USER'S MANUAL

Translation of the original instructions

Press to apply PVC on 3D panels

"ESTREMA/S"

Upstroke movement of the platen

ITALPRESSE

Dati di identificazione della macchina
Machine identification numbers
Données signalétiques de la machine
Kenndaten der Maschine
Datos de identificaccion de la maquina

pos. **22995**

Dichiarazione dell'Alta Direzione sul perseguimento degli obiettivi della Politica della Sicurezza aziendale:

La Direzione di ITALPRESSE S.p.A. considera tra i propri obiettivi aziendali il raggiungimento della Sicurezza intrinseca delle Macchine prodotte nel proprio Stabilimento di Bagnatica (BG). La Direttiva 2006/42/CE e successive modifiche indicano le procedure che devono essere messe in atto per garantire i requisiti essenziali ai fini della Sicurezza e della tutela della salute degli operatori e delle persone esposte.
L'applicazione dei criteri illustrati nella Direttiva, la verifica della loro efficacia ed il loro aggiornamento sono garantiti dalla Direzione Generale, e per lei dal Responsabile della Sicurezza, che a tal fine si avvale dei Servizi Tecnici che operano in collaborazione coi reparti di Produzione. Ai Servizi suddetti è attribuita l'autorità di identificare i problemi correlati con la Direttiva, di individuare la loro soluzione attraverso l'introduzione di azioni correttive e di verificarne l'applicazione.
Con l'approvazione della presente Dichiarazione la Direzione di ITALPRESSE S.p.A., e per lei il Responsabile della Sicurezza, si assume l'impegno di rendere operative le metodologie e di garantirne l'applicazione.

La Direzione

Top Management declaration on the pursuit of the objectives set out in the company safety policy:

The top management of ITALPRESSE S.p.A. numbers among its objectives the achievement of intrinsic safety for the machines produced in the factory at Bagnatica (Bergamo). EC directive 2006/42/EC and subsequent modifications lay down the procedures to be followed to guarantee the essential safety requirements and the protection of the operators and those exposed to the operation of the machinery. The application of the criteria laid down in the directive, the checking of their effectiveness and updating are guaranteed by general management, and on its behalf by the Safety Manager, by means of the services of qualified technicians operating together with the production sections. The technical service staff are authorised to identify any problems together with management, find a solution by means of corrective action and ensure that this is applied. With the approval of this declaration by the management of ITALPRESSE S.p.A., and on its behalf the Safety Manager, we accept the commitment to put the methods into practice and guarantee their application.

Company Management

Déclaration de la Direction concernant la réalisation des objectifs de la politique de sécurité de l'entreprise.

La Direction d'ITALPRESSE S.p.A. place parmi les objectifs majeurs de l'entreprise la réalisation de la sécurité intrinsèque des machines produites dans son usine de Bagnatica (Bergame).
La directive 2006/42/CE et successives modifications indique quelles sont les procédures à appliquer pour garantir les conditions fondamentales relatives à la sécurité et à la tutelle de la santé des opérateurs et des personnes exposées. Afin de garantir l'application des critères illustrés dans cette directive, le contrôle de leur efficacité et leur mise à jour, la Direction Générale, et pour elle le Responsable de la Sécurité, fait à ce propos recours aux Services Techniques qui opèrent en étroite collaboration avec les Unités de Production. Ces Services ont pour rôle d'identifier les problèmes corrélés à la directive, d'y apporter des solutions moyennant l'introduction de mesures correctives et de vérifier l'application de celles-ci. Par l'approbation de la présente déclaration, la Direction d'ITALPRESSE S.p.A., et pour elle le Responsable de la Sécurité, s'engage à rendre opérationnelles les méthodologies suggérées et à en garantir leur application.

La Direction

Erklärung der obersten Firmenleitung zur Verfolgung der sicherheitspolitischen Ziele des Unternehmens:

Die Direktion der ITALPRESSE S.p.A. sieht es als eins der Ziele des Unternehmens an, für die im eigenen Werk Bagnatica (BG) gebauten Maschinen eine vollkommene Sicherheit zu erreichen. Die EG-Richtlinie 2006/42/EG und nachfolgende Änderungen nennt die Verfahrensweisen, die als Grundvoraussetzungen zur Unfallverhütung und zum Schutz der Gesundheit der mit der Bedienung der Maschine betrauten oder ihren Wirkungen ausgesetzten Pesonen umgesetzt werden müssen. Die Anwendung der durch die Richtlinie vorgegebenen Kriterien, die Überprüfung ihrer Effizienz sowie ihre ständige Verbesserung werden von der Direktion, und fuer sie von der verantwortlichen Person für die Sicherheit, garantiert, denn zu diesem Zweck sind Techniker in Zusammenarbeit mit den Produktionsabteilungen im Einsatz. Diesem technischen Dienst ist die Aufgabe übertragen, alle im Zusammenhang mit den Vorgaben der Richtlinie stehenden Probleme festzustellen, Lösungsvorschläge für korrektive Veränderungen zu erarbeiten und deren Durchführung zu berprüfen. Mit der Annahme der vorliegenden Erklärung übernimmt die Direktion der ITALPRESSE S.p.A., und für sie die verantwortliche Person für die Sicherheit, die Verpflichtung, diese Methoden in die Praxis umzusetzen und ihre Durchführung zu garantieren.

Die Direktion

Declaración de la Dirección General con respecto a los objetivos de la Política de Seguridad empresarial:

La Dirección de ITALPRESSE S.p.A. considera entre los propios objetivos empresariales el logro de la Seguridad intrínseca de las Máquinas producidas en el propio Establecimiento de Bagnatica (Bergamo-Italia). La Norma 2006/42/CE y sucesivas modificaciones indican los procedimientos que se debe respetar para garantizar los requisitos esenciales para la Seguridad y tutela de la salud de los operadores y personas expuestas. La aplicación de los criterios ilustrados en la Norma, la verificación de su eficacia y su puesta al día están garantizados por la Dirección General, y por ella por el Responsable de la Seguridad, que para dicho fin cuenta con el asesoramiento de los Servicios Técnicos que trabajan en colaboración con los Repartos de Producción. A los susodichos Servicios se le atribuye la autoridad para identificar los problemas relacionados con la Norma, identificar sus soluciones por medio de la introducción de acciones para la corrección y comprobar la aplicación. Con la aprobación de la presente Declaración la Dirección de ITALPRESSE S.p.A., y por ella el Responsable de la Seguridad, se asume el compromiso de activar las metodologías y garantizar su aplicación.

La Dirección

ITALPRESSE S.p.A.
via delle Groane, 15 - 24060 Bagnatica (Bg) ITALIA

Oggetto della dichiarazione/Object of declaration/Sujet de la déclaration/Objekt der Erklaerung/Objeto de la declaracion

PRESSA A MEMBRANA - MEMBRANE PRESS

Macchina modello/Model/Modèle/ Maschinenbezeichnung/Modelo	Matricola/Serial Number/Matricule/ Seriennummer/Matricula	Anno di fabbricazione/Manufacturing year/ Année de fabrication/Baujahr/Año de fabrication
ESTREMA/S	183630114	2014

DICHIARAZIONE CE di CONFORMITÀ

Si dichiara che la macchina oggetto della dichiarazione è conforme a quanto prescritto dalla direttiva europea 2006/42/CE (Direttiva Macchine) e dalla direttiva 2004/108/CE (Direttiva Compatibilità Elettromagnetica), e se ne costituisce il fascicolo tecnico

EC DECLARATION OF CONFORMITY

We declare that the machine object of this declaration complies with the prescriptions of European Directive 2006/42/CE (Machines Directive) and 2004/108/CE (Electromagnetic Compatibility Directive) and the relevant technical file is constituted.

DECLARATION CE DE CONFORMITE'

On déclare que la machine objet de la déclaration est conforme à ce qui est préscrit par la directive européenne 2006/42/CE (Directive Machine) et par la directive 2004/108/CE (Directive Compatibilité Électromagnétique), et on en constitue dossier technique.

CE Konformitätserklärung

Der Unterzeichner erklärt, dass die o.a. Maschinen den Bestimmungen der Richtlinien 2006/42/CE (Maschinenrichtlinie) und 2004/108/CE (Elektromagnetische Verträglichkeit) entspricht und bezügliche technische Dokumentation erzeugt wird.

DECLARACION CE DE CONFORMIDAD

Se declara que la máquina objeto de la declaración es de conformidad según lo prescripto por la directiva europea 2006/42/CE (Directiva Máquinas); y por la directiva 2004/108/CE (Directiva Compatibilidad Electromagnetica), y se constituye el expediente técnico

Bagnatica, 28/01/2014

L'Amministratore Delegato - President - Der Geschaftsfuehrer -
Administrateur délégué - El administrator delegado
Carlo Sala

Precautions and safety instructions:

• Before starting up, using, maintaining or carrying out any other operation on the machine, read the user's manual carefully. This manual should always be kept close at hand.

• In no circumstances use the machine other than in the ways described in this manual. The manufacturer accepts no responsibility for damage to persons or property deriving from failure to observe the safety regulations.

• The operator should be in possession of all the necessary prerequisites for the use of a complex machine.

• Use all the necessary precautions (overalls, protective gloves, etc) to avoid burns from the hot working surfaces of the machine (the temperature is 110°C approx).

• Always use the robust work gloves laid down in the accident prevention laws of all countries.

• Do not allow unauthorised personnel to repair or carry out maintenance or other operations of any kind on the machine.

• The transport, installation and assembly operations should be carried out only by personnel with the necessary technical competence and experience in all the sectors involved.

• All operations on the electrical system should be carried out only by specialist sector technicians.

• The working area surrounding the machine should always be kept clean and unobstructed, for the sake of immediate, easy access to the electrical commands.

• The symbols below, used in the manual, warn the operator of the presence of risk factors in carrying out specific operations on the machine.

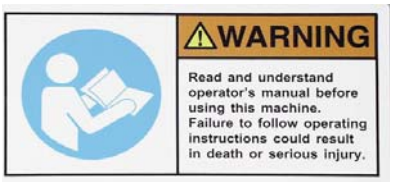
IMPORTANT: this machine is designed to be used by a single operator.

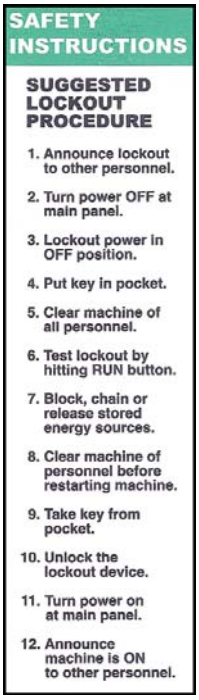
BEFORE OPERATING THE PRESS AND DURING ITS NORMAL WORK, THE OPERATOR MUST ALWAYS CHECK THAT NO PEOPLE (OR ANIMALS) ARE NEAR THE MACHINE!

NEVER INSERT PARTS OF THE BODY BETWEEN MOVING PLATENS AND/OR OUTSIDE THEIR HOUSING!

WARNING: BEFORE PERFORMING ANY CONNECTION, TEST, MAINTENANCE, LUBRICATION OR CLEANING OPERATIONS, THE MACHINE MUST BE LOCKED OUT WITH THE POWER OFF.
-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

SAFETY LABELS: the following safety labels are positioned on the machine and must not be removed for any reason.





CONTENTS

0. General information
0.1 Products that can be obtained
0.2 Control board

1. Packaging/transport

2. Raising methods

3. Installation
3.1 Installation requirements
3.1.1 Atmospheric requirements
3.1.2 Minimum space for use and maintenance
3.1.3 Type of support surface for the machine
3.1.4 Electric power supply
3.2 Installation and connections
3.2.1 Levelling of the press
3.2.2 Safety device
3.2.3 Electrical connection
3.2.4 Compressed air connection

4. Start–up
4.1 Oil level check
4.2 Motor rotation direction control
4.3 Platen heating
4.4 General load regulations for the pressing panels

5. Start-up/operation/stop

6. Malfunctions/breakdowns/faults
6.1 Poor vacuum level
6.2 Losses due to cylinder drawing
6.3 Ageing of the hydraulic oil
6.4 Magnetothermal blockage

7. Production change

8. Cleaning
8.1 Vacuum pump filter
8.2 Load tray
8.3 Central oleodynamic unit:
8.4 Cleaning the heater unit

9. Maintenance/inspection/checks
9.1 Oil replacement
9.2 Vacuum pump purifier
9.3 Filter maintenance
9.4 Gaskets
9.5 Greasing the mechanical parts

10. Temporary shutdown

11 Permanent shutdown (dismantling)

12. Technical specifications of the machine
12.1 Phonometric measurements

13. Technical assistance

14. Supplies and materials used
14.1 Recommended oils
14.2 Transmission grease
14.3 Production materials

15 Diagrams
15.1 Oil–dynamic diagram
15.2 Pneumatic diagrams
15.3 Vacuum seal system
15.4 Cylinder drawings and parts
15.5 Motor pump group
15.6 Electrical diagrams

0. General information

This user's manual was drawn up by the manufacturer and is an integral part of the machine accessories.
The information contained herein should be read by qualified personnel only.

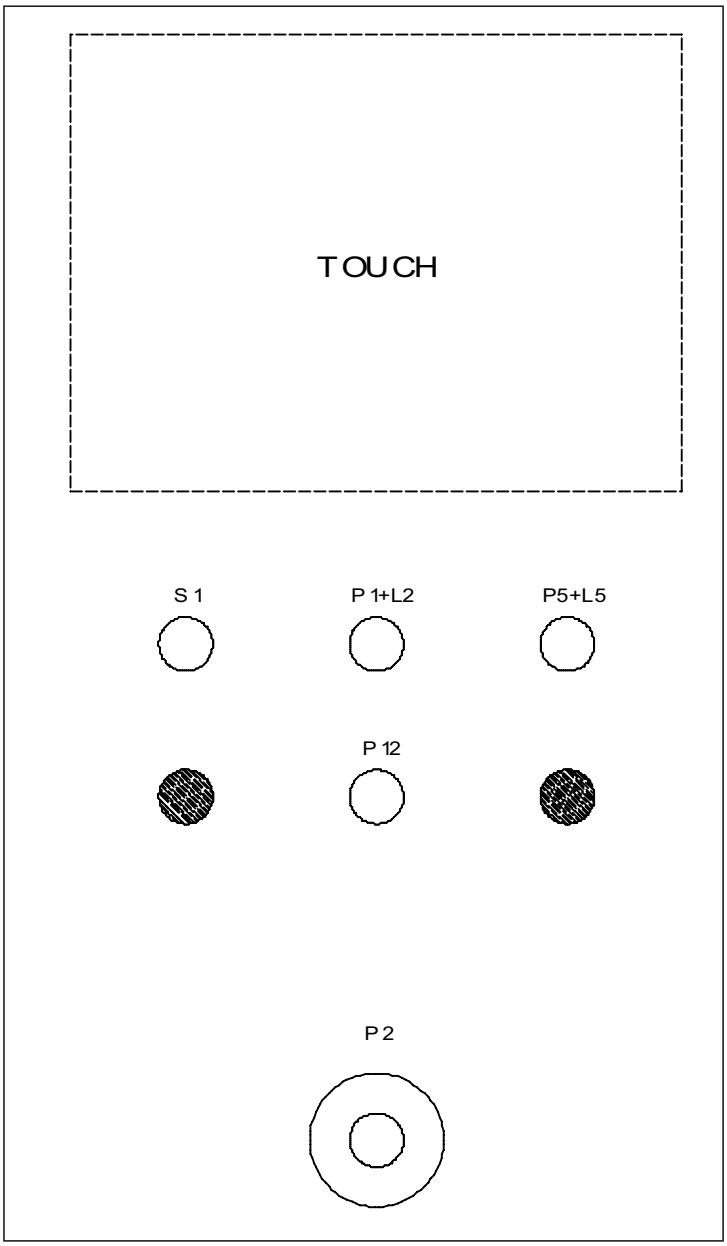
WARNING: THE MACHINE HAS BEEN DESIGNED TO BE USED BY ONE OPERATOR ONLY.

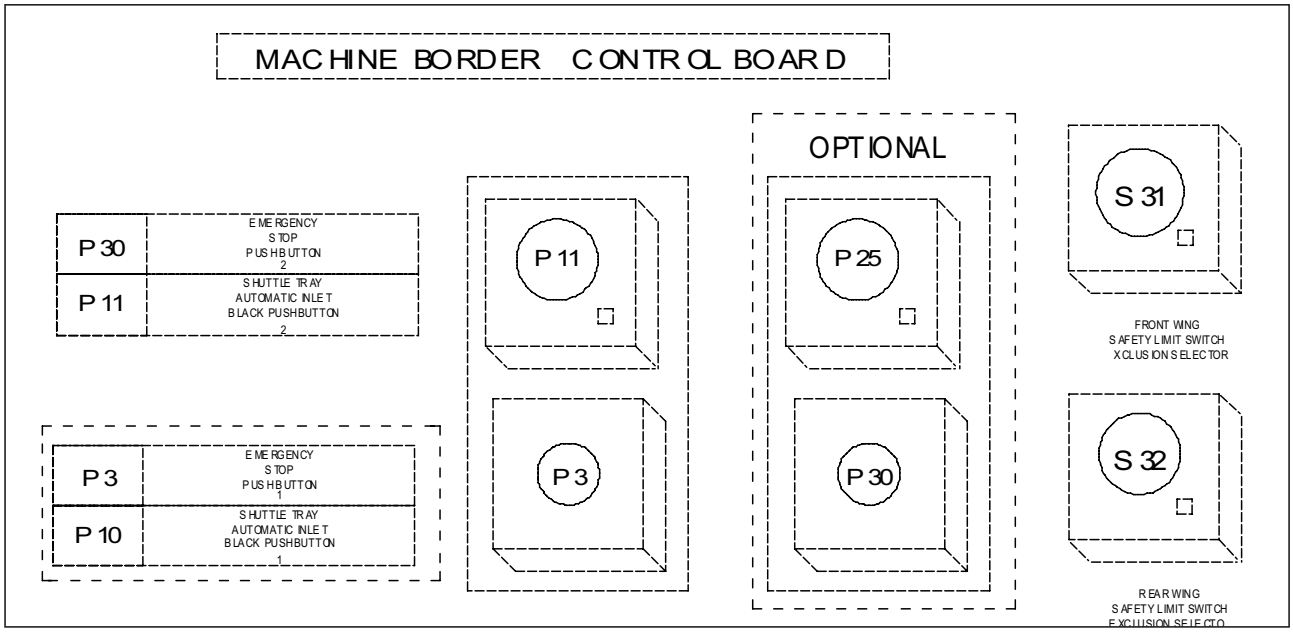
0.1 Products that can be obtained

The machine is designed for flat laminating and 3D thermoforming of PVC foils.

0.2 Control board

LOGO	DESCRIPTION
S 1	KEY SELECTOR TENSION OFF-ON
P 1+L2	GREEN LIGHT PUSHBUTTON GENERAL AUXILIARIES RUN
P 5+L5	RED LIGHT PUSHBUTTON EMERGENCY RESET
P 12	PUSHBUTTON WITH ARROW PRESS OPENING
TOUCH	CONTROL UNIT
P 3	RED MUSHROOM PUSHBUTTON MACHINE EMERGENZE





1. Packaging/transport

There are normally three methods of shipping the machine to the user:
• in packing cases
• in containers
• by truck

Transport in cases:

Packaging characteristics:

• The machine is contained in a single case.
• It is covered in cellophane and attached to the bottom of the case by rods to prevent it from moving during shipping.
• The inner walls of the case are covered with tar-coated paper as protection from dampness.
• A layer of cellophane is stapled to the outside of the case to protect it from the rain.
• Reinforcing steel bands are wound around the case.
• The cases bear written instructions on the movement methods.

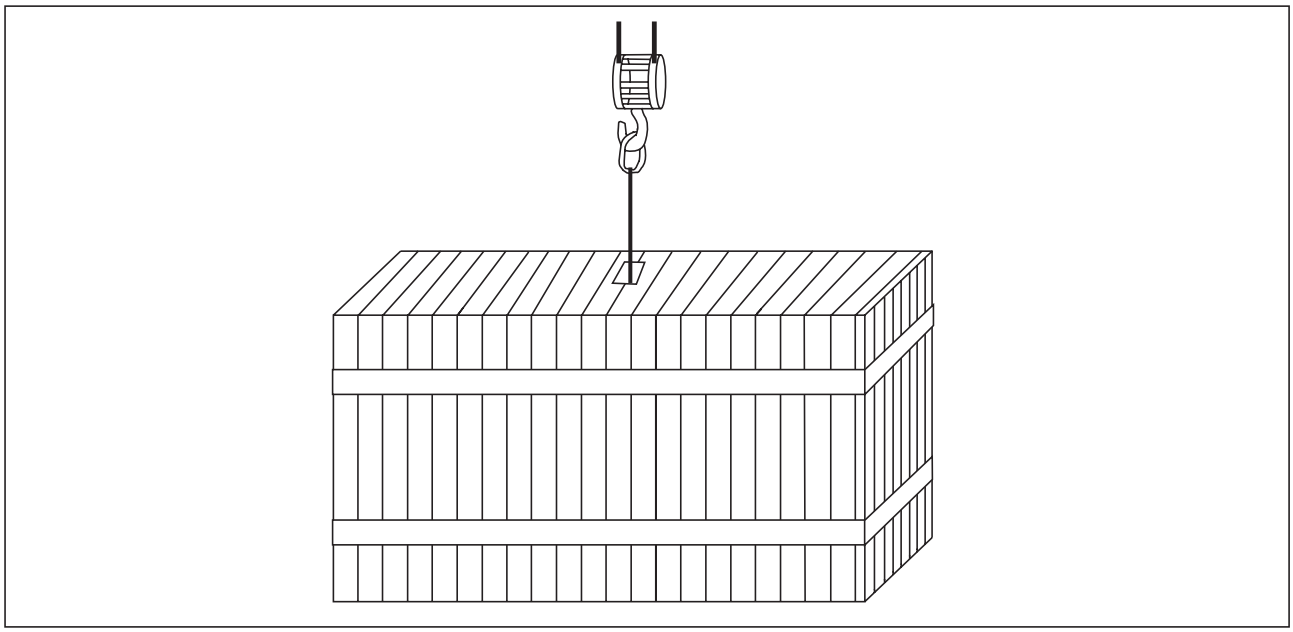
Raising:

Before raising the machine from the packaging, take note of its weight as set out in table of chapter 2!

The case has two holes on the upper part. To open these holes, pull away the celophane covering.

! THE TOP OF THE CASE IS NOT REMOVABLE

When the holes are opened, access is gained to the hooking points of the machine as shown in the diagram.



Once the case has been moved, REPLACE the wooden panels and cover the holes.

! DO NOT USE STRAPS OR MULES TO MOVE THE CASE.

Opening the case:

- Remove the metal straps taking care to avoid injury due to the tension.
- Remove the outer cellophane covering.
- Open the side walls using a suitable lever (crowbar)
- Remove the lid and side walls.
- Remove the cellophane around the machine.
- Before moving the machine, remove the rods that attach it to the bottom of the case:

To move the parts of the machine, use the method described in chapter 2.

Container or road transport:

The base of the machine should be fixed to the support surface by the wooden wedges. It should also be held down using cords or straps to keep it under tension.

BEFORE RAISING THE MACHINE FROM THE SUPPORT SURFACE, REMOVE THE WEDGES.

The machine should be raised as shown in chapter 2 below.

2. Raising methods

The raising and movement of the machine should be carried out by personnel trained and specialised in this type of operation.
The operations can be carried out only by overhead crane or crane, proceeding as described below and with reference to figure 2.1:

- use one belts with hooks, of the same length and of a suitable capacity;
- hook the belts to an overhead crane of suitable capacity;
- position the two hooks at the lifting points of the machine situated on the upper part;
- raise slowly and move with the maximum caution, avoiding even minimum swing, and position the machine in its operating zone.

! IMPORTANT: all personnel should keep clear of the suspended load and/or in any case from the operating range of the overhead crane during the lifting and movement of the machine.

3. Installation

3.1 Installation requirements

3.1.1 Atmospheric requirements

- Ambient air temperature: the electrical equipment can operate correctly at air temperatures from +5 to +40°C and at a mean temperature of no more than +35°C over a 24 hour period.

- Humidity: The electrical equipment of the machine is designed to operate correctly at a humidity between 30 and 95% (without condensation). The damaging effects of condensation can be avoided by taking the appropriate preventitive steps (eg. in-built heaters, air conditioners, drainage holes).

- Altitude: the machine is designed to operate at up to 1000 m above sea level.

- Contaminants: the machine is designed to operate in the presence of wood dust in the immediately surrounding area. Where there are other contaminating agents in the immediate vicinity of the machine (dust, acids, salts, corrosive gases), special agreements between the supplier and user may be necessary.

3.1.2 Minimum space for use and maintenance

At the set-up of the machine an additional space must be foreseen, to allow the operator to perform use and maintenance.

3.1.3 Type of support surface for the machine

The floor should be of the industrial type with a minimum resistance of 7 Kg/cm^2. The floor should be carefully levelled.

3.1.4 Electric power supply

SEE ELECTRICAL DIAGRAM

WARNING:
The voltage change in the electric network can never be more than +/- 5% of the voltage indicated on the plate.
Check the electric network voltage with the proper device; whenever the change is more than +/- 5% of the voltage indicated on the plate, please contact our Technical Assistance Department.

WARNING: BEFORE PERFORMING ANY CONNECTION, TEST, MAINTENANCE, LUBRICATION OR CLEANING OPERATIONS, THE MACHINE MUST BE LOCKED OUT WITH THE POWER OFF.
-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

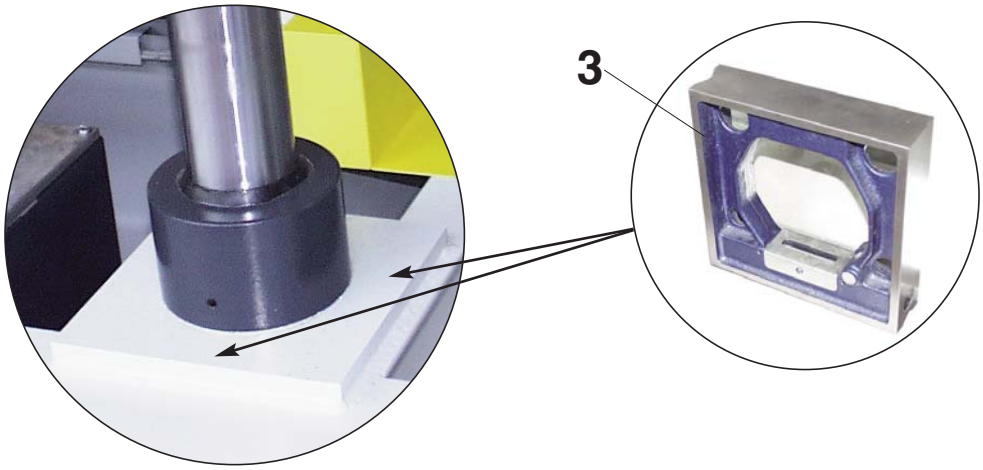
3.2 Installation and connections

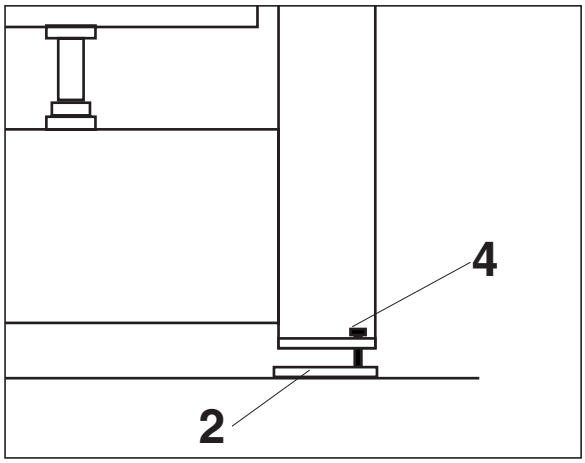
This paragraph describes the following operations:

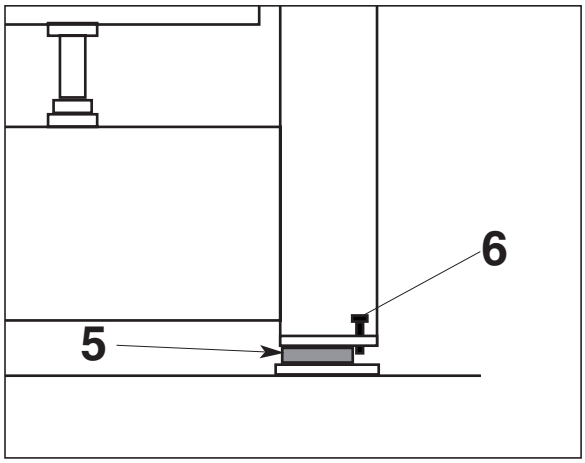
* levelling the machine (para. 3.2.1)
* electrical connections (para. 3.2.2)

3.2.1 Levelling of the press

1 - Be sure that the surface where the press is placed is perfectly levelled
2 - Put each equipment plate under each upright
3 - To check the levelling of the press You must use a centesimal level, taking as reference the 4 plates of cylinders support placed close the uprights
If the press will be not levelled, please proceed as follows:
4 - Operate on the screws placed at the base of the uprights to get the levelling in two directions
5 - After the reaching of the levelling in two directions, compensate the distance between the base of the upright and the counter-plate at floor with suitable thicknesses
6 - Loosen the screws so that the weight of the press is distributed on the plates and not on the screws.







3.2.2 Safety device

Red head pushbuttons for emergency stop. they are set
- on the press control board
- on the control bar

Two-handed press closure command: this guarantees operator safety during the dangerous closure movement of the mobile platen of the press (P6-P7).

Tilting shutter complete with electrical safety interlock:
In case one of the doors will be open by someone while the machine is performing the working cycle, the activation of the electrical safety interlocks will stop the machine.

WARNING: IN CASE OF DANGER, THE EMERGENCY MUST IMMEDIATELY BE DRIVEN BY ONE OF THE FOLLOWING DEVICES:

- THE RED "EMERGENCY STOP" PUSHBUTTONS, PLACED ON THE CONTROL BOARD AND ON THE CONSOLLE.

