



ITALPRESSE S. P. A.

MAINTENANCE HANDBOOK

OLEODYNAMIC PRESS MOD.

” ITT-SCF/10”

MATRICOLA N* 42081190

ALL RIGHTS RESERVED

DEARS SIRs,

HERE WITH ENCLOSED YOU WILL FIND INSTRUCTIONS FOR THE USE, RUNNING AND MAINTENANCE OF THE MACHINE YOU ORDERED.

MACHINE MODEL "ITT-SCF/10"

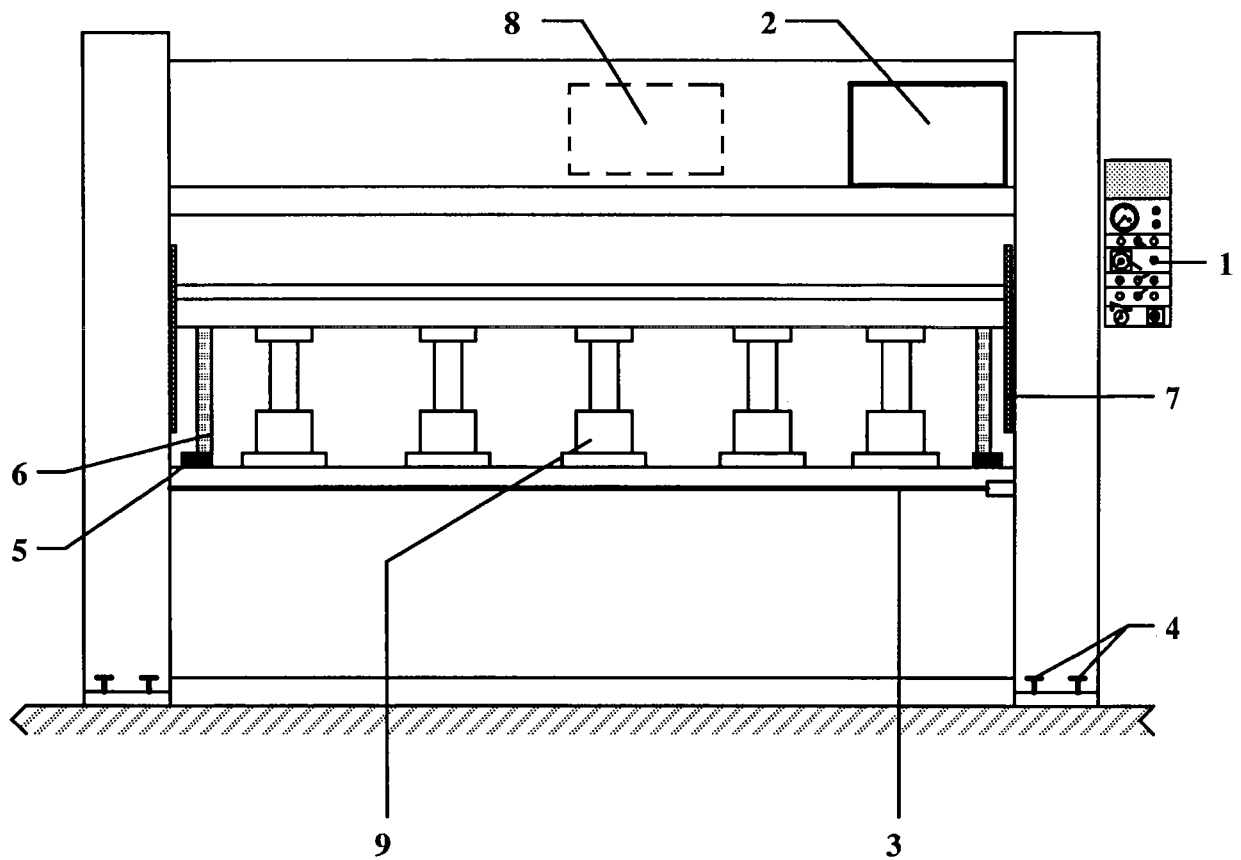
WE RECCOMEND THAT THE OPERATOR OF THE MACHINE ALWAYS KEEPS THESE INSTRUCTIONS CLOSE AT HAND, THUS MAKING HIS TASK EASIER AND ENABLING HIM TO KEEP IN MIND THOSE USEFUL HINTS WHICH, WHEN IGNORED, COULD LEAD TO MISUSE OF THE MACHINE, UN-NECESSARY WEAR AND EVEN BREAKAGES.

WE TRUST THAT YOU WILL COOPERATE WITH THESE RECCOMENDATIONS,AND REMAIN,

YOURS FAITHFULLY,

ITALPRESSE S. P. A.

OLEODYNAMIC PRESS MOD. "ITT-SCF/10"



- 1 - CONTROL BOARD
- 2 - ELECTRIC FEED BOX
- 3 - SAFETY ROPE
- 4 - LEVEL ADJUSTING SCREWS
- 5 - RACK'S REST
- 6 - RACK
- 7 - MOVABLE PLATEN WAIS
- 8 - OLEODYNAMIC UNIT
- 9 - CYLINDER

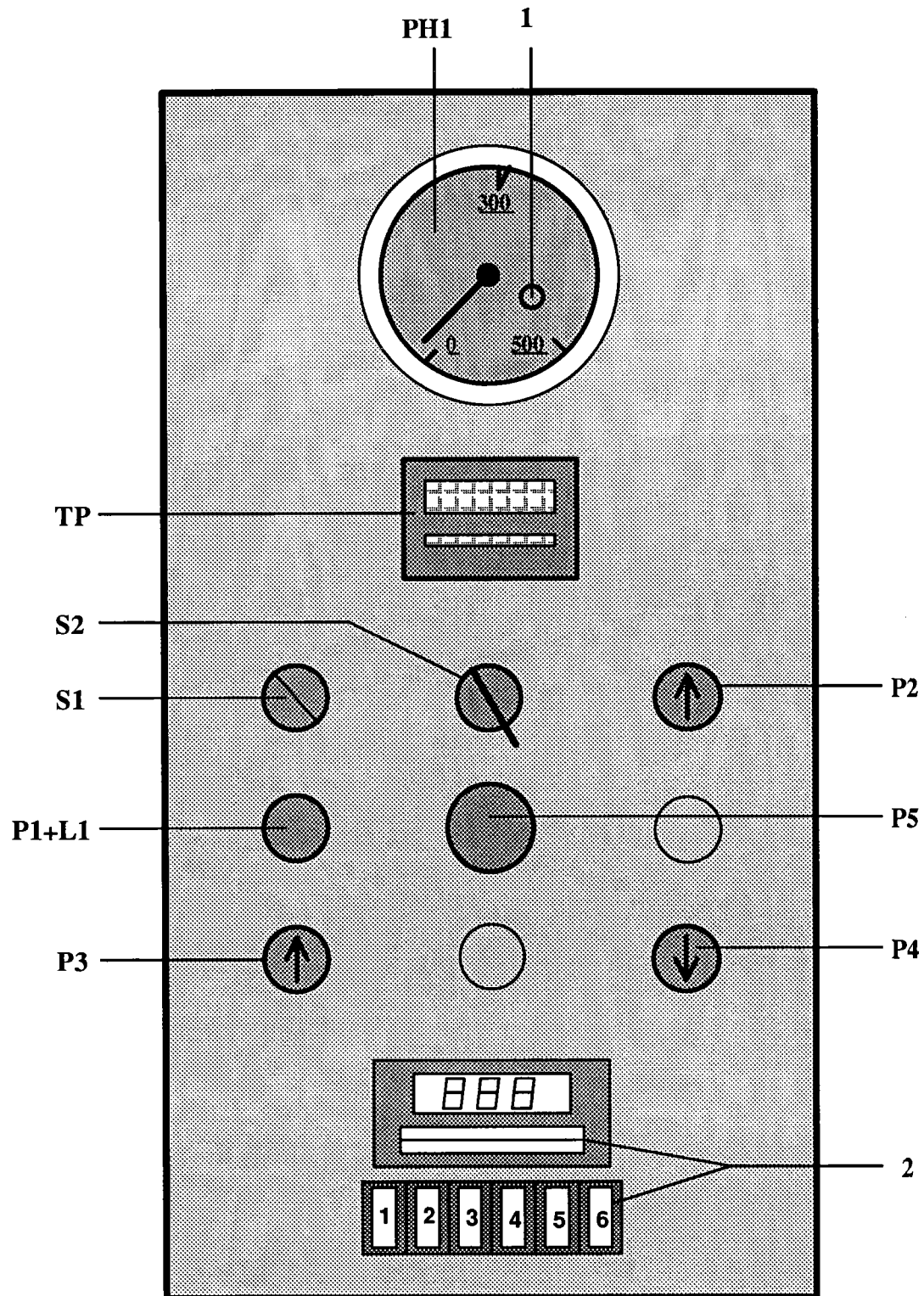
CONTROLS

- PLACE THE PRESS WITH THE HELP OF A WATER-LEVEL, TURNING THE POSITIONING SCREWS (Pos.4 pag.3) AND CONTROLLING THE LEVEL ON CYLINDERS SUPPORT PLATES (Pos.9 pag.3).
- ACCERTAIN THAT THE EFFECTIVE VOLTAGE OF THE LINE IS THE SAME AS INDICATED ON THE APPROVAL PLATE FIXED ON THE ELECTRIC LINE BOX.
- VERIFY THAT AT PRESS CLOSED THE OIL LEVEL IN THE GEARBOX REACHES THE MIN. HEIGHT OF mm.160.

SETTING AT WORK

- TURN GENERAL SWITCH (Pos.4 pag.4) MOUNTED ON CONTROL BOARD ON POS."1".
- SET THE PRESSURE ON MANOMETER (POS.1 PAG.4) WITH KNOB (POS.2 PAG.4) ACCORDING TO THE PANEL SURFACE AND TO THE SPECIFIC PRESSURE (SEE THE WORKING DIAGRAM).
- SELECT THE PRESSING TIME ON THE TIMER (POS.9 PAG.4) AND TURN ON SELECTOR (POS.8 PAG.4)
- PUSH PUSHBUTTON DOWN (Pos.11) TILL MOBILE PLATEN REACHES END-STROKE POSITION (PRESS COMPLETELY OPEN).
- PUSH TOGETHER BUTTONS (POS.3-12 PAG.4); NOW THE PRESS REACHES AUTOMATICALLY THE PRESSURE, KEEPS IT AS LONG AS THE TIME SELECTED ON THE TIMER, THAN OPENS AUTOMATICALLY.
- TO WORK WITH OUT AUTOMATISM (POS.8 "OFF"), OPEN THE PRESS WITH PUSH BUTTON (POS.11).

