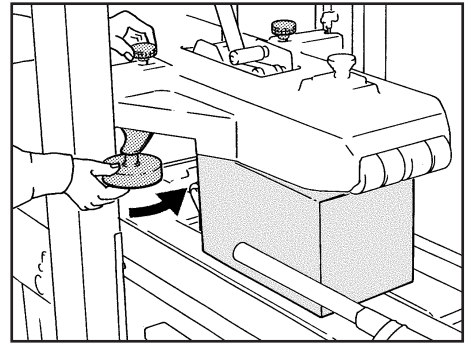




## 11-SET-UP AND ADJUSTMENTS

### 11.8 ADJUSTMENT OF THE TOP FLAP COMPRESSION ROLLERS

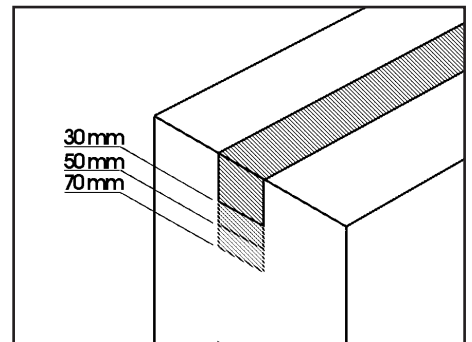
 Approach the rollers to the carton and tighten the knobs.



### SPECIAL ADJUSTMENTS

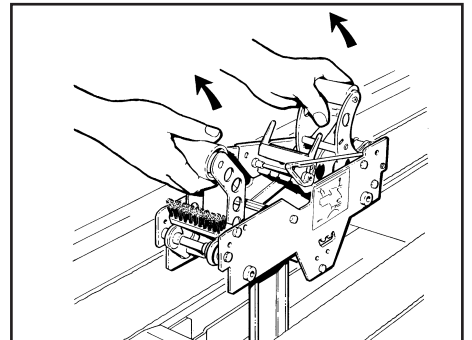
#### 11.9 CHANGE OF THE TAPE LEG LENGTH

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



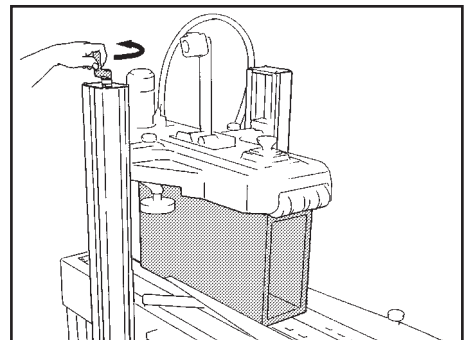
#### 11.10 COLUMN EXTENSION (OPTIONAL) AS82

Remove the taping head from its housing.

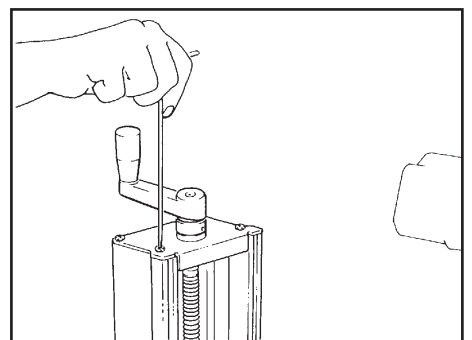


Position a wooden box or metal case on the conveyor bed.

Lower the top group using the crank until it reaches the support.

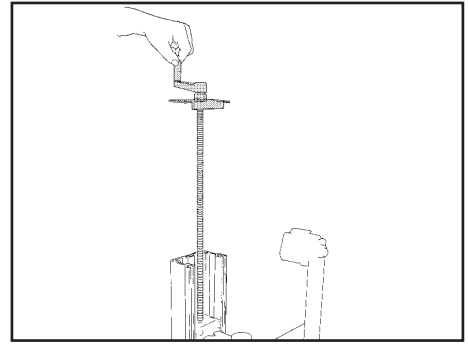


Remove the four screws of the upper cover of the column (handle side).

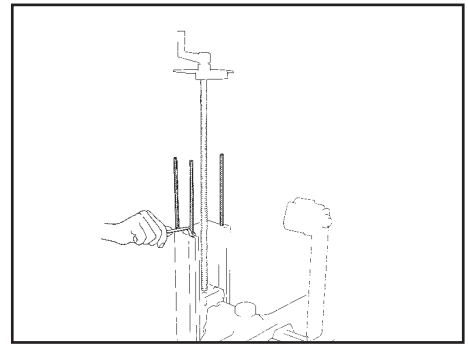


## 11-SET-UP AND ADJUSTMENTS

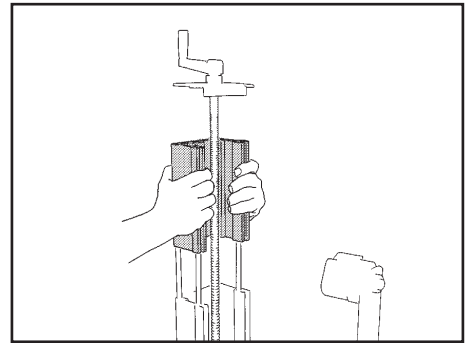
Turn the handle to raise the cover of some 430 mm over the column.



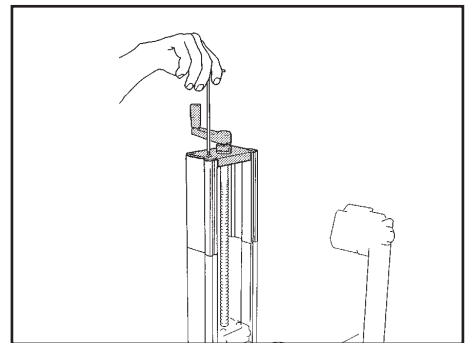
Screw the four spacers in the threaded holes and fasten them with an 8 mm wrench.



Insert in the four hexagonal spacer the column extension.

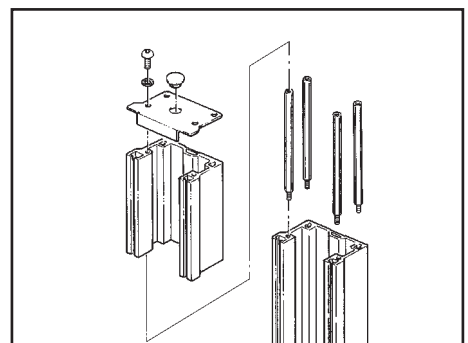


Turn the handle until the cover is down on the column.  
Fasten with the screws removed before.



Repeat the same operations on the column on the opposite side (without handle).

Raise the head with the handle, remove the rigid supports, insert the bottom taping head in its housing.



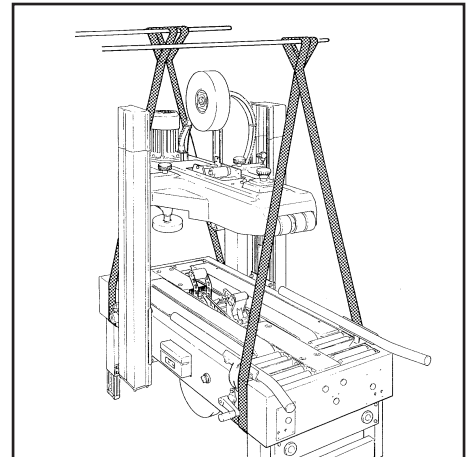
## 11-SET-UP AND ADJUSTMENTS

### OPTIONAL ACCESSORIES

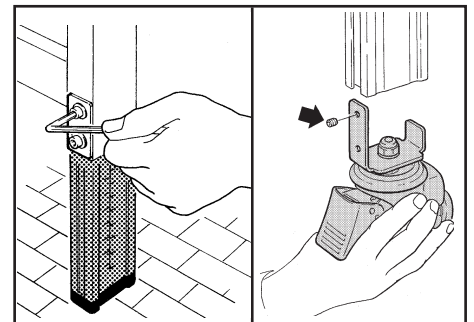
#### 11.11 AS77 CASTERS (OPTIONAL) (code nr. 7.8.04337.00B)

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

Lift the machine as shown on Picture.



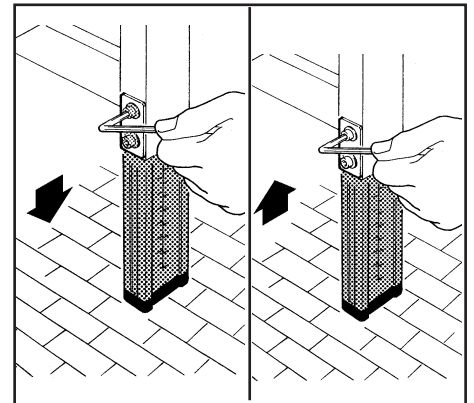
Remove the pad-feet, insert the casters fixing them with the two dowels and set the desired conveyor bed height (refer to the graduated leg label).  
(Caster height = 100 mm-4 inch).



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

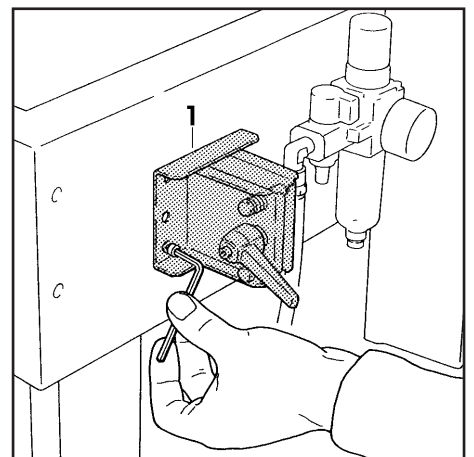
To obtain a higher range of conveyor bed height as indicated at section 4.7, it is necessary to replace the inner legs with the longer AS80 legs.

Uplift the machine as shown on Picture.  
Unlock the screws and take out the legs. Insert the new legs and block them at the desired height.



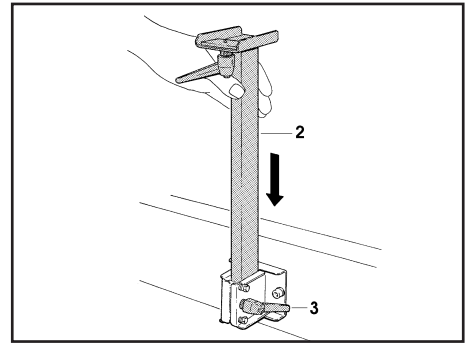
#### 11.13 ATTACHMENT FOR THE KOMPATTO INK-JET MARKER (OPTIONAL) (code nr. 7.8.04044)

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

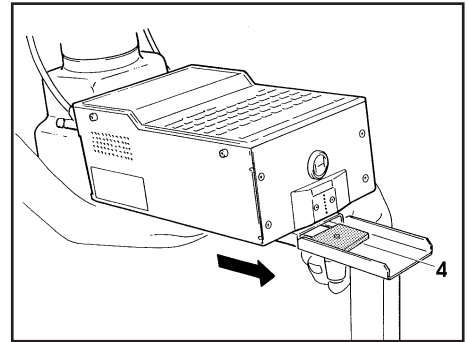


## 12-OPERATION

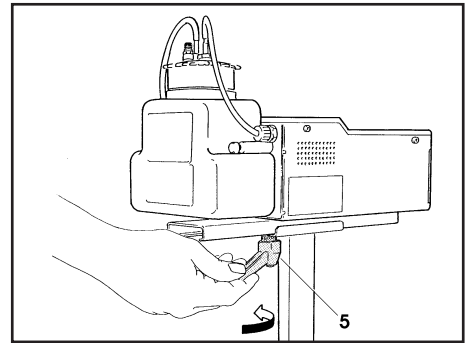
Insert the adjustable support **2** into the guide and lock it with the knob **3**.



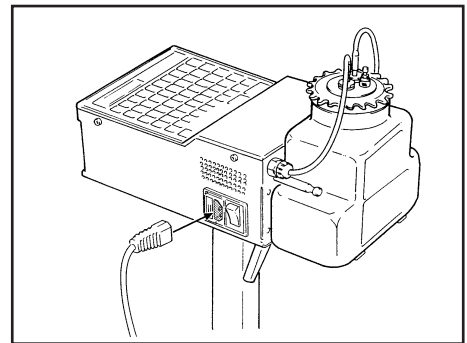
Slide the printing head into the horizontal plate of the support. Make sure to position correctly the plate **4**.



Block with handle **5**.

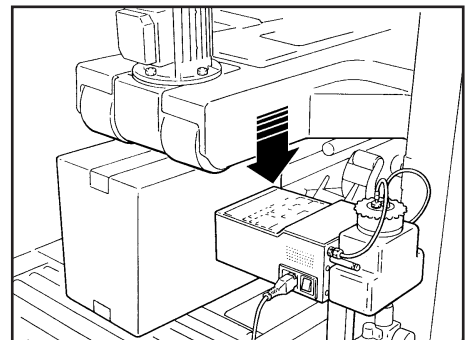


After checking that the voltage on the Kompatto nameplate matches your local voltage, connect the power cord to the mains.



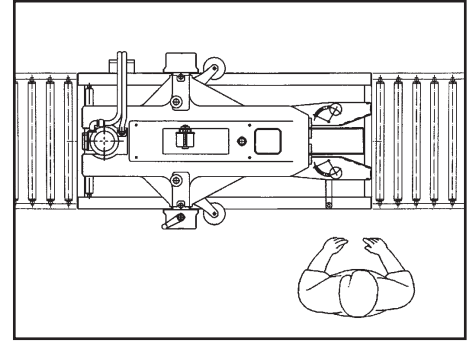
**WARNING:** the Kompatto can interfere with the machine upper assembly. Before adjusting the machine for a new box format, always slide the Kompatto unit fully outwards.

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



## 12-OPERATION

### 12.1 OPERATOR'S CORRECT WORKING POSITION



### 12.2 STARTING THE MACHINE

Push the main switch ON.

### 12.3 STARTING PRODUCTION

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

### 12.4 TAPE REPLACEMENT

**Be careful with the blades !**

Skill 1 operator



When needed, replace the tape roll, as follows:

-Press the LOCKABLE EMERGENCY STOP BUTTON;

-Repeat all the operations shown in sections 11.1 and/or 11.2

### 12.5 BOX SIZE ADJUSTMENT

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

### 12.6 CLEANING

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



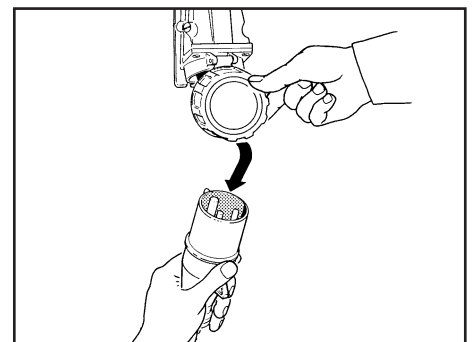
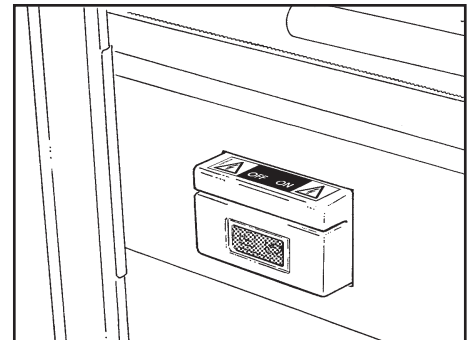
Disconnect the electric power.



CLEANING - Skill 1 operator

Use dry clothes or light detergents.

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



## 12-OPERATION

### 12.6 TABLE OF ADJUSTMENTS

OPERATIONS	OPERATOR'S SKILL	SECTIONS
Tape loading	1	11.1 - 11.2
Tape alignment	1	11.3
Checkout of the safety devices	1	12.8
Adjustment of tape drum friction brake	1	11.4
Box size adjustment	1	11.6
Adjustment of flap compression rollers	1	11.8
Adjustment of tape applying spring	1	11.5
Conveyor bed height adjustment	1	7.4
<b>Special adjustment:</b> Tape leg	2	11.9
<b>Special adjustment:</b> Column extension	2	11.10

### 12.7 SAFETY DEVICES CHECKOUT

- 1 Taping units blade guard (section 10.1)
- 2 Lockable emergency stop button (section 10.1)
- 3 STOP (OFF) button on main switch (sections 7.9.3 and 9.1)

### 12.8 TROUBLE SHOOTING

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

## 13-MAINTENANCE AND REPAIRS

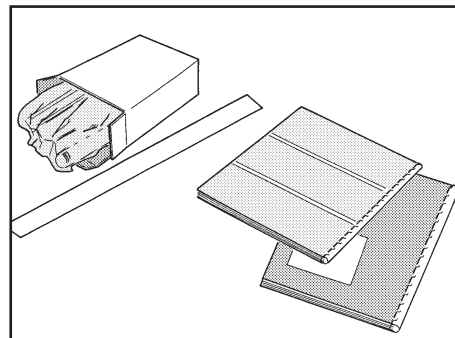
### 13.0 SAFETY MEASURES

(see section 3)

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

### 13.1 SPARE PARTS SUPPLIED WITH THE MACHINE

- 1 N.1 blade (spare blade for taping unit, cod. S4004152ZZZ);  
N.1 lower head spring (cod. S370017992Z);  
N.1 upper head spring (cod. S370017894Z);  
N.2 cutter spring (cod. S37022794Z);
- 2 Tape threading tool (to feed the tape through the taping unit)  
cod. S310091406Z
- 3 Instructions manual of the machine (cod. SMB00050K)
- 4 Instructions manual of the taping unit (cod. S300024196A)



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

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

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

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

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

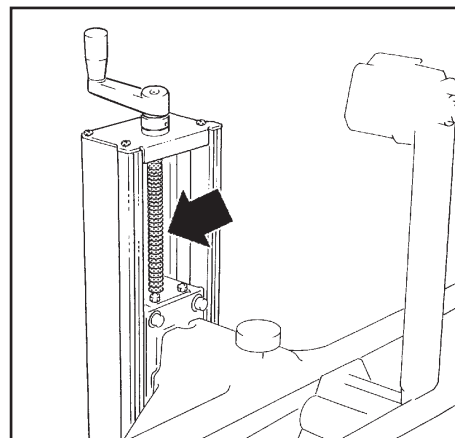
At the end of every maintenance operation check the safety devices.