WARNING: BEFORE PERFORMING ANY CONNECTION, TEST, MAINTENANCE, LUBRICATION OR CLEANING OPERATIONS, THE MACHINE MUST BE LOCKED OUT WITH THE POWER OFF.
-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

3.2.3 Electrical connection

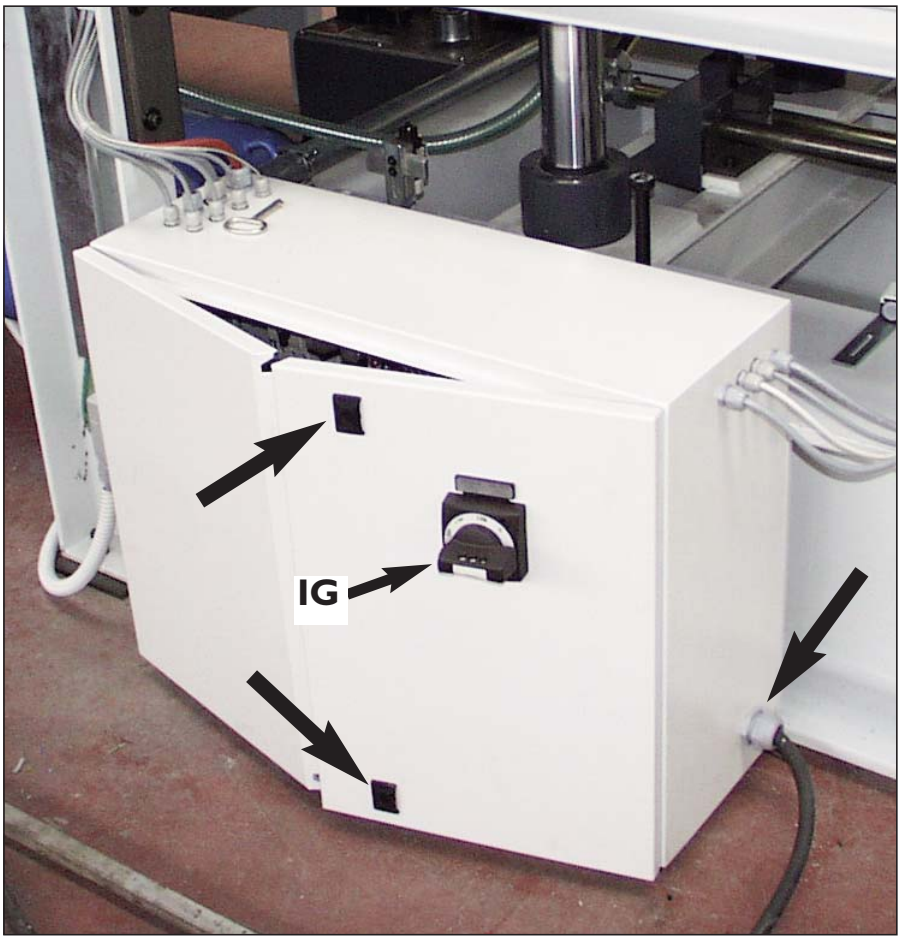
Make sure that the supply voltage is the same as indicated in the plate fitted to the inside of the electric cabinet (par. 3.1.4).

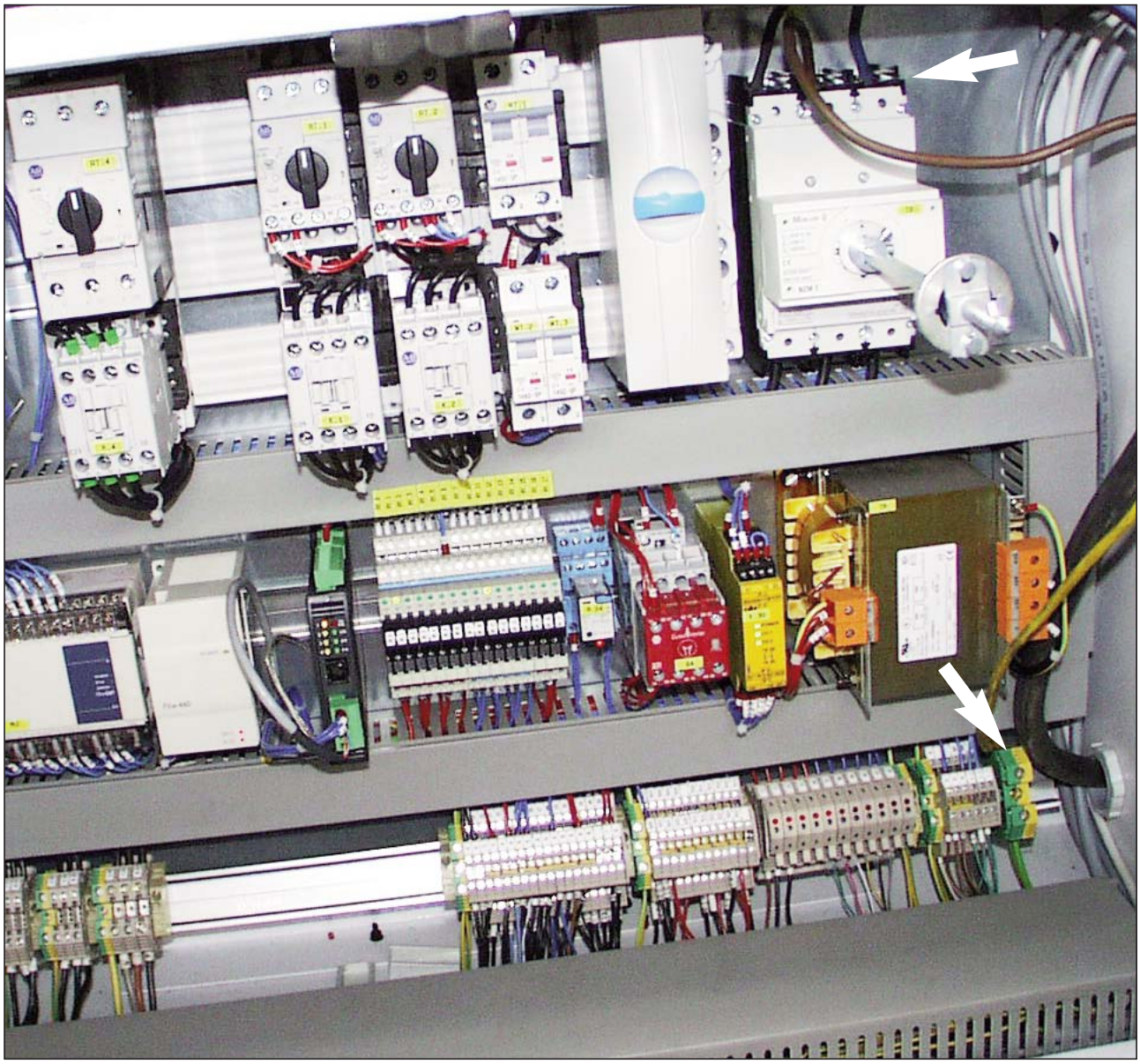
Make sure that the supply voltage is the same as indicated in the testing tab on the electrical panel. To connect the electrical panel, use a flameproof cable with three phase conductors and the earth cable (in yellow and green).

To connect the cable to the electrical panel of the machine, proceed as follows:

! MAKE SURE THAT THE CABLE IS NOT LIVE

a) Set the main switch IG to position "0" and open the two locks of the door to the electrical panel using the keys;
b) insert the cable in the electrical cabinet through the cable press at the rear





c) take the cable (not connected to the power supply!) and connect the three phase conductors with the terminal board of the main switch on the upper part. Fix the three conductors by tightening the worm screws. When carrying out this operation, make sure that the bare part of the wire is completely inserted in the clamp, to prevent contact with the outside

d) connect the conductor with green and yellow casing to the main earth terminal board of the machine (marked with "PE") situated within the cabinet;

e) block the cable by tightening the cable press;

f) close the door of the electrical cabinet by means of the two locks, using the key, and set the main switch "IG" to position "I".

THE KEY MUST BE REMOVED FROM THE ELECTRICAL CABINET AND ENTRUSTED TO A RESPONSIBLE.

3.2.4 Compressed air connection

The minimum inlet pressure should be 6 Ate. The capacity is 800 Nlt for each working cycle. If the supply available is insufficient, an air diaphragm of roughly 250 litres should be fitted.

The air inlet is near the lubricator and dry filter, and requires an inlet tube with one inch diameter.

Cracked (burnt) oil and impurities contained in the air can damage the quality of the product by staining the veneer or PVC.
Water vapours may cause damage to the operation of the electrovalves.
We therefore suggest the following compressed air specifications:

– Particles: The recommended quality level (ISO554: 1976) is 2, corresponding to a maximum impurity diameter of 1 micron and a maximum density of 1 mg/m3

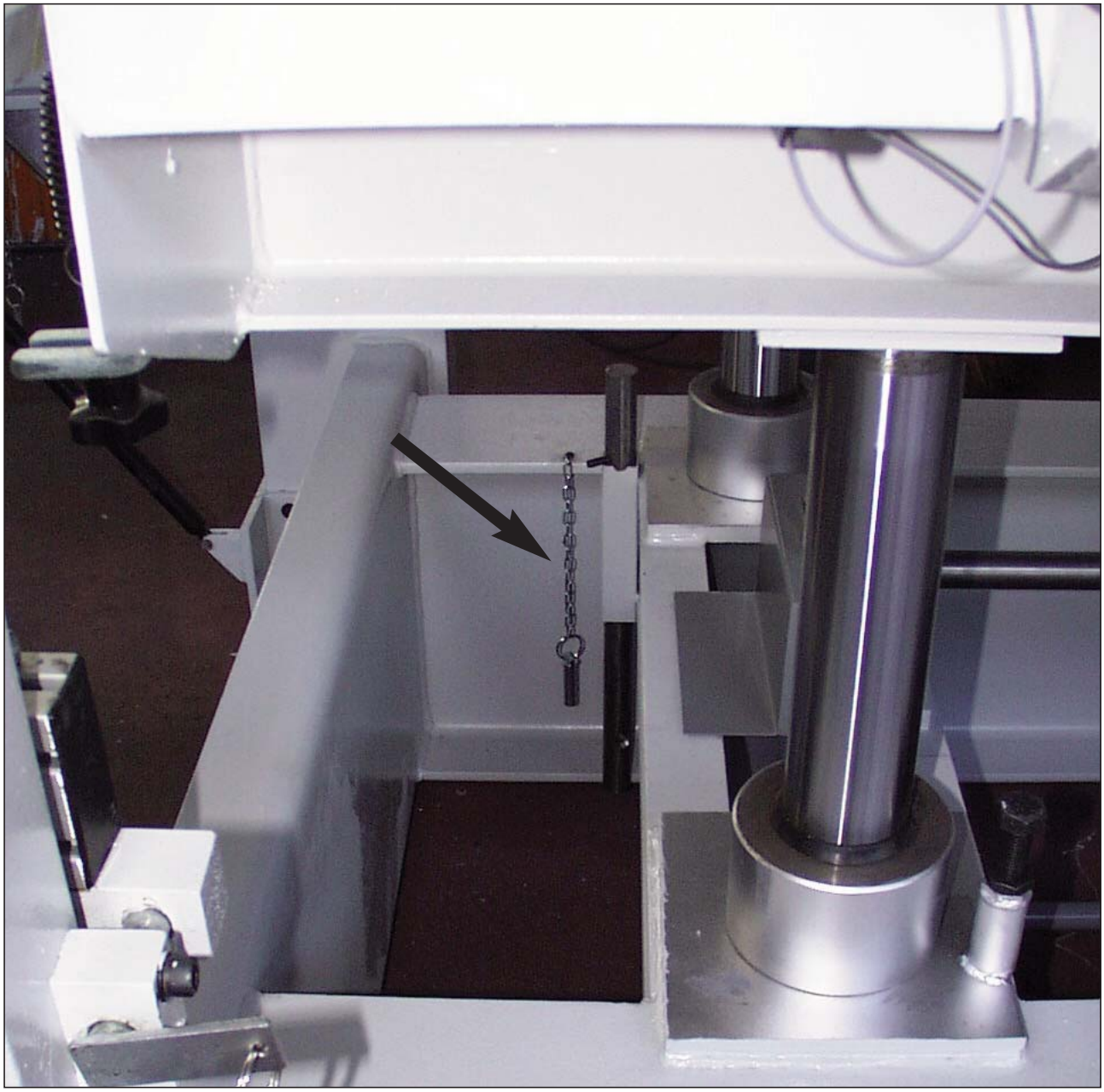
– Oil content: The recommended quality level is 2, equivalent to 0.1 mg/m3

– Water vapour: The maximum recommended level is 5 mg/m3. Beyond this level, an air drier has to be used.

4. Start-up

THE MACHINE IS FITTED WITH TWO MANUAL MECHANICAL STOPS WHICH BLOCK THE MOBILE PLATEN IN THE CLOSED POSITION. BEFORE OPENING THE PLATENS, CHECK THAT THE STOPS ARE NOT IN PLACE, TO AVOID DAMAGE TO THE MACHINE.

BEFORE OPERATING THE PRESS AND DURING ITS NORMAL WORK, THE OPERATOR MUST ALWAYS CHECK THAT NO PEOPLE (OR ANIMALS) ARE NEAR THE MACHINE!



WARNING: BEFORE PERFORMING ANY CONNECTION, TEST, MAINTENANCE, LUBRICATION OR CLEANING OPERATIONS, THE MACHINE MUST BE LOCKED OUT WITH THE POWER OFF.
-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

4.1 Oil level check

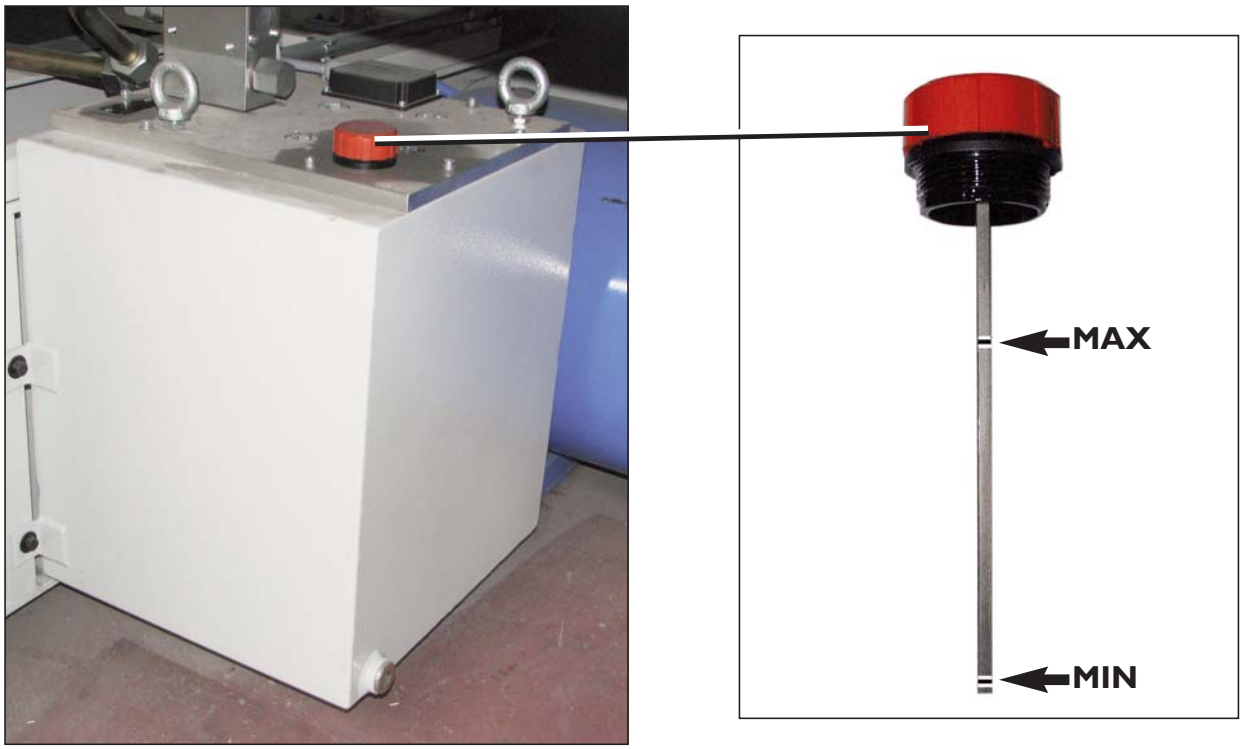
a) Oleodynamic unit oil

WARNING:

Before performing the operation described in this chapter, close the machine, insert the platen locking device to lock the platen and lockout the machine (see lockout procedure).

Check the oil level in the central hydraulic unit: when the machine is OPEN.

IN NO CIRCUMSTANCES SHOULD THE HYDRAULIC PUMP (LOCATED INSIDE THE CENTRAL UNIT) OPERATE WITHOUT OIL.



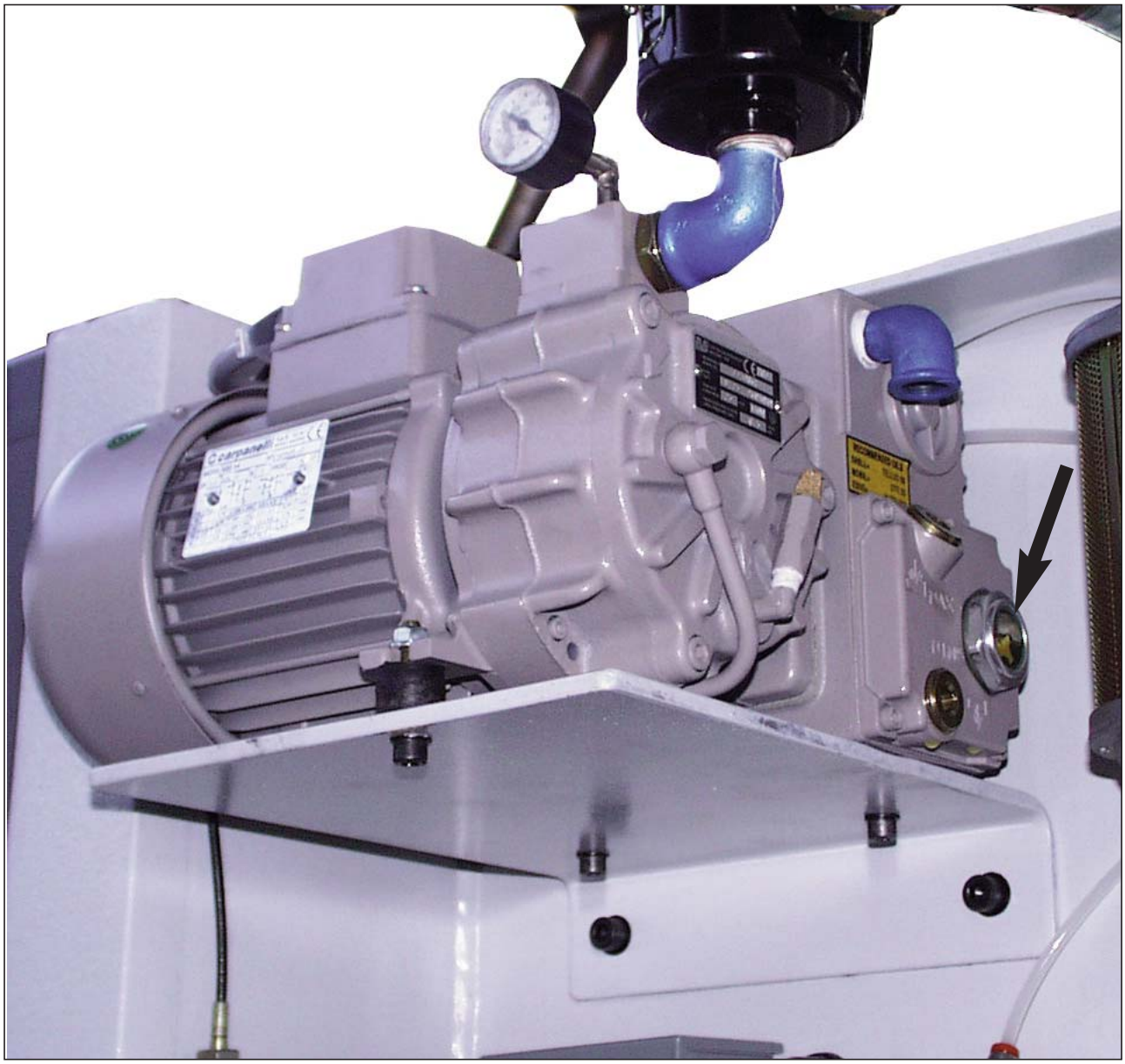
Check periodically the oil level using the cap of the central unit, fitted with a dipstick.

The oil level must be between the MAX level and MIN level.

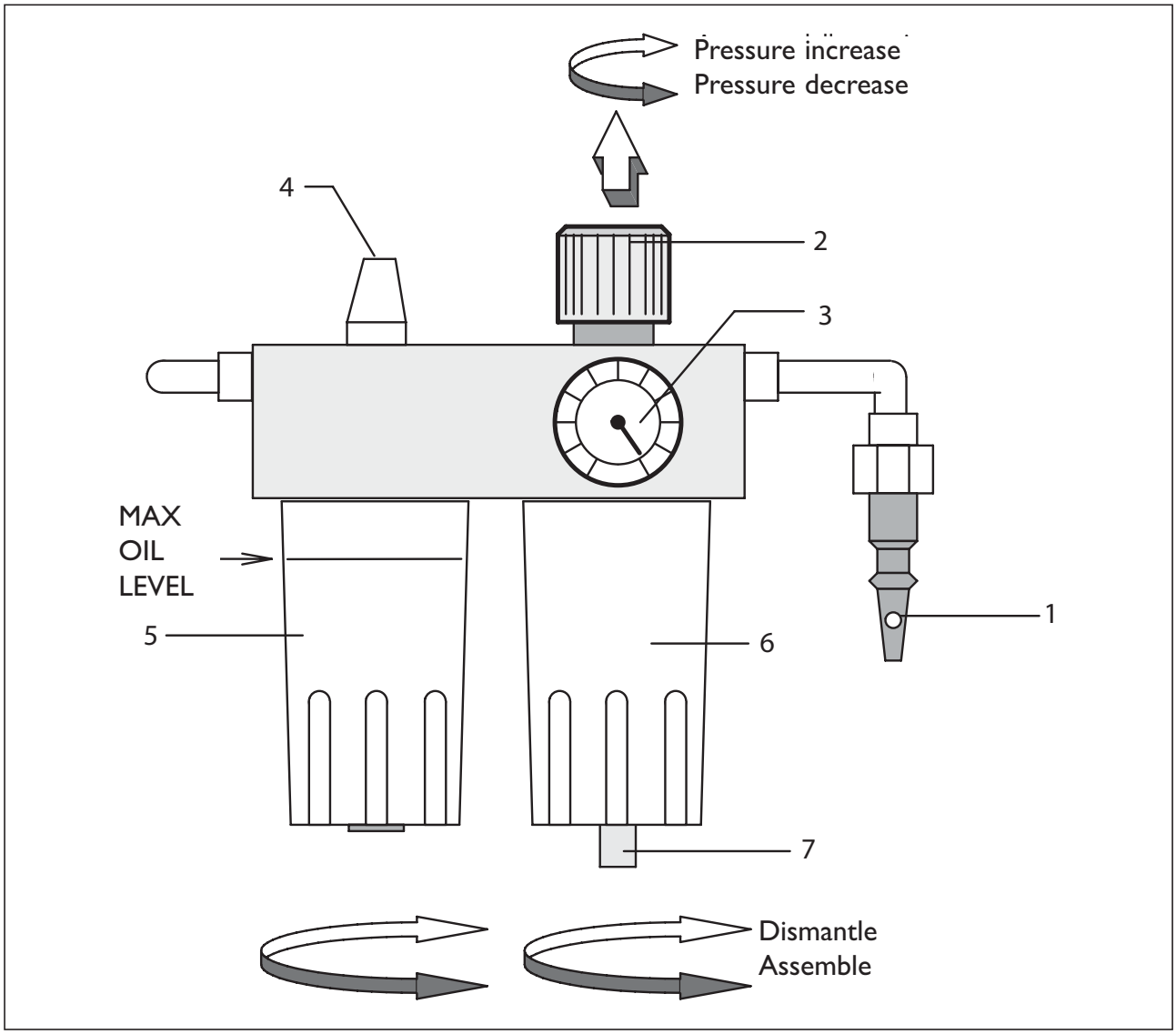
If it is necessary to refill or replace the oil, see chapter 11, "Supplies" and chapter 8, "Maintenance / inspection / checks".

b) vacuum pump:

gem visible from the right side
A level much higher than the recommended one causes leaks due to dragging of the discharge. A level below the minimum causes insufficient lubrication and a poor level of vacuum.



c) air lubricator: ”oil cup–tank” as shown in the figure.



1. Bayonet connection for compressed air
2. Pressure regulator knob
3. Pressure gauge
4. Regulating screw for the quantity of oil to be sent to the system
5. Oil cup-tank (check for the presence of oil from time to time)
6. Condensate collection cup
7. Condensate discharge screw

Check periodically that there's oil inside the proper glass "5".
To fill up the oil, remove the glass "5", as shown in picture , and fill up without going over the maximum level.

4.2 Motor rotation direction control

BEFORE OPERATING THE PRESS AND DURING ITS NORMAL WORK, THE OPERATOR MUST ALWAYS CHECK THAT NO PEOPLE (OR ANIMALS) ARE NEAR THE MACHINE!

WARNING! THIS OPERATION MUST BE DONE WITH THE UTMOST CARE BECAUSE THE MACHINE IS OPERATING!

CAUTION: FROM NOW THE OPERATOR MAY COME IN CONTACT WITH THE MOVING PARTS OF THE MACHINE.

- Switch on "Main supply" (S1)
- Press the lighted button, "General Power Gear" (P1+L2)
- Start the vacuum pump by the interface on the control panel
- Make sure the motor rotates in the direction indicated by the arrow

CAUTION: the motor must not rotate in the opposite direction for more than 10 seconds, otherwise it will be damaged!

If the motor rotates in the opposite direction, it is necessary to exchange two of the three electrical power phases in the machine control box.

4.3 Heating the levels

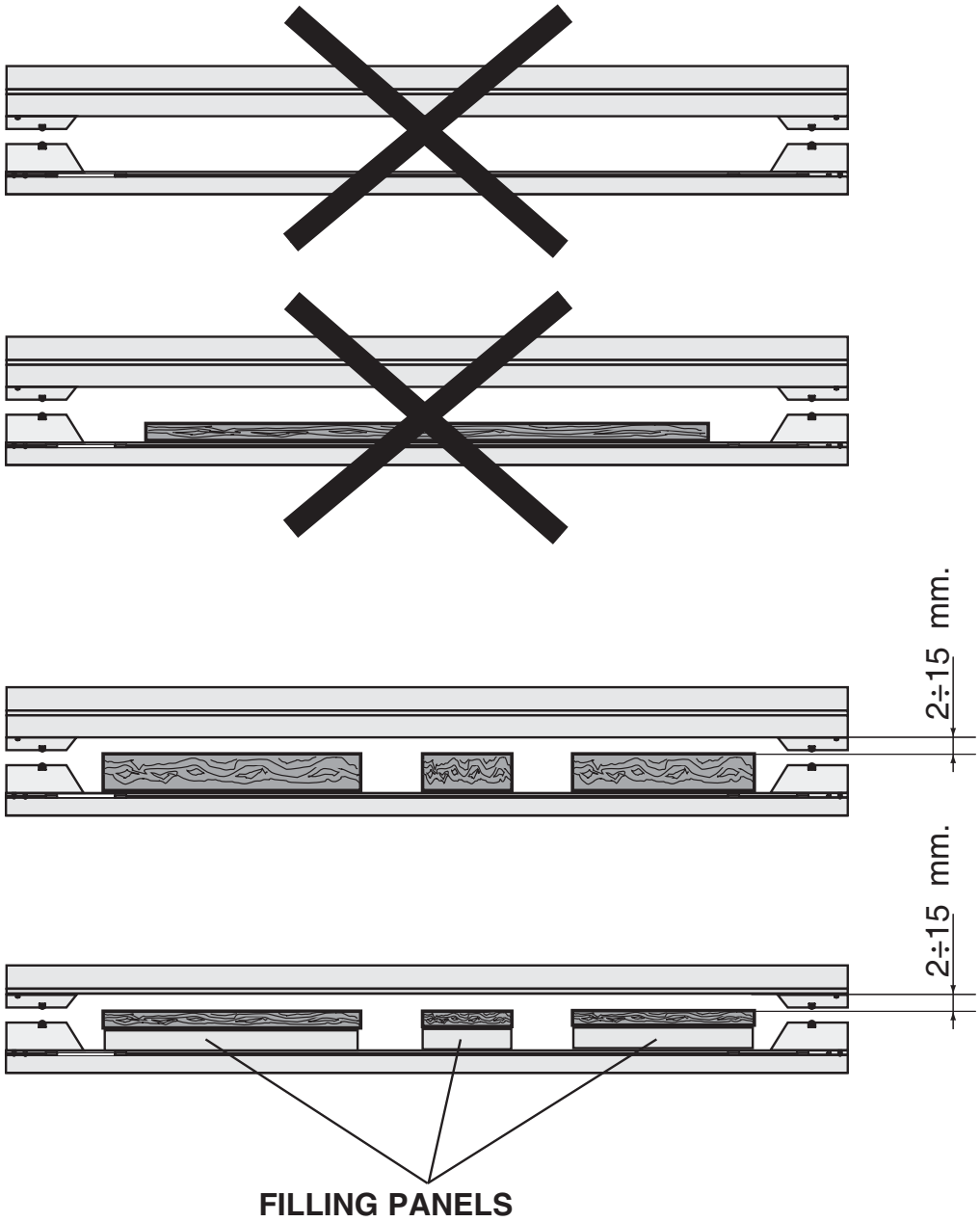
The press platens are heated by means of electric resistances.
The platens can reach a temperature of about 120°C, and it is therefore necessary to use specific protective gloves.

USE PROTECTIVE GLOVES WHILE OPERATING THE MACHINE, AS THE PLATENS REACH HIGH TEMPERATURES.

4.4 General rules for loading the panels in the press

During the positioning of the panels in the press, use protective gloves, as the press platens reach high temperatures.

DO NOT START A PRESSING CYCLE WITHOUT PANELS IN THE PRESS! IF THE PANEL THICKNESS IS TOO THIN PLEASE ADD FILLING PANELS TO REACH A SITUATION AS THE ONE SHOWN ON THE PICTURE.



5. Start-up/operation/stop

IMPORTANT: RED MUSHROOMS BUTTONS FOR "EMERGENCY STOP" MUST BE IMMEDIATELY PRESSED IN CASE OF DANGER. THEY ARE LOCATED ON THE CONTROL BOARD AND ON THE CONTROL ROPE

When the emergency stop is activated, any movement of the machine stops. to be able to reset the working cycle it is necessary to remove the reason of the emergency and to push the lamp pushbutton ”emergency reset” ”P20+L18”.