CONTROL BOARD



CONTROL BOARD

PH1 – MANOMETER

1 – MANOMETER ADJUSTMENT SCREW

P2 – UPSTROKE PUSH BUTTON (PUSH IT SIMULTANEOUSLY WITH BUTTON "P3")

S1 – MAIN SWITCH

S2 – DOWNSTROKE AUTOMATISM EXCLUSION SELECTOR

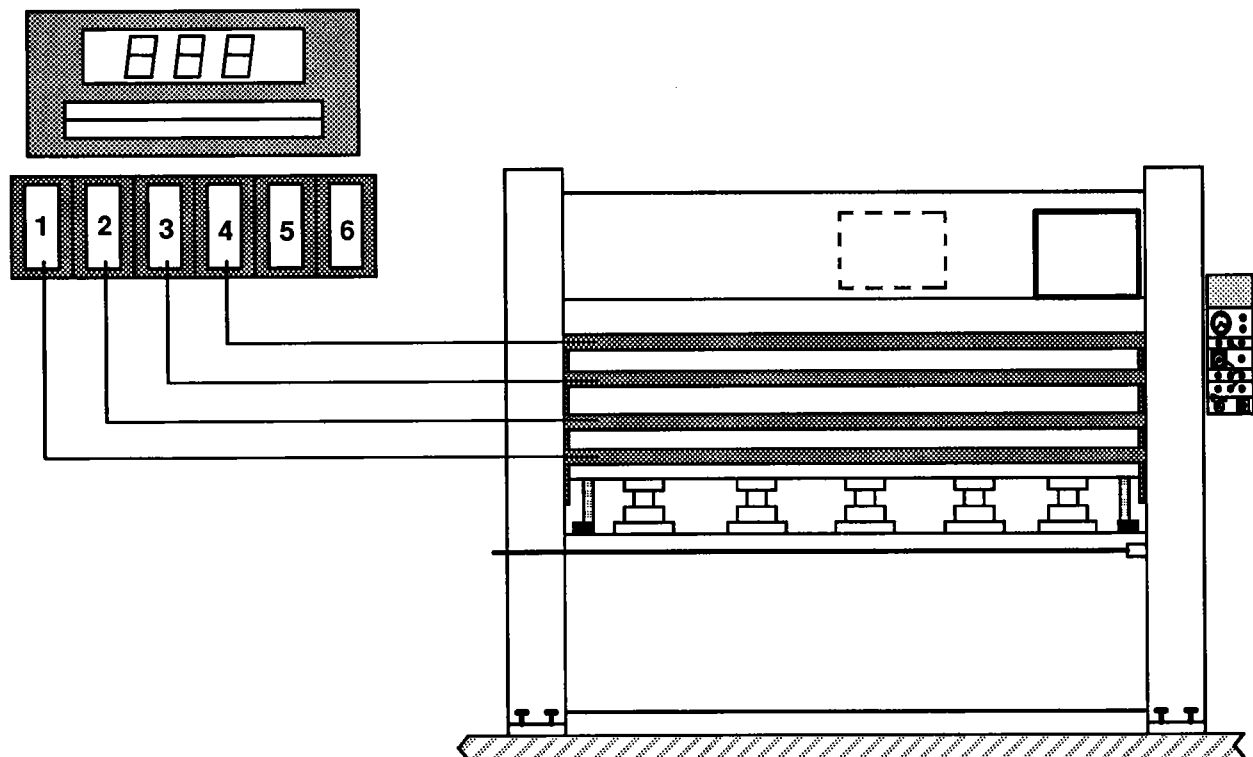
TP – AUTOMATIC DOWNSTROKE PRESSING TIMER (IT CAN BE EXCLUDED WITH SELECTOR "S2" "OFF")

P1+L1 – LUMINOUS PUSH BUTTON TO START AGAIN THE PRESS AFTER EMERGENCY

P4 – DOWNSTROKE PUSH BUTTON

P5 – STOP-EMERGENCY MUSHROOM PUSHBUTTON

2 – DIGITAL CONTROL OF TEMPERATURE F



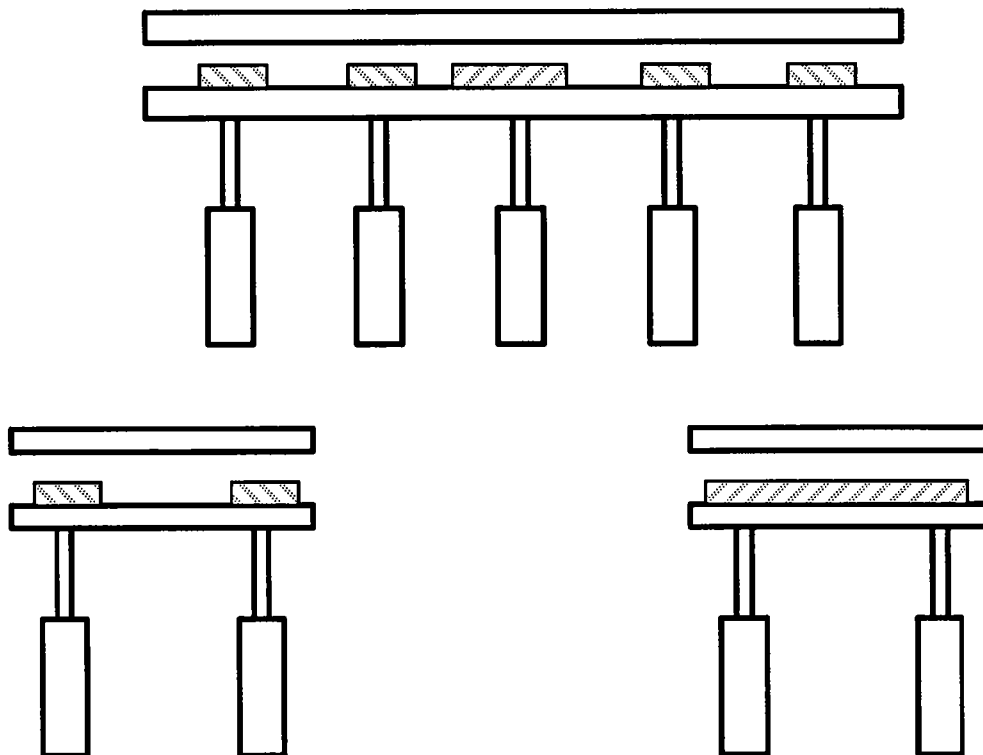
GENERAL RULES

- IF, UPON PUSHING OF UPSTROKE PUSHBUTTON, THE MOBILE PLAT DOESN'T RAISE, IT MEANS THAT THE PUMP IS TURNING IN THE OPPOSITE DIRECTION. THERE FORE THE CABLES IN THE FEED BOX MUST BE INVERTED .

- EVENTUAL OIL TOPPING UP IN THE OIL TANK SHALL BE EFFECTED WITH OIL TYPES AS SUGGESTED AT PAG.9. OLEODYNAMIC OIL SHOULD BE REPLACED AFTER THE FIRST 500 HOURS RUNNING AND THE EVERY 2000 HOURS.

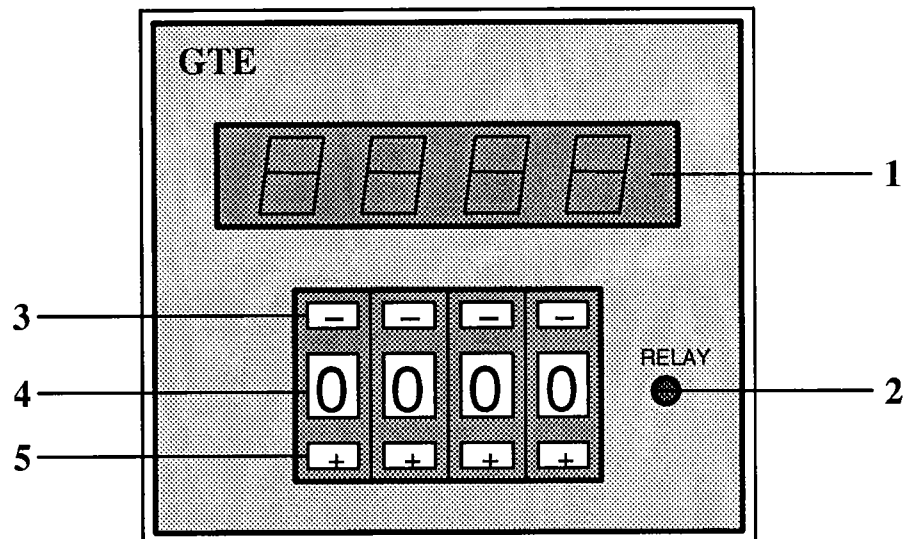
- THE WORKING PRESSURES ARE OBTAINED USING THE RESPECTIVE DIAGRAM ACCORDING TO THE PRESSING SURFACE AND TO THE SPECIFIC PRESSURE WHICH IS REQUIRED ON THE PANEL. IT MUST BE CONSIDERED THAT THE INTERESTED SURFACE IS THE EFFECTIVE ONE, OBTAINED EXCLUDING THE VACUUMS INSIDE THE PANELS.

- PANELS ARE TO BE PLACED IN THE PRESS OPENING AND CENTERED IN COMPARISON WITH THE PRESS' AXIS. IF A LITTLE PANEL HAS TO BE PRESSED, BE CAREFULL TO PUT SOME THICKNESSES SAME AS THE PANEL ONE, BY THE PISTONS (SEE DRAWING).



PRESSING TIMER

TIPO G-TE-00-40S-V.110 cod. 10 1834 2040



- 1 - DISPLAY
- 2 - LED PRESSING COMPLETED
- 3 - TIME DECREASE
- 4 - DISPLAY OF TIME SET IN SECOND
- 5 - TIME INCREASE

THE PRESSING TIME CAN VARY DUE TO THE THICKNESS OF THE MATERIAL TO BE GLUED, THE KIND OF MATERIAL AND PERCENTAGE OF WATER PRESENT IN THE GLUE. THE ADJUSTMENT OF PRESSING TIME IS MADE THROUGH PUSHBUTTONS POS."5" TO INCREASE THE TIME AND THROUGH PUSHBUTTONS POS."3" TO DECREASE IT. THE MEASUREMENT UNIT IS IN SECONDS.