### 13.4 SAFETY DEVICES CHECK-OUT

- 1 Taping units blade guard (section 10.1)
- 2 Lockable emergency stop button (section 10.1)
- 3 STOP (OFF) button on main switch (sections 7.9.3 e 9.1)

### 13.5 MACHINE LUBRICATION

Lubricate quarterly the column's endless screw.



## 13-MAINTENANCE AND REPAIR

### 13.6 SUGGESTED PRODUCTS FOR LUBRICATION

#### GREASE TYPE:

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

METAL/PLASTIC: PLATE MASTER M+L (molybdenum grease and PTFE for plastic and metallic materials)

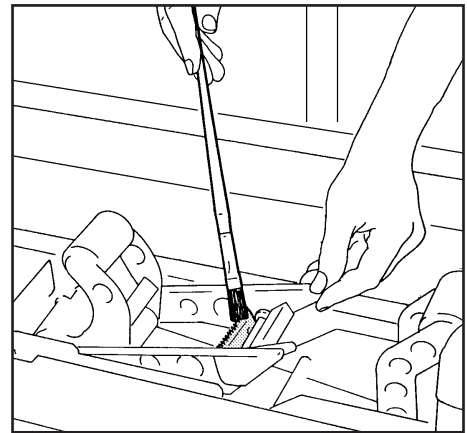
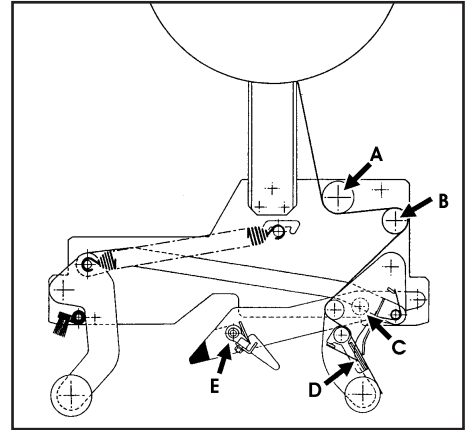
#### OIL TYPE:

regular lubricating oil or general purpose spray lubricant.

### 13.7 LUBRICATION OF THE TAPING UNIT

Lubricate monthly with oil the points shown on Picture.

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



### 13.8 BLADE CLEANING



Skill 2 operator

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

### 13.9 BLADE REPLACEMENT

Skill 2 operator

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

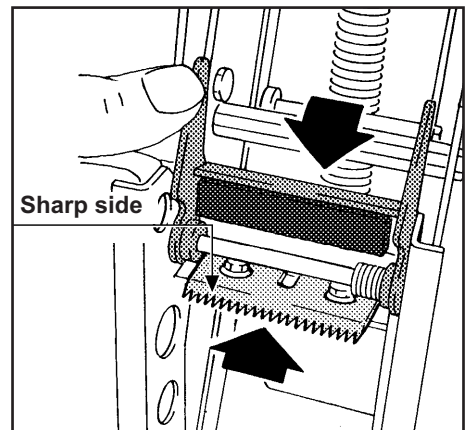
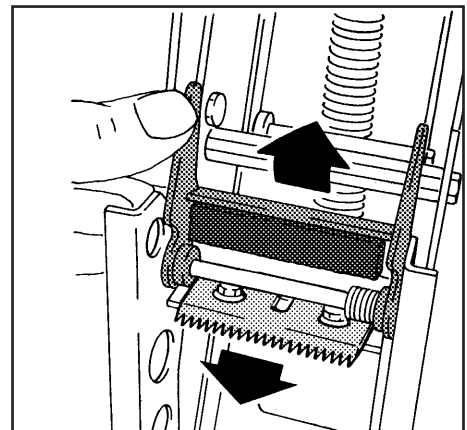
#### WARNING!

Very sharp blade.

Any error may lead to bad injuries.



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



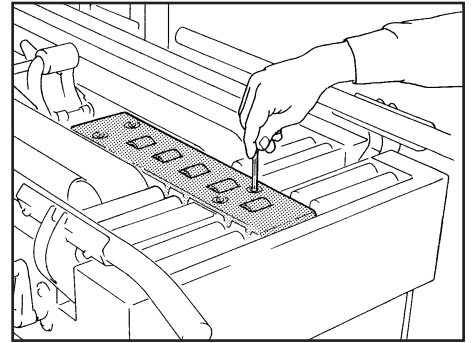


## 13-MAINTENANCE AND REPAIRS

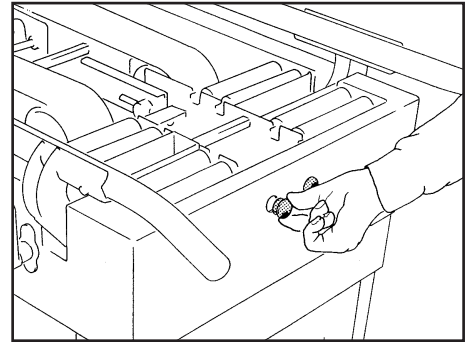
### 13.10 BOTTOM DRIVE BELTS REPLACEMENT

Skill 2 operator

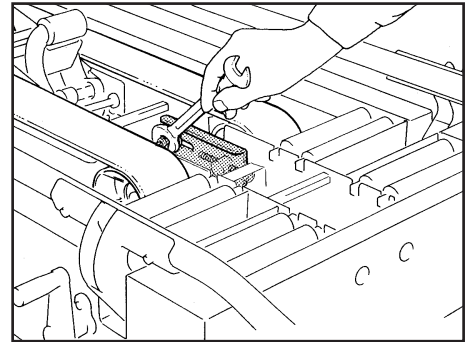
- Remove screws.
- Take the protection cover away.



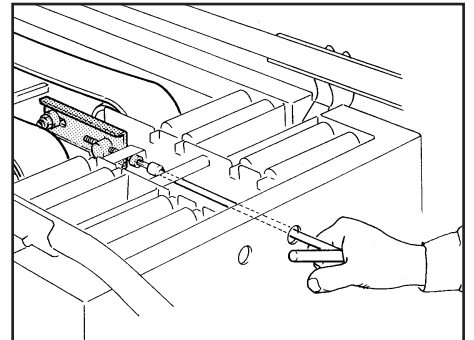
- Take the two caps away.



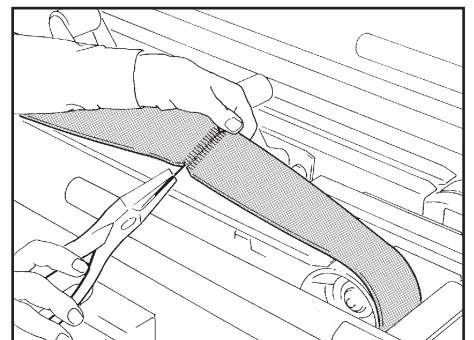
Loosen the locking nut.



Loosen the tensioning screw.



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

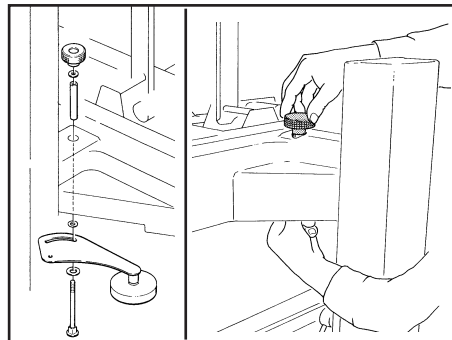


## 13-MAINTENANCE AND REPAIRS

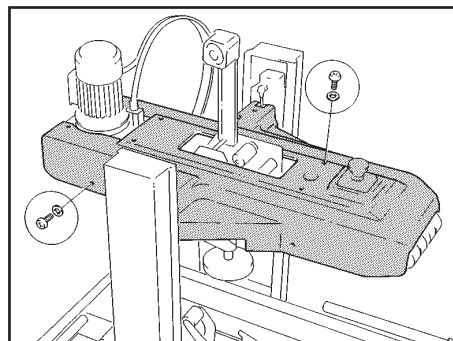
### 13.11 TOP DRIVE BELTS REPLACEMENT

Skill 2 operator

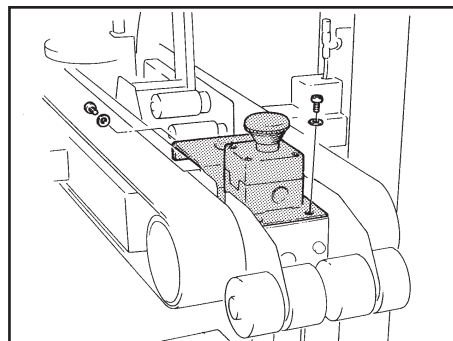
Loose the knobs of the side compression rollers and take the studs out from the bottom.



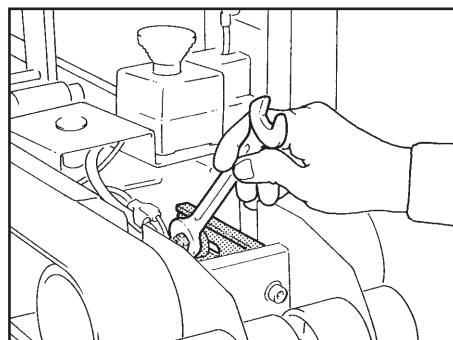
Remove the ten screws that hold the carter and take it out.



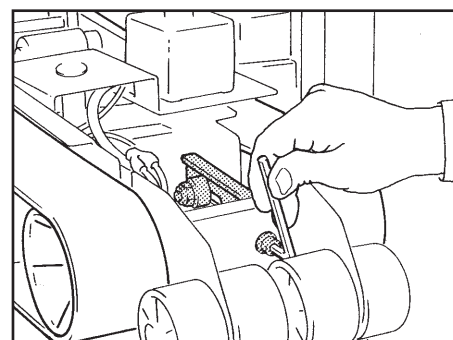
Remove the four screws that hold the EMERGENCY STOP support and put it near the taping unit.



Loosen the fastening screw.

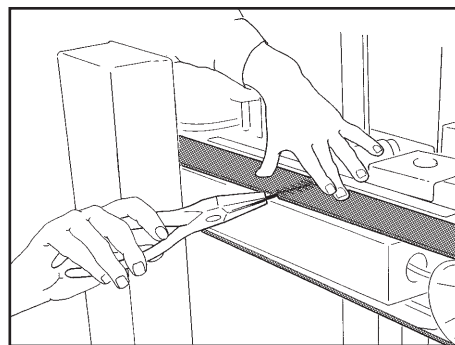


Loosen the tensioning screw.



## 13-MAINTENANCE AND REPAIRS

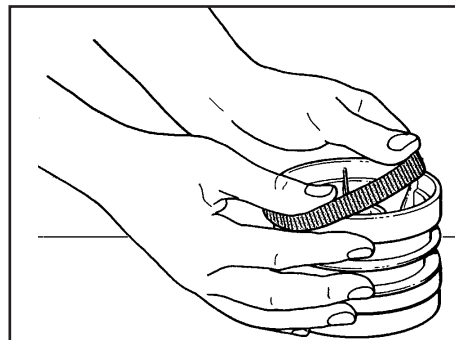
- Cut the worn belt.
- Position the new belt.
- Insert between the lace a nylon hinge.
- Adjust the belt tension.



### **WARNING!**

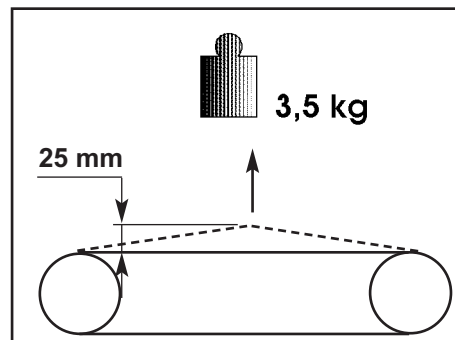


Before setting the new belt, check the wear of the orange plastic rings on the drive pulleys: replace them if they are worn out.



### **13.12 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





## 14-ADDITIONAL INSTRUCTIONS

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

The machine is made of the following materials:

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

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

### 14.2 INSTRUCTIONS ON EMERGENCY SITUATIONS

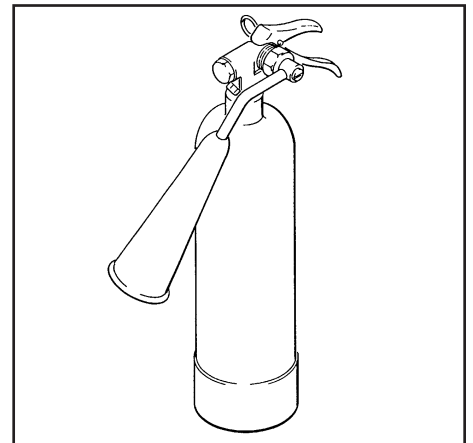
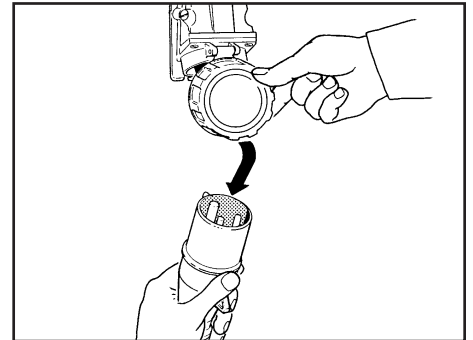
#### *ISTRUZIONI PER SITUAZIONI DI EMERGENZA*

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

#### **FIRE**

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

**DO NOT** use water.



## 15-ENCLOSURES

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### 15.1 STATEMENT OF CONFORMITY

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

### 15.2 SAFETY LABELS

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

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

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

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

Nothing to report

### 15.4 ELECTRIC TESTS

Electric tests:

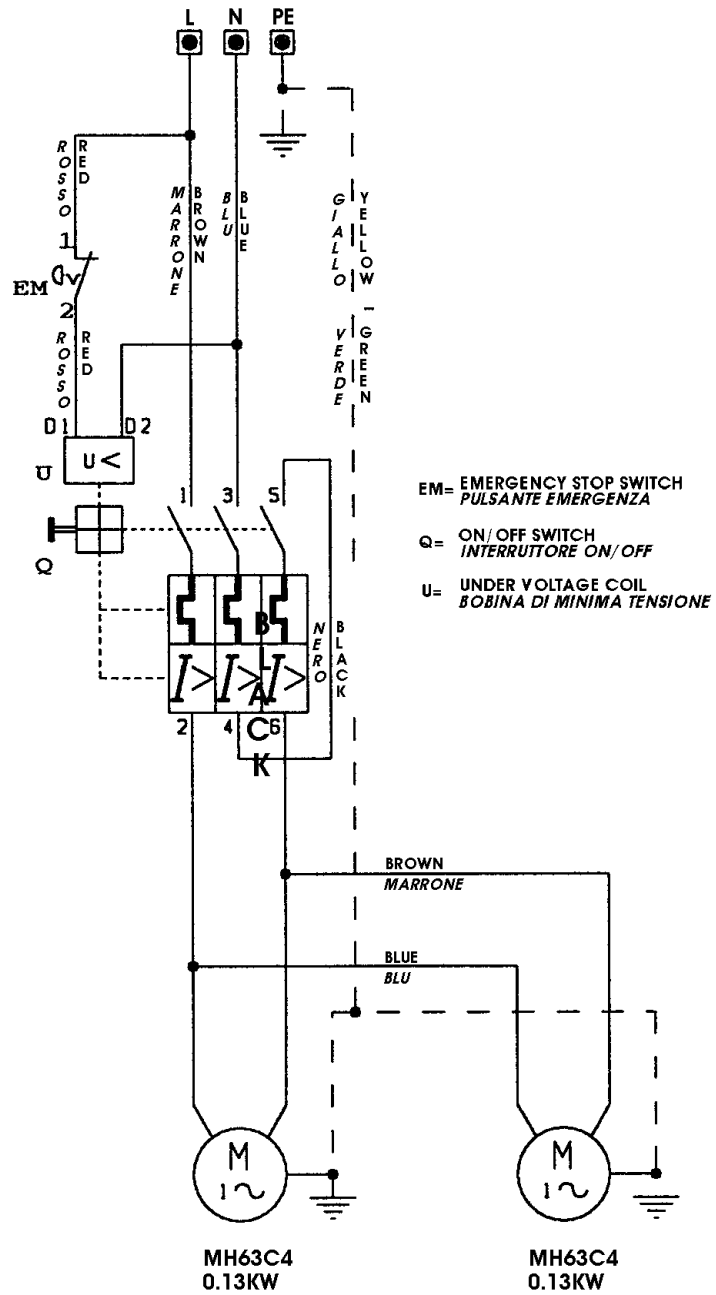
1 - Continuity of the ground circuit

2 - Insulation resistance

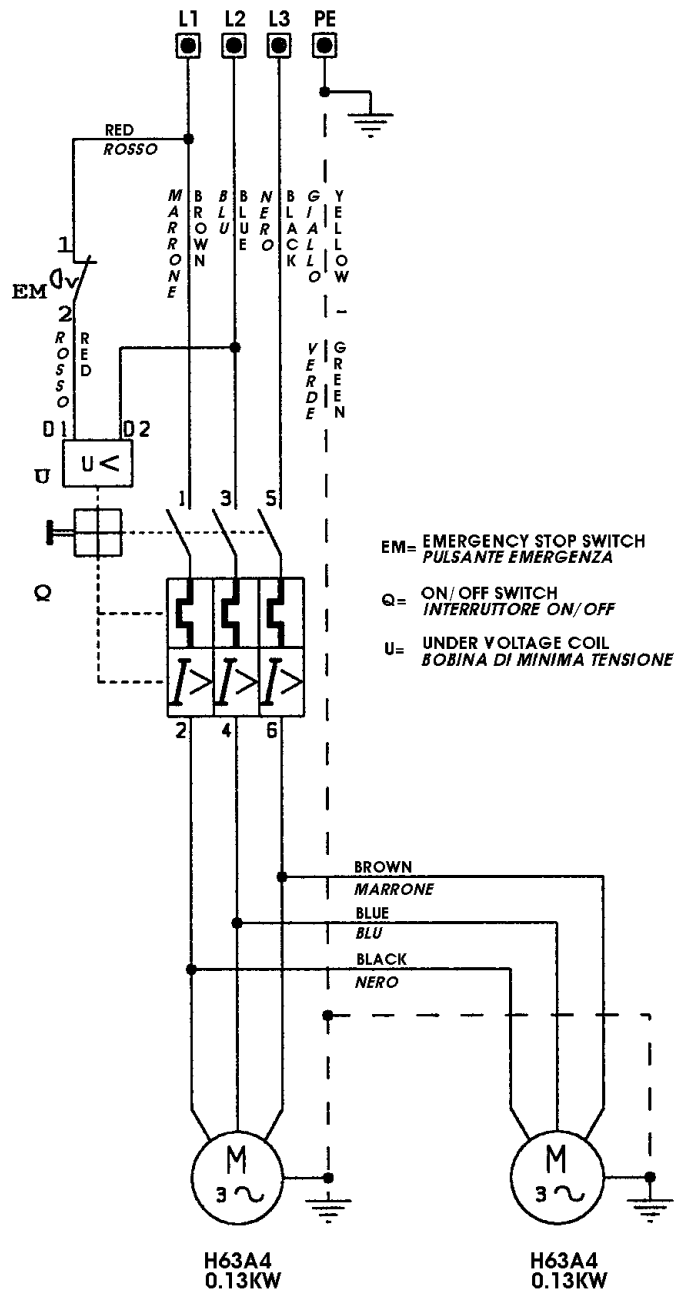
3 - High voltage insulation

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

# 16-DRAWINGS AND SCHEMATICS



SINGLE-PHASE  
MONOFASE



THREE-PHASE  
TRIFASE



Fig. 10125

Fig. 10130

Fig. 10128

Fig. 10129

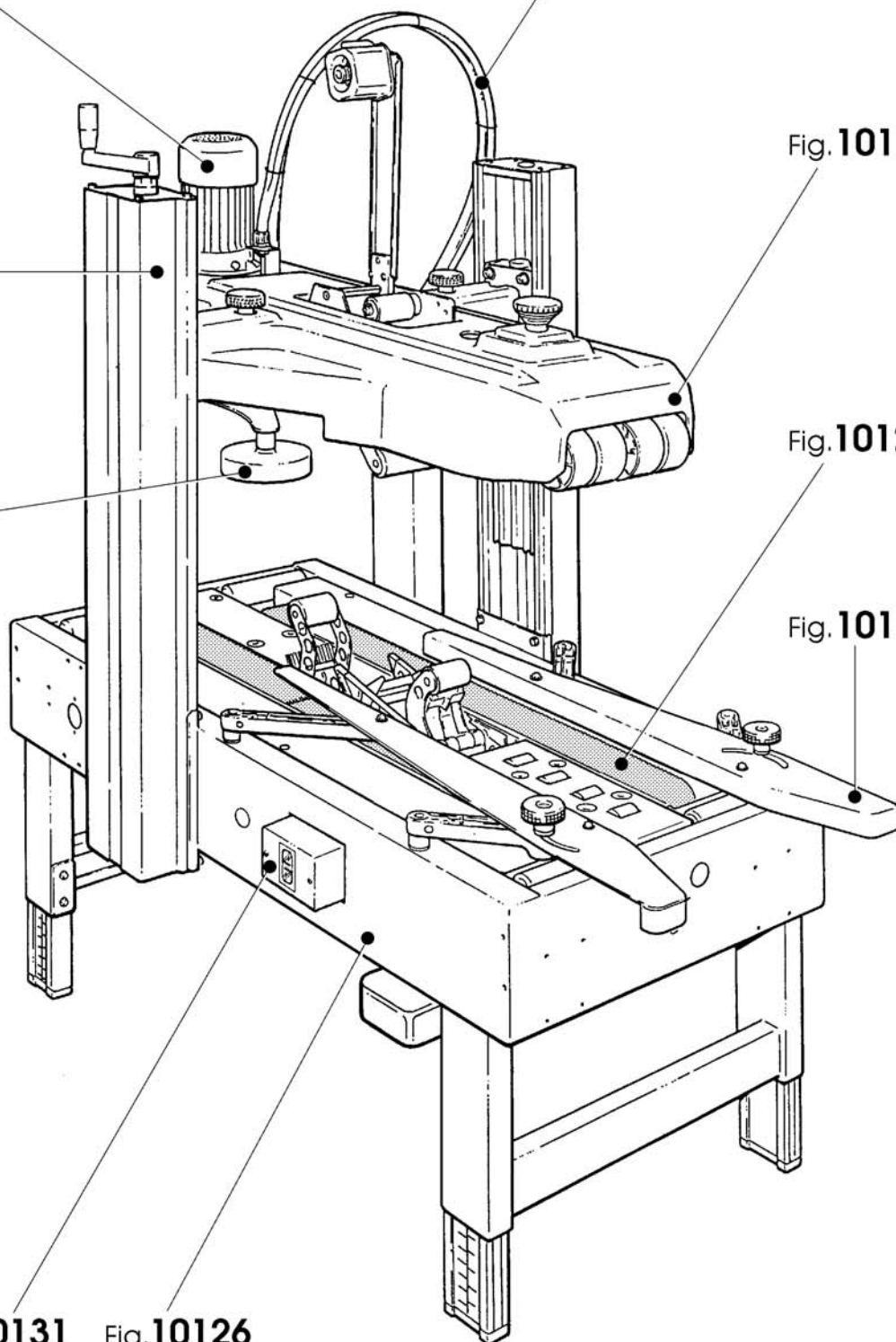
Fig. 5488

Fig. 10124

Fig. 10127

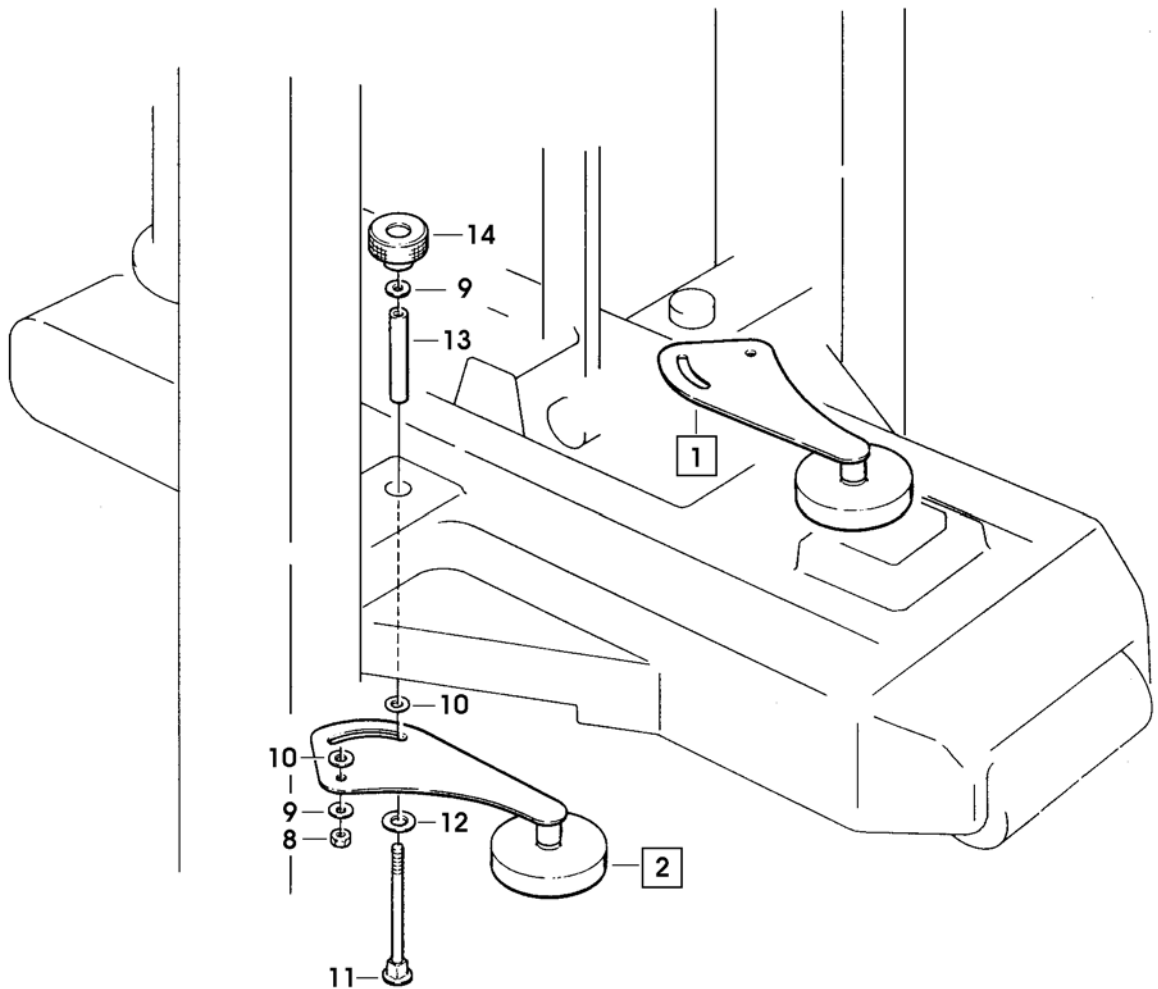
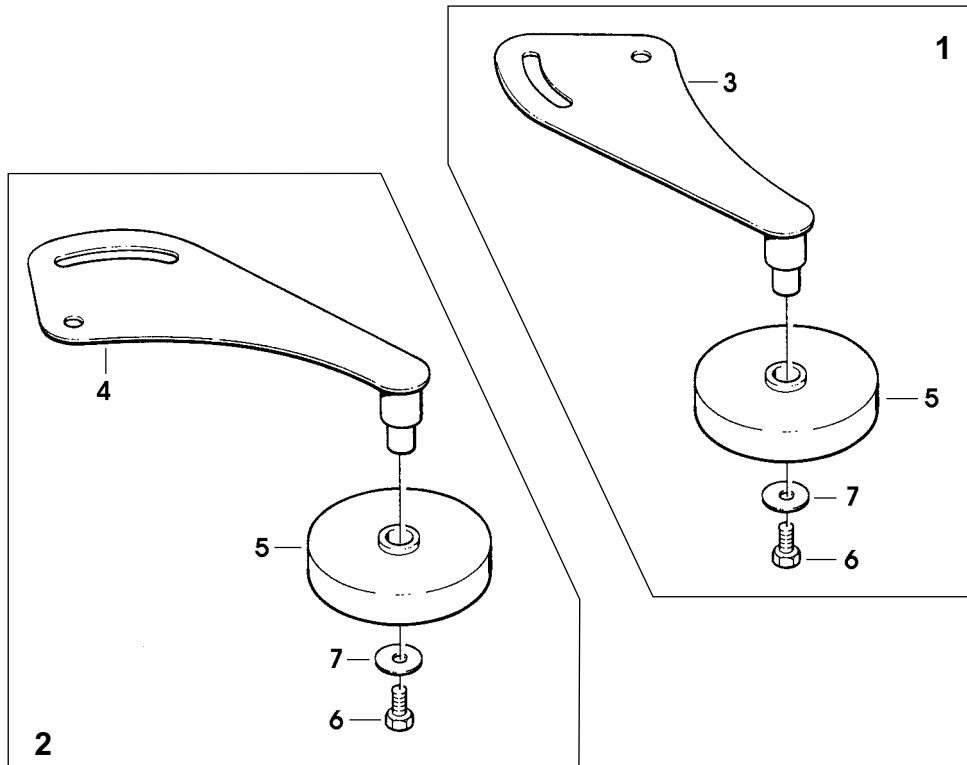
Fig. 10131

Fig. 10126



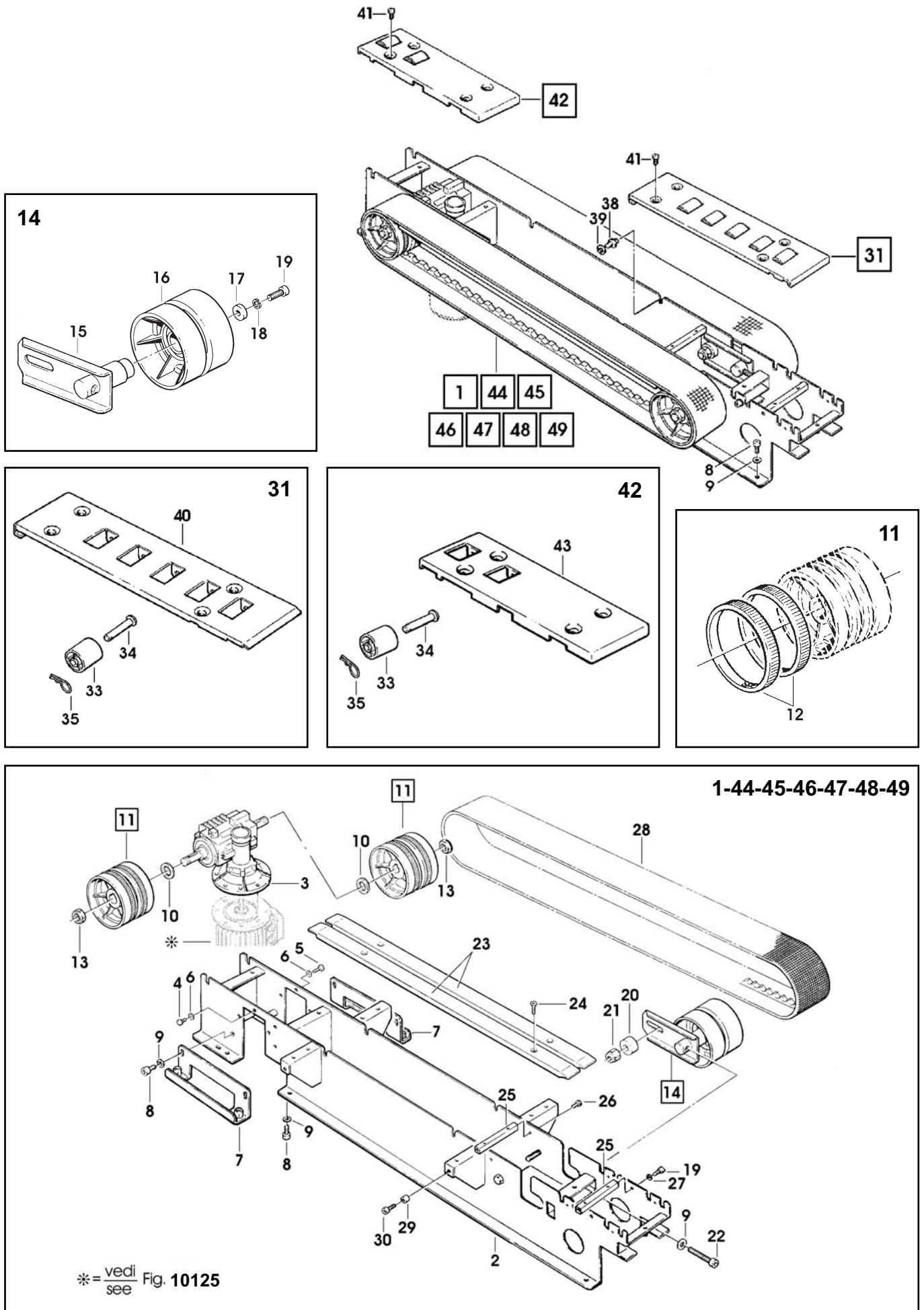
**Fig. 5488****PRESSATORI LATERALI****SEB0000149 S2-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	1.0000	PZ	4.7.08536.00A	S470853600A	BRACCIO PRESSATORE DX ASS. SA2
2	1.0000	PZ	4.7.08537.00A	S470853700A	BRACCIO PRESSATORE SX ASS. SA2
3	1.0000	PZ	4.4.05826.40A	S440582640A	BRACCIO X RULLO PRESS.DX ASS.
4	1.0000	PZ	4.4.05827.40A	S440582740A	BRACCIO X RULLO PRESS.SX ASS.
5	2.0000	PZ	3.1.00575	S3100575ZZZ	RULLO PRESSATORE
6	2.0000	PZ	3.4.00324.93	S340032493Z	VITE TE M8X16 ZINCATA
7	2.0000	PZ	3.3.05353.93	S330535393Z	RONDELLA /8,5X25X4
8	2.0000	PZ	3.4.00438.93	S340043893Z	DADO AUTOBLOCCANTE M10 BASSO
9	4.0000	PZ	3.4.00219.93	S340021993Z	RONDELLA PIANA X VITE M10 ZINC
10	4.0000	PZ	3.1.00079	S3100079ZZZ	RONDELLA NYLON /10,5/18X1
11	2.0000	PZ	3.4.02705.93	S340270593Z	VITE TBQS M10X120 UNI 5732 SA2
12	2.0000	PZ	3.4.00493.93	S340049393Z	RONDELLA PIANA X VITE M14 ZINC
13	2.0000	PZ	3.3.15380.93A	S331538093A	BUSSOLA BLOCCAGGIO PRESS.SA2
14	2.0000	PZ	3.4.02706.05	S340270605Z	MANOPOLA "ELESA" MBT-50 B-M10