ELECTRIC BOARD IS TO BE CLOSED THROUGH THE LOCK. TURN THE MAIN SWITCH ON POSITION "1".

BEFORE OPERATING THE PRESS AND DURING ITS NORMAL WORK, THE OPERATOR MUST ALWAYS CHECK THAT NO PEOPLE (OR ANIMALS) ARE NEAR THE MACHINE!

AUTOMATIC working cycle

1) The electric panel should be closed to enable the MAIN SWITCH to be activated.
2) Supply power to the panel using the ”Main Voltage” key selector S1.
3) Press the ”General auxiliary running” illuminated button P1+L2.
4) Switch on the ”Vacuum pump”
5) Activate the heating of the levels
6) Start up the air cycle using the ”Air cycle block”.
7) Select the AUTOMATIC working cycle using the ”Man/Aut”

AUTOMATIC working cycle

1) The electric panel should be closed to enable the MAIN SWITCH to be activated.
2) Supply power to the panel using the ”Main Voltage” key selector S1.
3) Press the ”General auxiliary running” illuminated button P1+L2.
4) Switch on the ”Vacuum pump”
5) Activate the heating of the levels
6) Start up the air cycle using the ”Air cycle block”.
7) Select the AUTOMATIC working cycle using the ”Man/Aut”
8) Place the parts to be processed on the load tray and cover them with PVC sheets or veneer. To ensure that the PVC adheres to the edges of the parts to be processed, wooden templates are placed under these and attached to the tray using adhesive strips. The strips prevent the templates from moving on the tray and ensure that the air enters and leaves the load tray holes. The system made up of adhesive strips, template, parts to be processed and PVC sheets should have a height less than the maximum useful thickness, which is 55 mm.
9) Keep pressed the buttons placed on the push-button panel with arrow ìautomatic cycle consent P6-P7, to reach the contact of the platens.
The machine automatically performs the pressing and the opening.

IMPORTANT: AT THIS POINT, THE OPERATORS RISK CONTACT WITH THE MOVING PARTS OF THE MACHINE

IMPORTANT: IN EMERGENCY, THE RED EMERGENCY STOP BUTTON ON THE ELECTRIC PANEL AND AUTOMATIC CYCLE START–UP COMMAND CONSOLE SHOULD BE PRESSED IMMEDIATELY

When the emergency stop is pressed all the operations of the machine are shut down. To reset the working cycle the blockage of the emergency button P3 has to be RELEASED.

REMEMBER: In automatic mode the start–up command is issued only by the two–hand command on the pushbutton panel.

10) Free the processed parts with a trimmer and remove them from the tray, raise the scrap of the PVC or veneer. The tray is ready for a new load.

WARNING: BEFORE PERFORMING ANY CONNECTION, TEST, MAINTENANCE, LUBRICATION OR CLEANING OPERATIONS, THE MACHINE MUST BE LOCKED OUT WITH THE POWER OFF.
-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

6. Malfunctions/breakdowns/faults

6.1 Poor vacuum level

The deterioration of the sealing properties of the vacuum system is caused by a poor vacuum level with a consequently negative effect on the quality of the product. Check the condition of the gaskets regularly and replace them if necessary.
If, after shaping, the PVC sheet is left for too long on the load tray, when it is raised and removed from the level it may remain stuck to the gasket along the edge of the load tray and cause this to leave its housing. Always check the correct positioning of the gasket in its housing.

6.2 Losses due to cylinder drawing

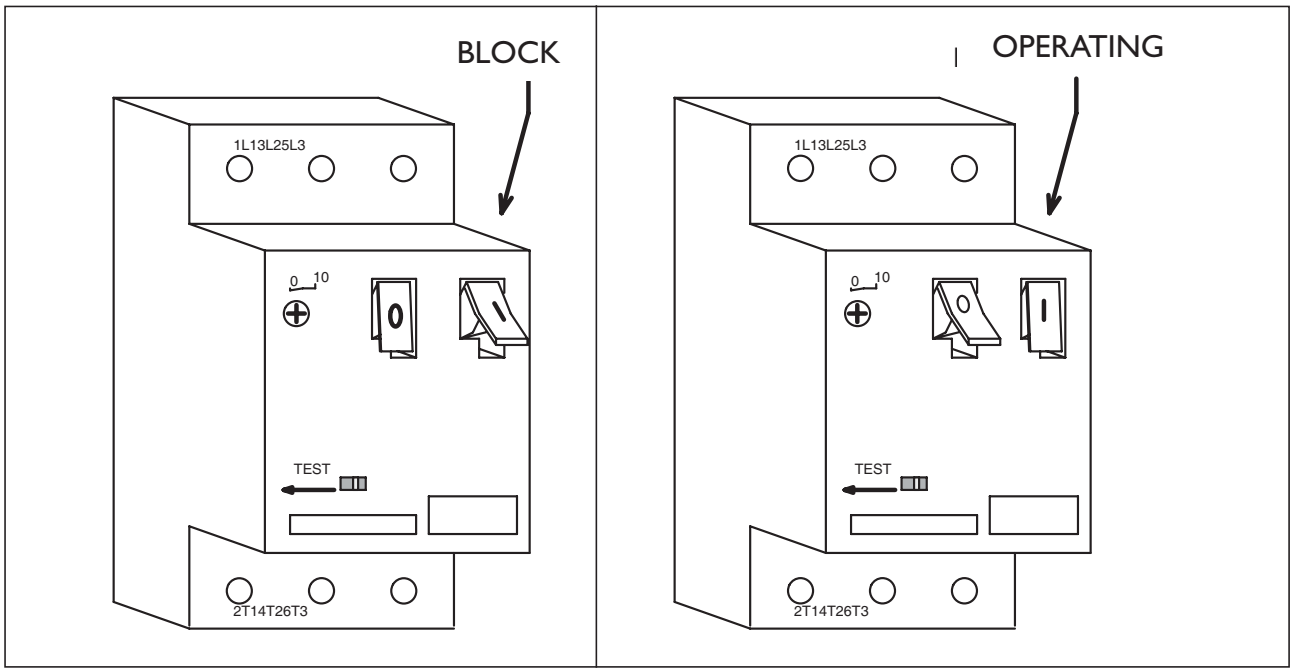
Inspect the cylinders to make sure there are no oil leaks caused by drawing, a sign of wear and tear on the gaskets. The types of gasket are described in paragraph "Drawings and cylinder parts".

6.3 Ageing of the hydraulic oil

The ageing of the hydraulic oil causes losses of its chemical–physical properties and obstructs the operation of the equipment. Top up or replace with hydraulic oil as described, at the interval set out.

6.4 Magnetothermal blockage

In the event of short circuits and overcurrents on the motor, the magnetothermal device in the electrical panel goes into BLOCK mode.
To rearm the device, open the electrical panel and press the black button until it reaches "OPERATING" position.
If the "BLOCK" mode continues, check the motor connections or contact our technical personnel.



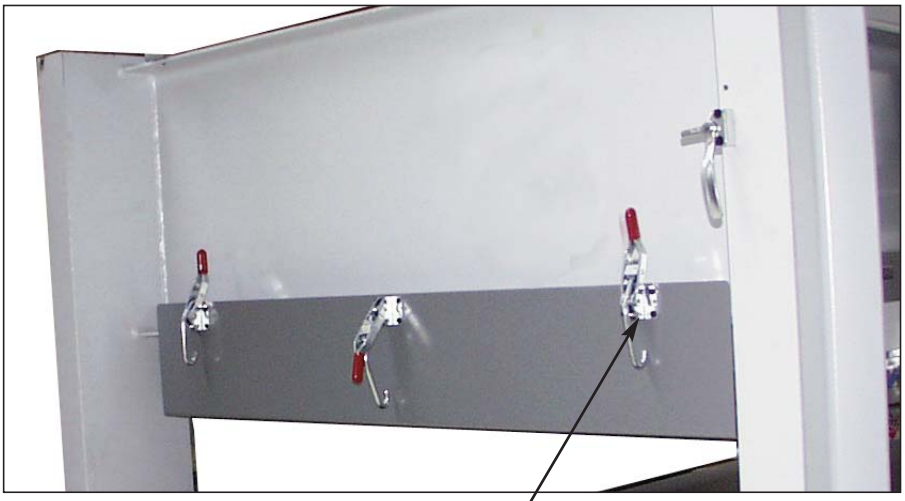
7. Production change

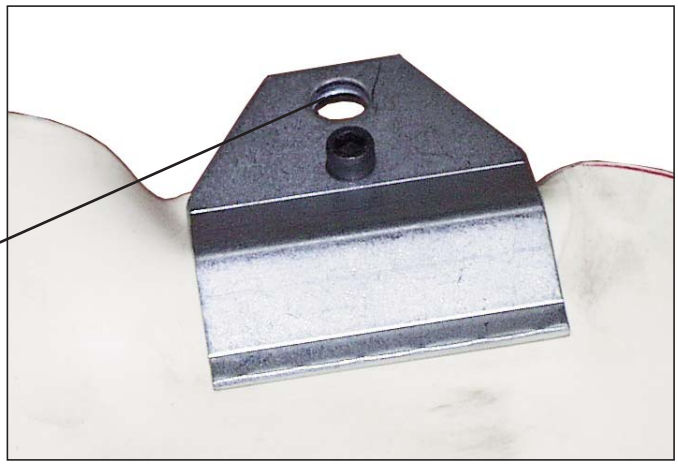
Membrane positioning (OPTIONAL)

The membrane (provided on request) is used to cover panels with bright PVC or veneer.

Instructions for membrane assembling:

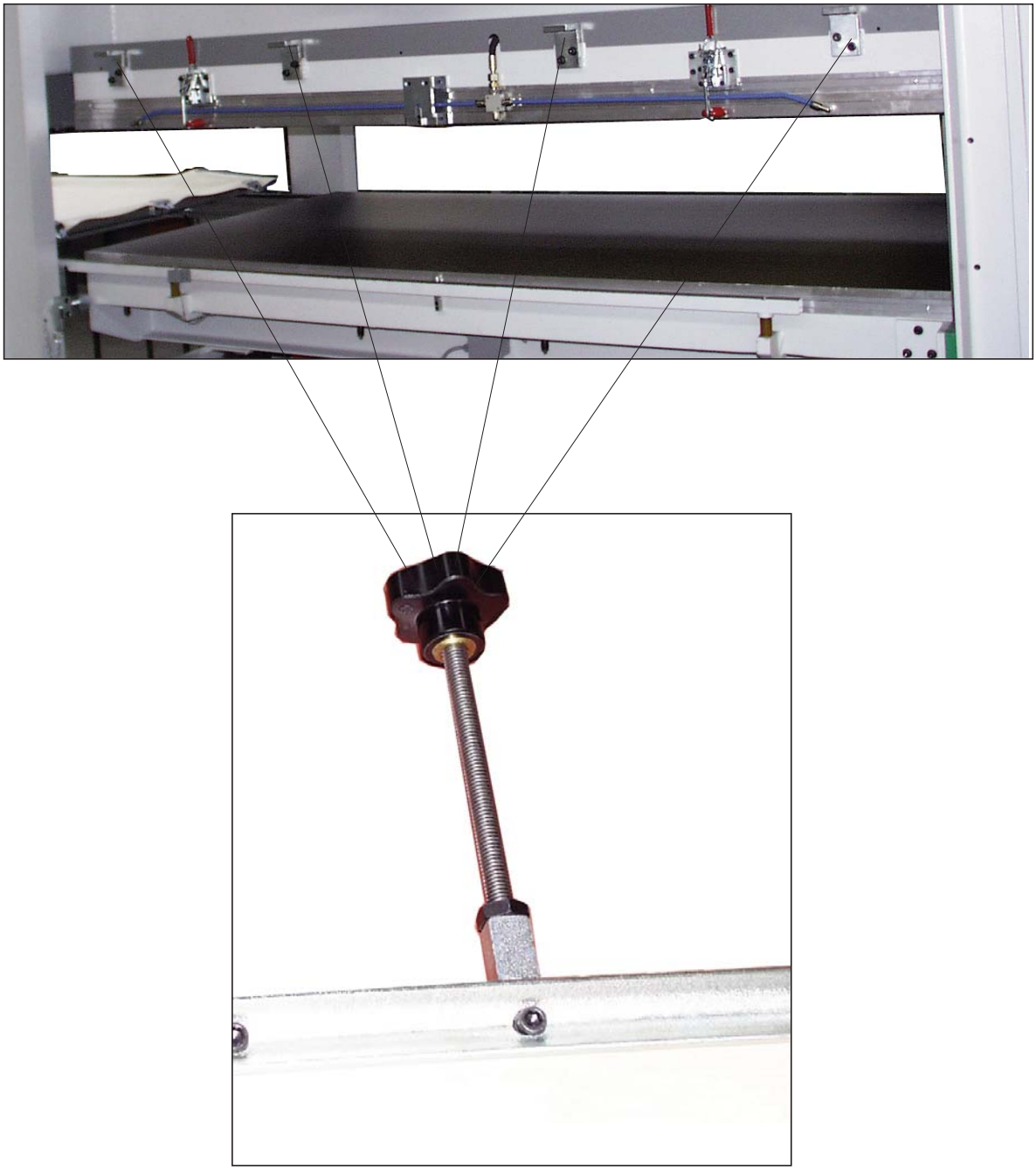
1 – Select the manual cycle with "S2" selector
2 – Pull the tray out of the press with the proper handles
3 – Rest the membrane onto the loading tray with the red-painted face turned upwards
4 – Insert the tray into the press
5 – Approach the lower platen to the upper one with the "P6-P7"closing push buttons
6 – Turn off the machine with "S1" selector and clear with the "IG" switch
7 – Clamp the membrane with the proper clamping systems (3 for each side) on both narrow sides of the press





8 - insert the lateral screws in the proper housing and screw the handle controls to stress the membrane (four for each side)

9 - In order to be able to work with the membrane cycle you must have the membrane cycle on with “S8” selector onto the control board.



WARNING: BEFORE PERFORMING ANY CONNECTION, TEST, MAINTENANCE, LUBRICATION OR CLEANING OPERATIONS, THE MACHINE MUST BE LOCKED OUT WITH THE POWER OFF.
-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

8. Cleaning

8.1 Vacuum pump filter

As the machine operates in dusty conditions (wood dust), the vacuum pump filter should be cleaned.
The protective extraction filter should be cleaned at intervals that can be learned only by experience. the procedure is as follows:
- Switch off the pump, undo the four screws that fix the extractor flange.
- Remove the flange, clean it with petrol and dry it with compressed air.
- Refit the parts in the correct order.

8.2 Load tray

The load tray should be cleaned to prevent the blockage of the air inlet and outlet holes, which would have a negative effect on the working capacities of the machine. It can be cleaned with a dry cloth.

8.3 Central oleodynamic unit:

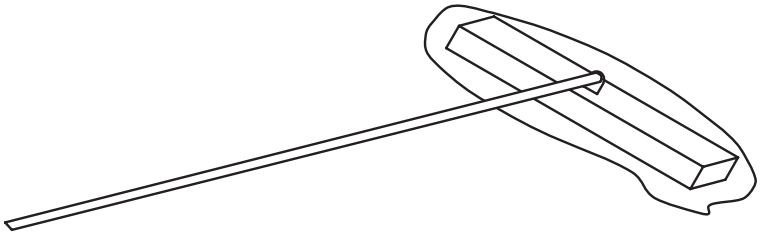
A hydraulic line which is duly and constantly taken care of assures a long lasting time without any disadvantages.
Among the main break-down causes it is possible to point out the jamming of the devices due to the hydraulic oil getting old (with a consequent loss of the chemical and physical properties).

OPERATION	**FREQUENCY**	
	NORMAL	*HEAVY DUTY*
Oil replacement and inner cleaning	every 2000	every 500 working hours
Outer cleaning	every four months	
Oil top-up	when level at minimum	
Oil filter cleaning	every three months	
Air filter cleaning	every three months	
Replacement of filter cartridges	every two years	
Pump and valves check	every two years	
Accumulator preloading check (optional)	every two years	

8.4 Cleaning the press levels

To ensure good product quality, the levels should always be kept clean. We recommend to carry out the cleaning operations by using specific tools.

fig. 7,2



NEVER GET INTO THE PRESS PLATENS; USE SPECIFIC TOOLS.

Clean the hot platens only with proper materials, both chemical and mechanical ones
Don't use cutting tools or mordant products as wooden chisel, crewdriver, metallic spatule, old metallic brushes, hydrochloric acid, unknown thinners, too much water.
Keep the platens surface with good separator agents.
This may be used also to remove little dirt.

The platens, especially the anodized ones, are easily to be cleaned with a polishing product.
Be careful with alu surfaces; they go easely scored
Always try first to clean with a piece of solid wood.

WARNING: BEFORE PERFORMING ANY CONNECTION, TEST, MAINTENANCE, LUBRICATION OR CLEANING OPERATIONS, THE MACHINE MUST BE LOCKED OUT WITH THE POWER OFF.
-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

9. Maintenance/inspection/checks

The safety devices removed during maintenance operations must be replaced and locked before using the machine

Make lubrication and maintenance operations exclusively when the machine is off.

9.1 Oil replacement

DISPOSE OF THE OIL REMOVED FROM THE MACHINE CORRECTLY!

a) Vacuum pump: The first oil change should take place after 400–600 hours of operation. The subsequent intervals should be every 1000 hours or at least once a year.

IMPORTANT: The pumping of noxious and polluting substances may require more frequent oil changes. When the oil looks dark and cloudy, this means that it has been significantly altered with a loss of its lubricating properties.
In such a case, it should be replaced.

Only direct experience can suggest the suitable interval between one oil change and the next.

The oil should be replaced when the machine is hot, proceeding as follows:

- Switch off the pump, undo the discharge cap and let the oil drain away completely.
- Tighten the cap, switch on for a few seconds with the extractor mouth open.
- Remove the cap once again, let the oil drip out for a few minutes and tighten it in its housing.
- Fill with oil, undoing the cap from the upper hole of the tank.
- Bring the oil level up to the level of the inspection port.

The same operation should be carried out for the subsequent top–ups.

b) Changing the oil in the central oleodynamic unit

! DISPOSE OF THE OIL REMOVED FROM THE MACHINE CORRECTLY!

The oil should be changed every 5000 working hours or in any case every 2 years.
A correctly and constantly maintained oleodynamic unit guarantees long life without operating problems.

Conform to the following instructions:

1. completely open the press

2. drain the used oil, through the indicated plug, and collect it; (1)

3. the new oil is loaded through the plug with the measuring stich, placed on the top of the unit; (2)

4. The level should be as described in 4.1.

Use the oil indicated in paragraph 14.1.

9.2 Vacuum pump purifier

The smoke elimination system is divided into two sections, both contained in the oil tank: the first is self–cleaning, and therefore requires no maintenance, while the second consists of a special cartridge which has to be replaced at an interval dependent on how the pump is used.

The replacement of the latter should take place when it begins to lose its effectiveness, or when the discharges contain excessive smoke. The procedure is as follows:

- Switch off the pump, undo the twelve screws that fix the cover of the oil tank, to the right of the pump, remove the cover.

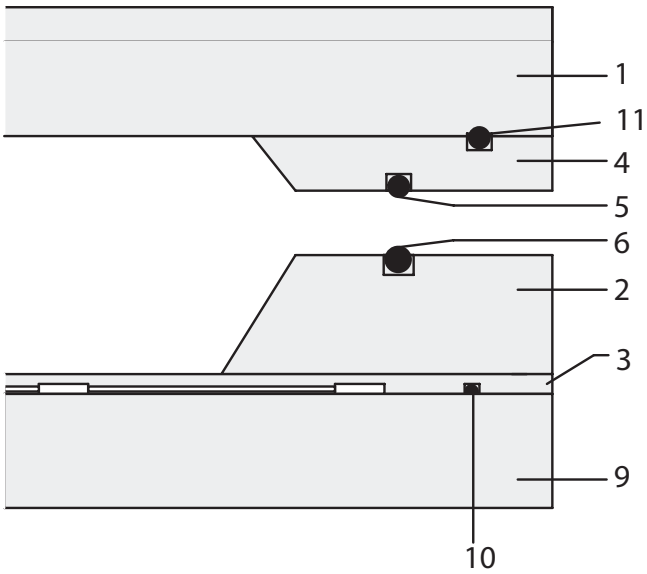
- Undo the four screws that hold the filter cartridge in place and remove this by hand.

- Replace the old parts with the new ones from the maintenance kit.

- Refit the parts in the correct order, without over–tightening.

9.3 Filter maintenance
See 8.1.

9.4 Gaskets



Periodically grease gaskets 6–10 with sv silicon grease.

When the gaskets are replaced, follow the instructions below:

The 5–10 gaskets should be fixed in their housing with a normal silicon glue to avoid leaks caused by depression–pressure.

N.B.: gasket 6 should not be glued in place under any circumstances!

WARNING: BEFORE PERFORMING ANY CONNECTION, TEST, MAINTENANCE, LUBRICATION OR CLEANING OPERATIONS, THE MACHINE MUST BE LOCKED OUT WITH THE POWER OFF.
-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

9.5 Greasing the mechanical parts

To keep the machine in efficient working order, careful maintenance is essential. One of the most important maintenance operations, to be carried out at regular intervals, is the greas-ing of the mechanical parts. The table below describes the main parts to be lubricated, if fitted, and the checking intervals.

DESCRIPTION .....MAINTENANCE PROGRAM

- Racks .....EVERY 100 WORKING HOURS

DATA										

- Guides .....EVERY 200 WORKING HOURS

DATA										

- Chains .....EVERY 250 WORKING HOURS

DATA										

- Balance lever fulcrums .....EVERY 500 WORKING HOURS

DATA										

- Bearing supports .....EVERY 2000 WORKING HOURS

DATA										

- Mechanism pivots .....EVERY 1000 WORKING HOURS

DATA										

10. Messa fuori servizio temporaneo - Temporary shutdown - Mise hors service temporaire - Vorübergehende Stillegung - Parada por algún tiempo

- If the machine is shut down temporarily, it is advisable to spray the following mechanical parts with an anti-oxidant: cylinders, mobile surface, guides.

- Set the machine to closed level position.

- Disconnect the machine from the electric power line and compressed air supply.

- Leave the oil (central oil dynamic unit) in the machine and change it upon restart if the shutdoiwn time is greater than 12 months.

- Upon restart, clean the mechanical parts coated with the protective spray using a dry cloth. Check the cylinder gaskets and change them if necessary.

11 Messa fuori servizio definitivo (smantellamento) - Permanent shut-down (dismantling) - Mise hors service définitive (démontage) - Endgültige Stillegung (Abbau) - Parada definitiva (desarmado)

The machine contains no materials which require special treatment when dismantling.

- Firstly, remove the fluids used in the machine: oil from the central oil dynamic unit, diathermal oil, air lubrication oil.

DISPOSE OF THE OILS USED IN THE MACHINE CORRECTLY.

- Collect the plastic and rubber materials, such as the cylinder gaskets, flexible tubes, cable covers, etc. These materials should be disposed of in accordance with the national laws in force.

- Remove the motors, electrical equipment, wiring, the equipment contained in the electrical panel, and recover the copper parts.

- The press body, levels and all the other steel parts can be disposed of as ferrous material.

12 Technical specifications of the machine

THERMO-FORMING PRESS MOD. ESTREMA/S
TO LAMINATE 3-D SURFACES WITH PLASTIC FOILS

Press frame made of steel profiles
Platen dimensions . . . . . .mm. 1300 x 2500 (51" x 98")
Useful dimensions (approximate) . . . . . .mm. 1150 x 2350 (45" x 92")
Max. useful thickness . . . . . .mm. 55 (2.15")
Loading side . . . . . .mm. 1300 (51")
Up-stroke movement of the bottom platen
Pressare cylinders . . . . . nr. 6
Max specific pressure . . . . . .Kg./cm^2 3+1 (42+14 psi)
Alluminium heating platen with built-in electric elements
Max. working temperature . . . . . .130 °C (265 °F)

CE safety standards

12.1 Phonometric measurements

The manufacturer declare that the sound level under written is referred to the machine described in the present instruction manual.

The continuous pondered sound level around the machine is **lower than 70 dB(A).**

13. Assistenza tecnica

In caso di necessità contattare i nostri Tecnici specificando il riferimento del Manuale d'uso in Vostro possesso.

Technical assistance

Where necessary, contact our technical personnel, specifying this user's manual as reference.

Assistance technique

En cas de besoin, contacter notre Service Technique en spécifiant la référence du Manuel d'Utilisation en votre possession.

Kundendienst

Bei Bedarf können Sie mit unserem technischen Büro Kontakt aufnehmen. Verwenden Sie hierzu die in Ihrem Handbuch zur Bedienung enthaltene Bezeichnung der Maschine.

Asistencia técnica

Si fuera necesario llamara a nuestros Técnicos específicando la referencia del Manual de Uso que Ud. posee

Indirizzo - Address - Adresse - Adresse - Dirección:

ITALPRESSE S.p.A.

via Delle Groane 15 BAGNATICA 24060 (BG)

Tel.:(035) 666341

Fax:(035) 6663400/401

E-MAIL: sales@italpresse.com

WEB: www.italpresse.com

14. Supplies and materials used

14.1 Tipi di olio consigliati - Recommended oils- Types d'huiles conseillées - Empfohlene Öle - Tipos de aceite aconsejados

– Per pompa del vuoto - Vacuum pump:
SHELL - CORENA OEL H100
MOBIL - RARUS 427
ESSO - NUTO H100

Centralina oleodinamica - Central oil dynamic unit - Centrale oléodynamique Baugruppe Hydraulik - Central oleondinámica

AGIP OSO 46
API CIS 46
BP ENERGOL HLP 46
CASTROL HYSPIN AWS 46
ELF ELFONA 46
ESSO NUTO 46
IP HYDRUS OIL 46
SHELL TELLUS OIL 46
TOTAL AZOLLA ZS 46
Quantità olio - Oil quantity - Quantité de huile - Ölmenge - Cantidad de aceite ~ 50 lt.

Per lubrificatore dell'aria - Air lubricator - Pour lubrificateur air - Für Luftschmierer - Para lubrificador aire

BP - ENERGOL HLP 22
ESSO - SPINESSO 22
MOBIL - MOBIL DTE
SHELL - TELLUS OIL 22

14.2 Tipi di grasso consigliati - Transmission grease - Types de graisses conseillées - Empfohlenes Schmierfett - Tipos de grasas aconsejadas

- LUBRIFICANTE PER RIDUTTORI A INGRANAGGI O A VITE SENZA FINE
- LUBRICANT FOR GEAR REDUCERS OR TANGENT SCREWS
- LUBRIFIANTS POUR REDUCTEURS A ENGRENAGES OU A VIS SANS FIN
- SCHMIERMITTEL FÜR ZAHNRAD-UNTERSETZUNGSGETRIEBE ODER UNTERSETZUNGETRIEBE MIT END-LOSSCHRAUBE
- LUBRIFICANTE PARA REDUCTORES DE ENGRANAJES O DE TORNILLOS SIN FIN

TIPO TYPE TYPE ART TIPO	APPLICAZIONE APPLICATION APPLICATION VERWENDUNG APLICACIÓN	MARCA BRAND MARQUE MARKE MARCA
olio minerale mineral oil huile minerale Mineralöl aceite mineral	riduttori a ingranaggi gear reducers réducteurs à engrenages Zahnradgetriebe zur Untersetzung reductor de engranajes	IP - MELLANA OIL 320/220 ESSO - SPARTAN EP 320/220 AGIP - BLASIA 320/220 MOBIL - MOBILGEAR 632/630 SHELL - OMALA 3P 320/220 BP - ENERGOL GR-XP 320/220
olio minerale mineral oil huile minerale Mineralöl aceite mineral	riduttori a vite senza fine tangent screw reducers réducteurs à vis sans fin Schneckengetriebe zur Untersetzung reductores de tornillo sin fin	IP - MELLANA OIL 460/320 ESSO - SPARTAN EP 460/320 AGIP - BLASIA 460/320 MOBIL - MOBILGEAR 634/632 SHELL - OMALA EP 460/320 BP - ENERGOL GR-XP 460/320
grasso sintetico synthetic grease graisse synthétique synthetisches Fett grasa sintética	ridutt. a ingran e a vite senza fine gear reducers and tangent screws réducteurs à engrenages et à vis sans fin Zahnrad- und Schneckengetriebe zur Untersetzung reductores de engranajes y de tornillos sin fin	IP - TELESIA COMPOUND B KLUEBER - STRUCTOVIS P LIQUID TOTAL - TOTALCARTER SY00
olio sintetico synthetic oil huile synthétique synthetisches Öl aceite sintetica	ridutt. a ingran. e a vite senza fine gear reducers and tangent screws réducteurs à engrenages et à vis sans fin Zahnrad- und Schneckengetriebe zur Untersetzung reductores de engranajes y de tornillos sin fin	IP - TELESIA OIL 150 KLUEBER - SYNTHESOI D220EP AGIP - BLASIA S
PER CREMAGLIERE, SUPPORTI RACK AND SUPPORT GREASE GRAISSE POUR CREMAILLERES, SUPPORTS SCHMIERFETT FÜR ZAHNSTANGEN, LAGER GRASA PARA CREMALLERAS, SOSTENES		AGIP-GR-MU/2
PER CILINDRI ED INGRASSAGGIO GENERALE CYLINDER AND GENERAL GREASE GRAISSE POUR CYLINDRES ET GRAISSAGE GENERAL SCHMIERFETT FÜR WALZEN UND ALLG. ABSCHMIEREN GRASA PARA CILINDROS Y ENGRASAJE GENERAL		AGIP - PV 20 (BIANCO) (WHITE) (BLANCHE) (WEIß) (BLANCO)

14.3 Materiali di produzione - Production materials - Matériaux de production - Werkstoffe - Materiales de produccion

Le colle devono essere utilizzate seguendo le istruzioni fornite dai Vostri Fornitori di colla.
VI SCONSIGLIAMO DAL PREPARARE O FARE USO DI COLLE SENZA ESSERE IN POSSESSO DI PRECISE ISTRUZIONI D'USO Vi suggeriamo di richiedere SEMPRE le schede tossicologiche delle colle che Vi vengono fornite e di spedirne una copia a ITALPRESSE S.p.A..

The glues should be prepared and used according to the supplier's instructions. ! BEFORE PREPARING OR USING THE GLUES, READ THE INSTRUCTIONS CAREFULLY.
ALWAYS ask the supplier for the toxicological specifications of the glues and the instructions for their correct use.