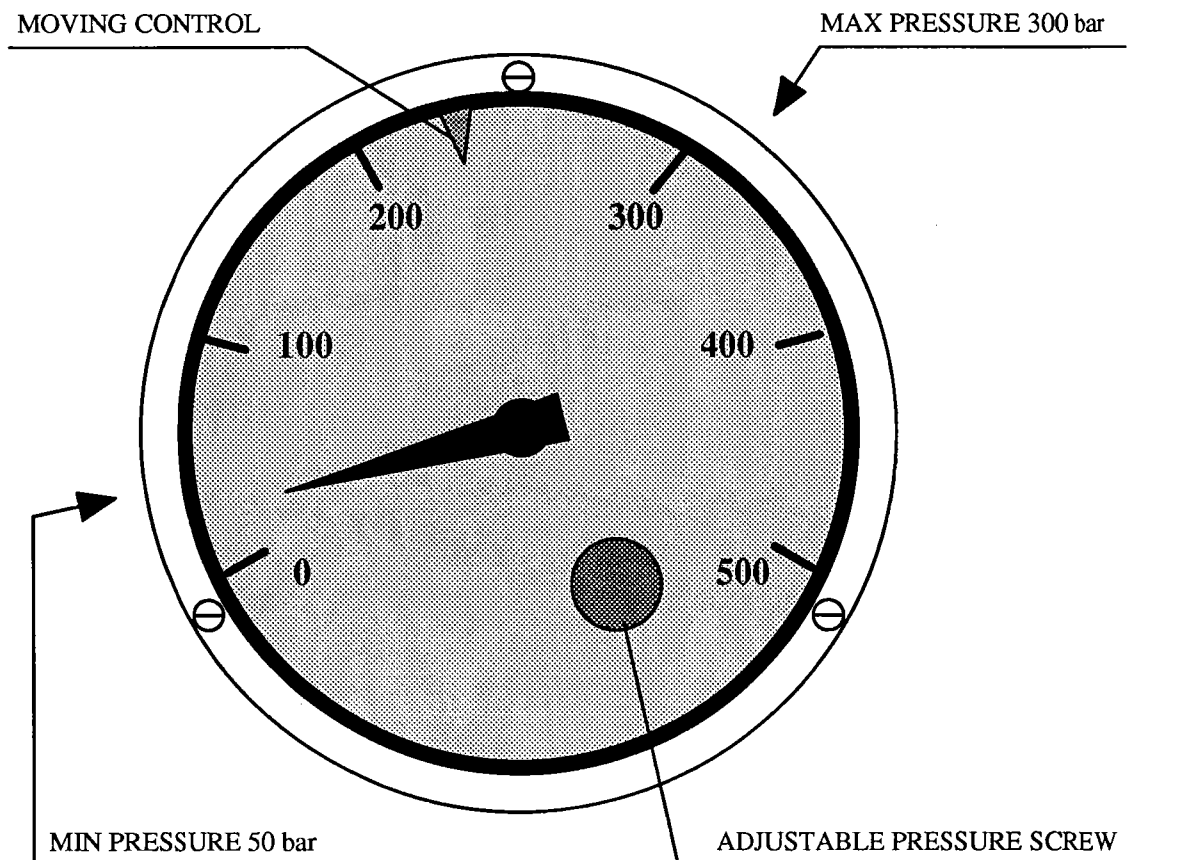
PRESSURE ADJUST

THE WORKING PRESSURE REQUIRED FOR THE GLUEING IS TO BE ADJUSTED ACCORDING TO THE REAL SURFACES TO BE PRESSED AND TO THE KIND OF MATERIAL TO BE GLUED.

HERE WITH ENCLOSED IS A SPECIAL DIAGRAM WHICH SHOWS DIRECTLY THE SPECIFIC PRESSURE IN KG/CM². WHICH IS REQUIRED ACCORDING TO THE SURFACE, IN SQUARE METERS, OF THE MATERIAL TO BE PRESSED AND TO THE PRESSURE, IN BAR, TO BE SET ON THE PRESSURE SWITCH. IF THE PRESS PLATEN SURFACE IS NOT COMPLETELY COVERED WITH MATERIAL, THE PIECES TO BE PRESSED SHOULD BE PLACED SO THAT EACH PRESSURE PISTON IS INVOLVED .

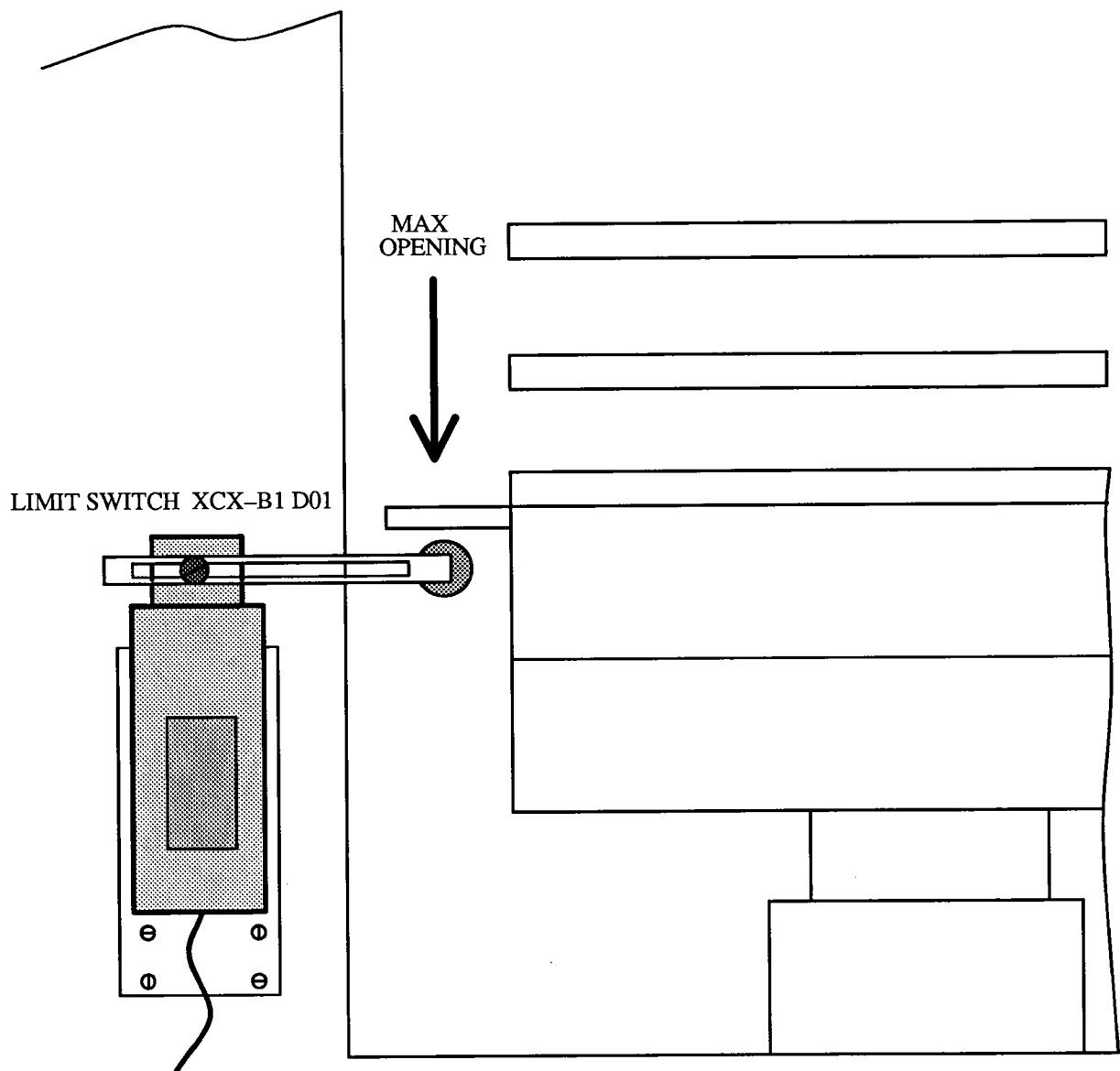
THE PRESSING PISTONS SHALL NEVER EFFECT FREE PRESSURES.

FAILING PANELS TO BE GLUED IT IS BETTER (INSTEAD OF WORKING WUTH PARTIALLY LOADED PLATEN) TO COVER THE PLATEN PARTS WHICH ARE LEFT FREE, WITH PANELS OF PROPER THICKNESS, THAT SUPPORT THE PRESSURE OF THE PISTONS WHICH ARE NOT DIRECTLY CONCERNED BY THE PIECES TO BE PRESSED.