**Fig. 10124    MOTORIZZAZIONE INFERIORE****SEB0000149    S2-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	1,0000	PZ		SBA0000776	MOT_INF_S2-S_380/415V_50/60HZ_
2	1,0000	PZ	4.5.06058.47	S450605847Z	MOTORIZ. INF. C/INSERTI S2/S
3	1,0000	PZ	3.8.03594	S3803594ZZZ	RIDUTT. NMRS041 1:20 ALBERO CORTO SM
4	3,0000	PZ	3.4.00371.93	S340037193Z	VITE TE M5X12 ZINCATA
5	3,0000	PZ	3.4.00329.93	S340032993Z	VITE TE M5X16 ZINCATA
6	6,0000	PZ	3.4.00061.93	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
7	2,0000	PZ	4.5.04912.47	S450491247Z	SQUADRETTA RINFORZO SPALLE S2
8	12,000	PZ	3.4.00584.93	S340058493Z	VITE TCEI M8X16 ZINCATA
9	14,000	PZ	3.4.00123.93	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
10	2,0000	PZ	3.3.16062.93A	S331606293A	DISTANZIALE X PULEGGE MOTRICI
11	2,0000	PZ	4.7.05876	S4705876ZZZ	PULEGGIA MOTRICE ASS.C/ANELLI
12	4,0000	PZ	3.1.00540.48	S310054048Z	ANELLO PER PULEGGIA
13	2,0000	PZ	3.5.00515.93	S350051593Z	DADO SPEC.AUTOBLOCC.M20X1 ZINC
14	2,0000	PZ	4.7.08528.00B	S470852800B	CARRELLO TENDICINGHIA ASS.SA2
15	2,0000	PZ	4.4.05687.93C	S440568793C	CARRELLO TENDICINGHIA ASS.
16	2,0000	PZ	4.6.01730	S4601730ZZZ	(P) PULEGGIA FOLLE COMP.
17	2,0000	PZ	3.3.04916.93	S330491693Z	RONDELLA /6,5/30X5
18	2,0000	PZ	3.4.00024.92	S340002492Z	RONDELLA ELAST.X VITE M6 BRUN.
19	4,0000	PZ	3.4.00577.93	S340057793Z	VITE TCEI M6X16 ZINCATA
20	2,0000	PZ	3.5.01802.93	S350180293Z	DIST.PERNO MOTORIZZAZ.INF.
21	2,0000	PZ	3.4.00438.93	S340043893Z	DADO AUTOBLOCCANTE M10 BASSO
22	2,0000	PZ	3.4.01703.93	S340170393Z	VITE TCEI M8X70 TUTTO FILETTO
23	4,0000	PZ	3.2.02909.93	S320290993Z	GUIDA SCORRIM.CINGHIA 200A
24	8,0000	PZ	3.4.00055.93	S340005593Z	VITE TSVEI M5X20 ZINCATA
25	2,0000	PZ	3.5.01757.93	S350175793Z	DISTANZIALE FISS.CARTER
26	2,0000	PZ	3.3.07876.93	S330787693Z	VITE TE M6X16 SPEC.
27	2,0000	PZ	3.4.00175.93	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
28	2,0000	PZ	3.4.01771	S3401771ZZZ	CINGHIA TRASCINAM.C/GIUNZIONE 75X1823 +-
29	4,0000	PZ	3.5.01852.93	S350185293Z	DIST.X CARTER LAT.200A-700A
30	4,0000	PZ	3.4.00045.93	S340004593Z	VITE TE M5X20 ZINCATA



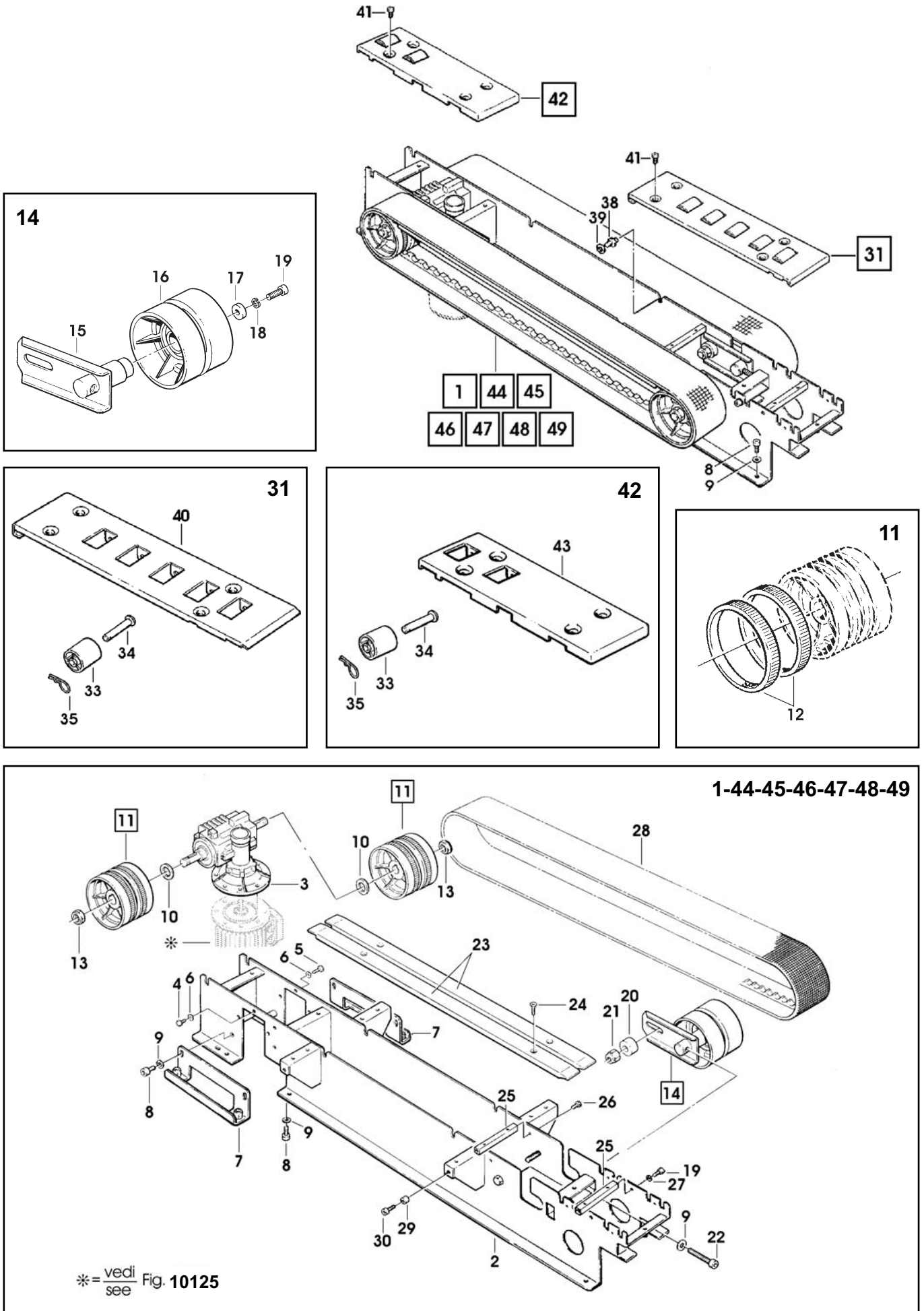
**S2-S**

Gen. 2007

**Fig. 10124**

**Fig. 10124    MOTORIZZAZIONE INFERIORE****SEB0000149    S2-S NASTRATRICE**

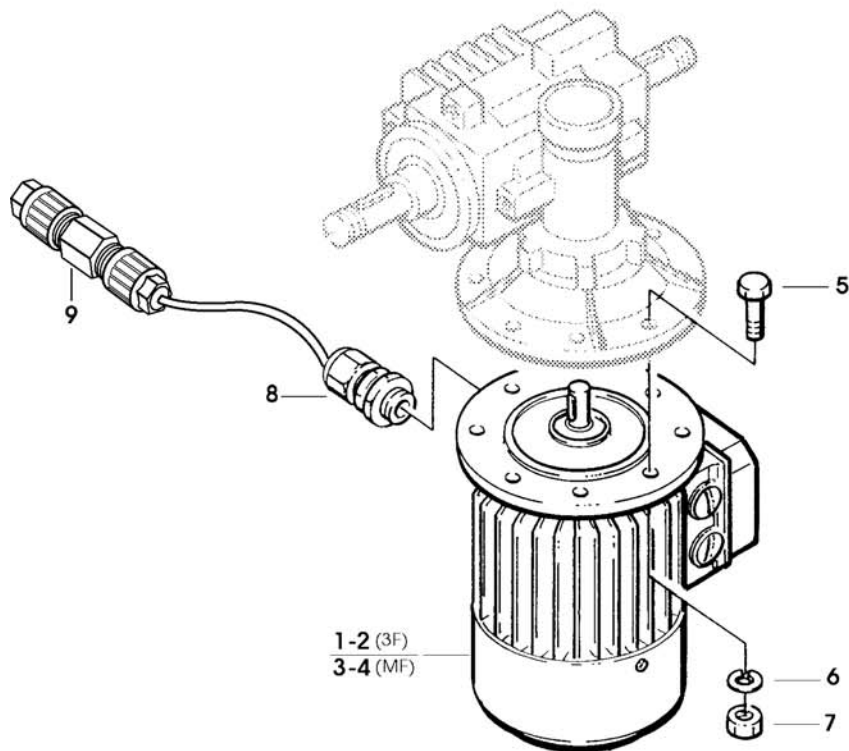
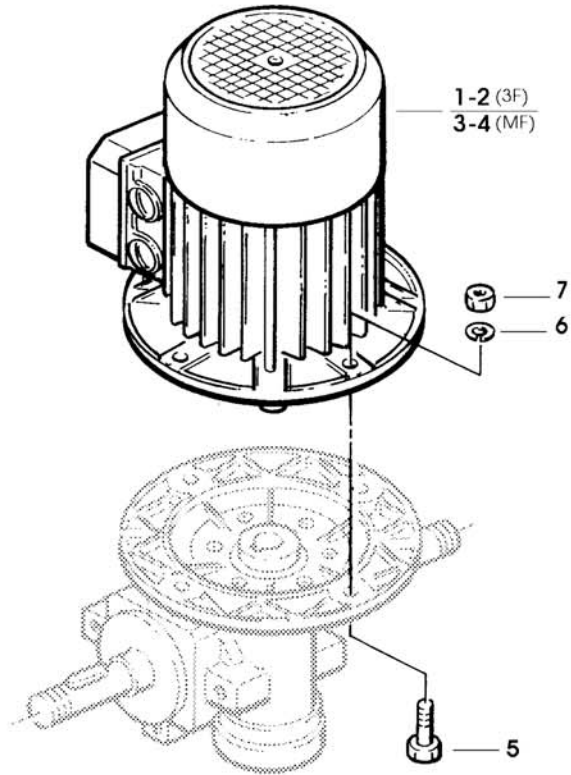
Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
31	1,0000	PZ	4.7.08850.00A	S470885000A	CARTER ANTERIORE ASS. S2-SA2
33	7,0000	PZ	3.1.00564	S3100564ZZZ	(P)RULLINO /32X38
34	7,0000	PZ	3.3.10702.93	S331070293Z	PERNO X RULLINI BANCALE
35	7,0000	PZ	3.7.00012.96	S370001296Z	MOLLETTA H75/H100
38	4,0000	PZ	3.5.01794.93	S350179493Z	PERNO ATTACCO UNITA'SUP.-INF.
39 K1	4,0000	PZ	3.2.03876.98	S320387698Z	RONDELLA INOX X CUSCINETTO GR. ENTRATA
40	1,0000	PZ	3.2.10168.17A	S321016817A	PIANETTO A RULLI ANTERIORE S2
41	8,0000	PZ	3.4.01708.93	S340170893Z	VITE TESTA MEZZA TONDA CROCE M5X16
42	1,0000	PZ	4.7.10822.00A	S471082200A	CARTER POST.MOTORIZZ.C/RULLINI
43	1,0000	PZ	3.2.05911.17D	S320591117D	CARTER POSTERIORE MOTORIZZAZ.INF. SA2 S
44	1,0000	PZ		SBA0000773	MOT_INF_S2-S_200/220V_50/60HZ_
45	1,0000	PZ		SBA0000777	MOT_INF_S2-S_440V_50HZ_3F
46	1,0000	PZ		SBA0000778	MOT_INF_S2-S_100/115V_50/60HZ_
47	1,0000	PZ		SBA0000779	MOT_INF_S2-S_220/230V_50HZ_MF
48	1,0000	PZ		SBA0000780	MOT_INF_S2-S_240V_50HZ
49	1,0000	PZ		SBA0000781	MOT_INF_S2-S_220V_50/60HZ_MF



**Fig. 10125    MOTORI ELETTRICI SEB0000149    S2-S NASTRATRICE**

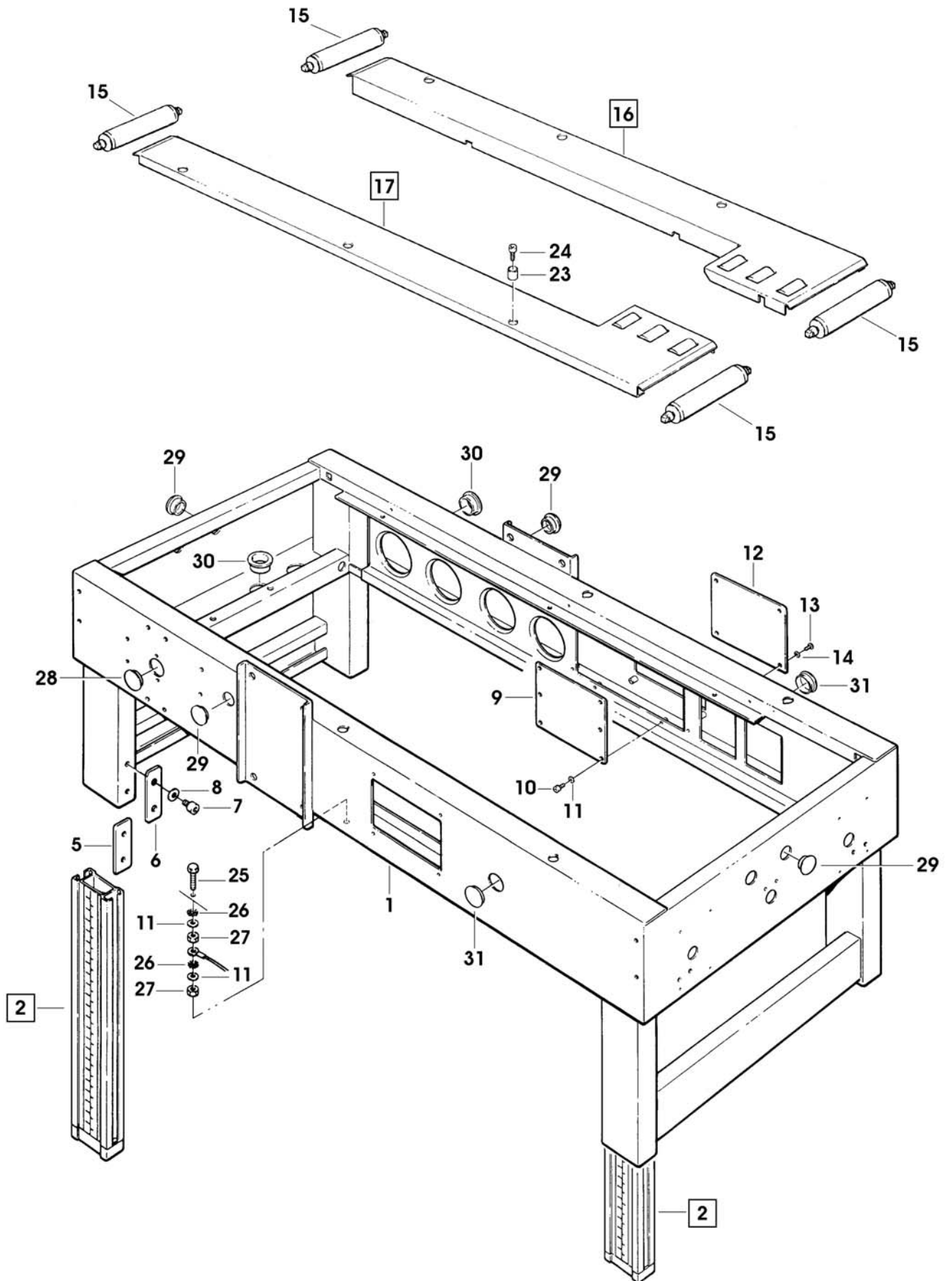
Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	2,0000	PZ	3.8.03442	S3803442ZZZ	MOTORE H63 A4 B5 KW0.13 200V 50/60HZ 22
2	2,0000	PZ	3.8.03440	S3803440ZZZ	MOTORE H63 A4 B5 220/240V-380/415V 50HZ
3	2,0000	PZ	3.8.03446	S3803446ZZZ	MOTORE MULTITENSIONE MH63 C4 KW0,12 B5
4	2,0000	PZ	3.8.03449	S3803449ZZZ	MOTORE MH63 C4 B5 220/240V MF 50HZ 0.13K
5	8,0000	PZ	3.4.00058.93	S340005893Z	VITE TE M8X25 ZINCATA
6	8,0000	PZ	3.4.00063.92	S340006392Z	RONDELLA ELAST.GROWER DIN 7980 (SEZ.QUA-
7	8,0000	PZ	3.4.00116.93	S340011693Z	DADO BASSO M8 ZINC.
8	1,0000	PZ	3.8.02139	S3802139ZZZ	BOCCHETTONE SKINTOP ST11
9	1,0000	PZ	3.8.08092.00A	S380809200A	CONNETTORE QUICKON-ONE DA 0.75 A 1.5 Q 1