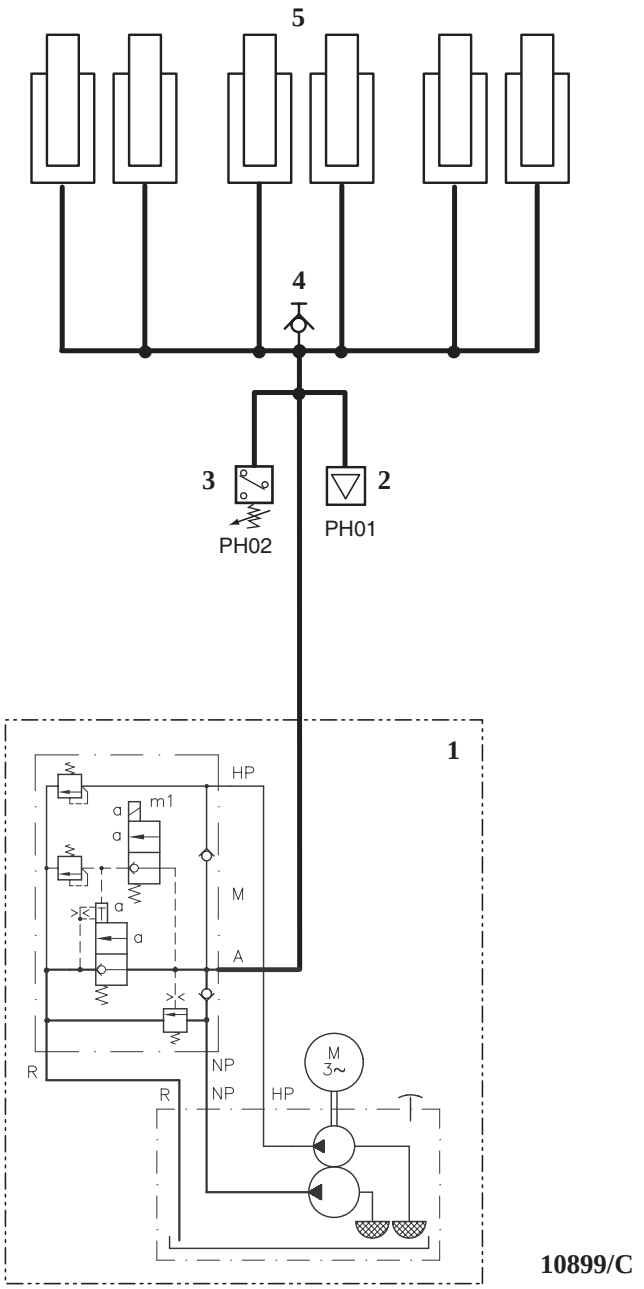
Les colles doivent être utilisées en suivant les instructions données par vos fournisseurs de colle.
AVANT LA PREPARATION ET L'UTILISATION DE COLLES IL EST CONSEILLE DE LIRE ATTENTIVEMENT LES INSTRUCTIONS CORRESPONDANTES. Nous vous conseillons de demander TOUJOURS les fiches toxicologiques des colles qui vous sont fournies et les instructions correctes pour une bonne utilisation de celles-ci.

Die Klebstoffe sind nach den von Ihren Lieferanten mitgelieferten Anleitungen anzuwenden.
WIR RATEN IHNEN, KEINE KLEBSTOFFE ZUZUBEREITEN ODER ANZUWENDEN, FUR DIE SIE NICHT UBER AUSFUHRLICHE ANLEITUNGEN ZUR ANWENDUNG VERFUGEN.
wir empfehlen Ihnen, IMMER eine Beschreibung der Gefahrenklasse der von Ihnen verwendeten Klebstoffe zu verlangen und eine Kopie davon an die ITALPRESSE S.p.A. zu senden.

Las colas se deben usar siguiendo las instrucciones dadas por vuestros abastecedores de cola. Les aconsejamos preparar o usar colas con las instrucciones precisas de uso. Le sugerimos pedir siempre las fichas toxicologicas de las colas

15 Diagrams

15.1 Hydraulic diagram



1 – Motor pump MPN44-HZ 2,4/59 SB75 KW 2,1 1003304640

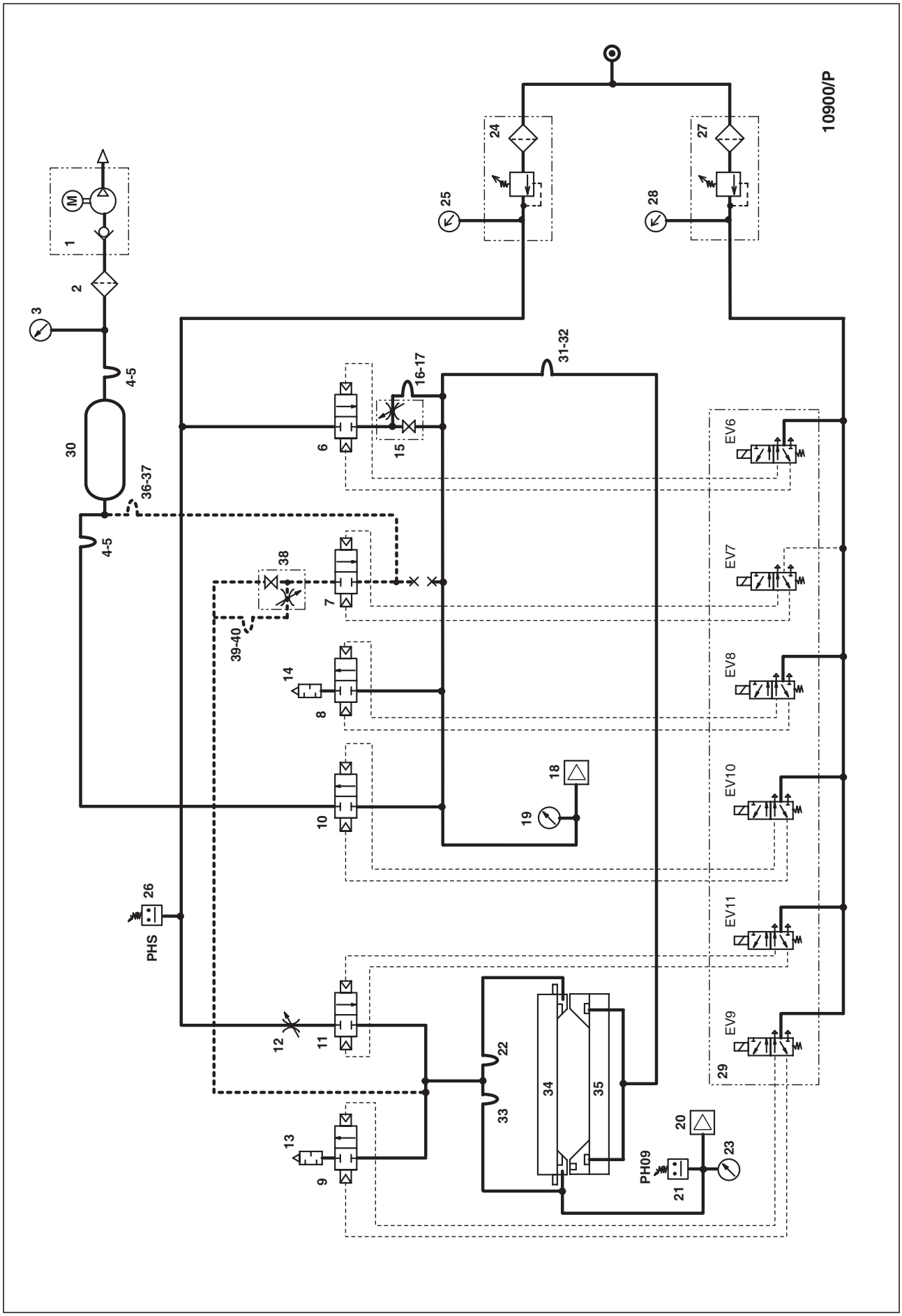
2 – Pressure transducer ART. 3396.086.101 400bar 0-10 VDC 1/4” 1018530132

3 –Pressure switch DG 34 1014720135

4 –Pressure Pressure check 620.01.204.21 1009360300

5 – Cylinder Ø 85 mm. nr.6 2500053797

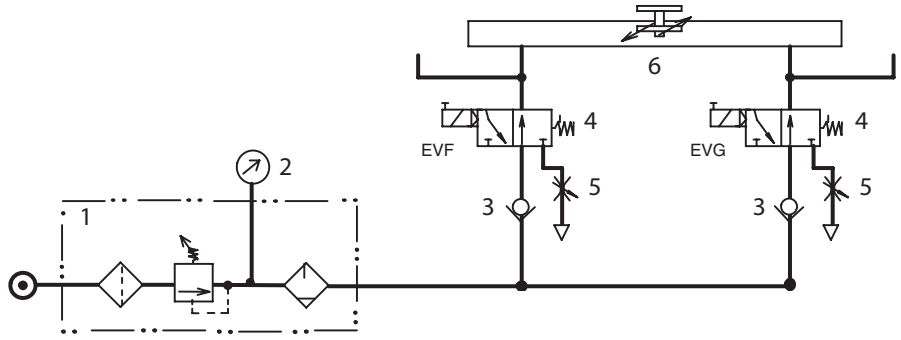
15.2 Pneumatic diagrams



Pneumatic press diagram description 10900/P

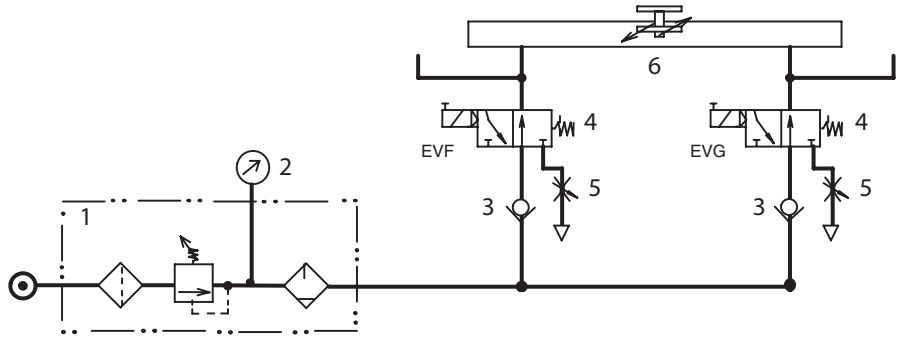
	STAND.	MEMB.	
1 – vacuum pump LB25/T 9601049/T V.220-255/380-440-50/60HZ	Nr.1		10 1446 4018
2 – vacuum filter Mod. 9001025 3/4”	Nr.1		10 0656 0135
3 – vacuum meter Φ 40 -1 0bar attacco rapido 1/8”	Nr.1		10 2102 0041
4 –flexible tube ARMOVIN DI 30 SP.5 HN–HNP	Nr.2		10 1873 1760
5 – fixing tube S.36-39	Nr. 4		10 0614 0340
6 – flow start–up valve ART. B–DE 1/2”	Nr.1		10 2009 9132
7 – flow start–up valve ART. B–DE 1/2”		Nr.1	10 2009 9132
8 – flow start–up valve ART. B–DE 1”	Nr.1		10 2009 9138
9 – flow start–up valve ART. B–DE 1/2”	Nr.1		10 2009 9132
10 – flow start–up valveART. B–DE 1”	Nr.1		10 2009 9138
11 – flow start–up valve ART. B–DE 1/2”	Nr.1		10 2009 9132
12 – Valve ART.3400 1/2”	Nr.1		10 1685 0060
13 – silencer filter M10 1”	Nr.1		10 0656 1600
14 – silencer filter M10 1”	Nr.1		10 0656 1600
15 – sphere valve ART. 5210 1/2”	Nr.1		10 2009 8500
16 – flexible tube 2556-4 De. 12 Di 6,4	Nr.1		10 1873 1040
17 –fixing tube velox 2B 10/18	Nr. 2		10 0614 1050
18 – Pressure transmitter -1+3 bar	Nr. 1		10 1853 0180
19 – pressure gauge D63-1+5bar Att. Post 1/4” con staffa	Nr. 1		10 1135 1080
20 – Pressure transmitter 0-+2,5 bar	Nr. 1		10 1853 0152
21 – pressure switch PM 10A	Nr. 1		10 1472 0250
22 – Hose 0100T DN10x900	Nr. 1		10 1873 1190
23 – pressure gauge D63-1+5bar Att. Post 1/4” con staffa	Nr. 1		10 1135 1080
24 – regulator filter FR 3/4” art. 0800.40.0001	Nr. 1		10 0656 0926
25 – pressure gauge D. 40 0/10 BAR 1/8”	Nr. 1		10 1135 0280
26 – pressure switch PM 10A	Nr. 1		10 1472 0250
27 – regulator filter FR 1/4”	Nr. 1		10 0656 0931
28 – pressure gauge D. 40 0/10 BAR 1/8”	Nr. 1		10 1135 0280
29 – Unit NORGREN 5 solenoid valve	Nr. 1		10 0778 5564
29 – Gruppo NORGREN 6 solenoid valve		Nr. 1	10 0778 5566
30 – vacuum tank lt. 470	Nr. 1		10 1737 0495
31 – flexible tube ARMOVIN DI 20 SP. 3,5 HN–HNP	Nr. 1		10 1873 1720
32 – fixing tube velox 2B 14/24	Nr. 2		10 0614 1040
33 – flexible tube 0100T DN10x600	Nr. 1		10 1873 1110
34 – upper platen	Nr.1		
35 – lower platen	Nr.1		
36 – flexible tube ARMOVIN DI 20 SP. 3,5 HN–HNP	Nr.1		10 1873 1720
37 – fixing tube d.20	Nr. 2		10 0614 1040
38 – sphere valve ART. 5210 1/2”		Nr. 1	10 2009 8500
39 – flexible tube 2556-4 De. 12 Di 6,4		Nr.1	10 1873 1040
40 – fixing tube 2B 10/18		Nr. 2	10 0614 1050

Pneumatic tray 1 translation diagram



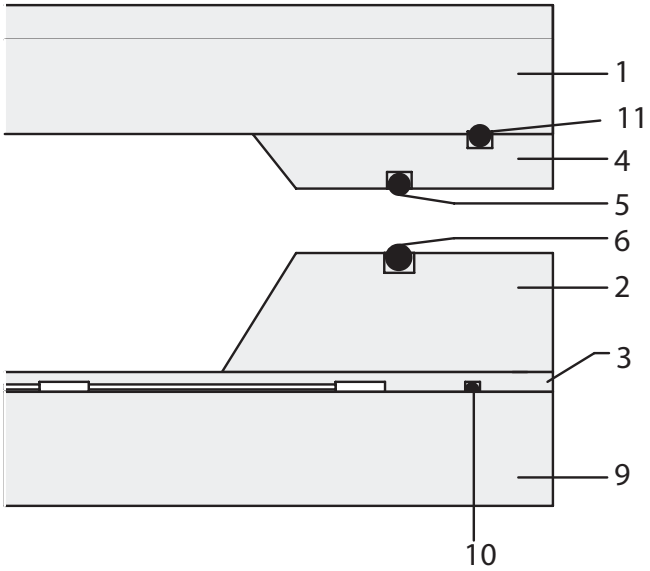
1 – filter–reducer–lubricator FR–L 3/8" . . . . . .Nr.1 . . . . .10 0656 0940
2 – pressure gauge 0–10 bar 1/8" . . . . . .Nr.1 . . . . .10 1135 0280
3 – valve 1/4" 6.07.14 . . . . . .Nr.2 . . . . .10 2009 0400
4 – electrovalve414.2.32.012 . . . . . .Nr.2 . . . . .10 0540 2170
5 – discharge regulator 6.03.14 . . . . . .Nr.2 . . . . .10 1618 0520
6 – cylinder M/46132/M/3065 . . . . . .Nr.1 . . . . .10 0343 3750

Pneumatic tray 2 translation diagram



1 – filter–reducer–lubricator FR–L 3/8" . . . . . .Nr.1 . . . . .10 0656 0940
2 – pressure gauge 0–10 bar 1/8" . . . . . .Nr.1 . . . . .10 1135 0280
3 – valve 1/4" 6.07.14 . . . . . .Nr.2 . . . . .10 2009 0400
4 – electrovalve414.2.32.012 . . . . . .Nr.2 . . . . .10 0540 2170
5 – discharge regulator 6.03.14 . . . . . .Nr.2 . . . . .10 1618 0520
6 – cylinder M/46132/M/3065 . . . . . .Nr.1 . . . . .10 0343 3750

15.3 Vacuum seal system



1 – upper electric level
2 – lower frame
3 – tray
4 – upper frame
5 – gasket t=7 in silicone
6 – gasket t=7 in silicone
9 – lower electric level
10 – gasket or t=4
11 – gasket or t=5

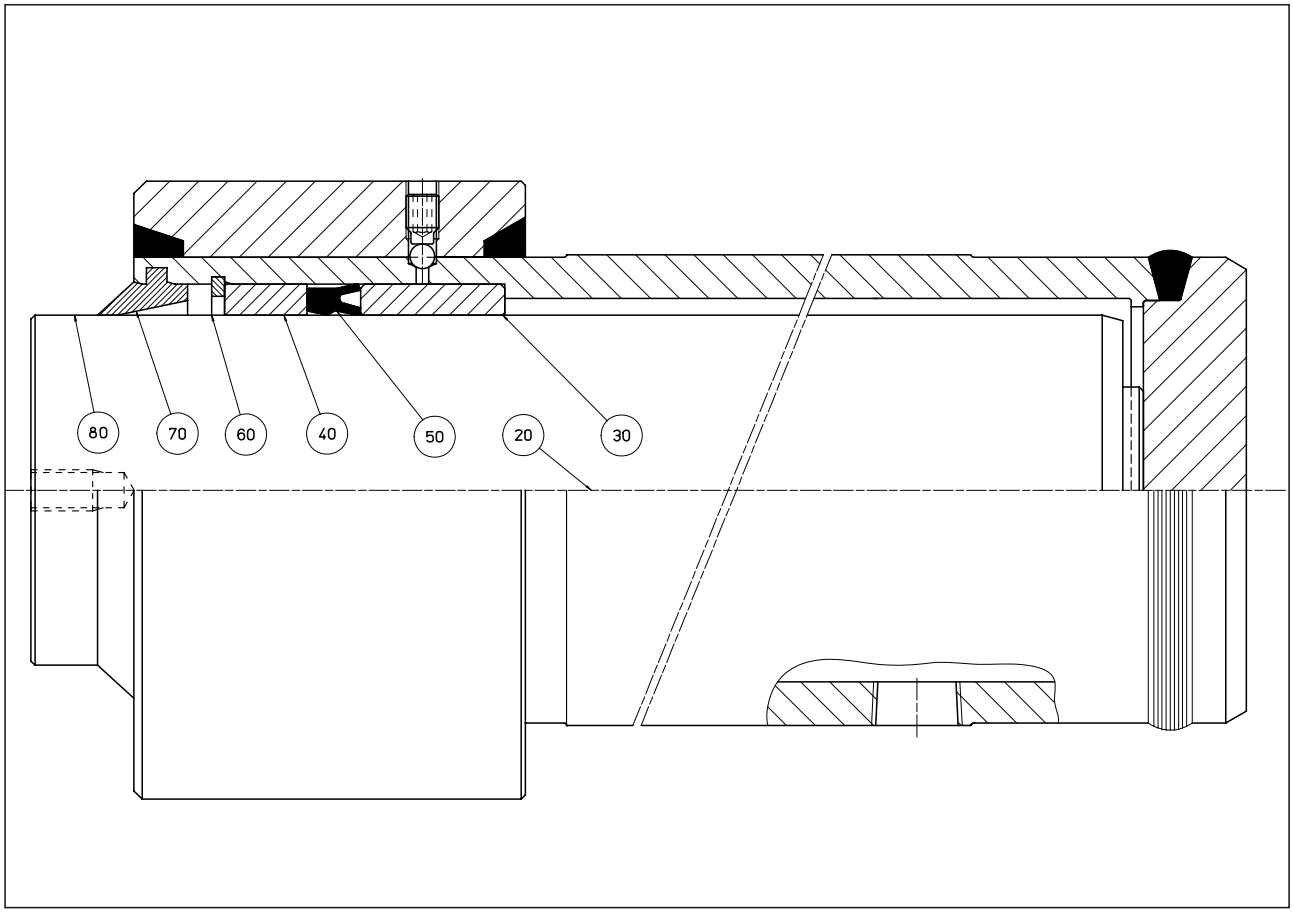
grease gaskets 6–10 regularly with sv type silicon grease.

gaskets 5–10 should be glued into their housings with normal silicon glue to avoid leaks caused by depression–pressure.

GASKET 6 SHOULD NOT UNDER ANY CIRCUMSTANCES BE GLUED!

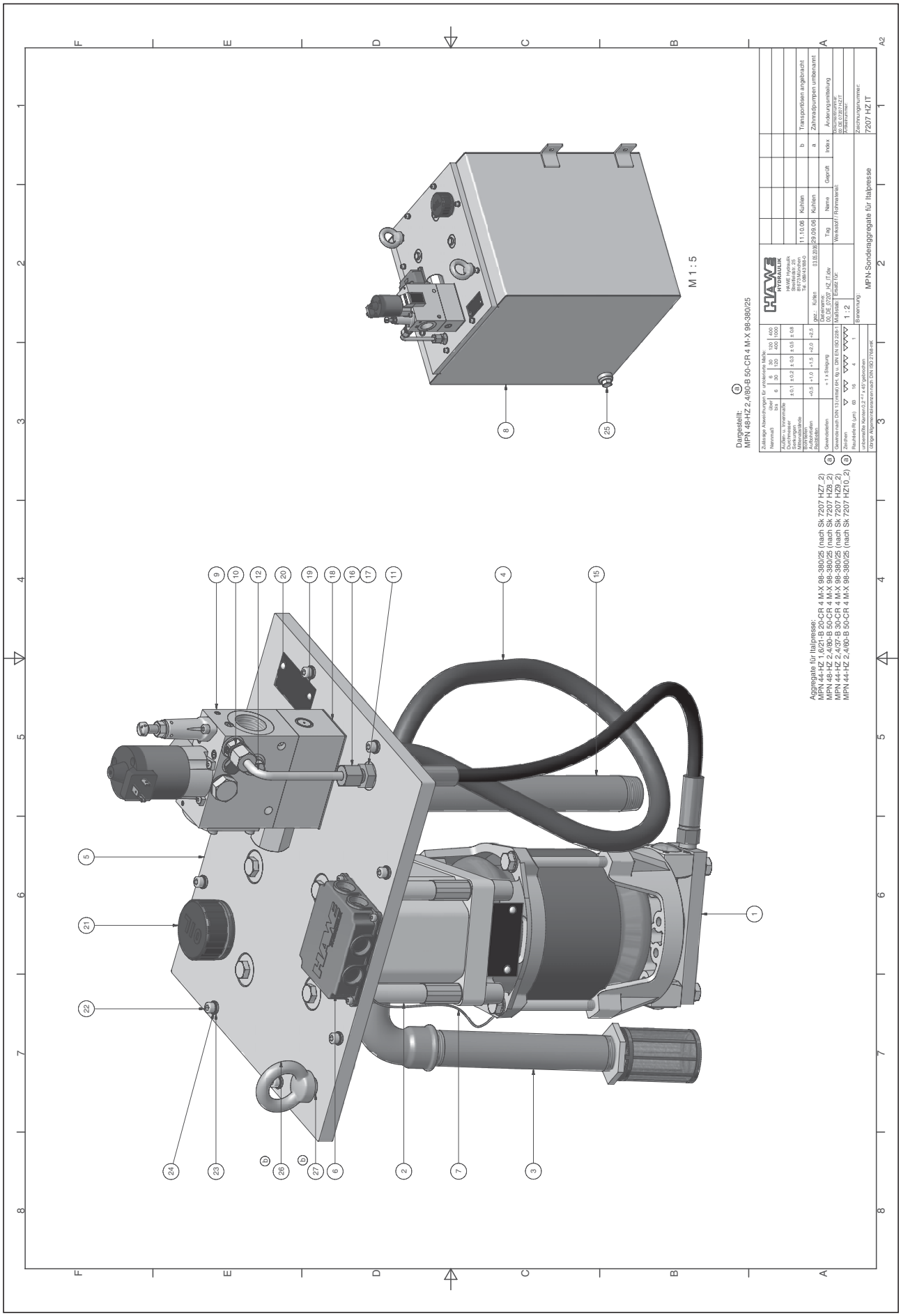
15.4 Cylinders

Thrust cylinder
Φ 85 -2500053797



CODICE	POS	DESCRIPTION	N.PZ
1003438200	20	JACKET	1
2500028106	30	BUSHING FOR CYLINDER LG.35	1
2500028105	40	BUSHING FOR CYLINDER LG.20	1
1007903785	50	GASKET EHRCO-HALLITE 605-4306800 85 X100X13	1
1017201320	60	STOP RING SEEGER PER INT. UNI 7437 D.100	1
1016150720	70	SCRAPER RING 85 TIPO R1	1
2500000595	80	SHAFT	1

15.5 Motor pump group



Stückliste 7207 HZ IT

Blatt 1/1

MPN–Sonderaggregate für Italpresse
Druckeinstellungen am CR 4 M: 380/25

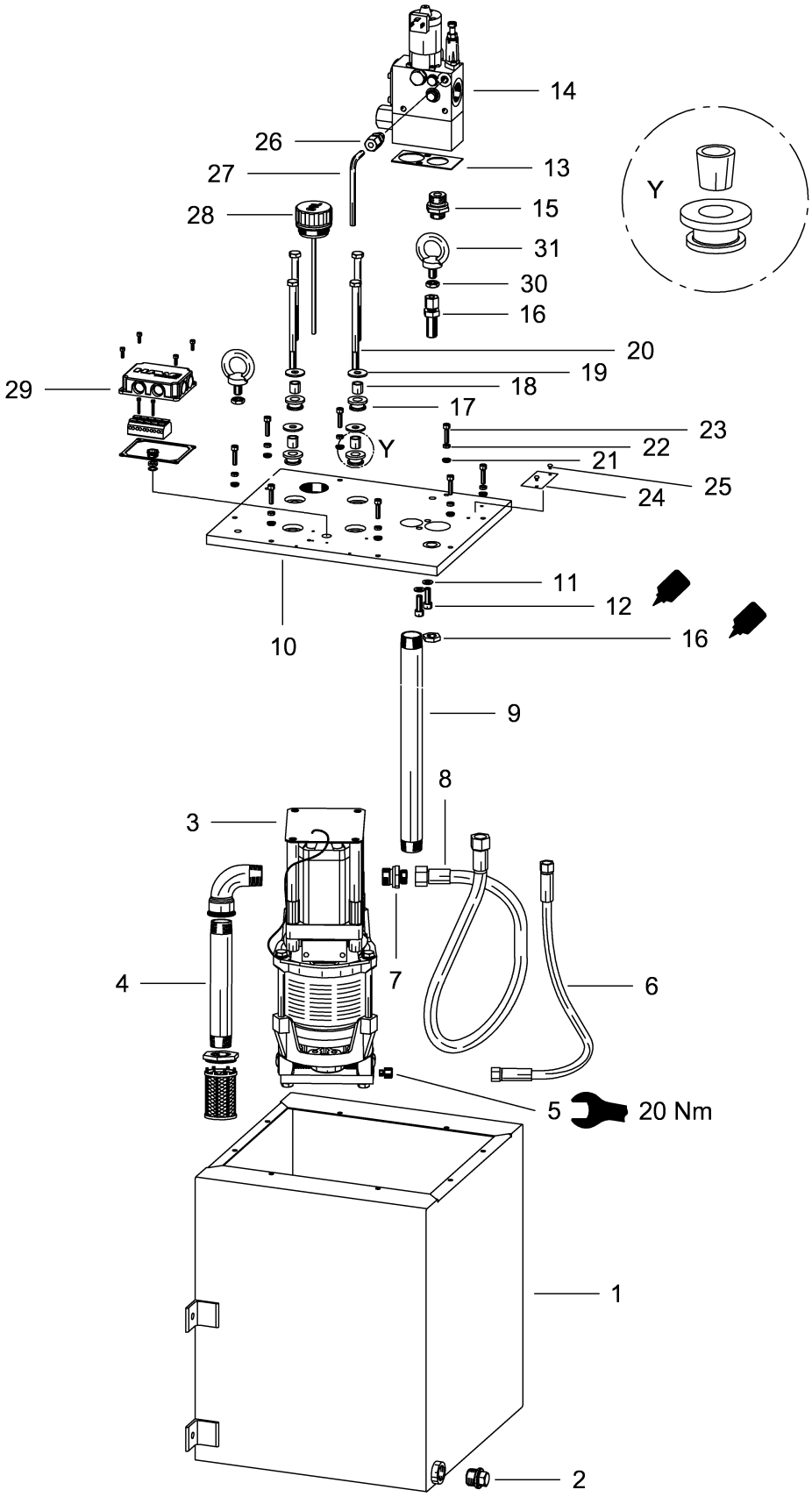
f	e	d MPN 48–HZ 2,4/80–B 50–CR 4 M–X 98	c MPN 44–HZ 2,4/60–B 50–CR 4 M–X 98	b MPN 44–HZ 2,4/37–B 30–CR 4 M–X 98	a MPN 44–HZ 1,6/21–B 20–CR 4 M–X 98	Benennung und Bemerkung	Zeichnungs–Nr.	Teil
		1	1	1	1	MPN Grundpumpe komplett n. Stckl. *)	7207 710	1
				1	1	MPN Befestigung C n. Stckl.	7207 725 c	2
			1			MPN Befestigung D n. Stckl.	7207 725 d	
		1				MPN Befestigung G n. Stckl.	7207 725 g	
					1	MPN Saugteile n. Stckl.	7207 730 h	3
				1		MPN Saugteile n. Stckl.	7207 730 l (d)	
		1	1			MPN Saugteile n. Stckl.	7207 730 i (d)	
					1	MPN Druckteile n. Stckl.	7207 740 ee (c)	4
				1		MPN Druckteile n. Stckl.	7207 740 gg (c)	
		1	1			MPN Druckteile n. Stckl.	7207 740 kk (d) (c)	
		1	1	1	1	Deckplatte D 20	7207 612 kpl	5
		1	1	1	1	MPN Klemmenkasten n. Stckl.	7207 752	6
		1	1	1	1	MPN Schutzleiter komplett n. Stckl.	7207 770	7
					1	Behälter B 20	7207 605 kpl	8
				1		Behälter B 30	7207 604 kpl	
		1	1			Behälter B 50	7207 606 kpl	
		1	1	1	1	Abschaltventil CR 4 M n. Stckl.	7150 000	9
		1	1	1	1	Ermeto GE 08–S R 1/4		10
		1	1	1	1	Ermeto SV 8–S		11
		1	1	1	1	Druckrohr	7207 983	12
		2	2	2	2	Zylinderschraube ISO 4762–M8x25–8.8–A2K		13
		2	2	2	2	Federring DIN 127–A8		14
		1	1	1	1	Doppelnippel DIN 2982 1 ZLx360		15
		2	2	2	2	Ermeto M 8–S		16
		2	2	2	2	Ermeto PSR 8–L/X		17
		1	1	1	1	Dichtung	7161 050	18
		1	1	1	1	Typenschild	7207 050...	19
		2	2	2	2	Kerbnagel ISO 8746 A 4x6		20
		1	1	1	1	Belüftungsfilter	7207 126	21
		8	8	8	8	Zylinderschraube ISO 4762–M6x25–8.8–A2K		22
		8	8	8	8	DUBO–Zahntellerring M6 Nr. 404		23
		8	8	8	8	DUBO–Schraubensicherung M6 Nr. 301		24
		1	1	1	1	Verschlussschraube mit Dichtring–G 3/4 A–NBR		25
		2	2	2	2	Ringschraube ISO 3266–M12–A2K		26
		2	2	2	2	Sechskantmutter DIN ISO 4035–M12–A2K		27
						*) Achtung:		
						Für Spalten c und d folgende Zahnradpumpen verwenden:		
		1				Zahnradpumpe Z 80		
						ALP 3–S–80–C0–FG–MU (Marzocchi)		
			1			Zahnradpumpe Z 60		
						ALP 3–S–60–C0–FG–MU (Marzocchi)		
						Für Spalte d folgende Änderungen vornehmen:		
						In Stückliste 7207 740 kk Ermeto RI 1–ED x 1/2		
						hinzufügen!		
						In Stückliste 7207 730 i Fitting Nr 92 1 ZI (Pos 3) durch		
						Fitting Nr. 92 1 – 1 1/4 ersetzen!	03.05.06	