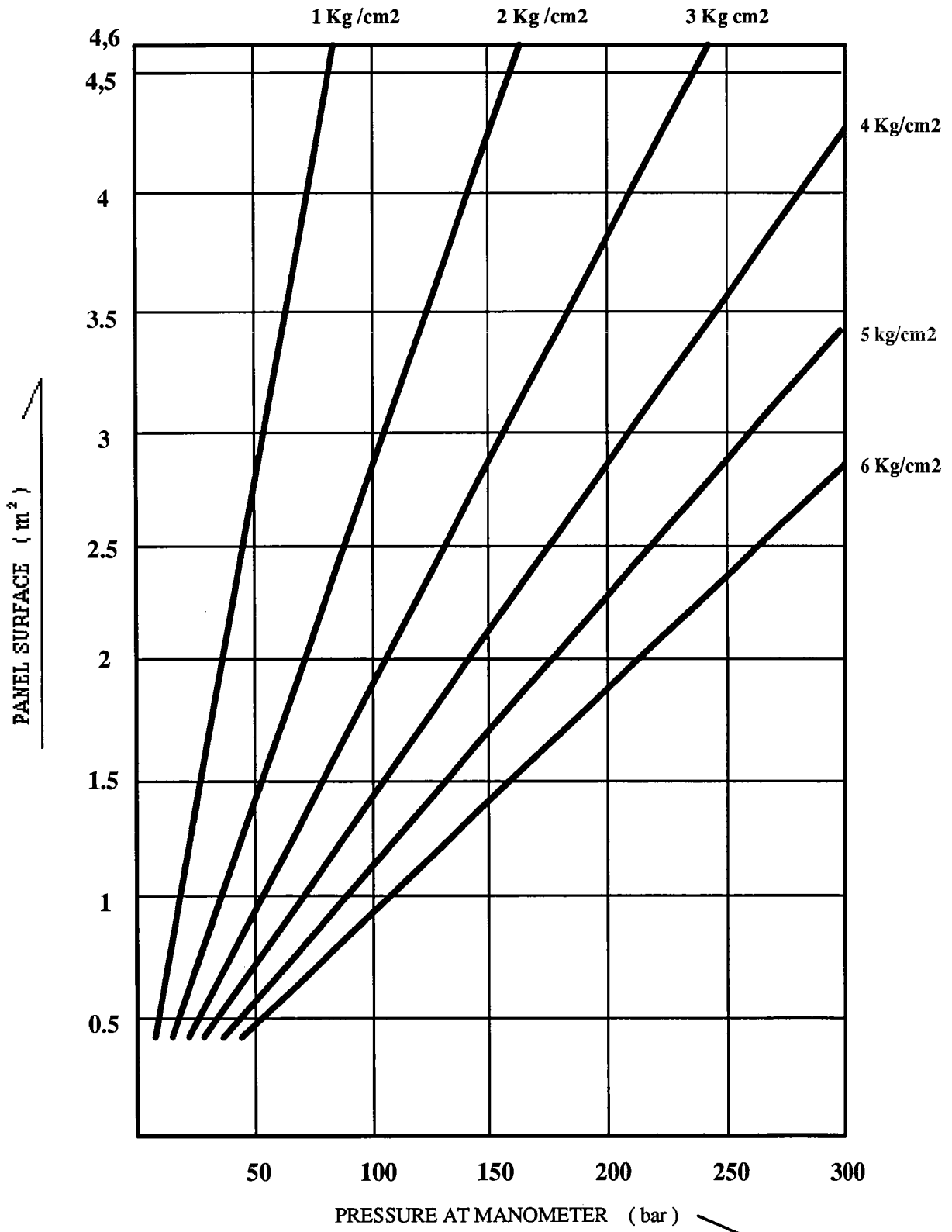


MAX OPENING SYSTEM

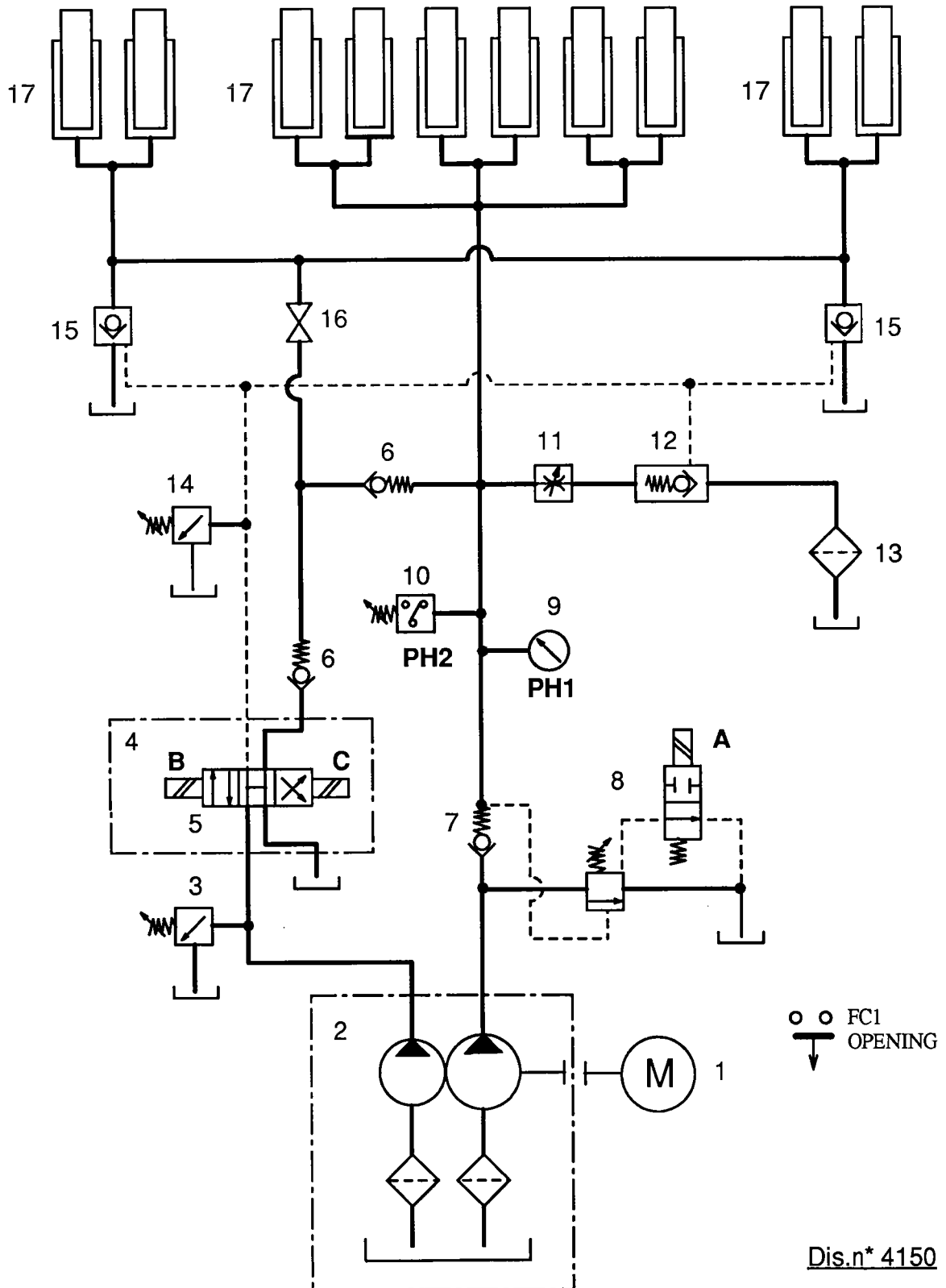
FC1



WORKING DIAGRAM



OLEODYNAMIC SCHEME



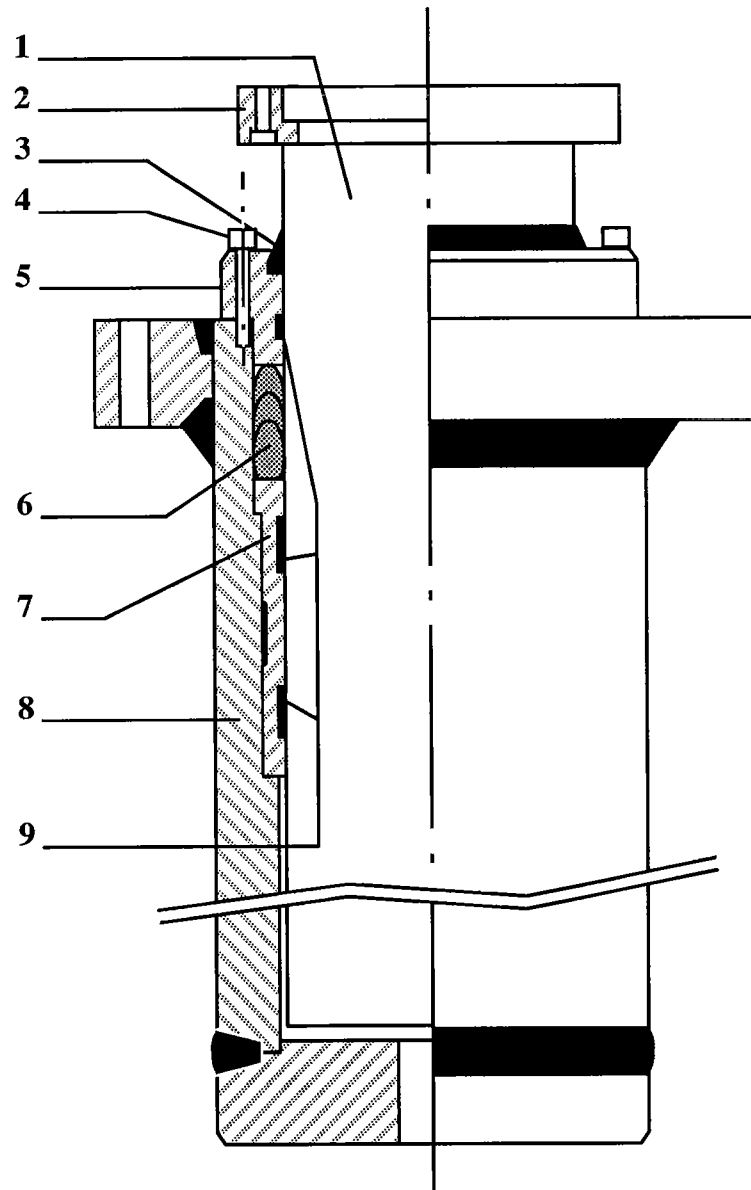
Dis.n° 4150

OLEODYNAMIC SCHEME DESCRIPTION


DIS. N* 4150

1 – MOTOR HP 10 4P B5 V. 440/760–60HZ		10 1184 1438
2 – UNIT GROUP HAR 107/8+HV–D16 (HRA90/8,4)		10 0330 1100
3 – VALVE MV 42 B		10 2009 2840
4 – PIASTRA BA–202		10 1430 0300
5 – ELECTROVALVE DHU 0710–X110 DC		10 0540 0519
6 – VALVE ADR 10	N*2	10 2009 1040
7 – VALVE ADR 32		10 2009 1830
8 – ELECTROVALVE ARAU 32/10/100–UX 110 DC		10 0540 0092
9 – MANOMETER D.100 BAR 0–500 FERMO 300		10 1135 0320
10 – PRESSOSTAT HAWE DG 35–Y8		10 1472 0150
11 – VALVE HAWE SB 43C		10 2009 3810
12 – VALVE RHV 5		10 2009 3760
13 – OIL FILTER FBO F 10–150 CR 180		10 0330 1100
14 – VALVE HAWE MV 42 E		10 2009 5800
15 – VALVE CB–32/16	N*2	10 2009 1520
16 – VALVE ART.2310 1/4”		10 2009 0120
17 – CYLINDER Φ 85 CORSA 410	N*10	20 0000 4189 mod.

CYLINDER Φ 85 C. 410



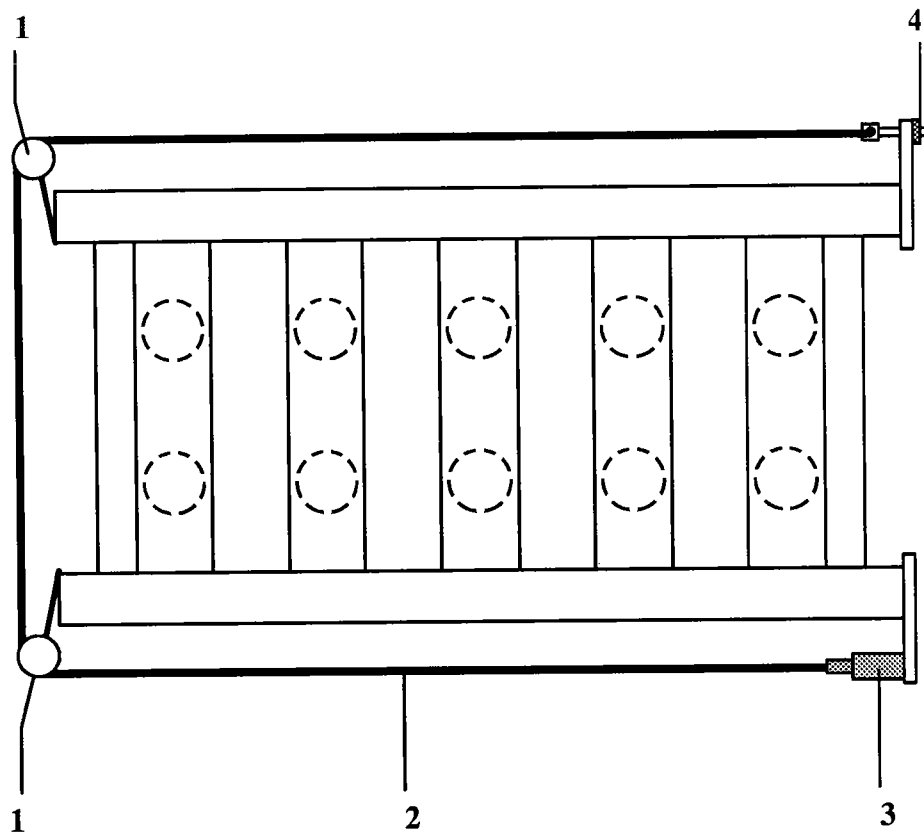
1 - PISTON ROD		
2 - FLANCH		
3 - OIL SCRAPER SG 857	D.85,7X104,8X4,7	10 1615 0920
4 - SCREW T.C.E.I. M10x45		10 2054 2200
5 - GUIDE		
6 - SEAL R 4590/AE	85,73X98,42X11,5	10 0790 3400
7 - BUSH		
8 - LINER		
9 - GUIDE RING "SLYDRINGS	ATS-S 9,5x2,5 Lung. 273 mm."	10 0135 0640

 <u>OIL FOR HYDRAULIC UNIT</u>	
MAKE	DENOMINATION
AGIP	LH 68
API	CIS 68
BP	ENERGOL HLP 68
CASTROL	HYSPIN AWS 68
ELF	ELFOLNA 68
ESSO	NUTO H 68
IP	HYDRUS OIL 68
MOBIL	DTE 26
OLIO FIAT	HTF 68
SHELL	TELLUS OIL 68
TAMOIL	HYDRAULIC OIL 68
TOTAL	AZOLLA ZS 68

SAFETY ROPE

THE SAFETY ROPE AWARD THE PRESS WORKS AU AN ELECTRIC LIMIT SWITCH, THAT, IF EXCITED, STOPS THE PRESS.