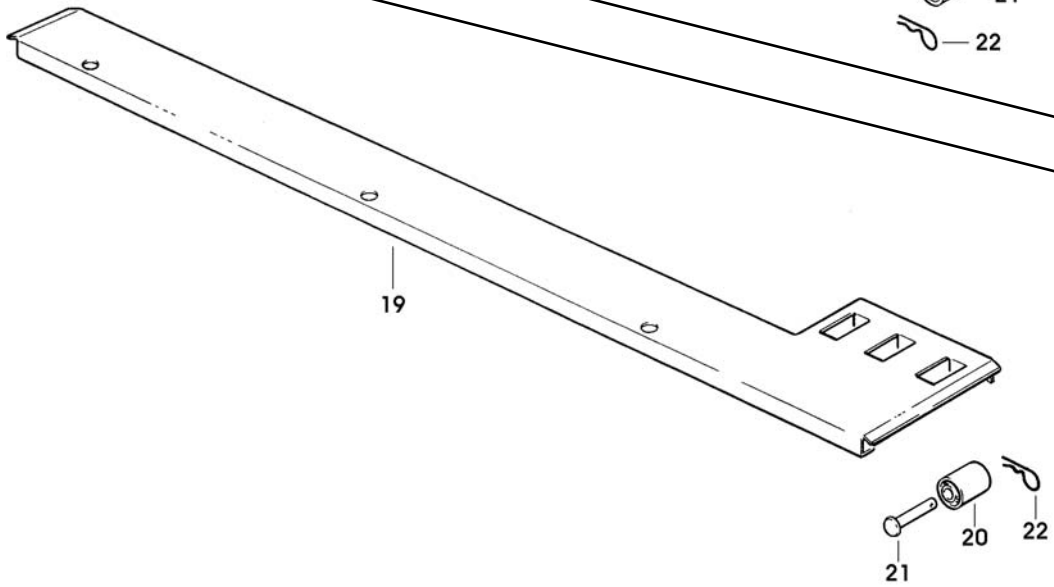
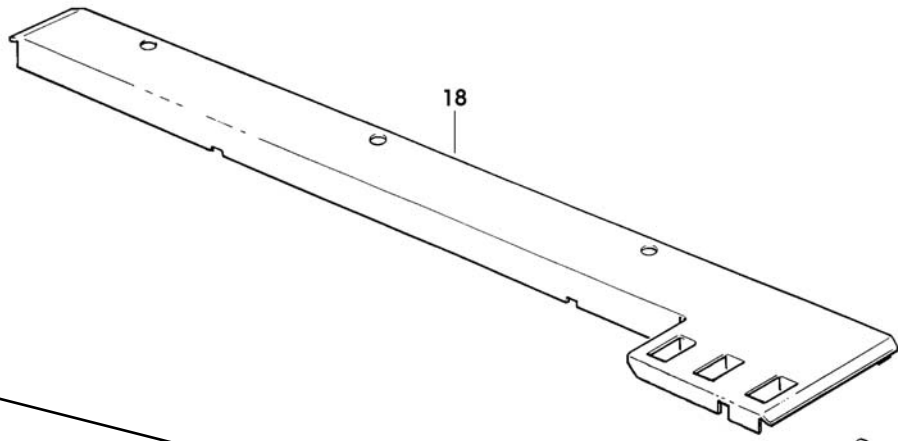
**Fig. 10126    BANCALE    SEB0000149    S2-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	1,0000	PZ		SBA0000494	BANCALE CON INSERTI S2-S
2	4,0000	PZ	4.3.04737	S4304737ZZZ	GAMBA CON PIEDINO SA2 SR4
3	4,0000	PZ	3.1.01498	M3101498ZZZ	tappo di chiusura x mont. fot.
4	4,0000	PZ	3.0.00982.95A	S300098295A	RIGHELLA MILLIMETRATA PER GAMBA H=44
5	4,0000	PZ	3.2.05671.93A	M320567193A	Muting piastrina fiss. gamba muting Sia
6	4,0000	PZ	3.2.05898.93A	S320589893A	STAFFA PER GAMBE E TRAVERSE SIAT 2000
7	8,0000	PZ	3.4.00584.93	S340058493Z	VITE TCEI M8X16 ZINCATA
8	8,0000	PZ	3.4.00123.93	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
9	1,0000	PZ	3.2.05876.47B	S320587647B	PIASTRA FISSAGGIO INTERRUETTORE SIAT 2000
10	4,0000	PZ	3.4.00318.93	S340031893Z	VITE TCEI M5X12 ZINCATA
11	6,0000	PZ	3.4.00061.93	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
12	1,0000	PZ	3.2.05888.47A	S320588847A	PIASTRA CHIUSURA VANO INT. SIAT 2000
13	4,0000	PZ	3.4.00830.93	S340083093Z	VITE TCBCR AUTOF.7SPX8 ZINCATA
14	4,0000	PZ	3.4.00043.93	S340004393Z	RONDELLA PIANA X VITE M4 ZINC.
15	4,0000	PZ	4.7.08522.00A	S470852200A	RULLO TIPO "G" ASS.SA2
16	1,0000	PZ	4.7.08800.00A	S470880000A	PIANO SCORRIMENTO LAT.DX ASS.S2
17	1,0000	PZ	4.7.08801.00A	S470880100A	PIANO SCORRIMENTO LAT.SX ASS.S2
18	1,0000	PZ	3.2.06082.17B	S320608217B	PIANO SCORRIMENTO DX S2
19	1,0000	PZ	3.2.06514.17B	S320651417B	PIANO SCORRIMENTO SX S2
20	6,0000	PZ	3.1.00564	S3100564ZZZ	(P)RULLINO /32X38
21	6,0000	PZ	3.3.10702.93	S331070293Z	PERNO X RULLINI BANCALE
22	6,0000	PZ	3.7.00012.96	S370001296Z	MOLLETTA H75/H100
23	6,0000	PZ	3.1.00981.05	S310098105Z	BUSSOLA
24	6,0000	PZ	3.4.00015.93	S340001593Z	VITE TCEI M6X25 ZINCATA
25	1,0000	PZ	3.4.00045.93	S340004593Z	VITE TE M5X20 ZINCATA
26	2,0000	PZ	3.4.00745.92	S340074592Z	RONDELLA DENT. X VITE M5 BRUN.
27	2,0000	PZ	3.4.00023.93	S340002393Z	DADO M5 ZINCATO

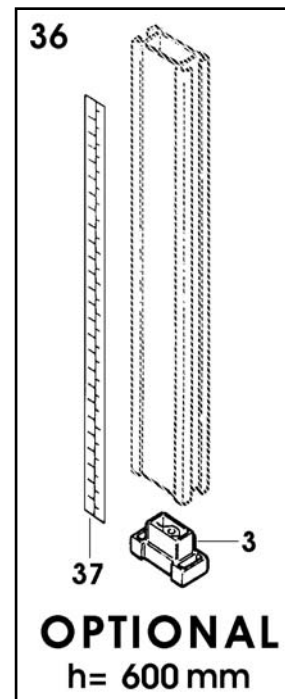
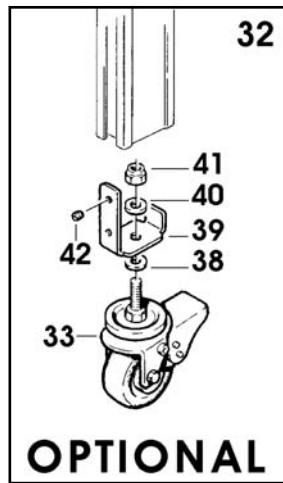
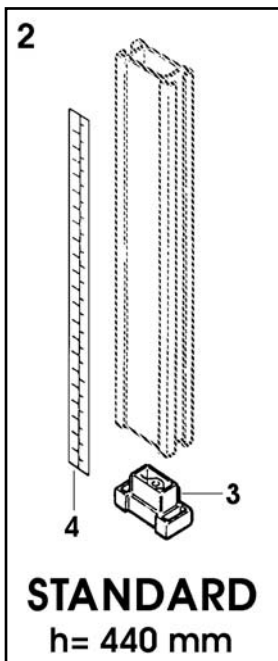


**Fig. 10126    BANCALE    SEB0000149    S2-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
28	1,0000	PZ	3.4.02573	S3402573ZZZ	TAPPO DP 1250 (PER FORO /32)
29	11,000	PZ	3.8.03667	S3803667ZZZ	TAPPO DP-875 SIAT-2000
30	2,0000	PZ	3.4.02661	S3402661ZZZ	PASSACAVO SB1250-15 "Heyco"
31	2,0000	PZ	3.4.02703	S3402703ZZZ	TAPPO DP 1187 "Heyco"
32	1,0000	PZ	7.8.04337.00B	S780433700B	AS77 SET RUOTE /80 SIAT 2000
33	4,0000	PZ	3.4.01501	S3401501ZZZ	RUOTA /80 POLIDERNYL
36	1,0000	PZ	7.8.04413.00A	S780441300A	AS80-SET GAMBE SPECIALI SIAT 2000
37	4,0000	PZ	3.0.01051.96A	S300105196A	ETICHETTA RIGHELLA MILLIMET. H=600 X GA
38	4,0000	PZ	3.2.02455.93	S320245593Z	DISTANZIALE PER RUOTE SM481
39	4,0000	PZ	3.2.07244.93A	S320724493A	ATTACCO RUOTA AS77
40	4,0000	PZ	3.4.00062.93	S340006293Z	RONDELLA PIANA X VITE M12 ZINC
41	4,0000	PZ	3.4.00735.93	S340073593Z	DADO AUTOBLOCCANTE M12 ZINCATO
42	8,0000	PZ	3.4.00415.92	S340041592Z	GRANO EIPP M8X8 BR.

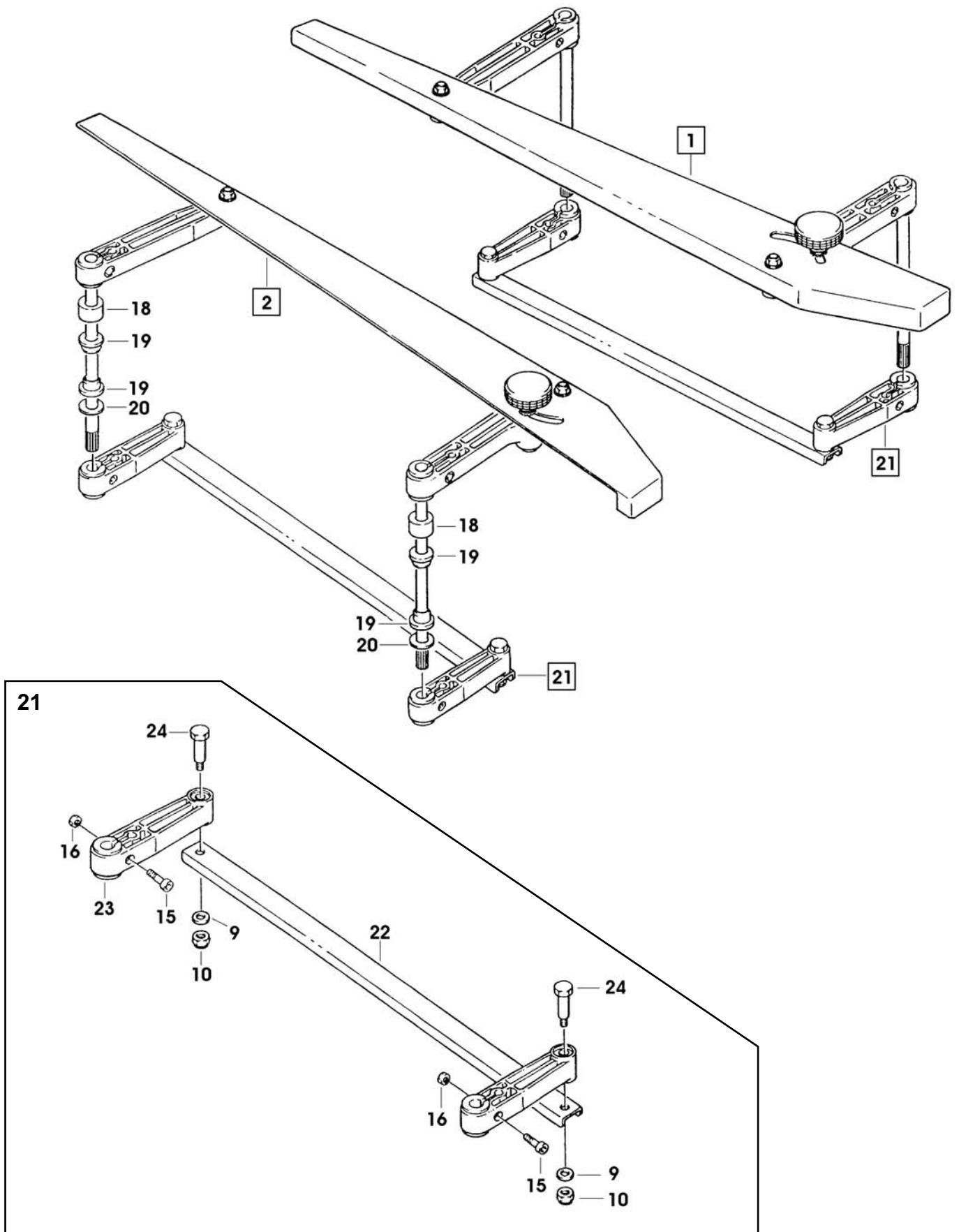


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**Fig. 10127    GUIDE LATERALI    SEB0000149    S2-S NASTRATRICE**

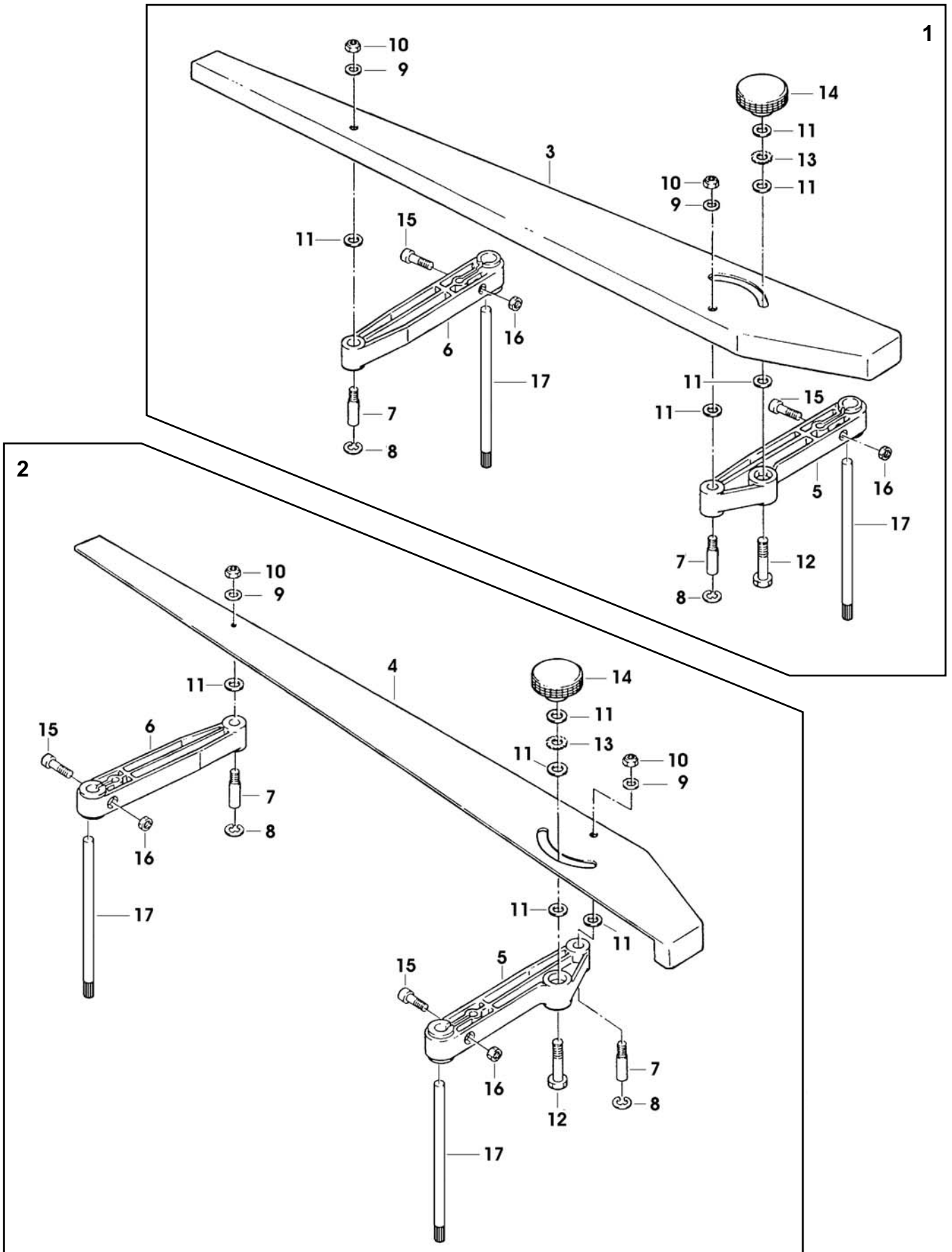
Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	1,0000	PZ	4.7.15234.00A	S471523400A	GUIDA DX ASSEMBLATA S2/S
2	1,0000	PZ	4.7.15235.00A	S471523500A	GUIDA SX ASSEMBLATA S2/S
3	1,0000	PZ	3.2.06095.40A	S320609540A	GUIDA DESTRA S2
4	1,0000	PZ	3.2.06096.40A	S320609640A	GUIDA SINISTRA S2
5	2,0000	PZ	3.1.00571.05	S310057105Z	(P) LEVA BLOCCAGGIO L=194
6	2,0000	PZ	3.1.00569.05	S310056905Z	(P )LEVA L=194
7	4,0000	PZ	3.3.05330.93	S330533093Z	PERNO /10X41
8	4,0000	PZ	3.4.00837.92	S340083792Z	ANELLO ARRESTO 10SP220
9	8,0000	PZ	3.4.00175.93	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
10	8,0000	PZ	3.4.00258.93	S340025893Z	DADO AUTOBLOCCANTE BASSO M6
11	10,000	PZ	3.4.00219.93	S340021993Z	RONDELLA PIANA X VITE M10 ZINC
12	2,0000	PZ	3.4.00499.93	S340049993A	VITE TE M10X35 ZINCATA
13	2,0000	PZ	3.4.01170.92	S340117092Z	RONDELLA DENT.EST./10 BRUNITA
14	2,0000	PZ	3.4.02706.05	S340270605Z	MANOPOLA "ELESA" MBT-50 B-M10
15	8,0000	PZ	3.4.00160.93	S340016093Z	VITE TCEI M6X20 ZINCATA
16	8,0000	PZ	3.4.00002.93	S340000293Z	DADO M6 ZINCATO
17	4,0000	PZ	3.3.29773.93A	S332977393A	PERNO PER LEVE GUIDE S2-S
18	4,0000	PZ	3.1.00573.05	S310057305Z	(P) DISTANZIALE /24X15
19	8,0000	PZ	3.1.00574	S3100574ZZZ	BUSSOLA DI GUIDA
20	4,0000	PZ	3.4.00062.93	S340006293Z	RONDELLA PIANA X VITE M12 ZINC
21	2,0000	PZ	4.7.08649.00A	S470864900A	BARRA ACCOPPIAMENTO LEVE AS.S2
22	2,0000	PZ	3.2.06097.93A	S320609793A	BARRA ACCOPPIAMENTO LEVE S2
23	4,0000	PZ	3.1.00568.05	S310056805Z	(P) LEVA L=115
24	4,0000	PZ	3.3.08317.93	S330831793Z	PERNO RULLINI TENDICAT.12A-S2