Änderung:

15.11.06 Kühlen c korrekturen
05.12.06 Steigleder d korrekturen

Ersatz für:

HAWE HYDRAULIK | HAWE Hydraulik Streitfeldstr. 25, 81673 München | 7208 HZ IT



SK 7207 HZ. 2

HAWE Hydraulik München © 2003, page 1 of 3, (CD3 Jan. 2007)

SK 7207 HZ. 2

Part No.	Qty.	Item	Nomenclature	Drawing No.	Add. Information
3705 504700	1	1	TANK B 20 COMPL.	7207 605	with coding B 20
3705 504600	1	1	TANK B 30 COMPL.	7207 604	with coding B 30
3705 504500	1	1	TANK B 50 COMPL.	7207 606	with coding B 50
3013 410800	1	2	TAPPED PLUG COMPL.WITH ELAST.SEAL G 3/4 A		
6801 096601	1	3	MPN 44-HZ 1.6/21 COMPL.	7207 710 D	
6801 096602	1	3	MPN 44-HZ 2.4/37 COMPL.	7207 710 D	
6801 096603	1	3	MPN 44-HZ 2.4/60 COMPL.	7207 710 D	
6801 096604	1	3	MPN 44-HZ 2.4/80 COMPL.	7207 710 D	
6801 057810	1	4	SUCTION COMPONENTS MPN 4-HZ 45	7207 730 H	with Pump MPN44-HZ 1.6/21
6801 057813	1	4	SUCTION COMPONENTS MPN 4-HZ 37	7207 730 L	with Pump MPN44-HZ 2.4/37
6801 057811	1	4	SUCTION COMPONENTS MPN 4-HZ 59 + 75	7207 730 I	with Pumps MPN44-HZ 2,.4/60 and MPN44-HZ 2.4/80
3026 407500	1	5	TAPPED SECTION	7207 013	Max. torque 20 Nm
3018 600900	1	6	PRESSURE HOSE HD 600 MM		
6030 921600	1	7	GE 10-L/R 1/2-ED/O CO.ERMETO	GE10LR1/2EDOMD A3C	with Pump MPN44-HZ 1.6/21
6030 967900	1	7	GE 18-L/R 3/4-ED/O CO.ERMETO	GE18LR3/4EDOMD A3C	with Pump MPN44-HZ 2.4/37
6030 956800	1	7	GE 18-LR-ED/OMD CO.ERMETO	GE18LREDOMDA3 C	with Pumps MPN44-HZ 2.4/60 und MPN44-HZ 2.4/80
3018 600800	1	8	PRESSURE HOSE DN 8 600 MM		with Pump MPN44-HZ 1.6/21
3018 602000	1	8	PRESSURE HOSE DN 16 600 MM		with Pumps MPN44-HZ 2.4/37; MPN44-HZ 2.4/60 und MPN44-HZ 2.4/80
6045 091200	1	9	DOUBLE NIPPLE 1" X 360		
3407 441000	1	10	COVER PLATE D 20 KPL.	7207 612	
6083 020100	2	11	LOCK WASHER SHAPE A DIN 127 8		
6005 022300	2	12	SKT.-HEAD SCREW ISO 4762 8X40 8.8 A2K		Secured with liquid threadlocker !
4765 416500	1	13	SEAL	7161 050	
6800 309000	1	14	CR 4 M-WG 110	7150 000 E	
6030 923400	1	15	RI 3/4-ED X 3/8 CO.ERMETO	RI3/4EDX3/8A3C	with Pump MPN44-HZ 1.6/21
6030 967900	1	15	GE 18-L/R 3/4-ED/O CO.ERMETO	GE18LR3/4EDOMD A3C	with Pumps MPN44-HZ 2.4/37; MPN44-HZ 2.4/60 und MPN44-HZ 2.4/80
6031 642600	1	16	SV 8-S/OMD CO.ERMETO	SV08SOMDA3C	Nut of the fitting secured with liquid threadlocker !
6130 310200	1	16.1	DPR 8-L/S CUTTING EDGE RING CO.ERMETO		
6066 120100	1	16.2	M 8-S SLEEVE NUT A 3 C (YELLO CO.ERM		
3004 448800	4	17	GROMMET	7207 010	

SK 7207 HZ. 2

Part No.	Qty.	Item	Nomenclature	Drawing No.	Add. Information
3004 452400	4	18	SLEEVE	7207 008	Observe mounting, see detail "Y"
6075 050100	4	19	WASHER DIN 9021 - 10.5		
6005 034700	4	20	HEX.HEAD SCREW ISO 4014-M10 x 170-8.8-A2K		with Pumps MPN44-HZ 1.6/21; MPN44-HZ 2.4/37 und MPN44-HZ 2.4/60
6000 323100	4	20	HEX.HEAD SCREW ISO 4014-M10 x 140-8.8-A2K		with Pump MPN44-HZ 2.4/80
6083 910100	8	21	LOCK WASHER CO.DUBO M 6 PART NO. 404		
6084 410100	8	22	SCREW LOCK CO.DUBO M 6 PART NO. 301 NYLON		
6005 017100	8	23	SKT.-HEAD SCREW ISO 4762 6X25 8.8 A2K		
4708 476800	1	24	TYPE PLATE, BLANK	7207 050	Blank !
6140 311200	2	25	GROOVED DRIVE STUD ISO 8746 4x6-ST -A2K		
6030 951600	1	26	GE 8-SR-ED/OMD CO.ERMETO	GE08SREDOMDA3 C	
6130 310200	1	26.1	DPR 8-L/S CUTTING EDGE RING CO.ERMETO		
6066 120100	1	26.2	M 8-S SLEEVE NUT A 3 C (YELLO CO.ERM		
3018 451000	1	27	PRESSURE PIPE	7207 983	
6285 550500	1	28	BREATHER WITH DIPSTICK	7207 126	
6801 055801	1	29	TERMINAL BOX MPN 4	7207 752 A	Complete
6065 730300	2	30	HEXAGON NUT SHAPE B DIN 439 12 04 A2K		
6016 120400	2	31	EYE BOLT ISO 3266-M12-A2K		

15.6 Electrical diagrams

FEATURES OF MACHINE

SERIAL NUMBER	
DRIVE VOLTAGE	110ac-24dc V
LINE VOLTAGE	+/- 5% 400 V
FREQUENCY	50 HZ
PHASES	3+PE
MAXIMUM POWER	11.5 KW
FULL LOAD CURRENT	20 A
INPUT CABLE SECTION	16 mmq

NOTES

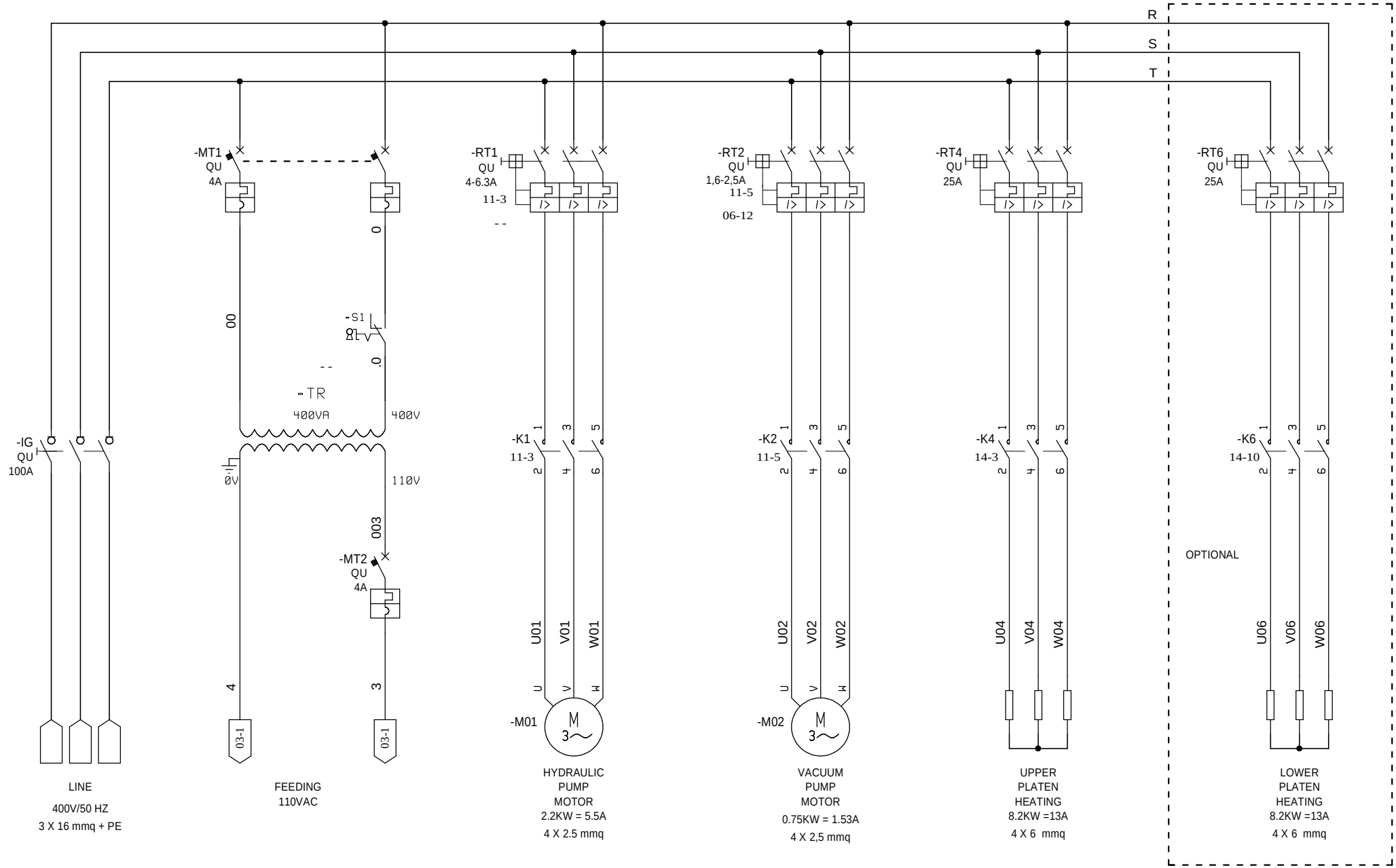
MODIFICATION	PAGE	DATE

ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 01

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

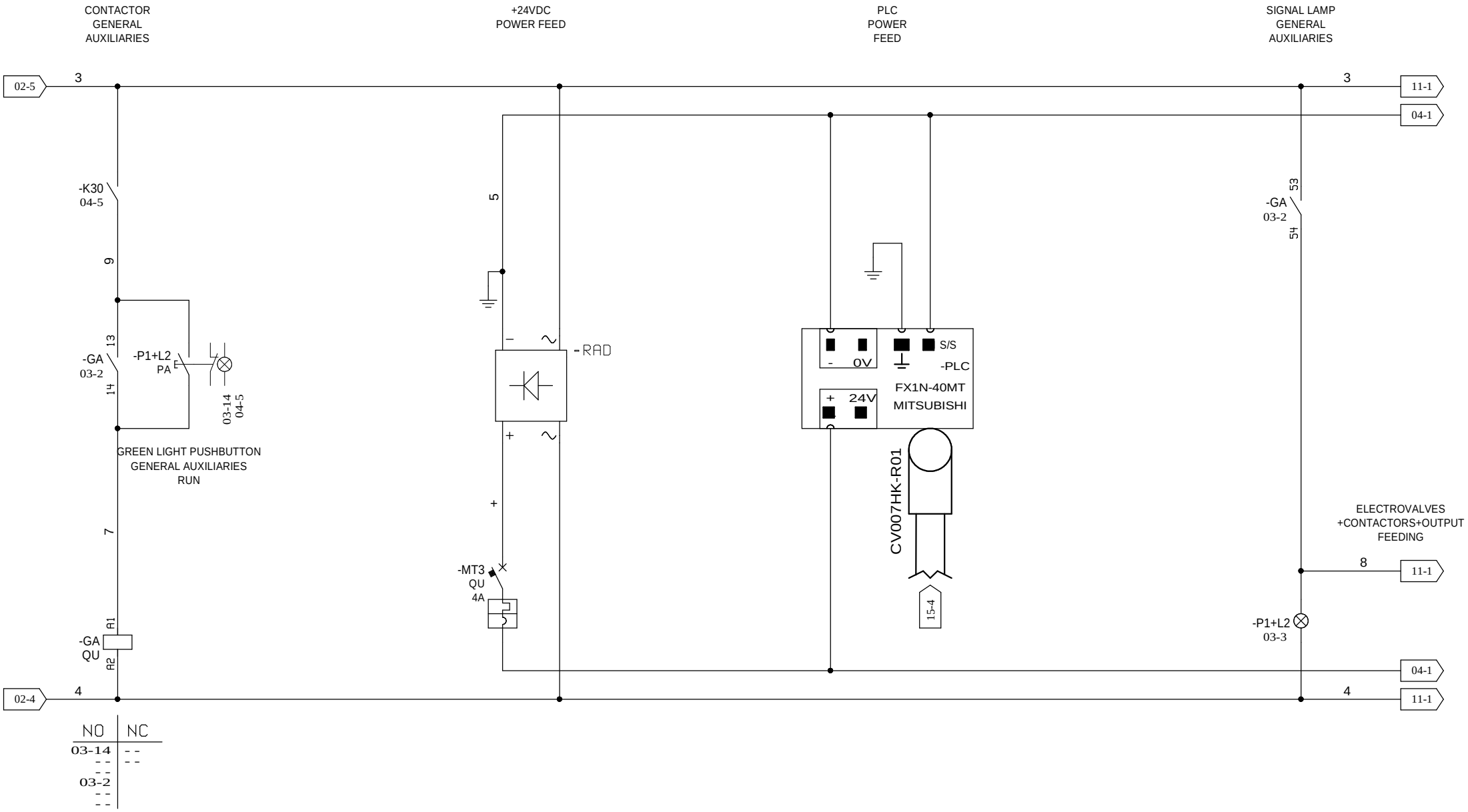


ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE
			DESIGNER GERACE
	DRAW 4289E	DATE 09.10.2008	PAGE 02

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

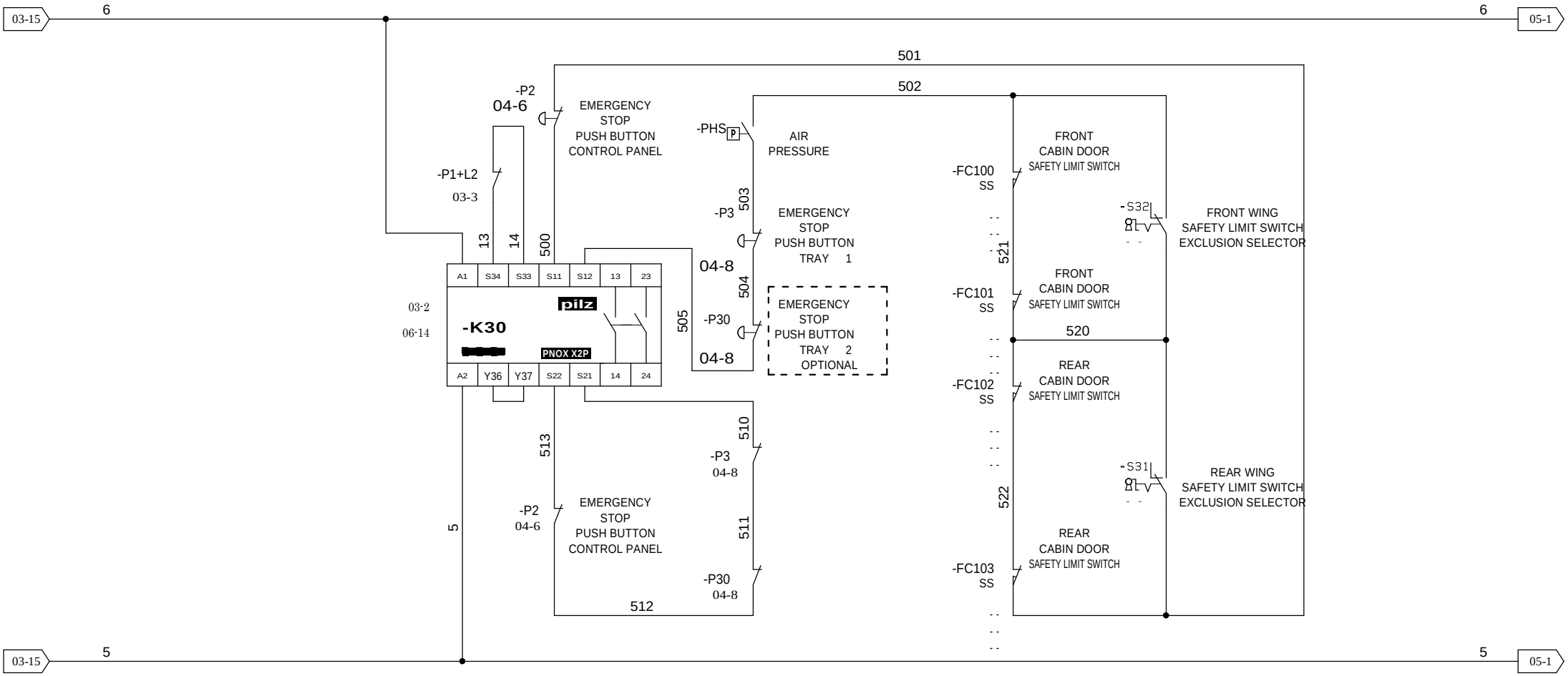


ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 03

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

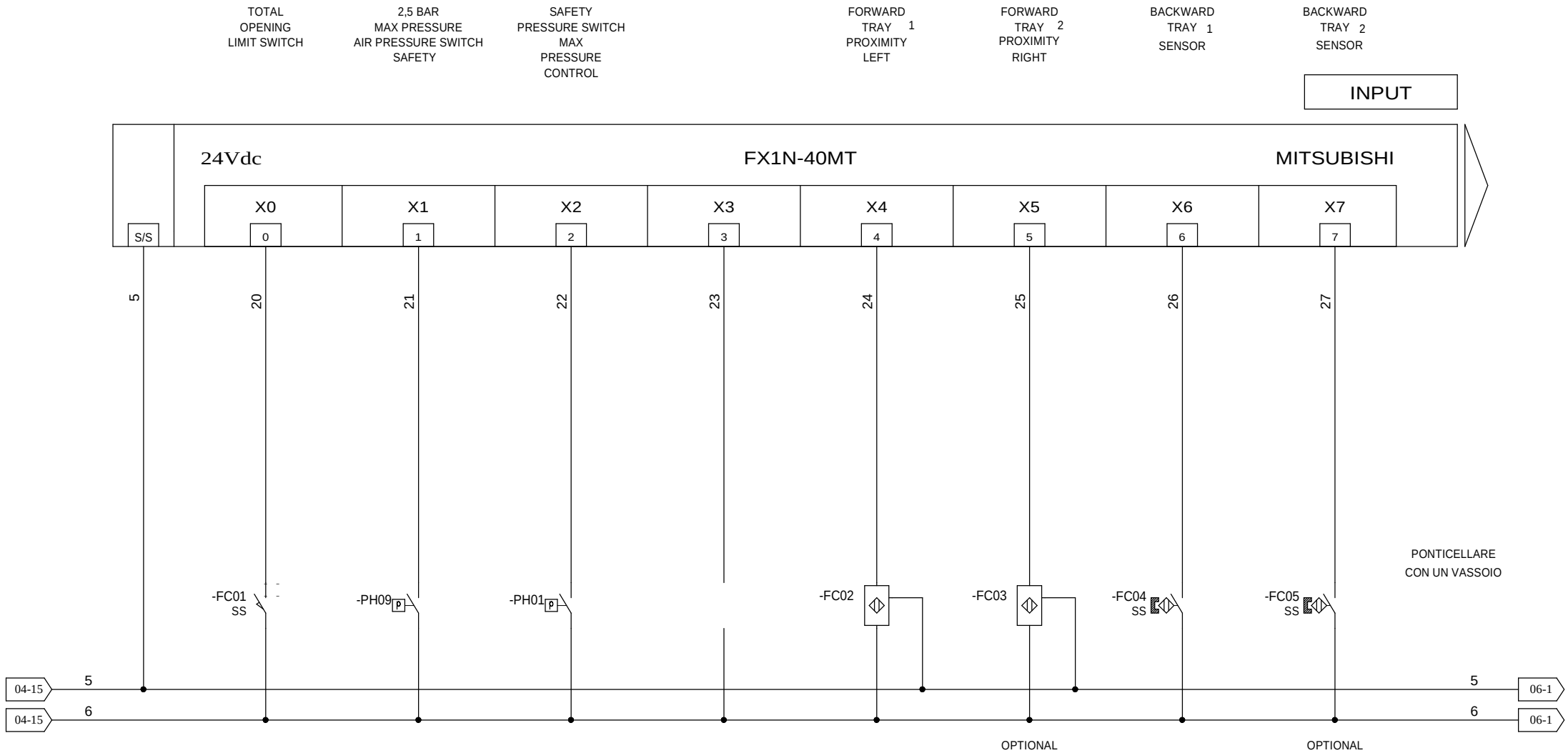


ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 04

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

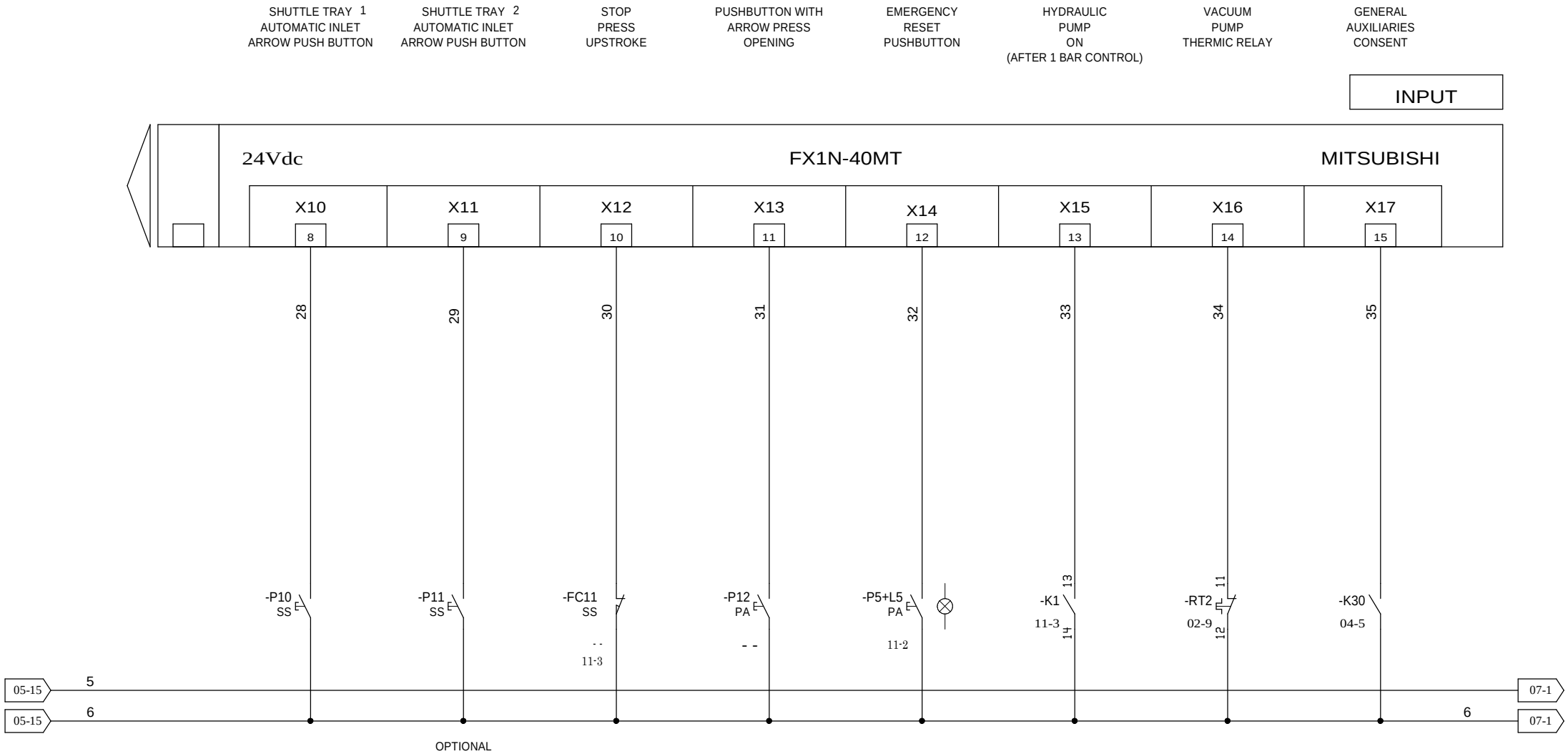


ITALPRESSE
FABBRICA MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE
			DESIGNER GERACE
	DRAW 4289E	DATE 09.10.2008	PAGE 05

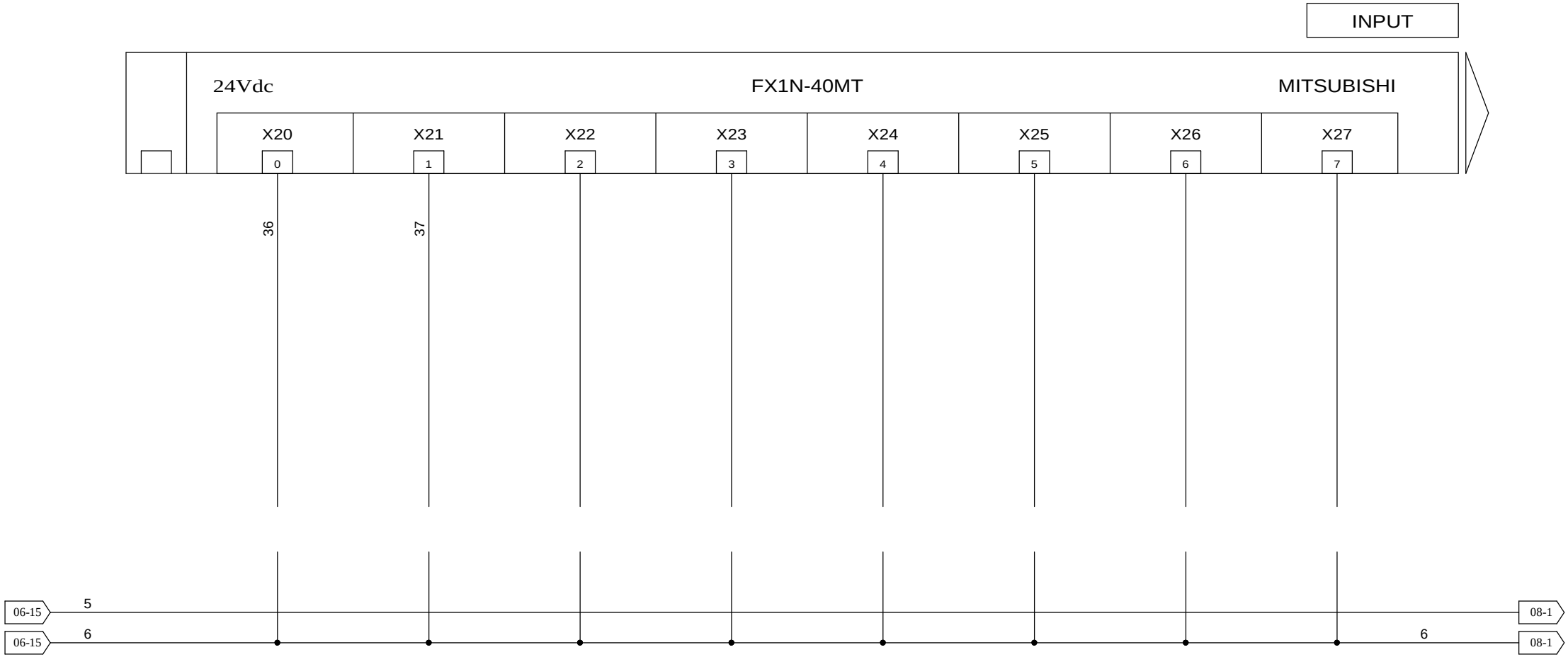
Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization



ITALPRESSE
FABBRICA MACCHINE PER LEGNO
24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 06