IF DURING ITS FUNCTIONING THE PRESS STOPS AND GOES IN EMERGENCY WITHOUT ANY APPARENT REASON IT MAY BE DUE TO THE SAFETY ROPE, TOO TIGHTEN OR TOO LOOSE.



SAFETY ROPE (TOP VIEW)

- 1= PULLEY
- 2= SAFETY ROPE
- 3= PULL SWITCH
- 4= DEVICE FOR TENSION ADJUSTMENT

PRINCIPALI CAUSE BLOCCO MACCHINA

- A – FUNE SICUREZZA TROPPO TESA
- B – FUNE SICUREZZA TROPPO LENTA
- C – PULSANTI CHIUSURA PIANO PRESSA NON PREMUTI CONTEMPORANEAMENTE

MAIN REASONS FOR MACHINE OUT OF SERVICE

- A – SAFETY ROPE TOO TIGHT
- B – SAFETY ROPE TOO LOOSE
- C – PRESS PLATEN CLOSING PUSHBUTTONS NOT PRESSED AT SAME TIME

PRINCIPALES RESON CAUSANTES HORS SERVICE

- A – CABLE DE SICURITE' TROP TENDU
- B – CABLE DE SICURITE' TROP LACHE
- C – POUSSOIR FERMETURE PLATEAU PRESSE NE PA PRESSES EU MEME TEMPS

HAUPTSAECHLICHE GRUENDE SPERRUNG MASCHINE

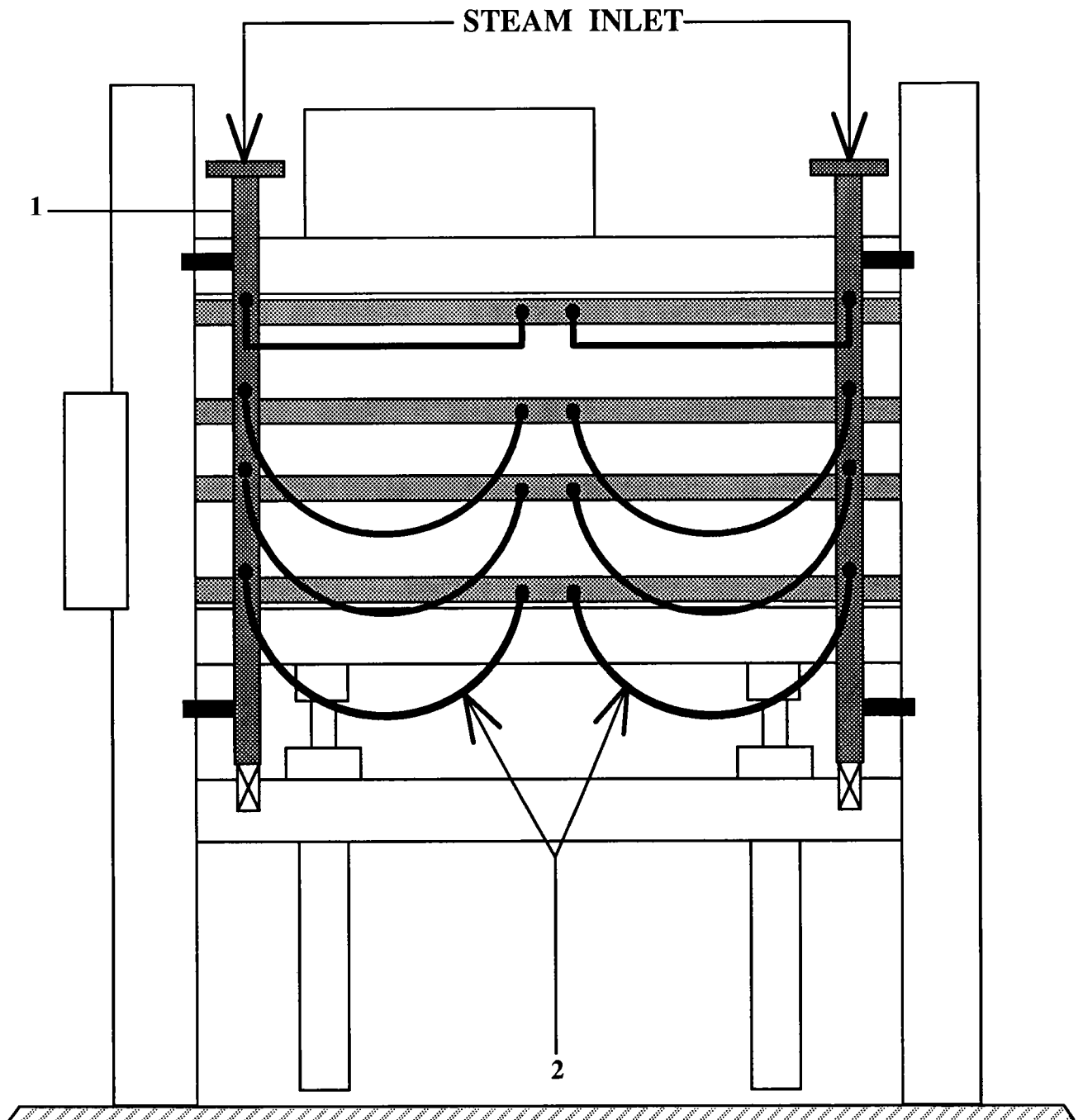
- A – SICHERHEITSSEIL ZU GESPANNT
- B – SICHERHEITSSEIL ZU LOCKER
- C – PRESSPLATEN SCHLIESSZEIT KNOEPFE NICHT GLEICHZEITIG GEDRUECKT

PRINCIPALES CAUSAS DE BLOQUEO MAQUINA

- A – CABLE DE SEGURIDAD DEMASNADO TIESO
- B – CABLE DE SEGURIDAD DEMASNADO FLOJO
- C – PULSADORES CIERRE PLATO PRENSA NO PRESSIONADO CONTEMPORANEAMENTE

OLEODYNAMIC GROUP									
MOTOR HP _____				VOLTAGE _____					
FABRICATION YEAR <div style="border: 1px solid black; width: 100%; height: 20px; margin-top: 5px;"></div>				CAPACITY PUMP lt/1' _____					
NOTE _____									
INTERVENTION SCHEDULE									
<i>OPERATION</i>	<i>FREQUENCE</i>	<i>INTERVENTION DATE</i>							
external cleaning	every 4 months								
oil refilling	when the level is at minimum								
oil replacement and internal cleaning	every 5000 working heures *								
filter cleaning	every 2 months								
filter cartridge replacement	every 3 months								
pump and valves blon-by checking	every 6 months								
pre-charge accumulator (eventual) checking	every 6 months								
ANNOTAZIONI	* = in any case every 2 years								
<div style="border: 1px solid black; height: 40px; margin-top: 5px;"></div>									
<p><i>an oleodynamic group correctly and constantly kept eusures a long life with no inconvenience among the mains causes of faults there can be the locking of equipments due to the again of hidraulic oil. (with following leak of its chemical and physical proprieties)</i></p> <p style="text-align: center;">ITALPRESSE S.P.A.</p>									

HEATING SYSTEM



1 - STEAM INLET MANIFOLD DN DN 40 PN 16

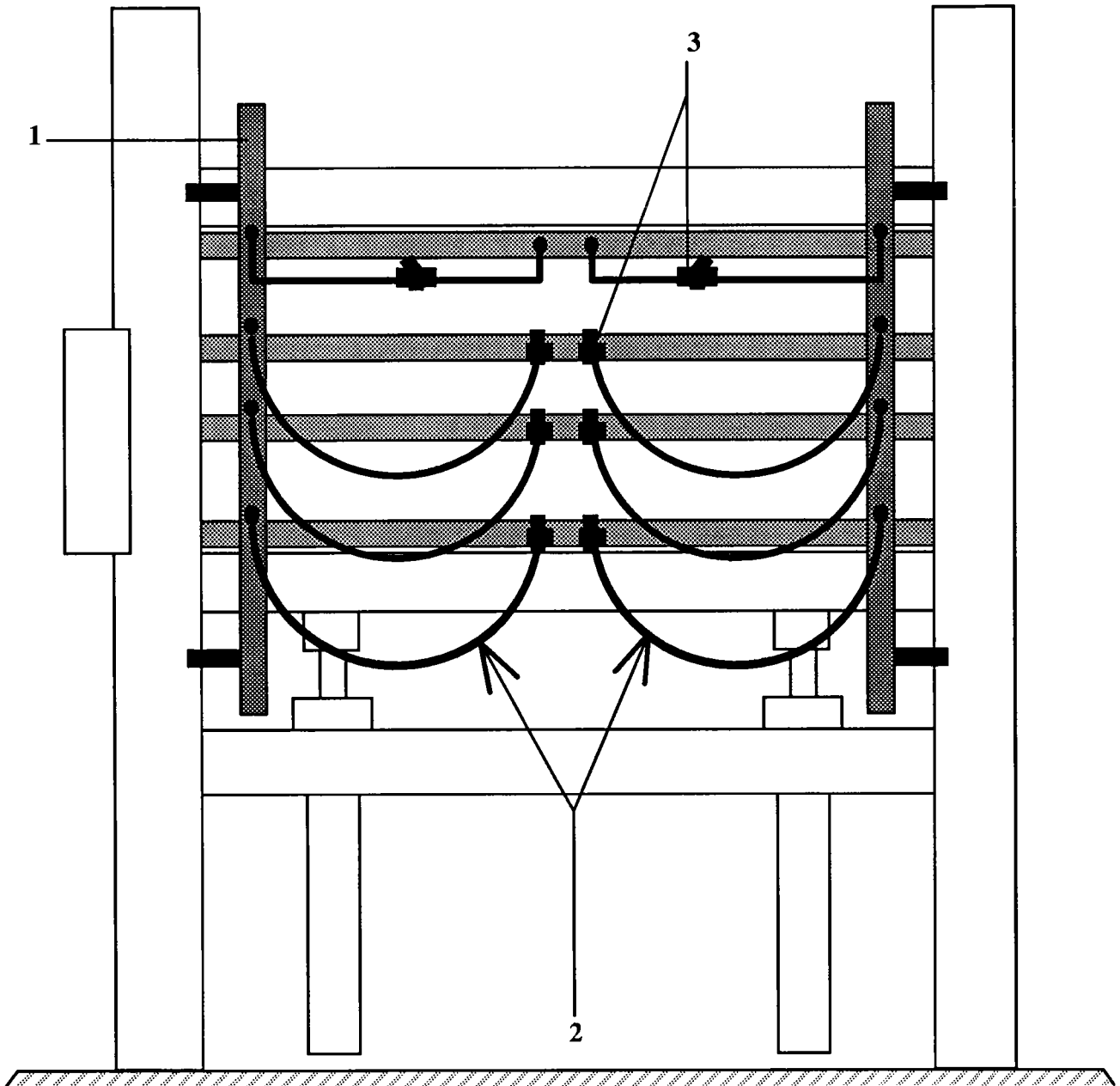
(N*2)