**Fig. 10127    GUIDE LATERALI    SEB0000149    S2-S NASTRATRICE**

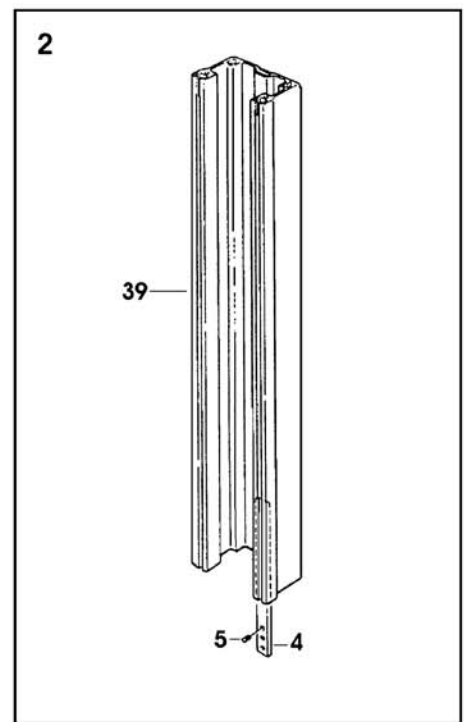
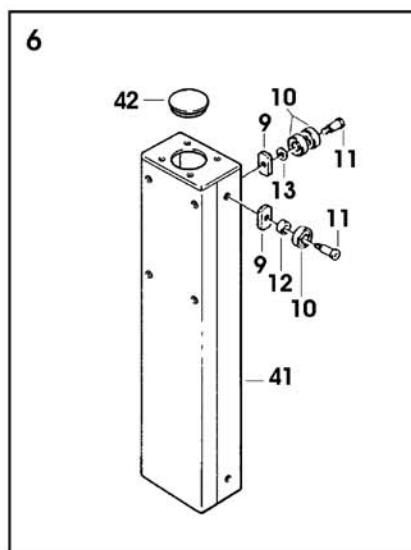
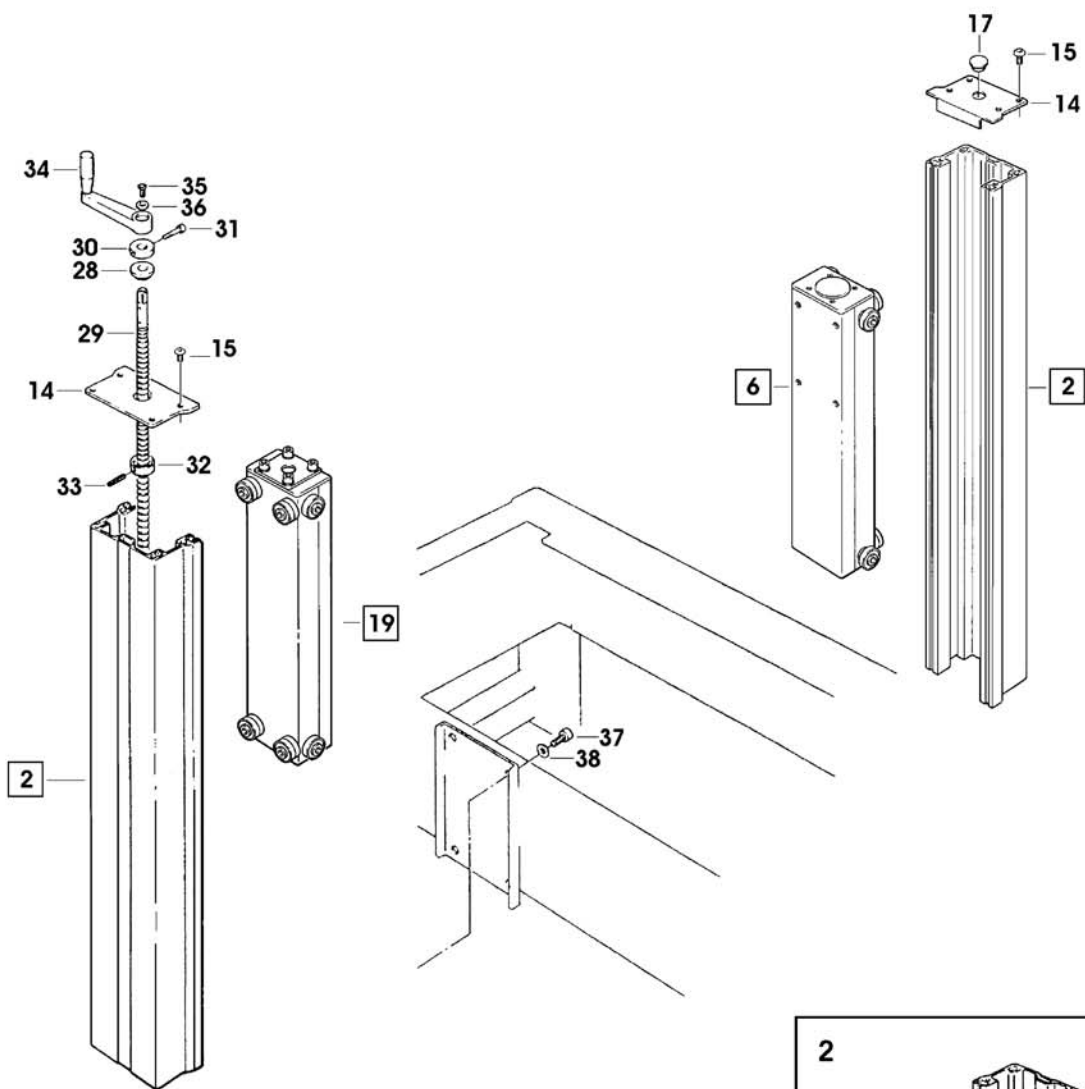
Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	1,0000	PZ	4.7.15234.00A	S471523400A	GUIDA DX ASSEMBLATA S2/S
2	1,0000	PZ	4.7.15235.00A	S471523500A	GUIDA SX ASSEMBLATA S2/S
3	1,0000	PZ	3.2.06095.40A	S320609540A	GUIDA DESTRA S2
4	1,0000	PZ	3.2.06096.40A	S320609640A	GUIDA SINISTRA S2
5	2,0000	PZ	3.1.00571.05	S310057105Z	(P) LEVA BLOCCAGGIO L=194
6	2,0000	PZ	3.1.00569.05	S310056905Z	(P )LEVA L=194
7	4,0000	PZ	3.3.05330.93	S330533093Z	PERNO /10X41
8	4,0000	PZ	3.4.00837.92	S340083792Z	ANELLO ARRESTO 10SP220
9	8,0000	PZ	3.4.00175.93	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
10	8,0000	PZ	3.4.00258.93	S340025893Z	DADO AUTOBLOCCANTE BASSO M6
11	10,000	PZ	3.4.00219.93	S340021993Z	RONDELLA PIANA X VITE M10 ZINC
12	2,0000	PZ	3.4.00499.93	S340049993A	VITE TE M10X35 ZINCATA
13	2,0000	PZ	3.4.01170.92	S340117092Z	RONDELLA DENT.EST./10 BRUNITA
14	2,0000	PZ	3.4.02706.05	S340270605Z	MANOPOLA "ELESA" MBT-50 B-M10
15	8,0000	PZ	3.4.00160.93	S340016093Z	VITE TCEI M6X20 ZINCATA
16	8,0000	PZ	3.4.00002.93	S340000293Z	DADO M6 ZINCATO
17	4,0000	PZ	3.3.29773.93A	S332977393A	PERNO PER LEVE GUIDE S2-S
18	4,0000	PZ	3.1.00573.05	S310057305Z	(P) DISTANZIALE /24X15
19	8,0000	PZ	3.1.00574	S3100574ZZZ	BUSSOLA DI GUIDA
20	4,0000	PZ	3.4.00062.93	S340006293Z	RONDELLA PIANA X VITE M12 ZINC
21	2,0000	PZ	4.7.08649.00A	S470864900A	BARRA ACCOPPIAMENTO LEVE AS.S2
22	2,0000	PZ	3.2.06097.93A	S320609793A	BARRA ACCOPPIAMENTO LEVE S2
23	4,0000	PZ	3.1.00568.05	S310056805Z	(P) LEVA L=115
24	4,0000	PZ	3.3.08317.93	S330831793Z	PERNO RULLINI TENDICAT.12A-S2





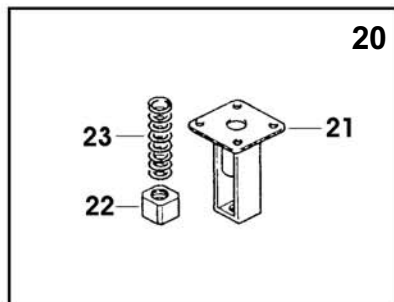
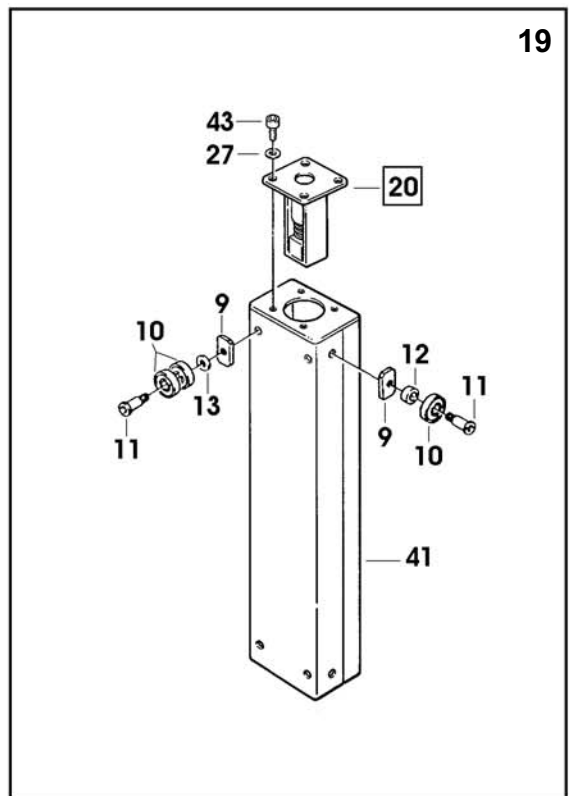
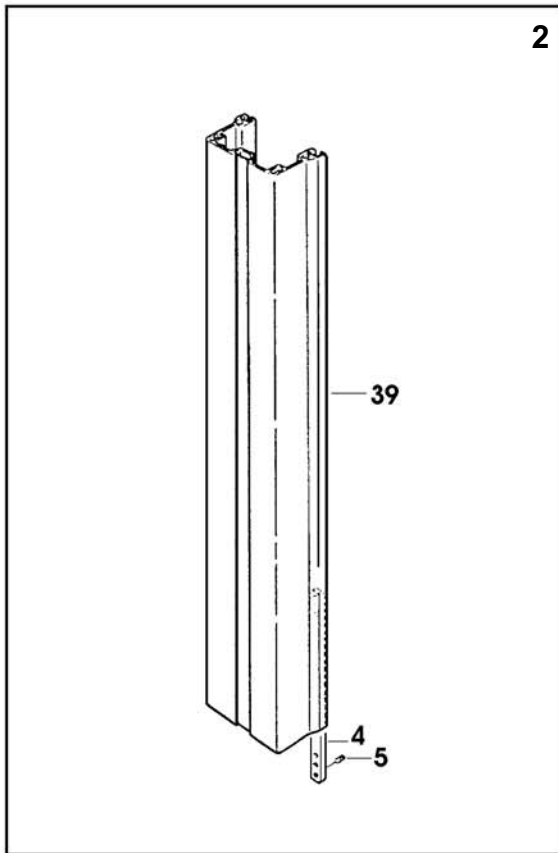
**Fig. 10128****COLONNE****SEB0000149****S2-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
2	2,0000	PZ		SBA0000496	COLONNA ASS.SERIE 2000
4	4,0000	PZ	3.3.29769.93A	S332976993A	PIASTRINA FISSAGGIO COLONNE
5	8,0000	PZ	3.4.01365.92	S340136592Z	GRANO EIPC DENTELLATO M8X10 BR
6	1,0000	PZ	4.7.09749.00B	S470974900B	COLONNA SCORREVOLE DX ASS.S2T
9	16,000	PZ	3.2.05673.96	S320567396Z	PIASTRINA FISSAGGIO CUSCINETTO
10	24,000	PZ	3.4.02623	S3402623ZZZ	CUSCINETTO A SFERE SIAT 2000
11	16,000	PZ	3.3.13486.93	S331348693Z	VITE PER CUSCINETTO SIAT-2000
12	8,0000	PZ	3.3.13488.93	S331348893Z	RONDELLA SIAT 2000 ZIN.
13	8,0000	PZ	3.3.13489.93	S331348993Z	RONDELLA /18X8 SP.1 SA2/SR4
14	2,0000	PZ	3.2.06074.47A	S320607447A	TESTATA X COLONNA FISSA S2
15	8,0000	PZ	3.4.01749.93	S340174993Z	VITE TBEI M6X12 ZINC.
17	1,0000	PZ	3.8.03667	S3803667ZZZ	TAPPO DP-875 SIAT-2000
19	1,0000	PZ	4.7.09750.00B	S470975000B	COLONNA SCORREVOLE SX ASS.S2T
20	1,0000	PZ	4.7.08808.00A	S470880800A	SUPPORTO CHIOCCOLA ASS.S2
21	1,0000	PZ	4.4.05884.47A	S440588447A	SUPPORTO CHIOCCIOLA ASS.S2
22	1,0000	PZ	3.1.01572.00A	S310157200A	CHIOCCIOLA PER COLONNA S2
23	1,0000	PZ	3.7.00317.00A	S370031700A	MOLLA /E 21/FILO 2,5 L. LIBERAS2
27	4,0000	PZ	3.4.00175.93	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
28	1,0000	PZ	3.1.00583	S3100583ZZZ	BUSSOLA
29	1,0000	PZ	3.3.16340.93A	S331634093A	VITE SOLLEVAMENTO PER S2 CON AS82
30	1,0000	PZ	3.3.15791.93A	S331579193A	GHIERA X VITE SOLLEVAMENTO S2
31	1,0000	PZ	3.4.00142.93	S340014293Z	VITE TCEI M4X25 ZINCATA
32	1,0000	PZ	3.3.15792.93A	S331579293A	BUSSOLA X VITE SOLLEVAMENTO S2
33	1,0000	PZ	3.4.01022.92	S340102292Z	SPINA ELASTICA D4X30 BRUNITA
34	1,0000	PZ	3.4.02700	S3402700ZZZ	MANOVELLA "ELESA" MT.80 AS 10X10 SIAT
35	1,0000	PZ	3.4.00516.93	S340051693Z	VITE TSVEI M5X12 ZINCATA
36	1,0000	PZ	3.5.00506.93	S350050693Z	RONDELLA FISSAGGIO MOTORI