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

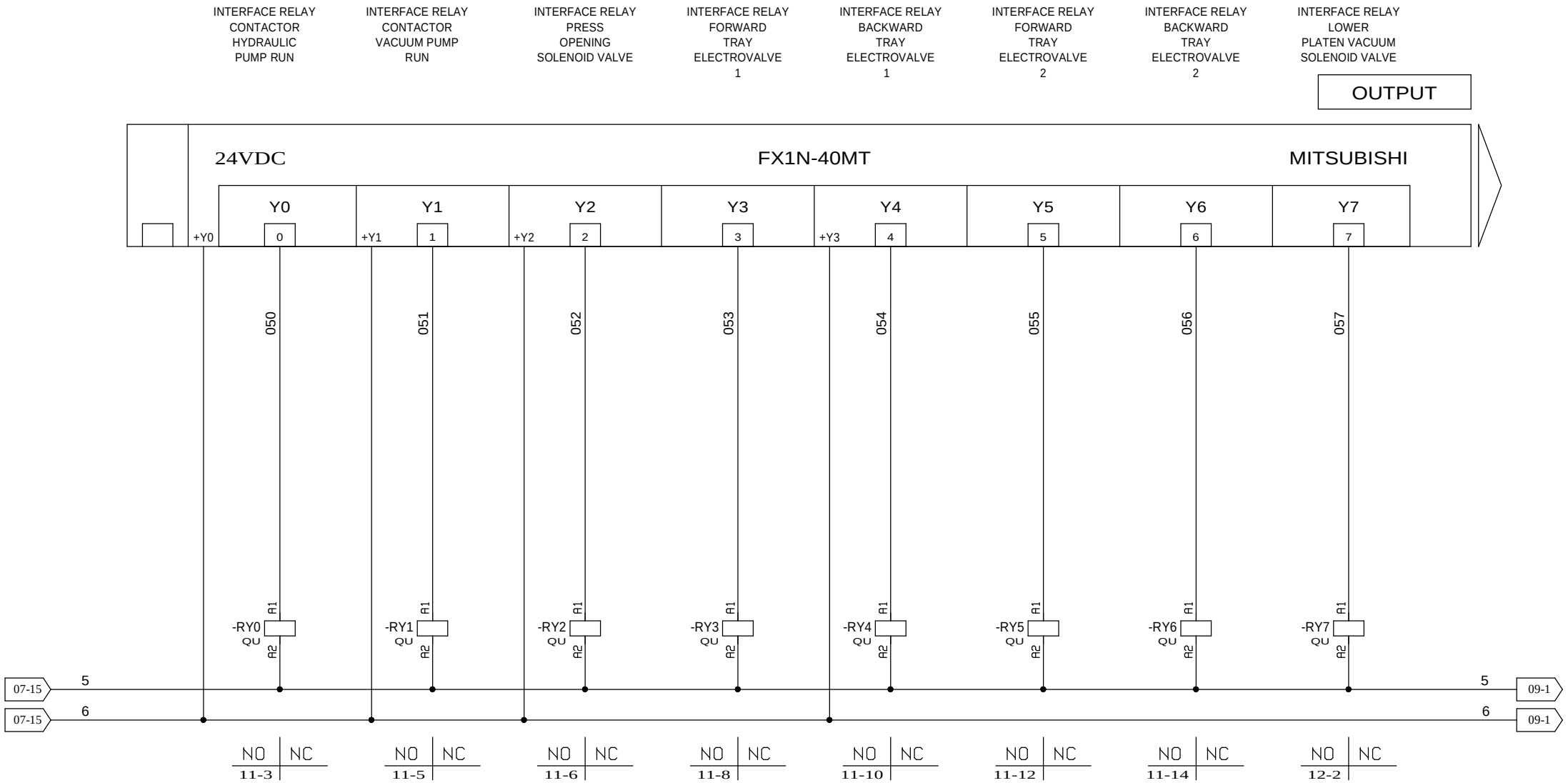


ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 07

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

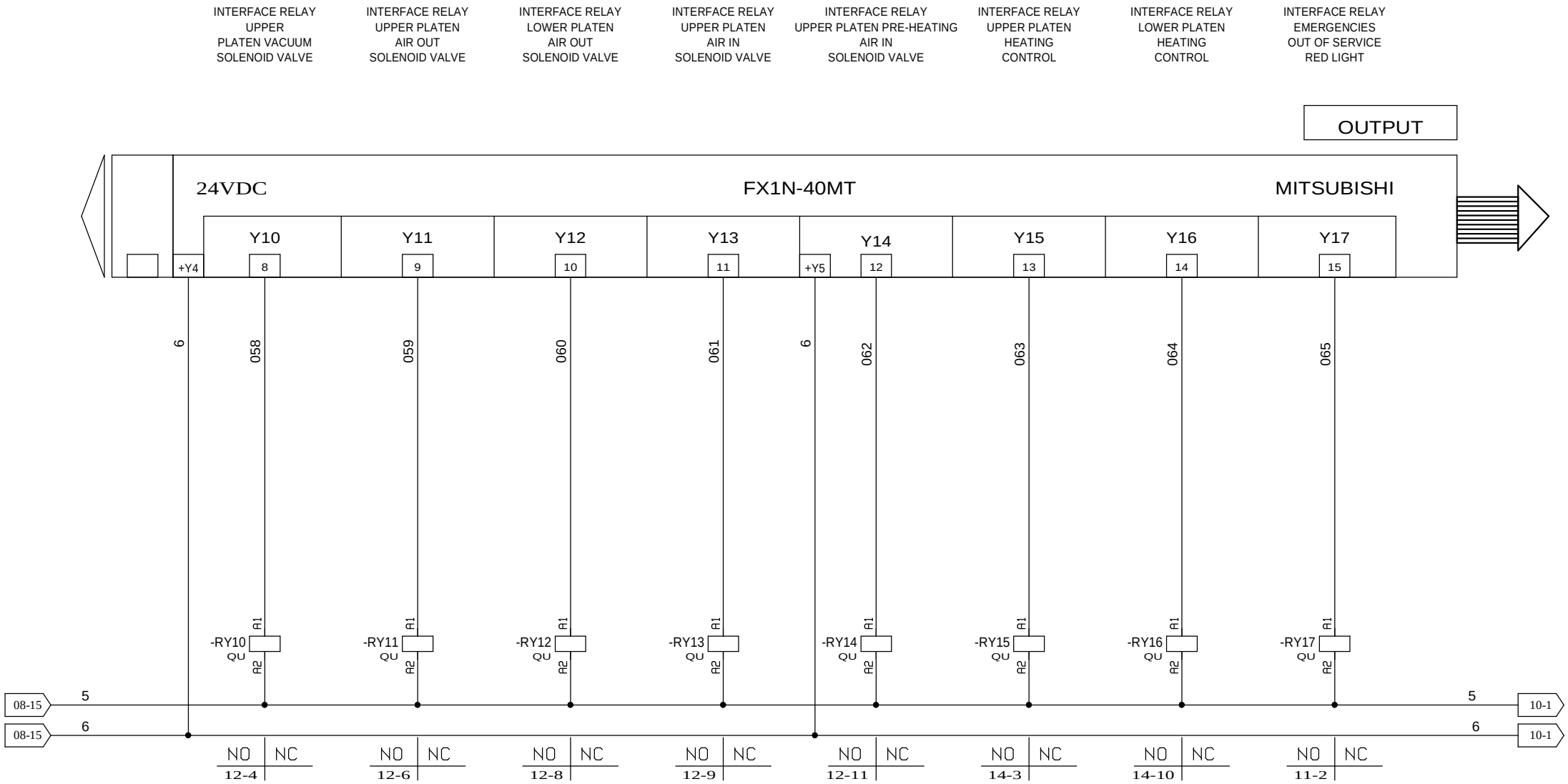


ITALPRESSE
FABBRICA MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 08

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

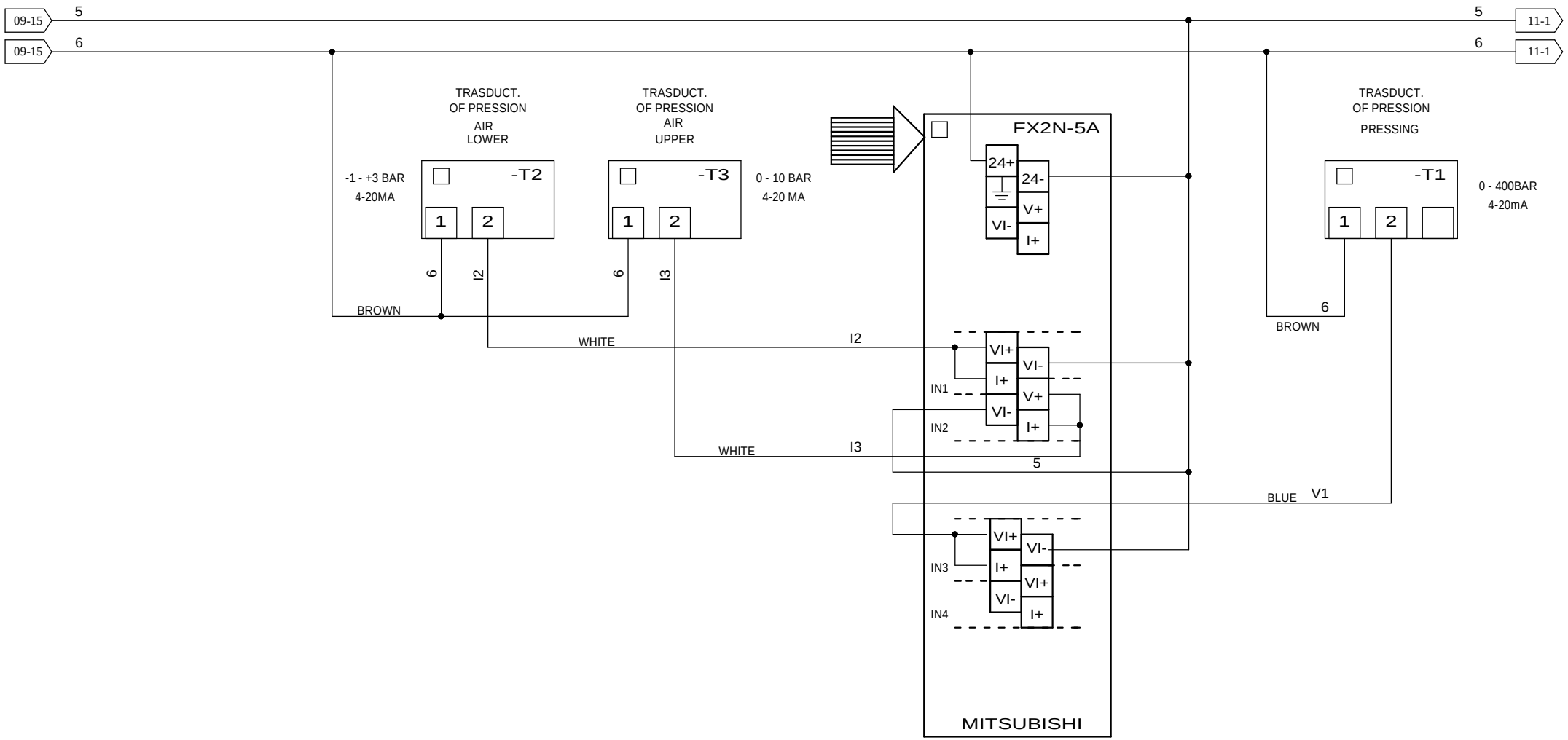


ITALPRESSE
FABBRICA MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE
			DESIGNER GERACE
	DRAW 4289E	DATE 09.10.2008	PAGE 09

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

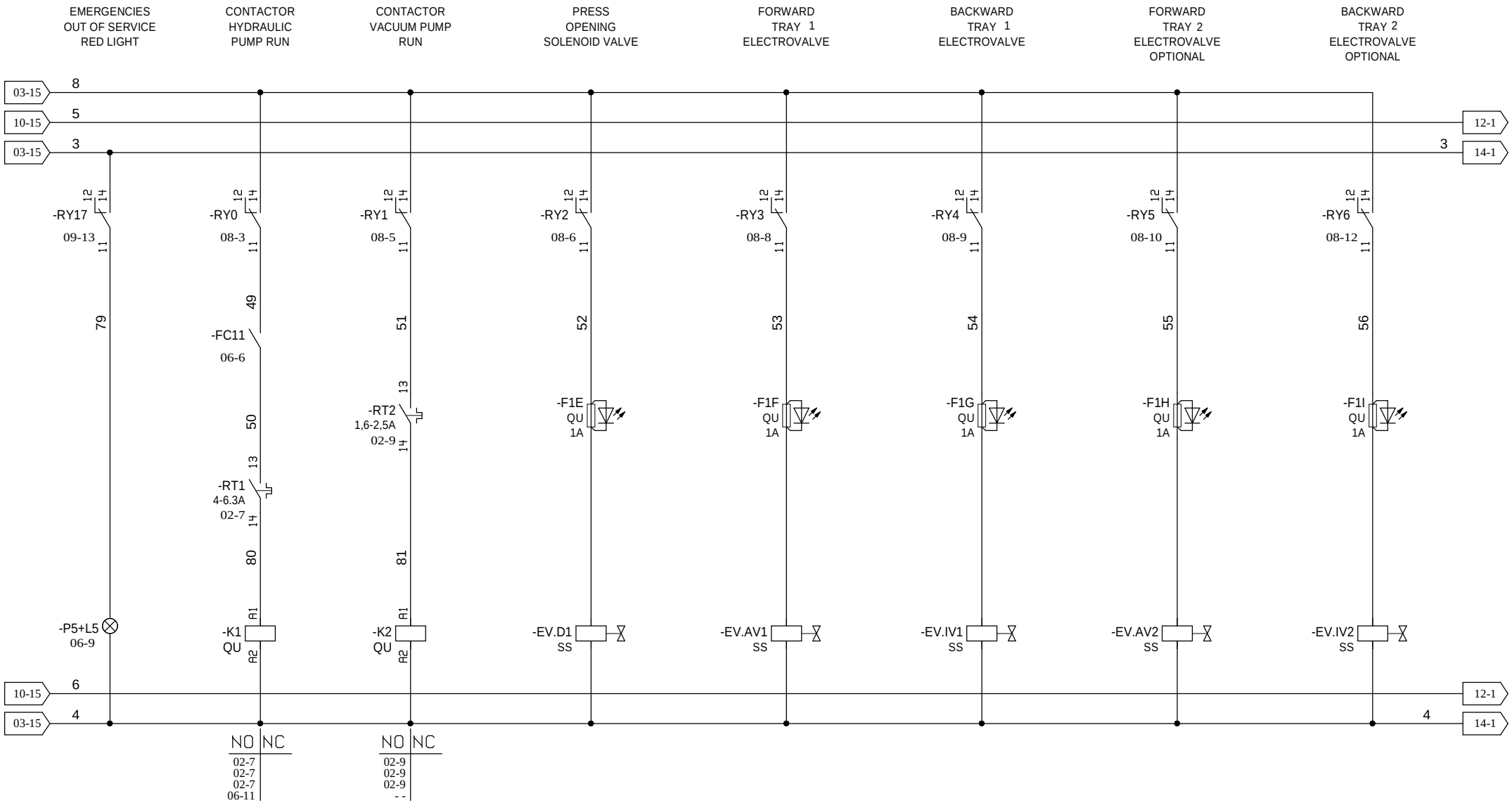


ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 10

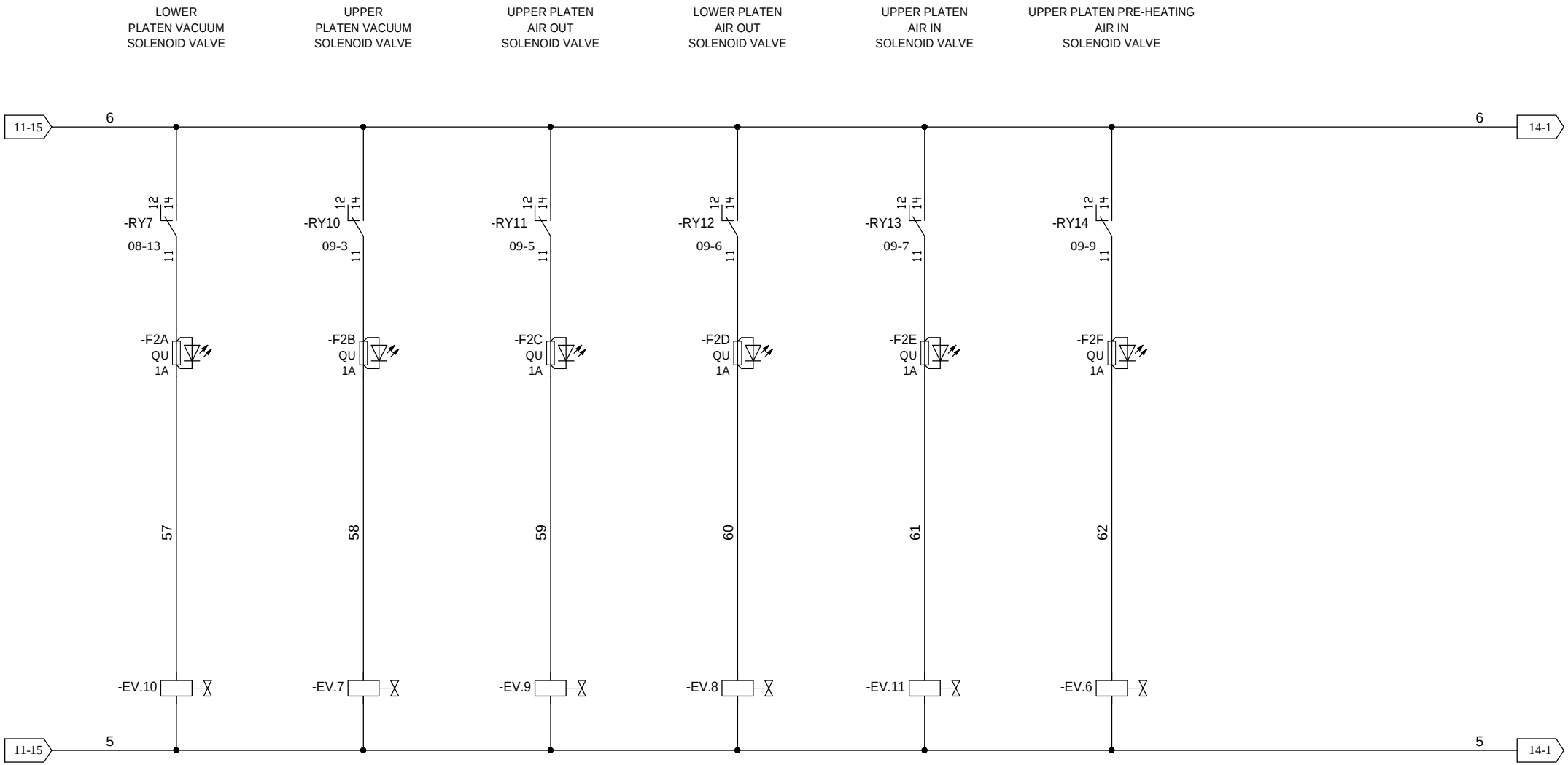
Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization



ITALPRESSE
FABBRICA MACCHINE PER LEGNO
24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE
			DESIGNER GERACE
	DRAW 4289E	DATE 09.10.2008	PAGE 11

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization



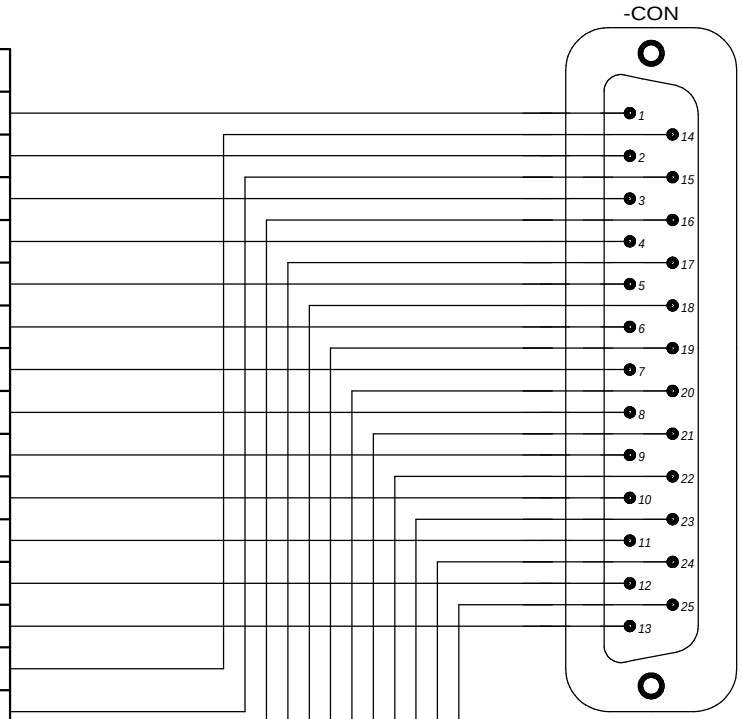
ITALPRESSE
FABBRICA MACCHINE PER LEGNO
24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE
			DESIGNER GERACE
	DRAW 4289E	DATE 09.10.2008	PAGE 12

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

ELECTRIC CONNECTIONS SCHEME CONTACTOR TSCF520

N. CONTACT	COIL N.	LOGO	N. CABLE	OPERATOR	STATION	N. CABLE	COLOR
1	1	EV.9	1	14	1	59	WHITE
2	2	EV.11	2	14	2	61	BROWN
3	3	EV.10	3	14	3	57	GREEN
4	4	EV.8	4	14	4	60	YELLOW
5	5	EV.6	5	14	5	62	GREY
6	6	EV.7	6	14	6	58	PINK
7	7		7	14	7		BLUE
8	8		8	14	8		RED
9	9		9	14	9		BLACK
10	10		10	14	10		VIOLET
11	11		11	14	11		GREY - PINK
12	12		12	14	12		RED - BLUE
13	COMUNE OV		13			5	WHITE - GREEN
14	1		14	12	1		BROWN - GREEN
15	2		15	12	2		WHITE - YELLOW
16	3		16	12	3		YELLOW - BROWN
17	4		17	12	4		WHITE - GREY
18	5		18	12	5		GREY - BROWN
19	6		19	12	6		WHITE - PINK
20	7		20	12	7		PINK - BROWN
21	8		21	12	8		WHITE - BLUE
22	9		22	12	9		BROWN - BLUE
23	10		23	12	10		WHITE - RED
24	11		24	12	11		BROWN - RED
25	12		25	12	12		WHITE - BLACK

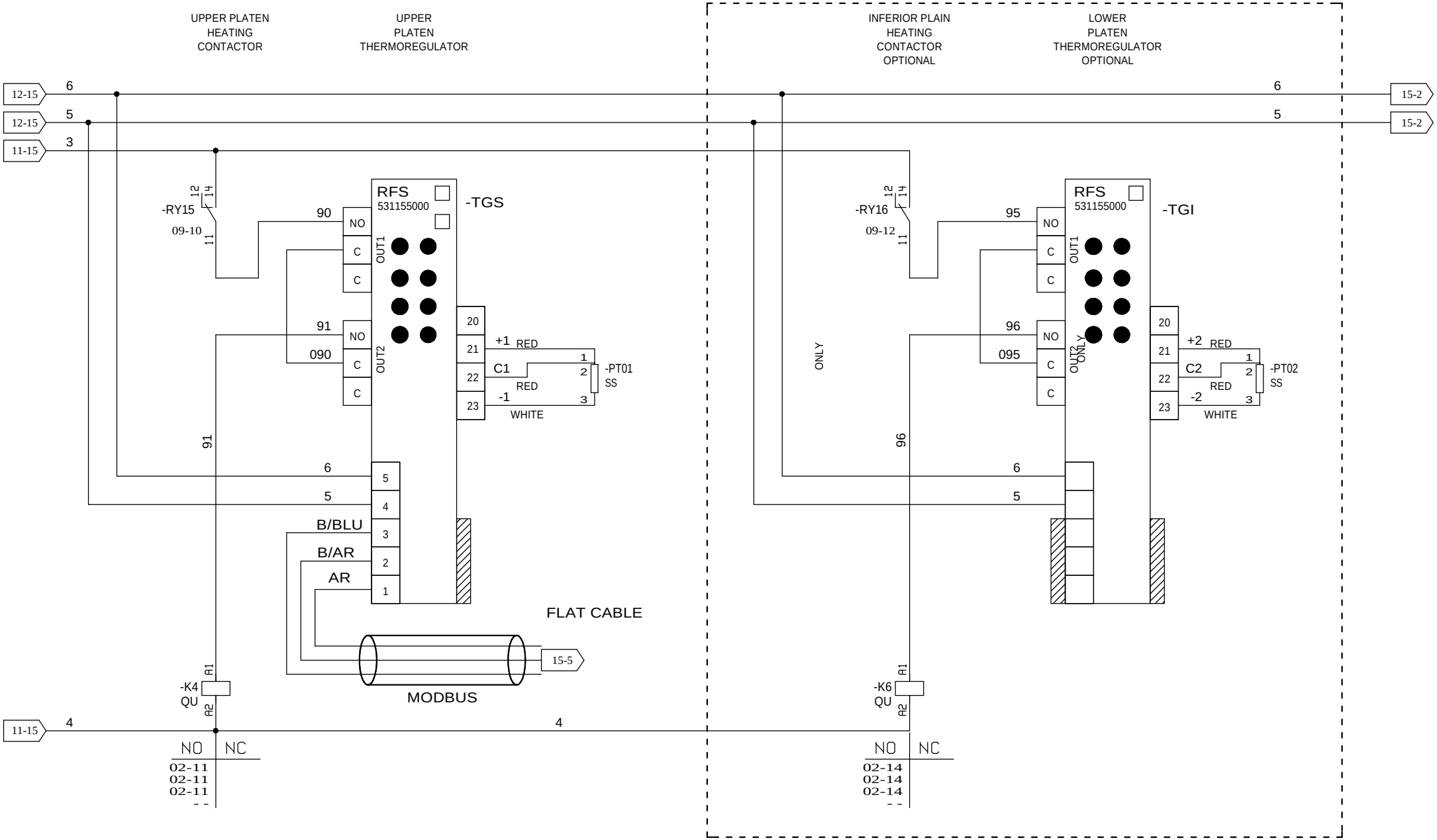


ITALPRESSE
FABBRICA MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 13

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

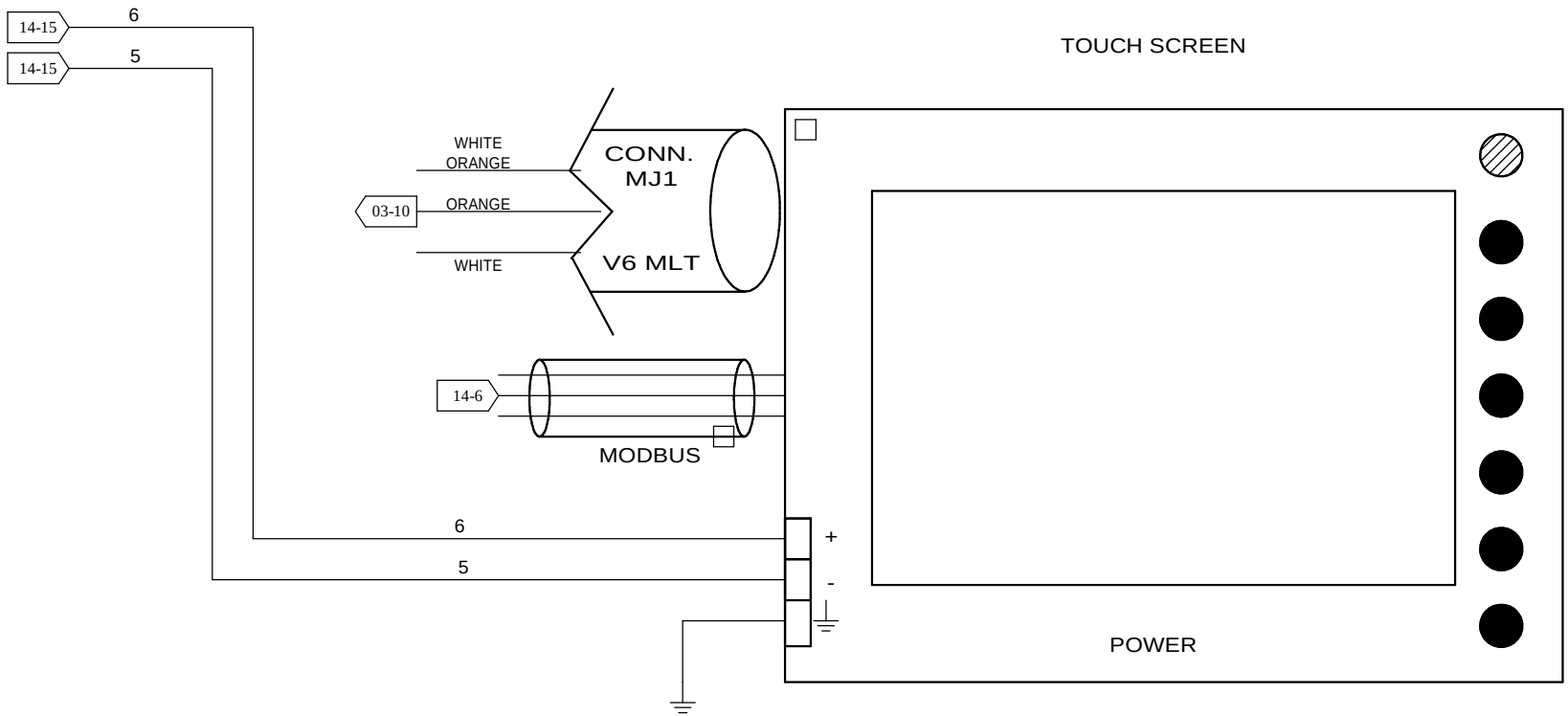


ITALPRESSE
FABBRICA MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 14

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

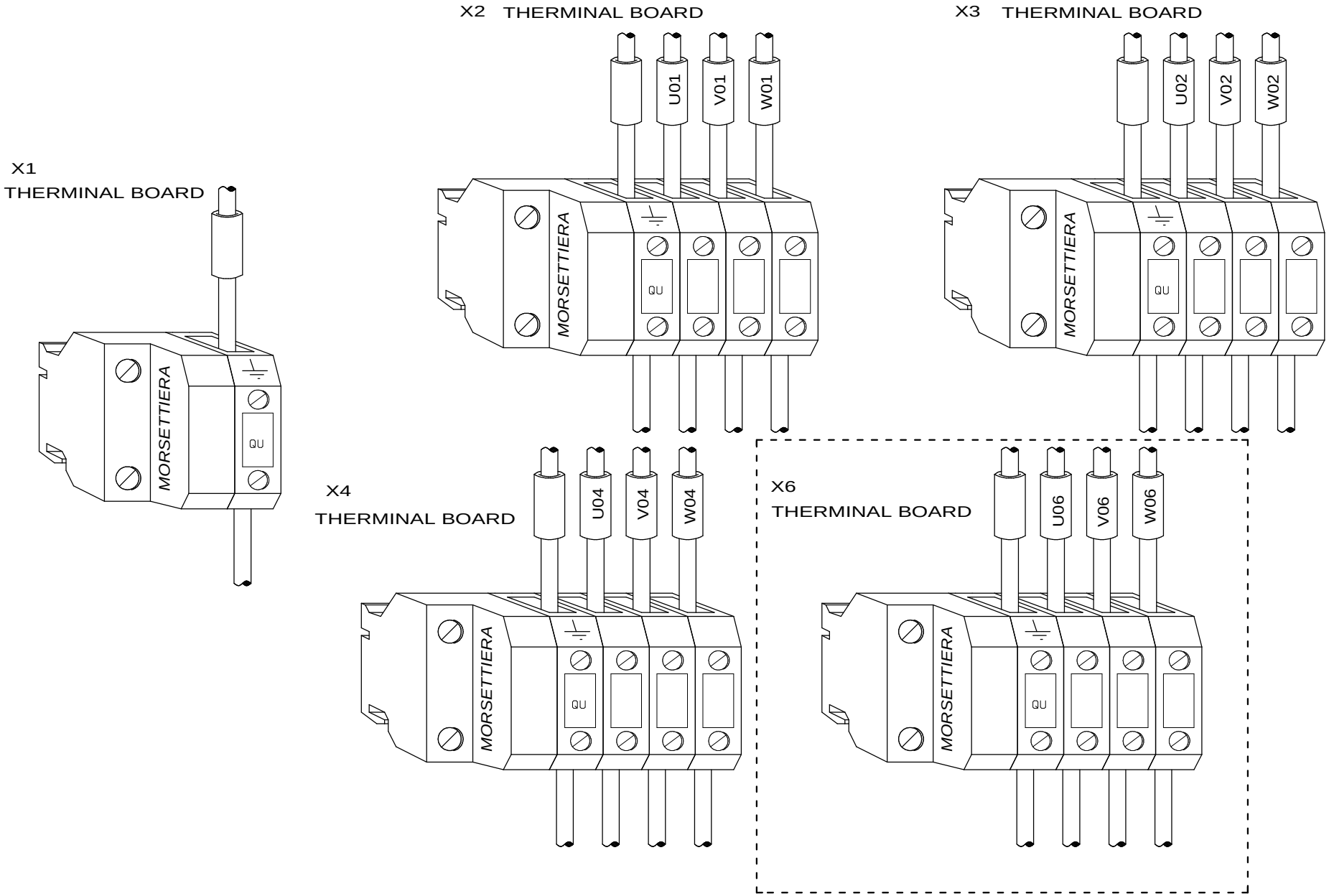


ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE	ESTREMA/S	P22995		PLANNER GERACE
				DESIGNER GERACE
		DRAW 4289E	DATE 09.10.2008	PAGE 15