2 - FLEXIBLE TUBES TM7/AX DN 13 LG. 1100 - FB+FB90 360

(N*6)

COD. 10 1873 6150

WATER EXHAUST



1 - WATER EXHAUST MANIFOLD 1"

2 - FLEXIBLE TUBES TM7/AX DN 13 LG. 1100 - FB+FB90 360

3 - WATER EXHAUST TH 20 F/S DN 1/2"

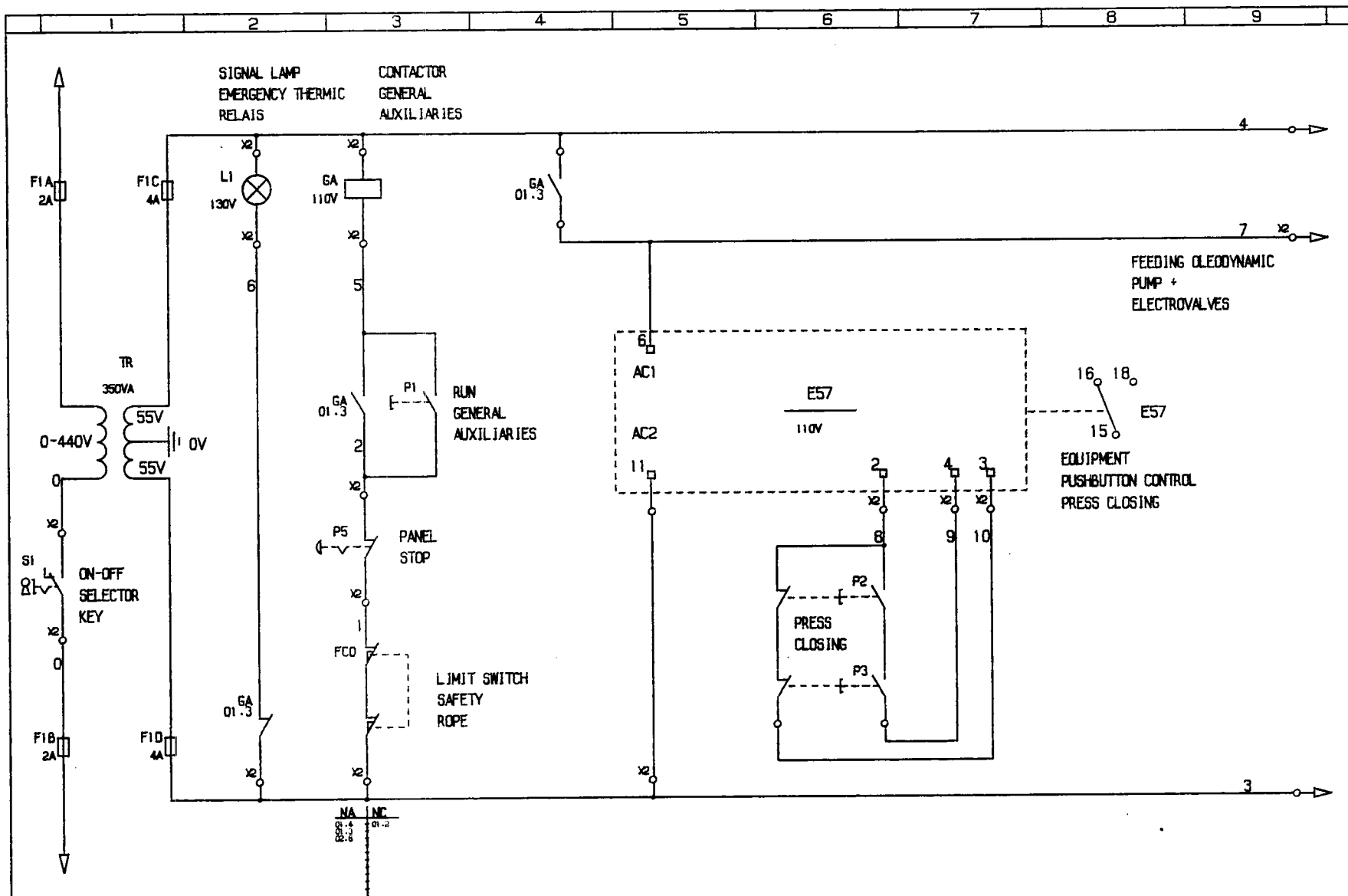
(N*2)

(N*6)

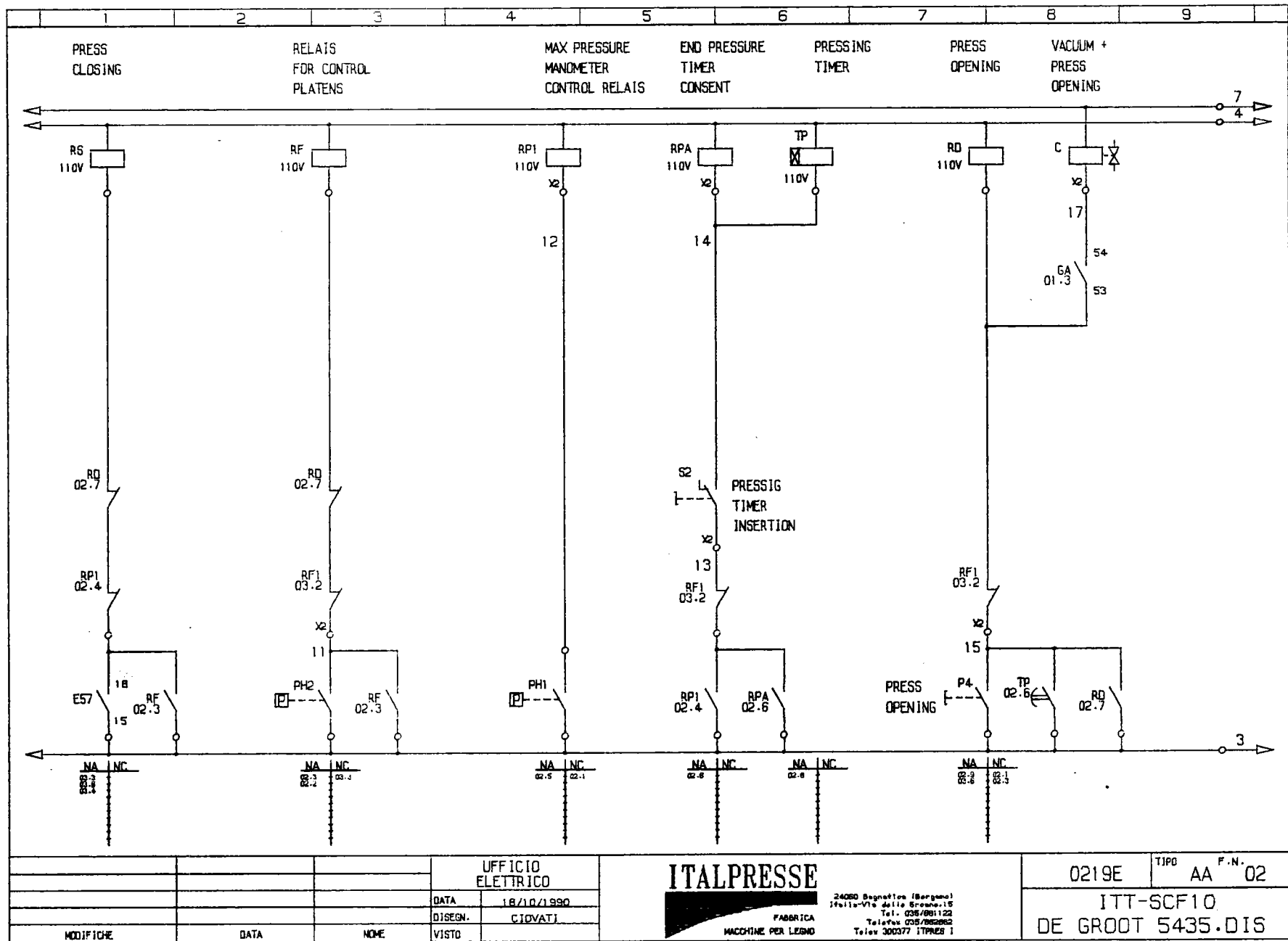
(N*8)

COD. 10 1873 6150

COD. 10 1715 0041



			UFFICIO ELETTRICO		ITALPRESSE <small>FABBRICA MACCHINE PER LEGNO</small>	<small>24080 Segrate (Bergamo) Italo-Via delle Granoie, 15 Tel. 035/881122 Telefax 035/883882 Telex 300377 ITALPRES I</small>	0219E	TIPO AA F.N. 01
			DATA	18/10/1990			ITT-SCF10 DE GROOT 5435.DIS	
MODIFICHE	DATA	NONE	DISEGN.	CIOVATI				
			VISTO					