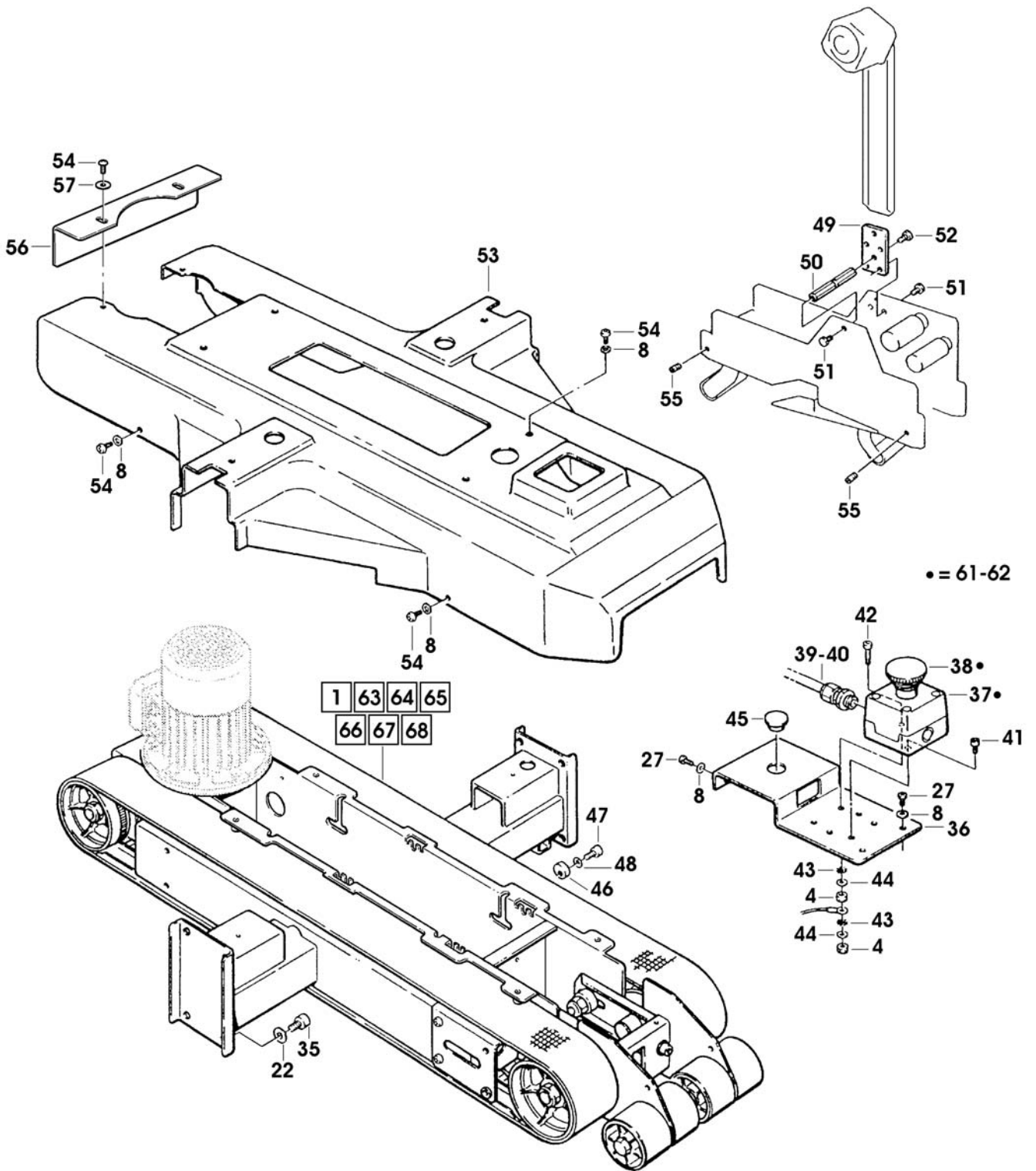
**Fig. 10128      COLONNE      SEB0000149      S2-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
37	8,0000	PZ	3.4.00589.93	S340058993Z	VITE TCEI M8X14 ZINCATA
38	8,0000	PZ	3.4.00123.93	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
39	2,0000	PZ		SBA0000715	Colonna con inserti S2
41	2,0000	PZ	4.5.05030.47	S450503047Z	COLONNA SCORREVOLE C/INS.S2T
42	1,0000	PZ	3.4.01748.05	S340174805Z	TAPPO /45X1,5 700R
43	4,0000	PZ	3.4.00577.93	S340057793Z	VITE TCEI M6X16 ZINCATA



**Fig. 10129****MOTORIZZAZIONE SUPERIORE****SEB0000149 S2-S NASTRATRICE**

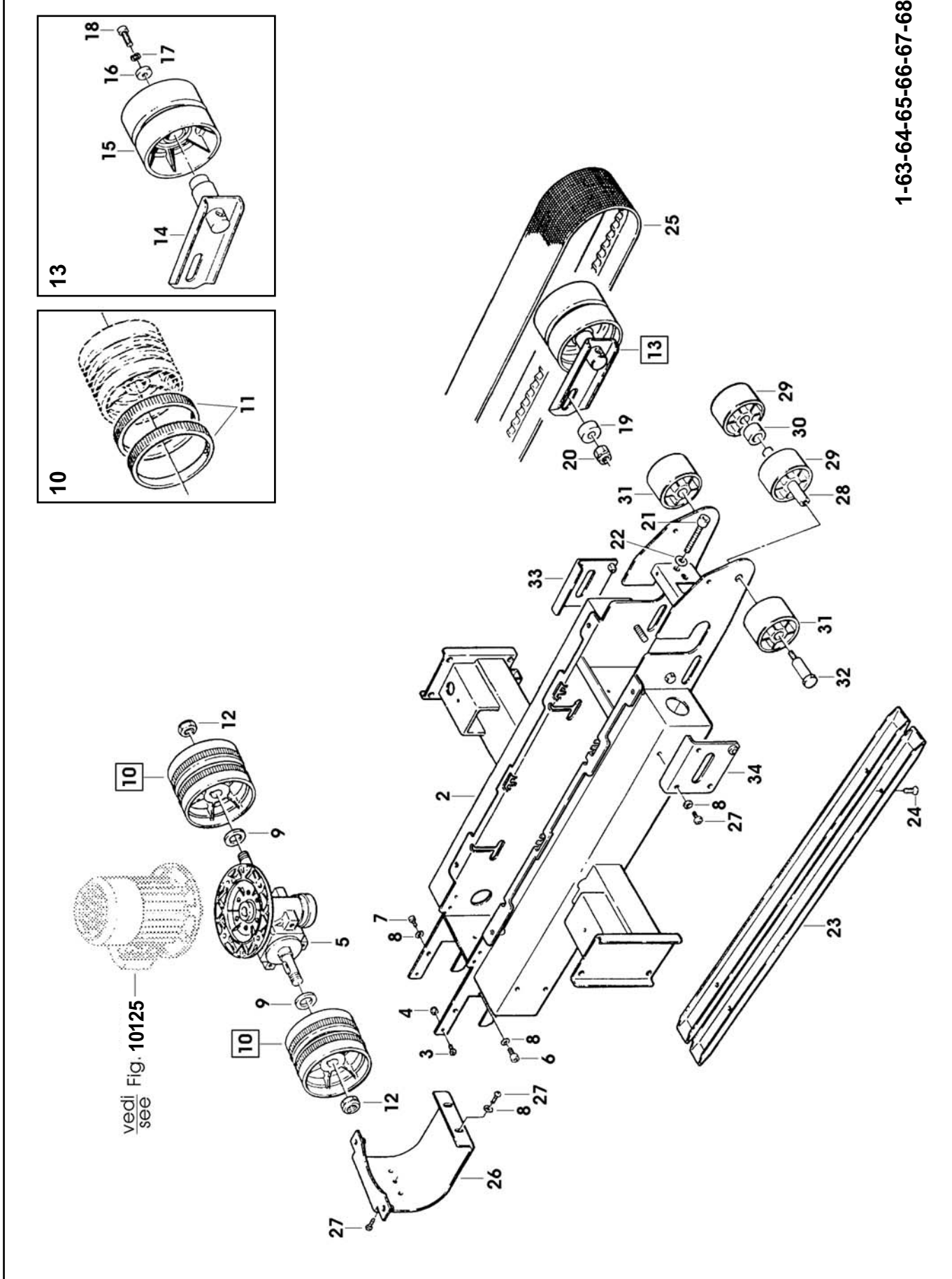
Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	1,0000	PZ		SBA0000123	Mot.Sup.SK2 220/240V 50HZ 3F 50/60HZ 3
2	1,0000	PZ	4.5.05191.47	S450519147Z	STRUTTURA MOTORIZZAZIONE SUP. C/INSERTI
3	2,0000	PZ	3.4.00012.93	S340001293Z	VITE TCBCR M4X10 ZINCATA
4	4,0000	PZ	3.4.00001.93	S340000193Z	DADO M4 ZINCATO
5	1,0000	PZ	3.8.03594	S3803594ZZZ	RIDUTT. NMRS041 1:20 ALBERO CORTO SM
6	3,0000	PZ	3.4.00112.93	S340011293Z	VITE TCEI M5X16 ZINCATA
7	3,0000	PZ	3.4.00318.93	S340031893Z	VITE TCEI M5X12 ZINCATA
8	26,000	PZ	3.4.00061.93	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
9	2,0000	PZ	3.3.16062.93A	S331606293A	DISTANZIALE X PULEGGE MOTRICI
10	2,0000	PZ	4.7.05876	S4705876ZZZ	PULEGGIA MOTRICE ASS.C/ANELLI
11	4,0000	PZ	3.1.00540.48	S310054048Z	ANELLO PER PULEGGIA
12	2,0000	PZ	3.5.00515.93	S350051593Z	DADO SPEC.AUTOBLOCC.M20X1 ZINC
13	2,0000	PZ	4.7.08528.00B	S470852800B	CARRELLO TENDICINGHIA ASS.SA2
14	2,0000	PZ	4.4.05687.93C	S440568793C	CARRELLO TENDICINGHIA ASS.
15	2,0000	PZ	4.6.01730	S4601730ZZZ	(P) PULEGGIA FOLLE COMP.
16	2,0000	PZ	3.3.04916.93	S330491693Z	RONDELLA /6,5/30X5
17	2,0000	PZ	3.4.00024.92	S340002492Z	RONDELLA ELAST.X VITE M6 BRUN.
18	3,0000	PZ	3.4.00577.93	S340057793Z	VITE TCEI M6X16 ZINCATA
19	2,0000	PZ	3.5.01802.93	S350180293Z	DIST.PERNO MOTORIZZAZ.INF.
20	2,0000	PZ	3.4.00438.93	S340043893Z	DADO AUTOBLOCCANTE M10 BASSO
21	2,0000	PZ	3.4.01743.93	S340174393Z	VITE TE M8X60 TUTTO FILETTO
22	10,000	PZ	3.4.00123.93	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
23	4,0000	PZ	3.2.02909.93	S320290993Z	GUIDA SCORRIM.CINGHIA 200A
24	8,0000	PZ	3.4.00055.93	S340005593Z	VITE TSVEI M5X20 ZINCATA
25	2,0000	PZ	3.4.01771	S3401771ZZZ	CINGHIA TRASCINAM.C/GIUNZIONE 75X1823 +-
26	1,0000	PZ	4.4.06934.17A	S440693417A	CARTER POST.MOTORIZZAZIONE SUPERIORE
27	11,000	PZ	3.4.00720.93	S340072093Z	VITE TESTA MEZZA TONDA M5X12 CROCE ZINC
28	1,0000	PZ	3.3.13641.93	S331364193Z	PERNO RULLI ENTRATA /15X106 SK2/SR4/S2
28	1,0000	PZ	3.3.13641.93	S331364193Z	PERNO RULLI ENTRATA /15X106 SK2/SR4/S2
29	2,0000	PZ	3.1.00580.05	S310058005Z	(P) RULLO ENTRATA
30	1,0000	PZ	3.1.01013	S3101013ZZZ	DISTANZIALE X RULLI ENTRATA
31	2,0000	PZ	3.1.01022.05	S310102205Z	RULLO ENTRATA MOTORIZZ.
32	2,0000	PZ	3.3.15387.93A	S331538793A	PERNO X RULLO ENTRATA ESTERNO SA2 SR4
33	1,0000	PZ	4.5.04919.47	S450491947Z	STAFFA DX FISSAGGIO PROTEZIONE SUP.C/INS.
34	1,0000	PZ	4.5.04920.47	S450492047Z	STAFFA SX FISSAGGIO PROTEZIONE SUP.C/INS.
35	8,0000	PZ	3.4.00589.93	S340058993Z	VITE TCEI M8X14 ZINCATA



**Fig. 10129    MOTORIZZAZIONE SUPERIORE    SEB0000149    S2-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
36	1,0000	PZ	4.4.05846.47A	S440584647A	SUPPORTO TASTO A FUNGO ASS. SA2 SR4
37	1,0000	PZ	3.8.02110	S3802110ZZZ	CUSTODIA IN PLASTICA GIALLA 800E-1PY,
38	1,0000	PZ	3.8.05094	S3805094ZZZ	PULSANTE EMERGENZA /40 800EM-MTS443LX01
39	1,0000	PZ	3.8.02139	S3802139ZZZ	BOCCHETTONE SKINTOP ST11
40	1,0000	PZ	3.8.02143	S3802143ZZZ	CONTRODADO GMP11
41	1,0000	PZ	3.4.00390.93	S340039093Z	VITE TCEI M4X12 ZINC.
42	1,0000	PZ	3.4.00142.93	S340014293Z	VITE TCEI M4X25 ZINCATA
43	2,0000	PZ	3.4.01830.92	S340183092Z	RONDELLA DENTELLATA X VITE M4
44	2,0000	PZ	3.4.00043.93	S340004393Z	RONDELLA PIANA X VITE M4 ZINC.
45	1,0000	PZ	3.8.03667	S3803667ZZZ	TAPPO DP-875 SIAT-2000
46	1,0000	PZ	3.3.15770.93B	S331577093B	FERMO PER UNITA' NASTRANTE TOP SA2-SR4
47	1,0000	PZ	3.4.00051.93	S340005193Z	VITE TCEI M6X12 ZINCATA
48	1,0000	PZ	3.4.00175.93	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
49	1,0000	PZ	3.3.15697.93A	S331569793A	STAFFA ATTACCO BRACCIO PORTAROTOLO
50	1,0000	PZ	3.3.06147.93	S330614793A	DISTANZIALE ESAGONALE 10X82
51	3,0000	PZ	3.4.00021.93	S340002193Z	VITE TE M6X12 ZINCATA
52	1,0000	PZ	3.4.00057.93	S340005793Z	VITE TE M6X20 ZINCATA
53	1,0000	PZ	3.1.01552.17C	S310155217C	PROTEZ.ANTINF.SUPERIORE SA2
54	12,000	PZ	3.4.01708.93	S340170893Z	VITE TESTA MEZZA TONDA CROCE M5X16
55	4,0000	PZ	3.5.02071.93	S350207193Z	ATTACCO UNITA'K13/14 ZINC.
56	1,0000	PZ	3.2.08729.40A	S320872940A	PROTEZ.CINGHIE MOTORIZZAZIONE SUP.S2-SA2
57	2,0000	PZ	3.4.00468.93	S340046893Z	RONDELLA TRIPLA X VITE M5 ZINC
58	1,0000	PZ	3.8.05198	S3805198ZZZ	PULSANTE EMERG. 3SB3000-1HA20
59	1,0000	PZ	3.8.05197	S3805197ZZZ	CONTATTO NC 3SB3420-0C
60	1,0000	PZ	3.8.05196	S3805196ZZZ	SCATOLA GIALLA 3SB3801-0AC
61	1,0000	PZ	4.7.11690.00A	S471169000A	PULSANTE EMERGENZA ASS.SM/XL ALLEN BRAD
62	1,0000	PZ	4.7.11689.00A	S471168900A	PULSANTE EMERGENZA ASS.SM/XL SIEMENS
63	1,0000	PZ		SBA0000118	Mot.Sup.SK2 100/110/115V 50/60 MOTORE S38
64	1,0000	PZ		SBA0000119	Mot.Sup.SK2 220/230/240V 50HZ MOTORE S38
65	1,0000	PZ		SBA0000120	Mot.Sup.SK2 220V 60HZ MF MOTORE S38
66	1,0000	PZ		SBA0000121	Mot.Sup.SK2 220V 50HZ MF MOTORE S38
67	1,0000	PZ		SBA0000122	Mot.Sup. SK2 200/220V 50/60HZ MOTORE S38
68	1,0000	PZ		SBA0000124	Mot.Sup.SK2 440V 50HZ 3F MOTORE 380