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization



ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 16

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

X7

	13	14	20	21	22	23	24	25	26	27	28	29	30	31	32	33	49	50	79
⏚	0	0	3	3	4	4	5	5	6	6	6	6	6	7	7	8	8	9	
			□																

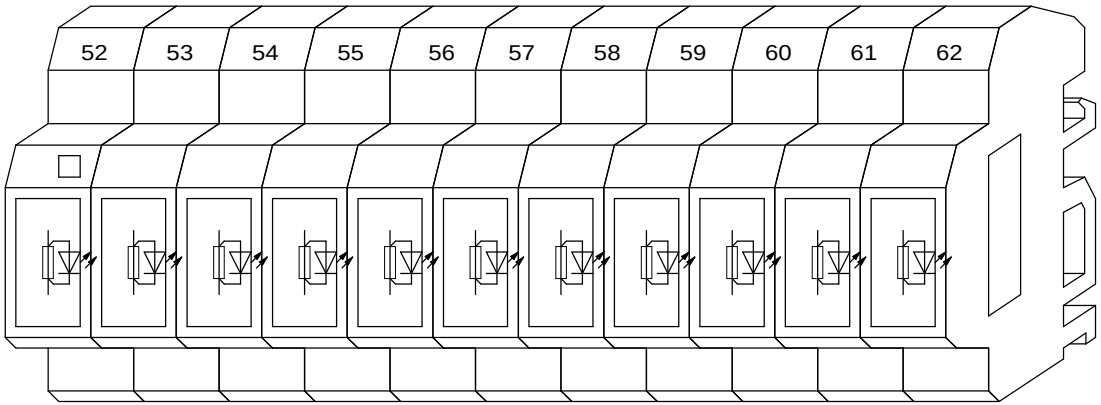
PRESS + TRAY

X8

	510	511	511	512	512	513		520	520	521	521	522	522
⏚	500	501	501	502	502	503	503	504	504	505			
		□											

GATES + EMERGENCY

X9



ELECTROVALVES

ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

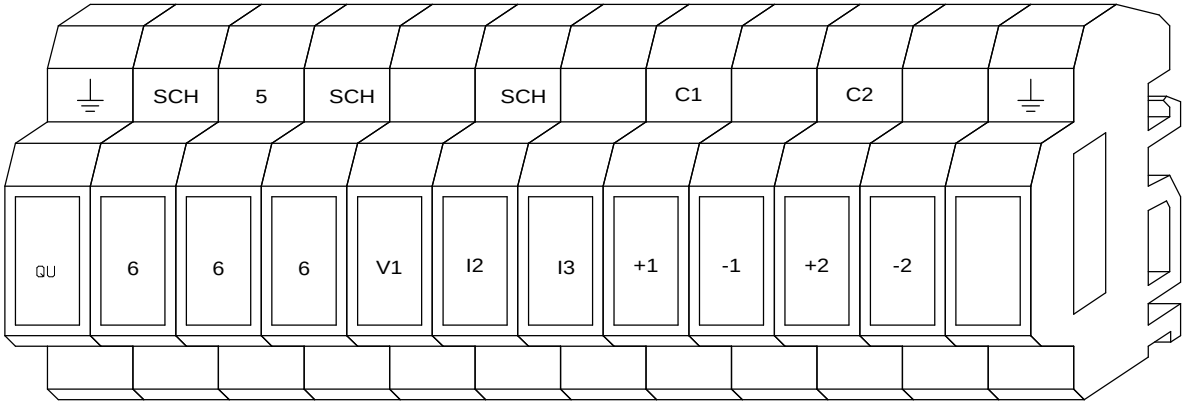
24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 17

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

PANEL LINE
25x1 MT 6

X12 THERMINAL BOARD



1 - - - 0
2 - - - 0
3 - - - 3
4 - - - 4
5 - - - 5
6 - - - 6
7 - - - 7
8 - - - 8
9 - - - 9
10 - - - 13
11 - - - 14
12 - - - 17
13 - - - 18
14 - - - 19
15 - - -
16 - - - 31
17 - - - 32
18 - - -
19 - - - 79
20 - - -
21 - - - 500
22 - - - 501
23 - - - 510
24 - - - 511

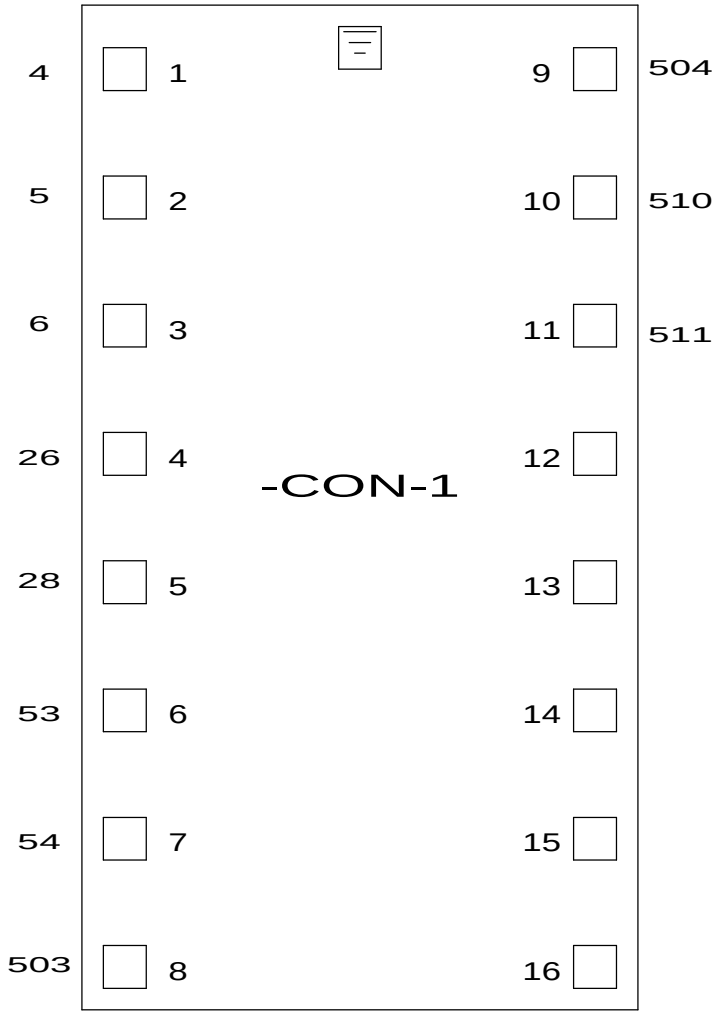
ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

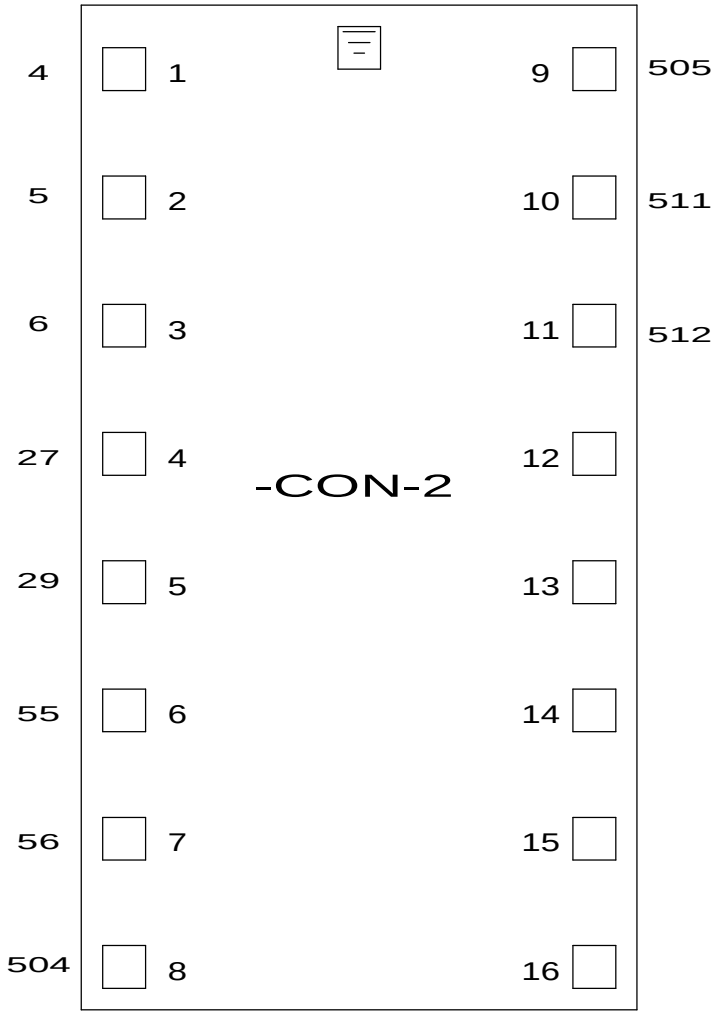
24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 18

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

CONNECTOR





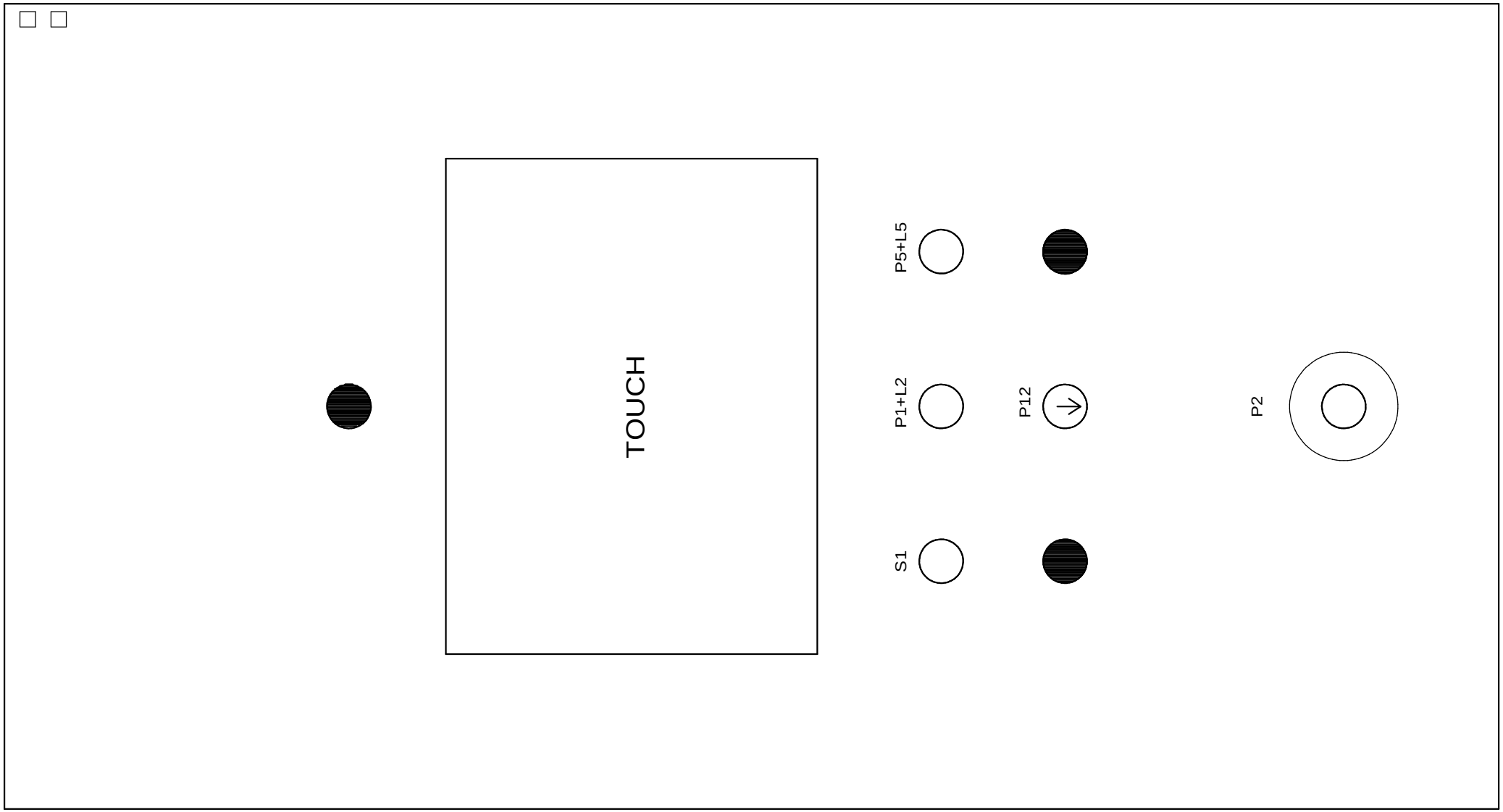
ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 19

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

CONTROL PANEL



ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 20

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

PANEL

LOGO	DESCRIPTION
S1	KEY SELECTOR TENSION OFF-ON
P1+L2	GREEN LIGHT PUSHBUTTON GENERAL AUXILIARIES RUN
P5+L5	RED LIGHT PUSHBUTTON EMERGENCY RESET
P12	PUSHBUTTON WITH ARROW PRESS OPENING
TOUCH	CONTROL UNIT
P3	RED MUSHROOM PUSHBUTTON MACHINE EMERGENZE

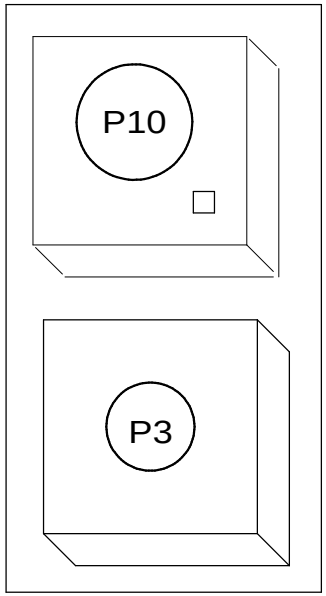
ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

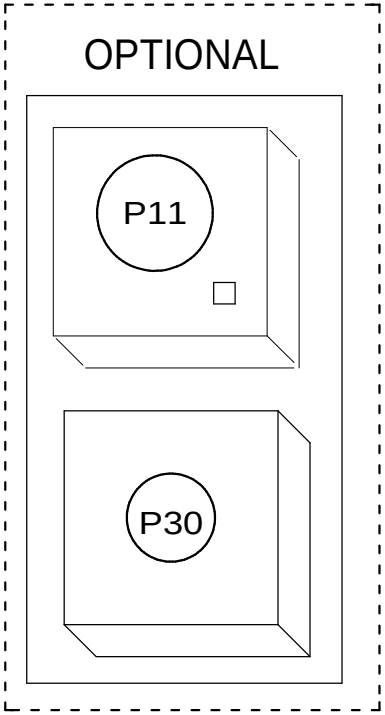
24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

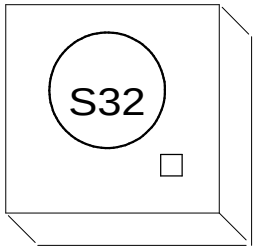
TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 22

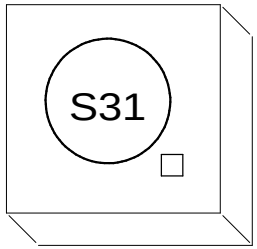
Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

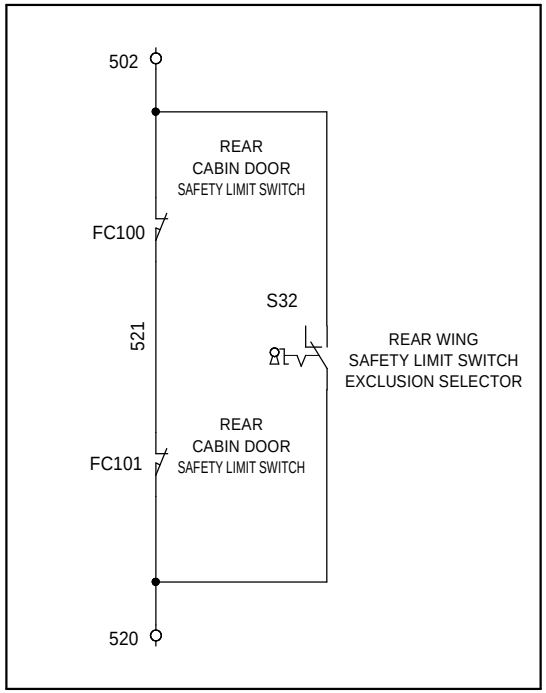
MACHINE BORDER CONTROL BOARD

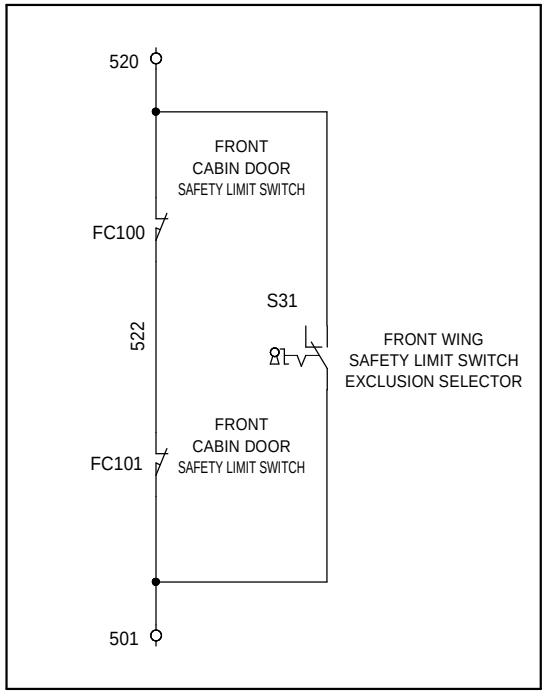












P30	EMERGENCY STOP PUSH BUTTON 2
P11	SHUTTLE TRAY AUTOMATIC INLET BLACK PUSHBUTTON 2

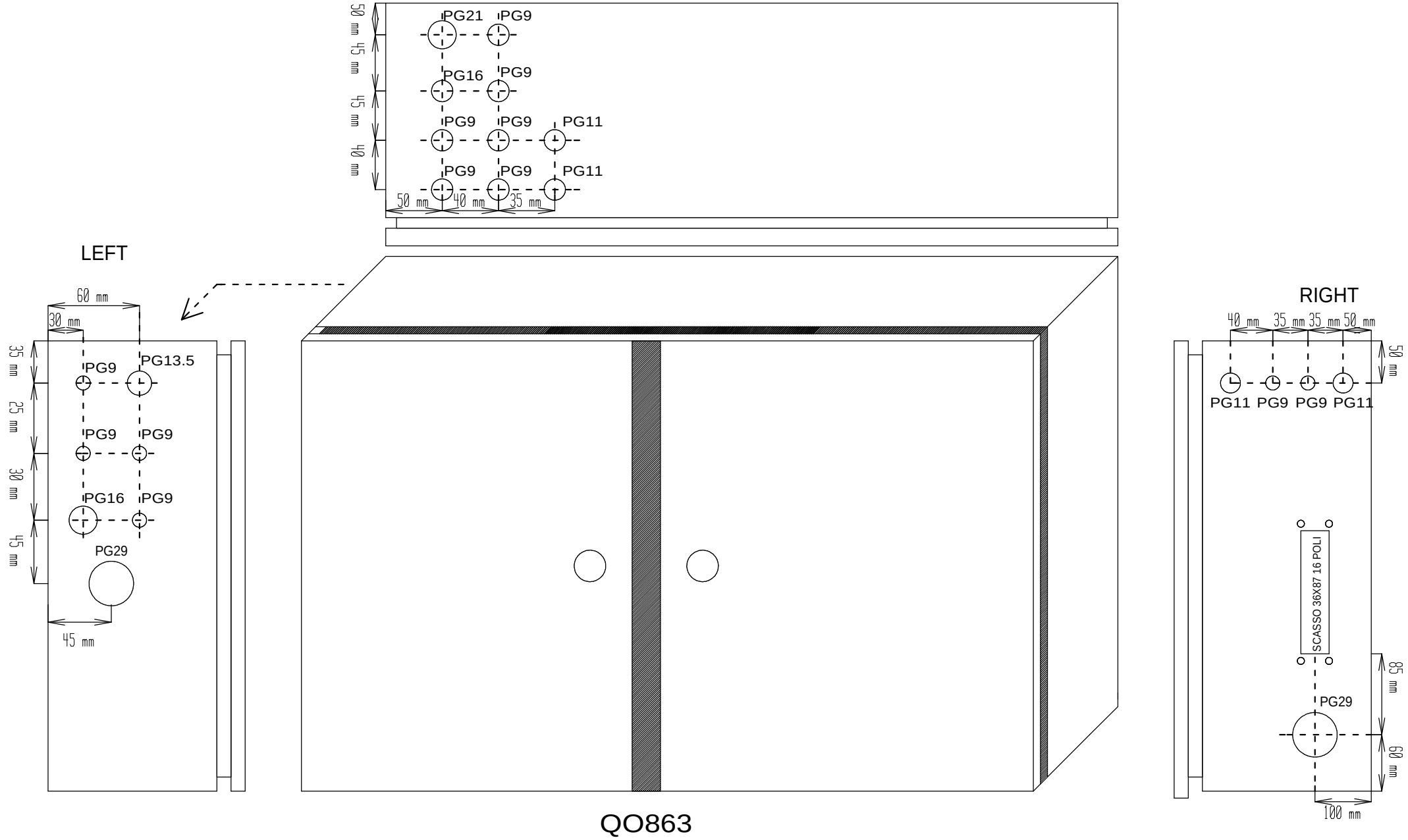
P3	EMERGENCY STOP PUSH BUTTON SHUTTLE TRAY 1
P10	AUTOMATIC INLET BLACK PUSHBUTTON 1

ITALPRESSE
FABBRICA MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 23

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization



QO863

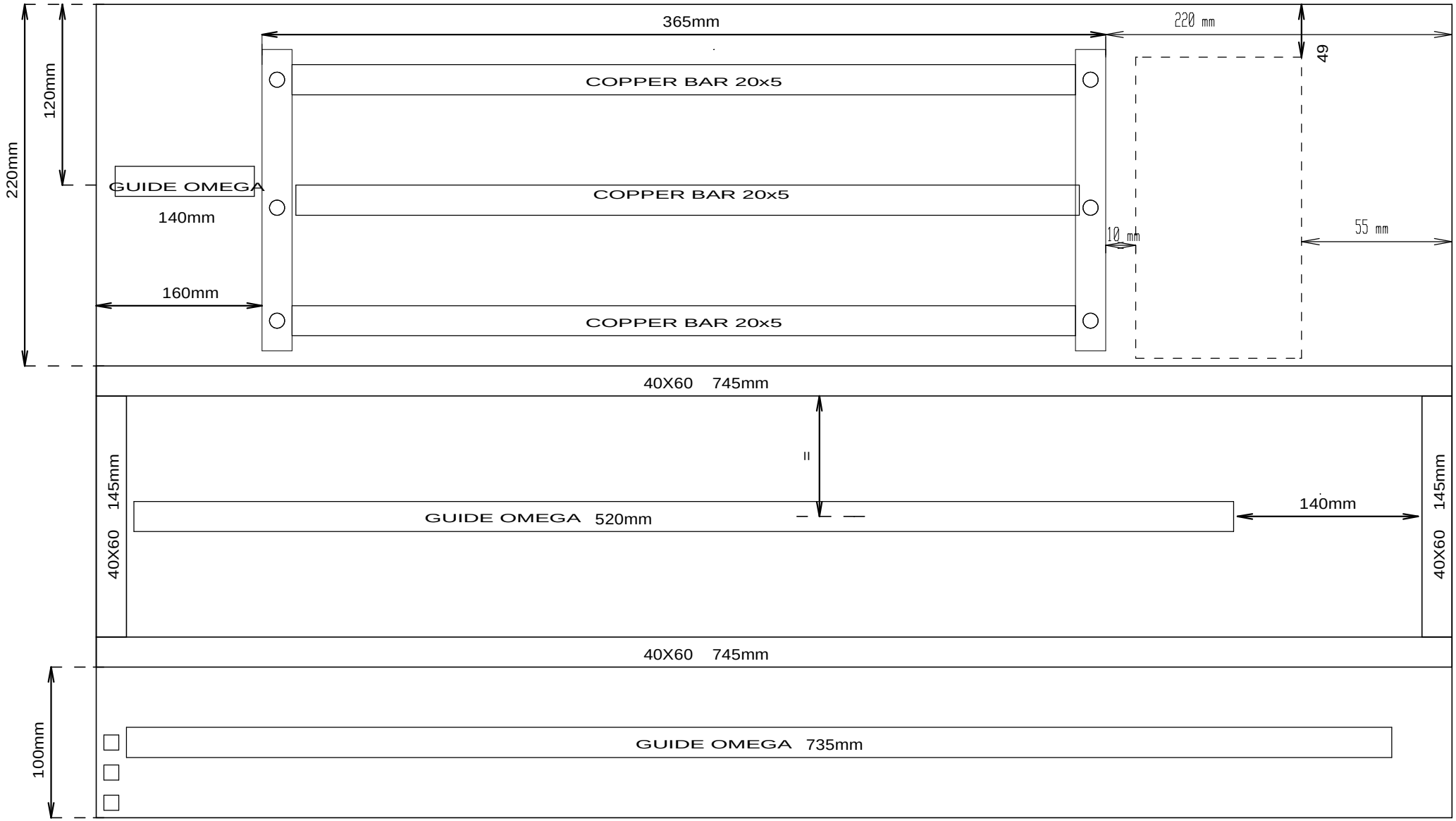
ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 24

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

ELECTRIC-BOARD



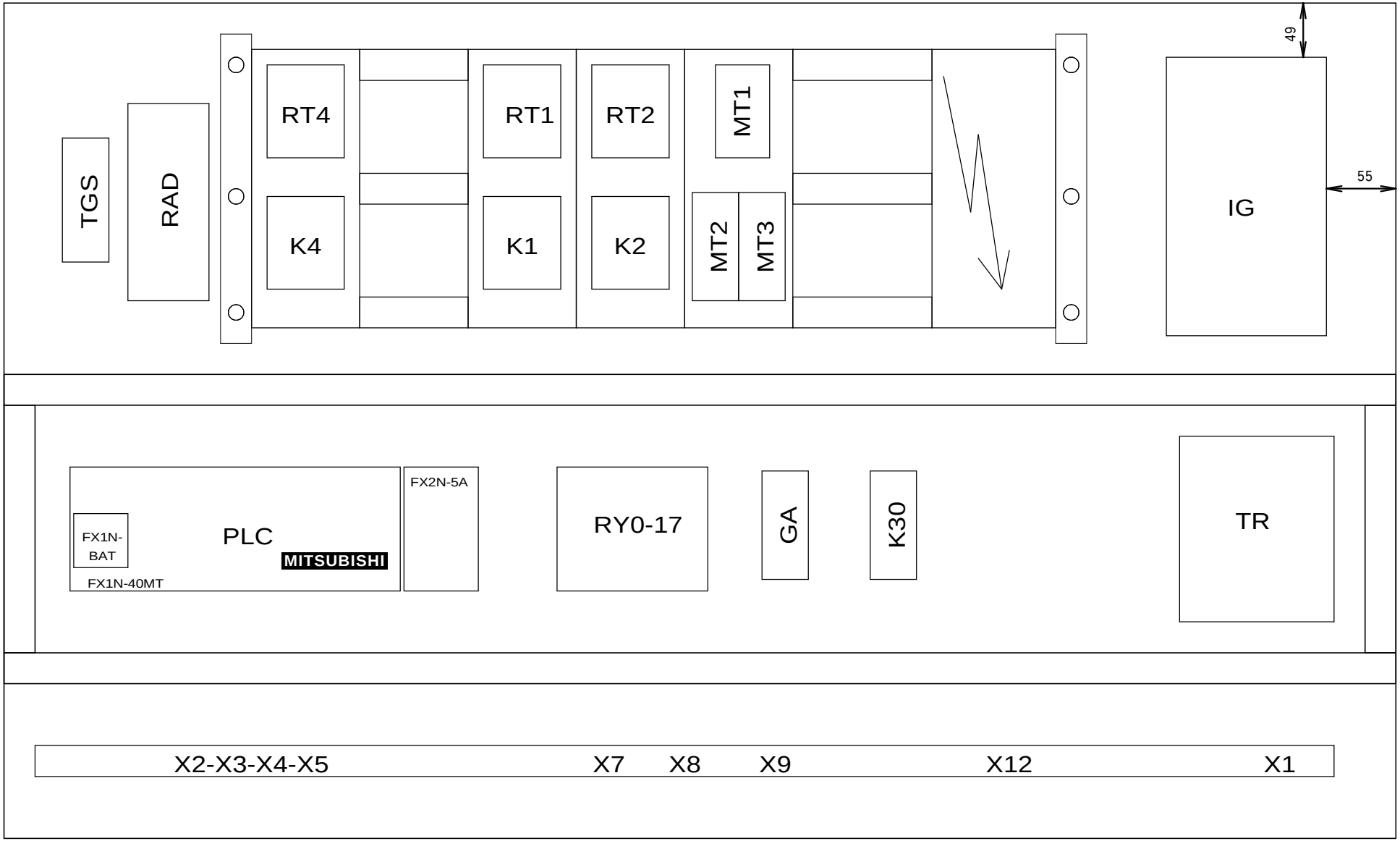
ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 25