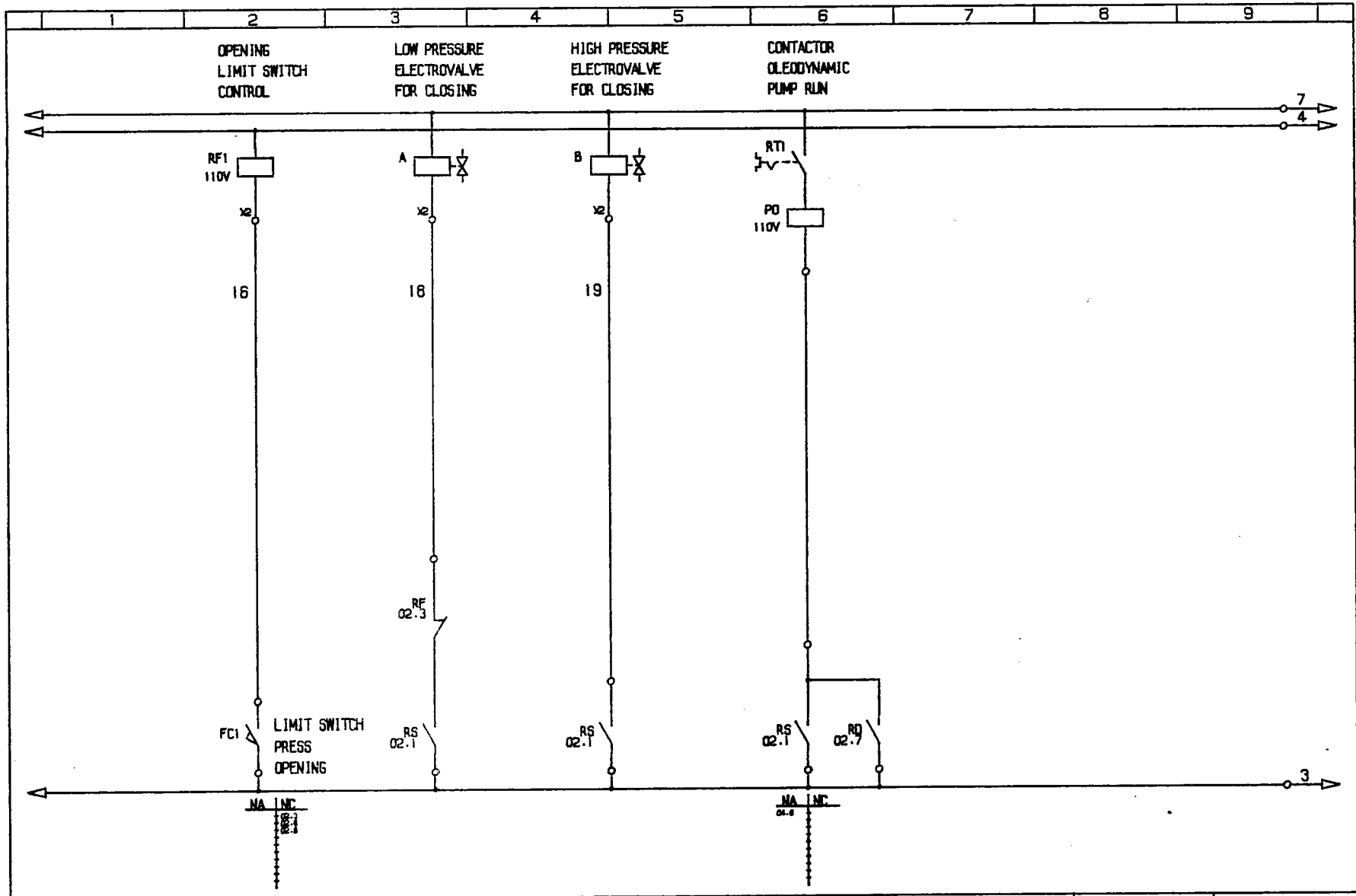
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			DATA	18/10/1990
			DISEGN.	CIDVAT
MODIFICHE	DATA	NOME	VISTO	

ITALPRESSE

FABBRICA
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0219E	TIPO AA F.N. 02
ITT-SCF10	
DE GROOT 5435.DIS	



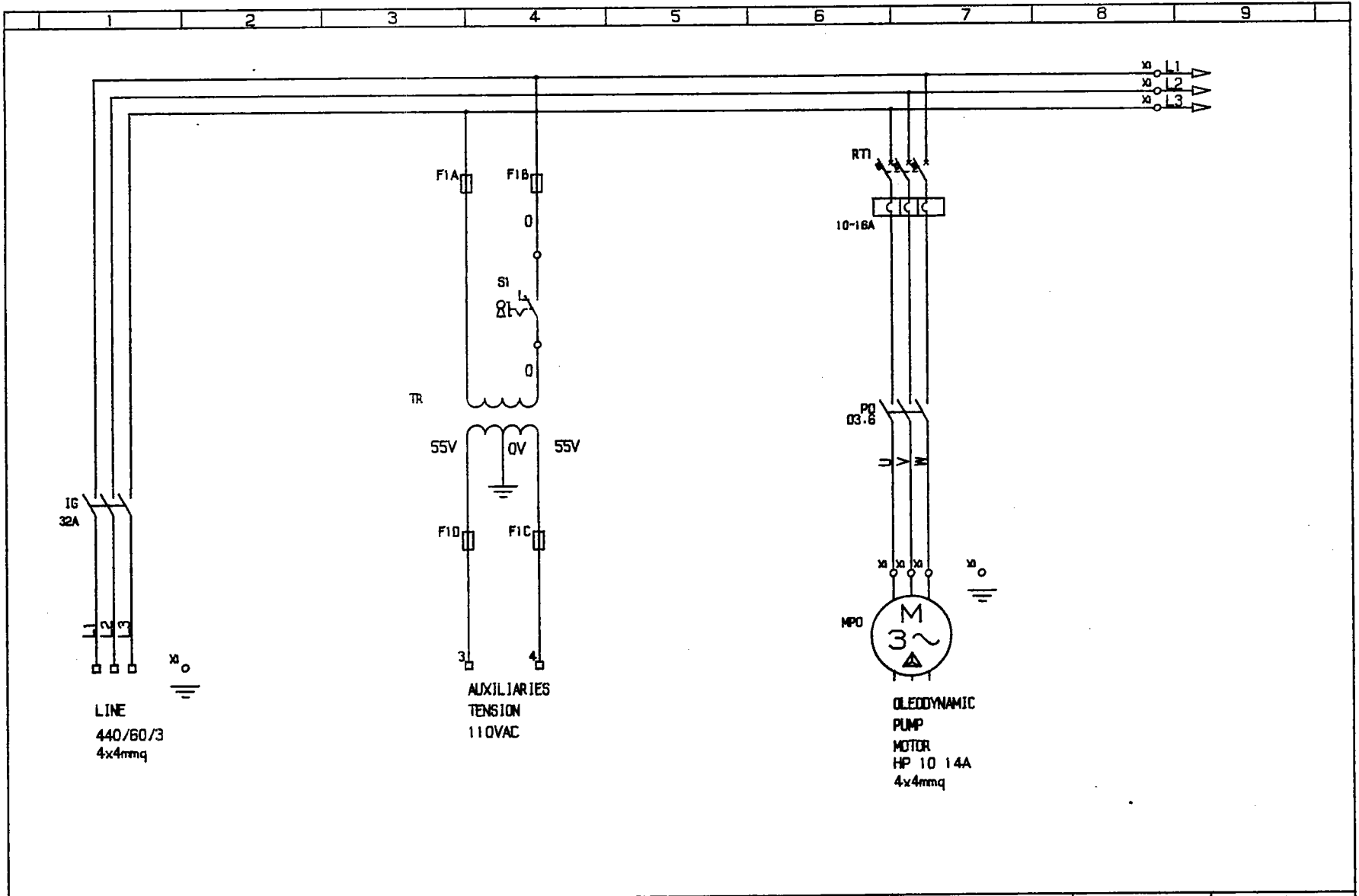
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			DATA 18/10/1990
			DISEGN. CIOVATI
MODIFICHE	DATA	NOME	VISTO

ITALPRESSE

FABBRICA
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0219E	TIPO AA F.N. 03
ITT-SCF10	
DE GROOT 5435.DIS	



			UFFICIO ELETTRICO		ITALPRESSE <small>FABBRICA MACCHINE PER LEGNO</small>	0219E	TIPO AA F.N. 04
			DATA	18/10/1990		ITT-SCF10	
			DISEGN.	CIOVATI	DE GROOT 5435.DIS		
MODIFICHE	DATA	NOME	VISTO				

24090 Sordafico (Bergamo)
 Istituto V.le della Speranza, 15
 Tel. 035/881122
 Telefax 035/882882
 Telex 300277 ITALPRES I

	1	2	3	4	5	6	7	8	9
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TERMINAL BLOCK

X1

U	V	W		L1	L2	L3	
o	o	o	o	o	o	o	o

TERMINAL BLOCK

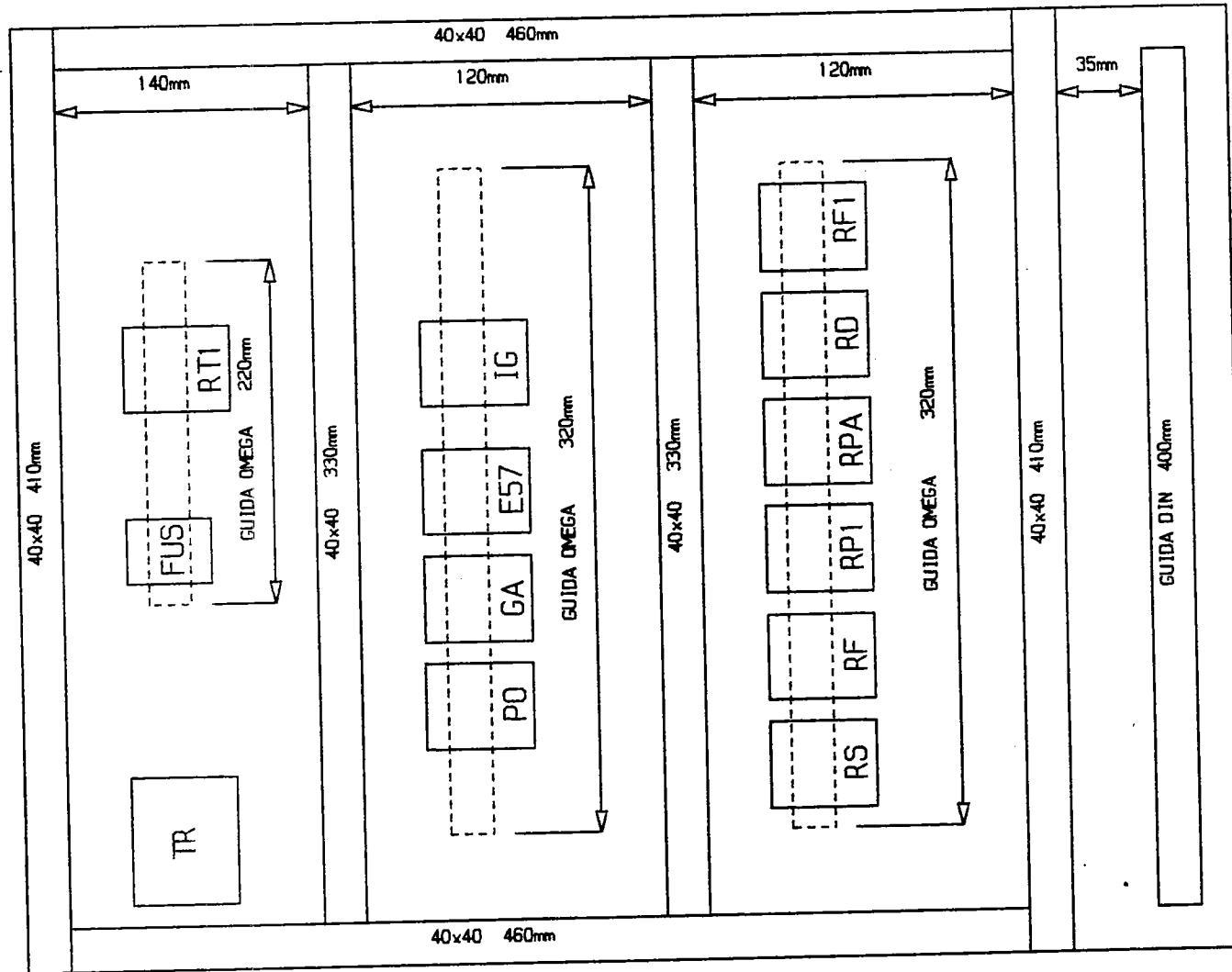
X2

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			UFFICIO ELETTRICO		ITALPRESSE  FABBRICA MACCHINE PER LEGNO	0219E	TIPO AA F.N. 05
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MODIFICHE	DATA	NOTE	VISTO				