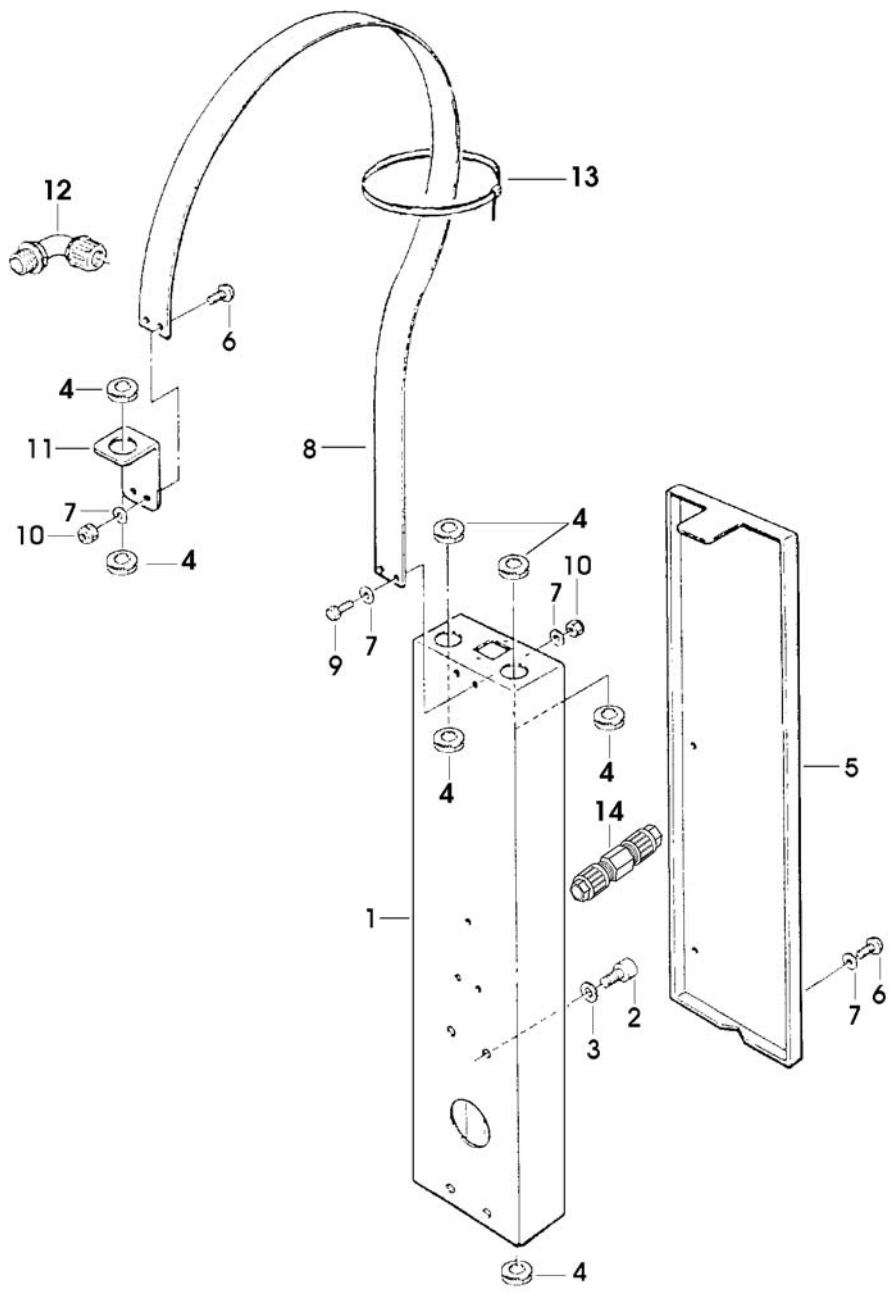


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see

1-63-64-65-66-67-68

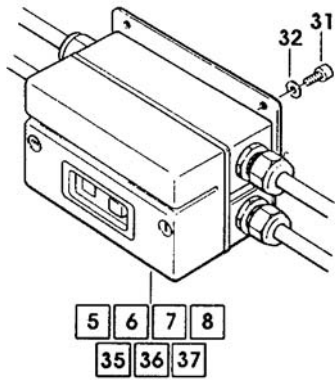
**Fig. 10130    CANALINA    SEB0000149    S2-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
1	1,0000	PZ	4.2.04224	S4204224ZZZ	CANALINA CON GUARNIZIONE
2	4,0000	PZ	3.4.00577.93	S340057793Z	VITE TCEI M6X16 ZINCATA
3	4,0000	PZ	3.4.00175.93	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
4	5,0000	PZ	3.8.01216	S3801216ZZZ	PASSACAVO GOMMA PER FORO /16.5
5	1,0000	PZ	3.2.05938.47B	S320593847B	CARTER CANALINA SA2 VERNIC.
6	8,0000	PZ	3.4.00720.93	S340072093Z	VITE TESTA MEZZA TONDA M5X12 CROCE ZINC
7	12,000	PZ	3.4.00061.93	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
8	1,0000	PZ	3.7.00155.47	S370015547Z	MOLLA A BANDELLA SM46/94
9	2,0000	PZ	3.4.00371.93	S340037193Z	VITE TE M5X12 ZINCATA
10	4,0000	PZ	3.4.00023.93	S340002393Z	DADO M5 ZINCATO
11	1,0000	PZ	3.2.06356.93A	S320635693A	SQUADRETTA ATTACCO BANDELLA SA2 SR4
12	1,0000	PZ	3.8.02139	S3802139ZZZ	BOCCHETTONE SKINTOP ST11
13	6,0000	PZ	3.8.01241	S3801241ZZZ	FASCETTA L=140x3,5 (NERA)
14	2,0000	PZ	3.8.08092.00A	S380809200A	CONNETTORE QUICKON-ONE DA 0.75 A 1.5 Q 1



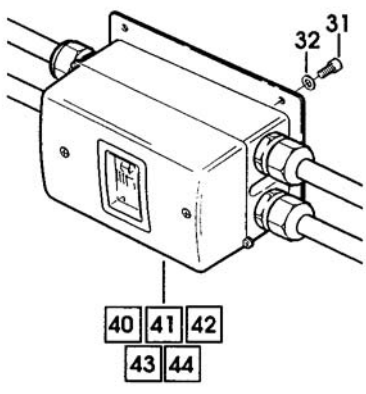
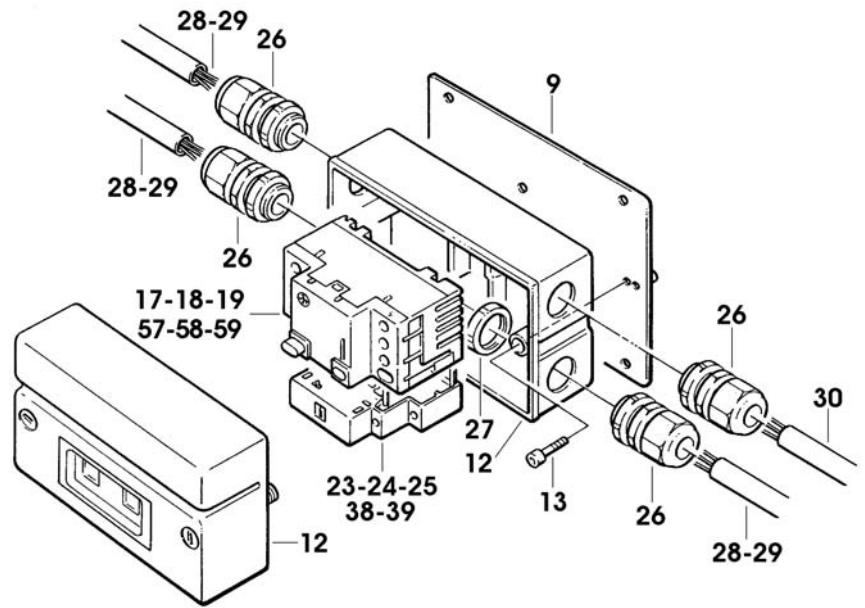
**Fig. 10131 INTERRUTTORE SEB0000149 S2-S NASTRATRICE**

Pos.	Q.tà	UM	Codice	NuovoCodice	Descrizione
5	1,0000	PZ	4.7.11366.00A	S471136600A	INTERR.ASS.200V/220V 50/60HZ H63 SA2-SR4
6	1,0000	PZ	4.7.11364.00A	S471136400A	INTERR.ASS.380V 50HZ 440V 60HZ H63 SA2-SR4
7	1,0000	PZ	4.7.11363.00A	S471136300A	INTERRUTT.ASS.100/115V 50/60HZ MH63 SA2-S
8	1,0000	PZ	4.7.11362.00A	S471136200A	INTERRUTT.ASS.220/230V 50/60HZ MH63 SA2-S
9	1,0000	PZ	4.5.04871.47	S450487147Z	SUPPORTO INTERRUTTORE C/INSERTI
12	1,0000	PZ	3.8.03660	S3803660A	CUSTODIA KT3-25-KAZ IP55
13	2,0000	PZ	3.4.00016.93	S340001693Z	VITE TCEI M4X20 ZINCATA
17	1,0000	PZ	3.8.02079	S3802079ZZZ	INTERRUTTORE TERMICO KTA 3-25 (2,5-4)
18	1,0000	PZ	3.8.01844	S3801844ZZZ	INTERRUTTORE TERMICO KTA 3-25 1,6-2,5A
19	1,0000	PZ	3.8.03758	S3803758ZZZ	INTERRUTTORE TERMICO KTA3-25 (6,3-10) S
23	1,0000	PZ	3.8.03662	S3803662ZZZ	BOBINA DI MINIMA KT3-25UA 220V
24	1,0000	PZ	3.8.03663	S3803663ZZZ	BOBINA DI MINIMA KT3-25UA 380V
25	1,0000	PZ	3.8.03661	S3803661A	BOBINA DI MINIMA KT3-25UA 110V
26	4,0000	PZ	3.8.00854	S3800854ZZZ	BOCCHETTONE SKINTOP ST 16
27	4,0000	PZ	3.8.03846	S3803846ZZZ	CONTRODADO GMP16
28	2,0000	PZ	3.8.01703	S3801703ZZZ	CAVO VIN.4X1,5 MT.5 X 3F
29	2,0000	PZ	3.8.01704	S3801704ZZZ	CAVO VIN.3X1,5 MT.5 X MF
30	1,0000	PZ	3.8.02654	S3802654ZZZ	CAVO 3X1 C/2 ROSSI + 1 GIALLO/VERDE (MT.
31	4,0000	PZ	3.4.00318.93	S340031893Z	VITE TCEI M5X12 ZINCATA
32	4,0000	PZ	3.4.00061.93	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
35	1,0000	PZ	4.7.11365.00A	S471136500A	INTERR.ASS.240V 50HZ H63 SA2-SR4 AL
36	1,0000	PZ	4.7.11411.00A	S471141100A	INTERRUTT.ASS.440/415V 50HZ H63 SA2-SR
37	1,0000	PZ	4.7.11412.00A	S471141200A	INTERRUTT.ASS.240V 50HZ MH63 SA2-SR4 "A
38	1,0000	PZ	3.8.05110	S3805110ZZZ	BOBINA DI MINIMA KT3-25UA 240V ART.140-UV
39	1,0000	PZ	3.8.05111	S3805111ZZZ	BOBINA DI MINIMA KT3-25UA 415V ART.140-UV
40	1,0000	PZ	4.7.11491.00A	S471149100A	INTERR.ASS.200/220V 50/60HZ 240V 50HZ
41	1,0000	PZ	4.7.11492.00A	S471149200A	INTERR.ASS.380/415V 50HZ 440V 60HZ 3F SA
42	1,0000	PZ	4.7.11493.00A	S471149300A	INTERR.ASS.440V 50HZ 3F SA2/SR4 SI
43	1,0000	PZ	4.7.11494.00A	S471149400A	INTERR.ASS.100V 50/60 HZ 110 115V 60HZ
44	1,0000	PZ	4.7.11495.00A	S471149500A	INTERR.ASS.220/230/240V 50HZ MF SA
45	1,0000	PZ	3.8.05125	S3805125ZZZ	CUSTODIA ISOLANTE 3ZV1913-1A S00 IP55 S
46	2,0000	PZ	3.4.00130.93	S340013093Z	VITE TSVEI M4X15 ZINCATA
47	1,0000	PZ	3.8.05118	S3805118ZZZ	INTERR.AUT. 3RV1011-1DA10 S00 2.2-3.2 10
48	1,0000	PZ	3.8.05117	S3805117ZZZ	INTERR.AUT. 3RV1011-1BA10 S00 1.4-2A 100
49	1,0000	PZ	3.8.05120	S3805120ZZZ	INTERR.AUT. 3RV1011-1HA10 S00 5.5-8A 100
50	1,0000	PZ	3.8.05122	S3805122ZZZ	BOBINA DI MINIMA TENSIONE 230V 3RV1902-1A
51	1,0000	PZ	3.8.05123	S3805123ZZZ	BOBINA DI MINIMA TENSIONE 400V 3RV1902-1A
52	1,0000	PZ	3.8.05124	S3805124ZZZ	BOBINA DI MINIMA TENSIONE 440V 3RV1902-1A
53	1,0000	PZ	3.8.05121	S3805121ZZZ	BOBINA DI MINIMA TENSIONE 110V 3RV1902-1A
57	1,0000	PZ	3.8.01815	S3801815ZZZ	INT.TERMICO KTA-3-25 0,63-1A
58	1,0000	PZ	3.8.01830	S3801830ZZZ	INTERRUTTORE TERMICO KTA 3-25 1-1,6A
59	1,0000	PZ	3.8.05072	S3805072ZZZ	INTERRUTTORE TERMICO -KTA3-25 (4-6,3A)
60	1,0000	PZ	3.8.05116	S3805116ZZZ	INTERR.AUT. 3RV1011-0KA10 S00 0.9-1.25A
61	1,0000	PZ	3.8.05119	S3805119ZZZ	INTERR.AUT. 3RV1011-1FA10 S00 3.5-5A 100



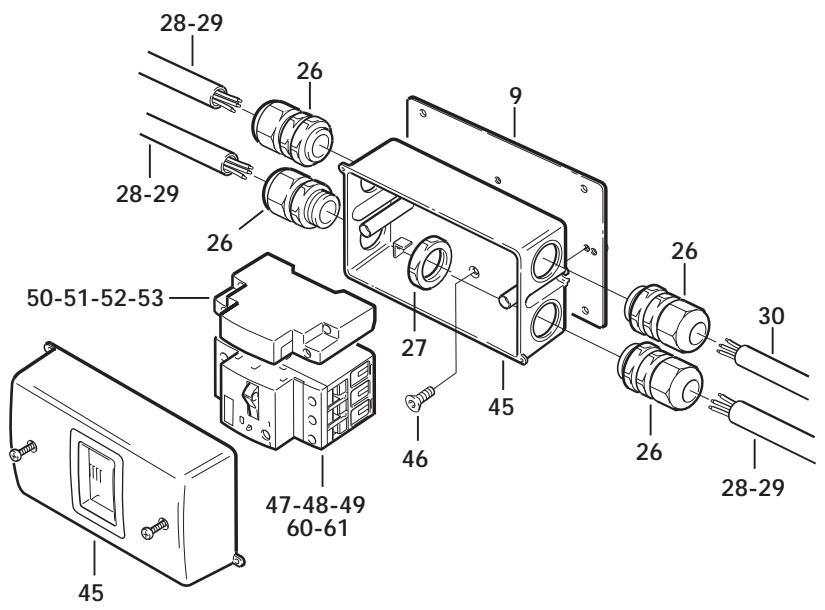
**ALLEN  
BRADLEY**

**5-6-7-8-35-36-37**

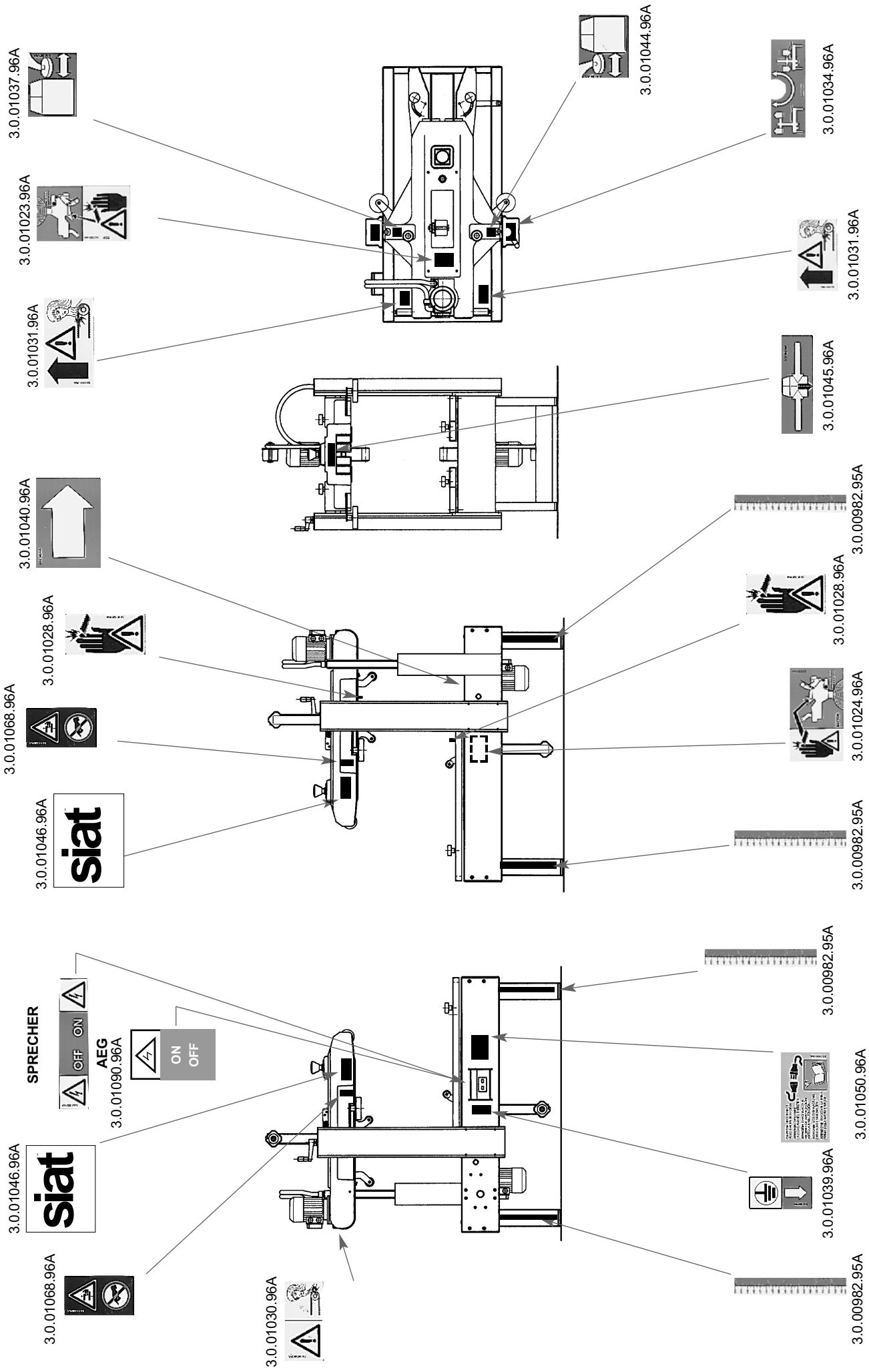


**SIEMENS**

**40-41-42-43-44**







**S2-S LABELS - ETIQUETTES - ETIKETTES - ETICHTEN - ETICHETTE** Fig. 5707