24080 Bagnatica (Bergamo)
 Italtel-Via delle Grazie,18
 Tel. 035/861122
 Telex 035/862282
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CUBICLE



MODIFICHE	DATA	NOME	VISTO	UFFICIO ELETTRICO
				DATA 18/10/1990
				DISCEN. CIOVATI

ITALPRESSE

FABBRICA
MACCHINE PER LEGNO

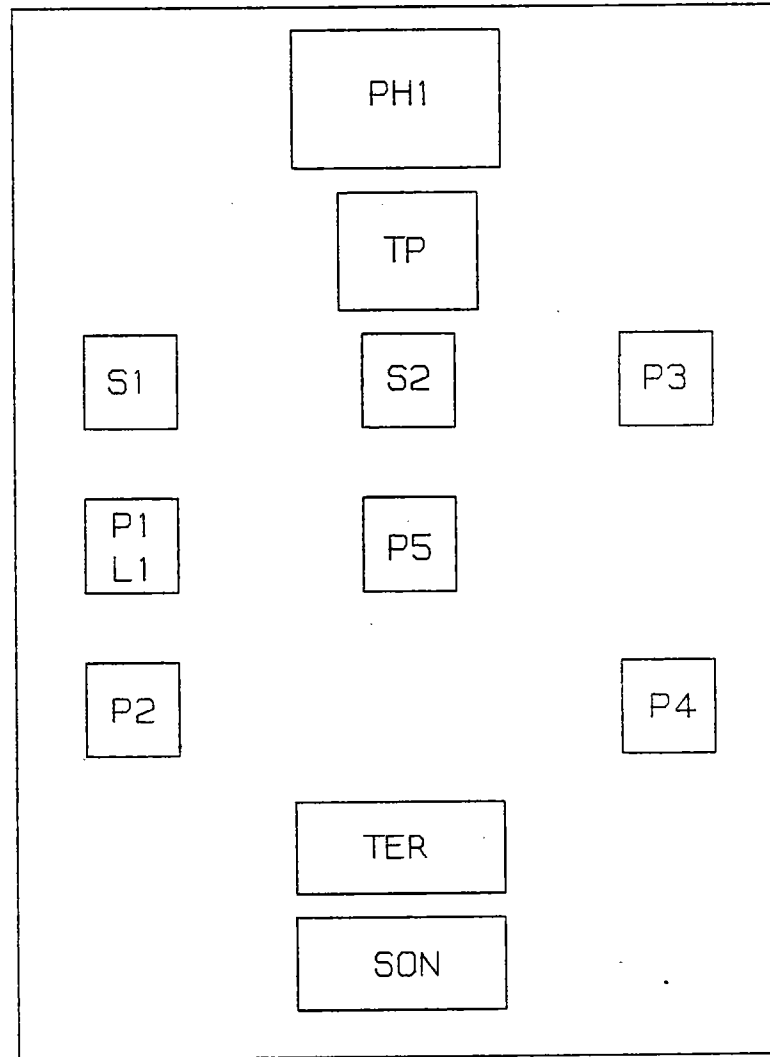
24080 Begonia (Bergamo)
Viale V.le dello Sport, 18
Tel. 035/781130
Telex 628/IMPRES
Telefax 300377 IMPRES I

0219E TIPO AA F.N. 06
ITT-SCF10
DE GROOT 5435.DIS

PANEL PA

RED LAMP "OUT SERVICE"
 RED LIGHT PUSHBUTTON RUN GA
 ARROW PUSHBUTTON "PRESS DOWNSTROKE"
 ARROW PUSHBUTTON "PRESS DOWNSTROKE"
 ARROW PUSHBUTTON "PRESS UPSTROKE"
 STOP PUSHBUTTON
 KEY SELECTOR "MAIN SWITCH 0-1"
 SELECTOR "MAN-AUT"
 TIMER PRESSAGE
 DIGITAL CONTROL OF TEMPERATURE
 PROBE CHOICE EQUIPMENT

L1
 P1
 P2
 P3
 P4
 P5
 S1
 S2
 TP
 TER
 SON



			UFFICIO ELETTRICO		0219E		TIPO PA F.N. 100	
			DATA	16/10/1990	 FABBRICA MACCHINE PER LEGNO 24060 Bagnatica (Bergamo) V.le V.le della Grande 15 Tel. 035/881122 Telefax 035/882682 Telex 300377 ITPRES I			
			DISEGN.	CIOVATI				
MODIFICHE	DATA	NOME	VISTO		ITT-SCF10 DE GROOT 5435.DIS			

PANEL

01	S1	10_0347_0280	—	KEY_SELECTOR	—	XB2-BG2
01	P3	10_1484_1760	—	ARROW_PUSHBUTTON	ZB2-BA335	TELEMEC
01	L1	10_1049_1641	130V	LAMP	TIPO-BA-9S	COMMERC
01	P5	10_1484_1960	—	PUSHBUTTON_BODY	ZB2-BW-065	TELEMEC
01	P1	10_1484_2095	—	RED_LIGHT_PUSHBUTTON	ZB2-BW-34	TELEMEC
01	P2	10_1484_1960	—	PUSHBUTTON_BODY	ZB2-BW-065	TELEMEC
02	S2	10_0347_0240	—	SELECTOR_2_POSITIONS	XB2-BD21	TELEMEC
02	S2	10_1484_2096	—	PUSHBUTTON_BODY	ZB2-BW061	TELEMEC
02	P4	10_1484_1760	—	ARROW_PUSHBUTTON	ZB2-BA335	TELEMEC
02	P4	10_1484_2096	—	PUSHBUTTON_BODY	ZB2-BW061	TELEMEC
02	TP	10_1834_2040	110V	TIMER	G-TE-00-40S	CET
01	P1	10_1484_2096	—	PUSHBUTTON_BODY	ZB2-BW061	TELEMEC
01	S1	10_1484_2096	—	PUSHBUTTON_BODY	ZB2-BW061	TELEMEC
01	P3	10_1484_1960	—	PUSHBUTTON_BODY	ZB2-BW-065	TELEMEC
01	P2	10_1484_1760	—	ARROW_PUSHBUTTON	ZB2-BA335	TELEMEC
01	P5	10_1484_1880	—	SHAPED_PUSHBUTTON	XB2-BC42	TELEMEC
02	PH1	10_1135_0320	0-500BAR	MANOMETHER D.100 BAR 0-500 F.300-D.C-D/	—	MATER
01	TER	00_0000_0000	—	TEMPERATURE CONTROL	MOD.F.48	EROELEC
01	SON	00_0000_0000	—	PROBE_CHOICE_EQUIPMENT	MOD.S.48	EROELEC

CUBICLE

01	E57	10_0145_0330	110V	CONTROL_PUSHBUTTONS	E57.0X02	TESCH
02	RD	10_1620_1400	110V	RELAY_RA4+UL/CSA +BASE SM1310 SV 15/4	MG-4	BIESSE
03	PO	10_0356_1980	110V	CONTACTOR	—	LC1-D25
03	RF1	10_1620_1400	110V	RELAY_RA4+UL/CSA +BASE SM1310 SV 15/4	MG-4	BIESSE
04	RT1	10_0950_2067	10-16A	AUTOMATIC SWITCH	GV1-M20	TELEMEC
05	X1	10_1163_0120	—	BLOCK K10	N. 8	—
05	X2	10_1163_0080	—	BLOCK K5	N. 24	—
04	IG	10_0950_1500	32A	DOOR BLOCK SWITCH	P1-32/V/SVB	KLOCKNE
02	RPA	10_1620_1400	110V	RELAY_RA4+UL/CSA +BASE SM1310 SV 15/4	MG-4	BIESSE
02	RP1	10_1620_1400	110V	RELAY_RA4+UL/CSA +BASE SM1310 SV 15/4	MG-4	BIESSE
02	RF	10_1620_1400	110V	RELAY_RA4+UL/CSA +BASE SM1310 SV 15/4	MG-4	BIESSE
02	RS	10_1620_1400	110V	RELAY_RA4+UL/CSA +BASE SM1310 SV 15/4	MG-4	BIESSE
01	F1B	10_0698_0040	2A	GLASS FUSE	—	WEBER
01	GA	10_0211_0120	—	CONTACTS	LA1.D11.A65	TELEMEC
01	F1	10_1454_0280	—	FUSE CARRIER	UK/SI N.4	PHONIX
01	F1C	10_0698_0080	4A	GLASS FUSE	—	WEBER
01	TR	10_1852_1578	350VA	TRANSFORMER_VA350X3_HZ.50/60_0/440	—	55/0/55
01	F1D	10_0698_0080	4A	GLASS FUSE	—	WEBER
01	F1A	10_0698_0040	2A	GLASS FUSE	—	WEBER
01	GA	10_0356_1520	110V	CONTACTOR	—	CA2-DN1

ON THE MACHINE

00	—	10_0318_0360	—	BOX_ILME_9VC	—	ILME
01	FC0	10_0663_0160	—	LIMIT_SWITCH	ES61-Z2	STEUTE
03	FC1	10_0663_0720	—	LIMIT_SWITCH	XCK-J10541	TELEMEC
00	—	10_1469_0220	—	CONNECTOR_PG_13.5	N.2	—
00	—	10_1500_1720	—	CONNECTOR_D.16	N.2	COMMERC
00	—	10_1469_0200	—	CONNECTOR_PG_9	N.4	—
00	—	10_0784_0640	—	SHEATH_INDUPLAST_D.16	MT.0.5	—