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

ELECTRIC-BOARD



ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 26

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

CABLES LIST

1	4x2,5 3000mm M01(U01-V01-W01)	☐	12	3X0.5 SCH 3000mm T1 (5-6-V1)	☐
2	4x2,5 4500mm M02 (U02-V02-W02)	☐	13	5x1 2500mm FC11(6-30-49-50)	☐
3	4x4 SILICON 3500mm UPPER RESISTANCE (U03-V03-W03)	☐	14	5x1 2500mm FC2-FC3(5-6-24-25)	☐
4	25x1 5500mm CONTROL PANEL	☐	15	3x1 4000mm PORTE ANTERIORI(501-520)	☐
5	3x1 2500mm FC1(6-20)	☐	16	3x1 9000mm PORTE POSTERIORI(520-502)	☐
6	3x1 3000mm PH01(6-22)	☐		NORGREEN AIR SOLENOID VALVE	
7	3x1 4000mm PHS (502-503) 9VC	☐			
8	3x1 5000mm PH09(6-21)	☐			
9	CABLE				
10	3X0.5 SCH 5000mm T2 (6-I2)	☐			
11	3X0.5 SCH 5000mm T3 (6-I3) SIM 170	☐		GUAINE - SCATOLE	☐

ITALPRESSE
FABBRICA MACCHINE PER LEGNO
24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 27

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

Listato materiale

Pag.	Sigla	Codice	Descrizione 1	Descrizione 2	Descrizione 3	Quantità	Ubicazione
002	-S1	1003470280	SELETTORE A CHIAVE XB4-BG21	(EX.XB2-BG21)	(EX.XB2-BG21)	31	PA
003	-P1+L2	1002060083	BASE DI FISSAGGIO ZB4-BZ009 PER	PULSANTERIA TELEMECANIQUE			PA
003	-P1+L2	1005100240	ELEMENTO DI CONTATTO ZBE 101 (NO)	PULSANTERIA TELEMECANIQUE			PA
003	-P1+L2	1005100280	ELEMENTO DI CONTATTO ZBE 102 (NC)	(EX ZB2-BE102)	(EX ZB2-BE102)		PA
003	-P1+L2	1005100312	ELEMENTO LUMINOSO LED 110V VERDE	ZBV-G3 PER PULSANTERIA	(EX ZB2-BE102)		PA
003	-P1+L2	1014842041	TESTA PULSANTE LUMIN. VERDE	ZB4-BW333	(EX.ZB2-BW33)		PA
004	-P2	1002110015	BLOCCO CONTATTI (NC) M22-AK01	216503	(EX.BK-01) - MOELLER -		PA
004	-P2	1002110020	BLOCCO CONTATTI NC M22-K01	ART. 216378	(EX.EK01) - MOELLER		PA
004	-P2	1014842115	PULSANTE A FUNGO ROSSO EMERGENZA	M22-PV ART.216876 - MOELLER -	(EX RPV)		PA
004	-P2	1018094375	TARGHETTA PER PULSANTE EMERGENZA	NEUTRA GIALLA M22-XAK- ART.216464	(EX.1AK) MOELLER		PA
006	-P12	1002060083	BASE DI FISSAGGIO ZB4-BZ009 PER	PULSANTERIA TELEMECANIQUE			PA
006	-P12	1005100240	ELEMENTO DI CONTATTO ZBE 101 (NO)	PULSANTERIA TELEMECANIQUE			PA
006	-P12	1014841760	PULSANTE FRECCIA ZB4-BA335	(EX.ZB2BA335)	(EX.ZB2BA335)		PA
006	-P5+L5	1002060083	BASE DI FISSAGGIO ZB4-BZ009 PER	PULSANTERIA TELEMECANIQUE			PA
006	-P5+L5	1005100240	ELEMENTO DI CONTATTO ZBE 101 (NO)	PULSANTERIA TELEMECANIQUE			PA
006	-P5+L5	1005100314	ELEMENTO LUMINOSO LED V.110 ROSSO	ZBV-G4PER PULSANTERIA TELEMECANIQUE			PA
006	-P5+L5	1014842095	TESTA PULSANTE LUMIN. ROSSO	ZB4-BW343	(EX.ZB2-BW34)		PA
015	-C-MODBUS	1003260868	CAVO DI COLLEGAMENTO SERIALE	PER MODBUS V6 MLT-5MT(TOUCH-RFS)			PA
015	-TOUCH	1019100036	PANNELLO TOUCH SCREEN V606EC20	2 RS485 ALIM 24VDC MITSUBISHI			PA
020	-PA1	1014060639	CONSOLLE PER TRANSFORMER-ESTREMA/S	260X896 (+ COD. 1014060640)			PA
020	-PA1	1014060651	PANN. COMANDI ESTREMA/S TOUCH	IN ALLUMINIO 240X876			PA
020	-TAP	1018060960	TAPPO ZB5 SZ3 TELEMECANIQUE				PA
027	-C5	1003282800	CAVO PVC GRI.UL-AWM-2587-90 C-	25AWG18 CSA-AWM-I-II 25G1	VDE-NF-USE-FRNO5VV5-F		PA
027	-C5	1014690250	PRESSACAVO GRIGIO PG29 ART.PTE29 IN	POLIAMMIDE COMPLETO DI CONTRODADO			PA
002	-IG	1011280342	MANIGL. NERA NZM1-XTVD-NA	ART.271445 COM.ROT (X 100A)	(EX.H-NZM7) MOELLER	162	QU
002	-IG	1011280344	CALOTTA DI PROTEZIONE NZM1-XIPA	IP2X3P ART.266748	(EX.H-NZM7)-MOELLER		QU
002	-IG	1014770011	PROLUNGA ALBERO NZM 1/2-XV4 400MM	ART.261232	(EX.NZM7) MOELLER		QU
002	-IG	1017400525	SEZIONATORE NS1-100-NA ART.102682	(EX.NZM7-100-CNA EX.N1-100-NA)	(EX.NZM7-100-CNA EX.N1-100-NA)		QU
002	-IG	1018094351	TARGHETTA MONITRICE ZFS62-NZM7	INGLESE ART.065957	(EX.ZS62-NZM6/NZM9) MOELLER		QU
002	-MT1	1009503340	INTERR.AUT.BIP. 4A UL-CSA	1492-SP2-C040 ART.30554	(EX.1492-CB2G040) ALL.BR.		QU
002	-MT2	1009503315	INTERR.AUT.UNIP. 4A UL-CSA	1492-SP1-C040 ART.30535	(EX.1492-CB1G040) ALL.BR.		QU
002	-RT1	1002111133	BLOCCO CONT.AUSIL.PER MAGNETOTERMI	140M-C-AFA11			QU
002	-RT1	1009500507	INTERR.MAGNETOT. 4-6.3A	140M-C2E-B63 ALLEN BRADLEY			QU
002	-RT2	1002111133	BLOCCO CONT.AUSIL.PER MAGNETOTERMI	140M-C-AFA11			QU
002	-RT2	1009500505	INTERR.MAGNETOT. 1.6-2.5A	140M-C2E-B25 ALLEN BRADLEY			QU
002	-RT4	1009507405	INTERR.MAGNETICO 140M-F8N C.25	ALL.BR. (+ COD.1009507420)			QU
002	-RT6	1009507405	INTERR.MAGNETICO 140M-F8N C.25	ALL.BR. (+ COD.1009507420)			QU
002	-TR	1018521610	TRAS. VA400(P) 0/230/400/415	(S1)0-110 DOPPIO ISOL. CL.B. + SCH.	- TMUL 140 -12008 -		QU
003	-GA	1003564060	CONTATTORE 700S-CF 620 KDC 110V	ALLEN BRADLEY			QU
003	-GA	1006561150	FILTRO X CONTATTORI 100-FSC-280	ALLEN BRADLEY	EX.199-FSMA1		QU
003	-MT3	1009503315	INTERR.AUT.UNIP. 4A UL-CSA	1492-SP1-C040 ART.30535	(EX.1492-CB1G040) ALL.BR.		QU
003	-PLC	1019100032	UNITA BASE FX1N-40MT MELSEC	MITSUBISHI ALIM.24VDC			QU
003	-PLC	1019100034	CAVO SERIALE MELSEC-TOUCHSCREEN	TIPO CV007HK-R01 5MT MITSUBISHI			QU
003	-PLC	1019100063	BATTERIA TAMPONE PER FX1S/FX1N	ART.FX1N-BAT -MITSUBISHI-			QU

ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE	ESTREMA/S	P22995		PLANNER GERACE
				DESIGNER GERACE
		DRAW 4289E	DATE 09.10.2008	PAGE 28

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

Listato materiale

Pag.	Sigla	Codice	Descrizione 1	Descrizione 2	Descrizione 3	Quantità	Ubicazione
003	-RAD	1001170280	ALIMENTATORE DR120 115-230/24/5A	COD.ET4065	EX.1001170250		QU
004	-K30	1011505008	MODULO SICUREZZA ARRESTO/EMERGENZA	PNOZX2.P 24V AC/DC ART.777303 CON	RESTART MANUALE/AUTOMATICO		QU
008	-RY0	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
008	-RY1	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
008	-RY2	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
008	-RY3	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
008	-RY4	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
008	-RY5	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
008	-RY6	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
008	-RY7	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
009	-RY10	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
009	-RY11	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
009	-RY12	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
009	-RY13	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
009	-RY14	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
009	-RY15	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
009	-RY16	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
009	-RY17	1011500708	MODULO RELE INTERF.MRS 24VDC	1CO-WEIDM. ART.853364	+ COD.1011500709 + 1011500710		QU
010	-EXP	1019100051	MODULO ESPANSIONE 4IN.ANAL.1OUT.AN.	FX2N-5A MITSUBISHI			QU
011	-F1E	1006982160	FUSIBILE VETRO WEBER 5X20-1A				QU
011	-F1F	1006982160	FUSIBILE VETRO WEBER 5X20-1A				QU
011	-F1G	1006982160	FUSIBILE VETRO WEBER 5X20-1A				QU
011	-F1H	1006982160	FUSIBILE VETRO WEBER 5X20-1A				QU
011	-F1I	1006982160	FUSIBILE VETRO WEBER 5X20-1A				QU
011	-K1	1003564020	CONTATT.100C16KD10 110V	16A 110VAC50/60HZ 1NO ALLEN BRADLEY	(EX.100A18ND3)		QU
011	-K1	1006561150	FILTRO X CONTATTORI 100-FSC-280	ALLEN BRADLEY	EX.199-FSMA1		QU
011	-K2	1003564000	CONTATT.100C09KD10 110V	9A 110VAC50/60HZ 1NO ALLEN BRADLEY	(EX.100A09ND3) ALLEN BRADLEY		QU
011	-K2	1006561150	FILTRO X CONTATTORI 100-FSC-280	ALLEN BRADLEY	EX.199-FSMA1		QU
012	-F2A	1006982160	FUSIBILE VETRO WEBER 5X20-1A				QU
012	-F2B	1006982160	FUSIBILE VETRO WEBER 5X20-1A				QU
012	-F2C	1006982160	FUSIBILE VETRO WEBER 5X20-1A				QU
012	-F2D	1006982160	FUSIBILE VETRO WEBER 5X20-1A				QU
012	-F2E	1006982160	FUSIBILE VETRO WEBER 5X20-1A				QU
012	-F2F	1006982160	FUSIBILE VETRO WEBER 5X20-1A				QU
014	-K4	1003564010	CONTATT.100C23KD10 110V	23A 110VAC50/60HZ 1NO ALLEN BRADLEY	EX 100A24ND3		QU
014	-K4	1006561150	FILTRO X CONTATTORI 100-FSC-280	ALLEN BRADLEY	EX.199-FSMA1		QU
014	-K6	1003564010	CONTATT.100C23KD10 110V	23A 110VAC50/60HZ 1NO ALLEN BRADLEY	EX 100A24ND3		QU
014	-K6	1006561150	FILTRO X CONTATTORI 100-FSC-280	ALLEN BRADLEY	EX.199-FSMA1		QU
014	-TERM	1003260701	CAVO PER TERMORESISTENZA 3X0.35MMQ	COMPENSATO CORAZZATO			QU
014	-TGI	1003500312	CONNETTORI TERMOREGOLATORI RFS	EROELECTRONIC (+COD.1018380026)			QU
014	-TGI	1018380026	TERMOREGOLATORE RFS 531155000	EROELECTRONIC			QU
014	-TGS	1003500312	CONNETTORI TERMOREGOLATORI RFS	EROELECTRONIC (+COD.1018380026)			QU
014	-TGS	1018380026	TERMOREGOLATORE RFS 531155000	EROELECTRONIC			QU
016	-X1	1011631120	MORSETTO WPE 35 ART.N101050	GIALLO/VERDE	(EX. USLKG 35) - WEIDMULLER		QU

ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 29

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

Listato materiale

Pag.	Sigla	Codice	Descrizione 1	Descrizione 2	Descrizione 3	Quantità	Ubicazione
016	-X1	1017800040	STAFFA TERMINALE EW 35 (8.5)	ART. 0383560000	EW 35 WEIDMULLER		QU
016	-X2	1011631000	MORSETTO WDU 4 ATEX	ART.1020100000	WEIDMULLER (EX. UK 5 N)		QU
016	-X2	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	EX.USLKG 6 N (EX N101020)		QU
016	-X3	1011631000	MORSETTO WDU 4 ATEX	ART.1020100000	WEIDMULLER (EX. UK 5 N)		QU
016	-X3	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	EX.USLKG 6 N (EX N101020)		QU
016	-X4	1011631005	MORSETTO WDU 6 ART.N102020	WEIDMULLER (EX.UK 6 N)			QU
016	-X4	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	EX.USLKG 6 N (EX N101020)		QU
016	-X6	1011631005	MORSETTO WDU 6 ART.N102020	WEIDMULLER (EX.UK 6 N)			QU
016	-X6	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	EX.USLKG 6 N (EX N101020)		QU
017	-X7	1011631050	MORSETTO WDK 2.5 PER WQV	ART.1021500000	(EX.UKK 5) WEIDMULLER		QU
017	-X7	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	EX.USLKG 6 N (EX N101020)		QU
017	-X7	1014270960	PIASTRA TERMINALE PER WDK 2.5	WAP-WDK ART.N105910 PER MORSETTO	MORS.(EX.DUKK3/5)WEIDMUL		QU
017	-X7	1017800040	STAFFA TERMINALE EW 35 (8.5)	ART. 0383560000	EW 35 WEIDMULLER		QU
017	-X8	1011631050	MORSETTO WDK 2.5 PER WQV	ART.1021500000	(EX.UKK 5) WEIDMULLER		QU
017	-X8	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	EX.USLKG 6 N (EX N101020)		QU
017	-X9	1011630950	MORSETTO PORTAFUS.WSI 6LD CON LED	24V ART.101220 - WEIDMULLER	WEIDMULLER		QU
017	-X9	1011630951	MORSETTO PORTAFUS.WSI 6LD CON LED	110/220V ART.101240 - WEIDMULLER	WEIDMULLER		QU
017	-X9	1017800040	STAFFA TERMINALE EW 35 (8.5)	ART. 0383560000	EW 35 WEIDMULLER		QU
018	-X12	1011631050	MORSETTO WDK 2.5 PER WQV	ART.1021500000	(EX.UKK 5) WEIDMULLER		QU
018	-X12	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	EX.USLKG 6 N (EX N101020)		QU
018	-X12	1017800040	STAFFA TERMINALE EW 35 (8.5)	ART. 0383560000	EW 35 WEIDMULLER		QU
025	QU1	1001080042	ADATTATORE PER BARRE W01606-32606	63A SIST.60M. 2 GUIDE			QU
025	QU1	1001080043	ADATTATORE PER BARRE 32A SINGOLO	(W32442) CON VITI W43002 WOHNER	WOHNER		QU
025	QU1	1001080051	ADATTATORE PER SBARRE 63A W32455				QU
025	QU1	1002030035	BARRA RAME 20X5 (01620) WOHNER				QU
025	QU1	1003020120	CANALETTA APERTA 40X60 MOD.T1-E	IBOCO			QU
025	QU1	1007980160	GUIDA DIN DR7 (OMEGA)ART.ERI 557800	IBOCO			QU
025	QU1	1014270990	PIASTRA PER MORSETTI DI	ALLACCIAMENTO (01240) SEZ. 6-50MMQ.			QU
025	QU1	1014610050	PORTASBARRE TRIPOLARE WOHNER	(01500)			QU
025	QU1	1017800080	STAFFA TERMINALE BG/S				QU
004	-FC100	1006633015	FINEC. CHIAVE CADET COD.440K-C21061	MINIATURAGUARD MASTER X PORTELLA	'EX CADET 21003'	143	SS
004	-FC101	1006633015	FINEC. CHIAVE CADET COD.440K-C21061	MINIATURAGUARD MASTER X PORTELLA	'EX CADET 21003'		SS
004	-FC102	1006633015	FINEC. CHIAVE CADET COD.440K-C21061	MINIATURAGUARD MASTER X PORTELLA	'EX CADET 21003'		SS
004	-FC103	1006633015	FINEC. CHIAVE CADET COD.440K-C21061	MINIATURAGUARD MASTER X PORTELLA	'EX CADET 21003'		SS
004	-P3	1014842116	PULSANTE FUNGO ROSSO EMER.	M22-PV/KC02/IY216524	(EX.RPV/KC/I) - MOELLER -		SS
004	-P30	1014842116	PULSANTE FUNGO ROSSO EMER.	M22-PV/KC02/IY216524	(EX.RPV/KC/I) - MOELLER -		SS
004	-S31	1003470280	SELETTORE A CHIAVE XB4-BG21	(EX.XB2-BG21)	(EX.XB2-BG21)		SS
004	-S32	1003470280	SELETTORE A CHIAVE XB4-BG21	(EX.XB2-BG21)	(EX.XB2-BG21)		SS
005	-FC01	1006630071	FINECORSA LSM-11S	ART.266140 - MOELLER			SS
005	-FC01	1018440101	TESTINA ROTANTE LSM-XP ART.266158	- MOELLER -	- MOELLER -		SS
005	-FC02	1014770302	PROSSIMITY M08 PNP CAVO 3 MT. BES	M08 MI PSC 15B BV03	(EX.1014770024)		SS
005	-FC03	1014770302	PROSSIMITY M08 PNP CAVO 3 MT. BES	M08 MI PSC 15B BV03	(EX.1014770024)		SS
005	-FC04	1017311122	SENSORE MAGNETICO COD.M/50/LSU/5V	PRECABLATI CON CAVO 5MT.	(NON NECESSITA DI STAFFE DI		SS
005	-FC05	1017311122	SENSORE MAGNETICO COD.M/50/LSU/5V	PRECABLATI CON CAVO 5MT.	(NON NECESSITA DI STAFFE DI		SS

ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE	ESTREMA/S	P22995		PLANNER	GERACE
				DESIGNER	GERACE
		DRAW 4289E	DATE 09.10.2008		PAGE 30

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

Listato materiale

Pag.	Sigla	Codice	Descrizione 1	Descrizione 2	Descrizione 3	Quantità	Ubicazione
005	-PH01	1003501535	CONNET. X ELETTR. GRIGIO SENZA LED	KA042000A9 ART.62548 CAVO 4 MT CNE			SS
006	-FC11	1006630071	FINECORSA LSM-11S	ART.266140 - MOELLER			SS
006	-FC11	1018440101	TESTINA ROTANTE LSM-XP ART.266158	- MOELLER -	- MOELLER -		SS
006	-P10	1002060083	BASE DI FISSAGGIO ZB4-BZ009 PER	PULSANTERIA TELEMECANIQUE			SS
006	-P10	1005100240	ELEMENTO DI CONTATTO ZBE 101 (NO)	PULSANTERIA TELEMECANIQUE			SS
006	-P10	1014841520	PULSANTE NERO ZB4-BA2	PULSANTERIA TELEMECANIQUE	(EX.ZB2-BA2)		SS
006	-P11	1002060083	BASE DI FISSAGGIO ZB4-BZ009 PER	PULSANTERIA TELEMECANIQUE			SS
006	-P11	1005100240	ELEMENTO DI CONTATTO ZBE 101 (NO)	PULSANTERIA TELEMECANIQUE			SS
006	-P11	1014841520	PULSANTE NERO ZB4-BA2	PULSANTERIA TELEMECANIQUE	(EX.ZB2-BA2)		SS
010	-T1	1018530135	TRASD. PRES.4-20MA- 0..400BAR-ATTAC	G1/4$.MASCHIO- CONN. M12 - TRAFAG -	(+ COD.CONN.1018530134)		SS
010	-T1	1018530134	ACC.TRASDUTTORE CONNET.90 GRADI	CAVO5MT-ART.NAT.CON5.90-TRAFAG-	(PER TRASD.1018530132 E 1018530135)		SS
010	-T2	1018530180	TRASD.PRESS.-1+3 BAR 4-20MA G1/4$	CL.0.6% MOD.TK-E-1-E-N03U-M-V	EX.TKG-E-1-M-N03U-M		SS
010	-T2	1018530185	ACC.TRASDUTTORE CONNETTORE 4 POLI	MOD. CON006	(+ COD. 1018530180) GEFRAN		SS
010	-T3	1018530154	TRASD.PRESS. 0 - 10 BAR 4-20MA	G.1/4$ CL. 1% ART.TK-E-1-E-B01D-M-V	ART. 3296.075.001		SS
011	-EV.AV1	1003501512	CONNETT. X ELETTR. LED+VARIST.110V	KB132V55T9 ART. 44672 CON CAVO CNE	MEX.VS-RS64-Y09-CC38		SS
011	-EV.AV2	1003501512	CONNETT. X ELETTR. LED+VARIST.110V	KB132V55T9 ART. 44672 CON CAVO CNE	MEX.VS-RS64-Y09-CC38		SS
011	-EV.D1	1003501521	CONNET. X ELETTR.LED+VAR+RADR 110V	KA132R55T9 ART.44674CAVO 4 MT CNE			SS
011	-EV.IV1	1003501512	CONNETT. X ELETTR. LED+VARIST.110V	KB132V55T9 ART. 44672 CON CAVO CNE	MEX.VS-RS64-Y09-CC38		SS
011	-EV.IV2	1003501512	CONNETT. X ELETTR. LED+VARIST.110V	KB132V55T9 ART. 44672 CON CAVO CNE	MEX.VS-RS64-Y09-CC38		SS
014	-PT01	1018390005	TERMORESISTENZA D.5 L.300 CON MOLLA	LUNGH.MT.10 CON CAVO CORAZZATO			SS
014	-PT02	1018390005	TERMORESISTENZA D.5 L.300 CON MOLLA	LUNGH.MT.10 CON CAVO CORAZZATO			SS
019	-CON-1	1003500310	CONNETTORE IVO CNE 16A V.380-16	POLI ILME			SS
019	-CON-2	1003500310	CONNETTORE IVO CNE 16A V.380-16	POLI ILME			SS
023	-SC1	1014870240	PULSANTIERA METALLICA 1 FORO	XAP M1501			SS
023	-SC2	1014870240	PULSANTIERA METALLICA 1 FORO	XAP M1501			SS
023	-SC3	1014870240	PULSANTIERA METALLICA 1 FORO	XAP M1501			SS
023	-SC4	1014870240	PULSANTIERA METALLICA 1 FORO	XAP M1501			SS
025	QU	1003462121	COFANO QO863 (800X600X300)	PER ESTREMA/S RAL 7035 -DIS.015977-			SS
025	QUSS	1014690200	PRESSACAVO GRIGIO PG9 ART.PTE09 IN	POLIAMMIDE COMPLETO DI CONTRODADO			SS
025	QUSS	1014690210	PRESSACAVO GRIGIO PG11 ART.PTE11 IN	POLIAMMIDE COMPLETO DI CONTRODADO			SS
025	QUSS	1014690220	PRESSACAVO GRIGIO PG13.5 ART.PTE13	IN POLIAMMIDE COMPLETO DI CONTROD.			SS
025	QUSS	1014690230	PRESSACAVO GRIGIO PG16 ART.PTE16 IN	POLIAMMIDE COMPLETO DI CONTRODADO			SS
025	QUSS	1014690240	PRESSACAVO GRIGIO PG21 ART.PTE21 IN	POLIAMMIDE COMPLETO DI CONTRODADO			SS
025	QUSS	1014690250	PRESSACAVO GRIGIO PG29 ART.PTE29 IN	POLIAMMIDE COMPLETO DI CONTRODADO			SS
027	-C1	1003281060	CAVO PVC GRI.UL-AWM-2587-90 C-	4XAWG14 CSA-AWM-I/II 4G2.5	VDE-NF-USE-FRN05VV5-F		SS
027	-C1	1014690220	PRESSACAVO GRIGIO PG13.5 ART.PTE13	IN POLIAMMIDE COMPLETO DI CONTROD.			SS
027	-C10	1003281021	CAVO PVC GRI.UL-AWM-2587-90	C-3XAWG18(1)CSA-AWM-I/II 3G1	-VDE-NF-USE-FRN05VV5-F		SS
027	-C11	1003281021	CAVO PVC GRI.UL-AWM-2587-90	C-3XAWG18(1)CSA-AWM-I/II 3G1	-VDE-NF-USE-FRN05VV5-F		SS
027	-C12	1003282402	CAVO PVC GRI.UL-AWM-2587-90 C-	5XAWG18 CSA-AWM-I/II	VDE-NF-USE-FRN05VV5-F 5G 1		SS
027	-C12	1014690210	PRESSACAVO GRIGIO PG11 ART.PTE11 IN	POLIAMMIDE COMPLETO DI CONTRODADO			SS
027	-C13	1003282402	CAVO PVC GRI.UL-AWM-2587-90 C-	5XAWG18 CSA-AWM-I/II	VDE-NF-USE-FRN05VV5-F 5G 1		SS
027	-C13	1014690210	PRESSACAVO GRIGIO PG11 ART.PTE11 IN	POLIAMMIDE COMPLETO DI CONTRODADO			SS
027	-C15	1003281021	CAVO PVC GRI.UL-AWM-2587-90	C-3XAWG18(1)CSA-AWM-I/II 3G1	-VDE-NF-USE-FRN05VV5-F		SS
027	-C15	1014690200	PRESSACAVO GRIGIO PG9 ART.PTE09 IN	POLIAMMIDE COMPLETO DI CONTRODADO			SS

ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE	
			DESIGNER GERACE	
	DRAW 4289E	DATE 09.10.2008		PAGE 31

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

Listato materiale

Pag.	Sigla	Codice	Descrizione 1	Descrizione 2	Descrizione 3	Quantità	Ubicazione
027	-C16	1003281021	CAVO PVC GRI.UL-AWM-2587-90	C-3XAWG18(1)CSA-AWM-I/II 3G1	-VDE-NF-USE-FRN05VV5-F		SS
027	-C16	1014690200	PRESSACAVO GRIGIO PG9 ART.PTE09 IN	POLIAMMIDE COMPLETO DI CONTRODADO			SS
027	-C19	1003281016	CAVO MMQ. 3X0.50 SCHERMATO	ELITRONIC CY MARCHIATO A NORME CON	FILI COLORATI (ART.36981)		SS
027	-C2	1003281060	CAVO PVC GRI.UL-AWM-2587-90 C-	4XAWG14 CSA-AWM-I/II 4G2.5	VDE-NF-USE-FRN05VV5-F		SS
027	-C2	1014690220	PRESSACAVO GRIGIO PG13.5 ART.PTE13	IN POLIAMMIDE COMPLETO DI CONTROD.			SS
027	-C20	1003180120	CASSETTA WESTEC S4 189x167x80	178X155X69			SS
027	-C20	1003180360	CASSETTA WESTEC S1 101X101X58	COD. 8000.6261.0			SS
027	-C20	1007840401	GUAINA INDUPLAST GRIGIO RAL 7035	D.10 ART.IN 701010			SS
027	-C20	1007840761	GUAINA INDUPLAST GRIGIO RAL 7035	D.19			SS
027	-C21	1003281016	CAVO MMQ. 3X0.50 SCHERMATO	ELITRONIC CY MARCHIATO A NORME CON	FILI COLORATI (ART.36981)		SS
027	-C22	1003281016	CAVO MMQ. 3X0.50 SCHERMATO	ELITRONIC CY MARCHIATO A NORME CON	FILI COLORATI (ART.36981)		SS
027	-C3	1003286405	CAVO PER ALTA TEMPERAT. 180 GR. 4X4	MQ(FORELIND)			SS
027	-C3	1014690240	PRESSACAVO GRIGIO PG21 ART.PTE21 IN	POLIAMMIDE COMPLETO DI CONTRODADO			SS
027	-C7	1003281021	CAVO PVC GRI.UL-AWM-2587-90	C-3XAWG18(1)CSA-AWM-I/II 3G1	-VDE-NF-USE-FRN05VV5-F		SS
027	-C7	1014690200	PRESSACAVO GRIGIO PG9 ART.PTE09 IN	POLIAMMIDE COMPLETO DI CONTRODADO			SS
027	-C7	1014690300	RIDUZIONE PG 13.5 - PG9 ART.18574	(PG13.5=MASCHIO PG9=FEMMINA)			SS
027	-C9	1003281021	CAVO PVC GRI.UL-AWM-2587-90	C-3XAWG18(1)CSA-AWM-I/II 3G1	-VDE-NF-USE-FRN05VV5-F		SS

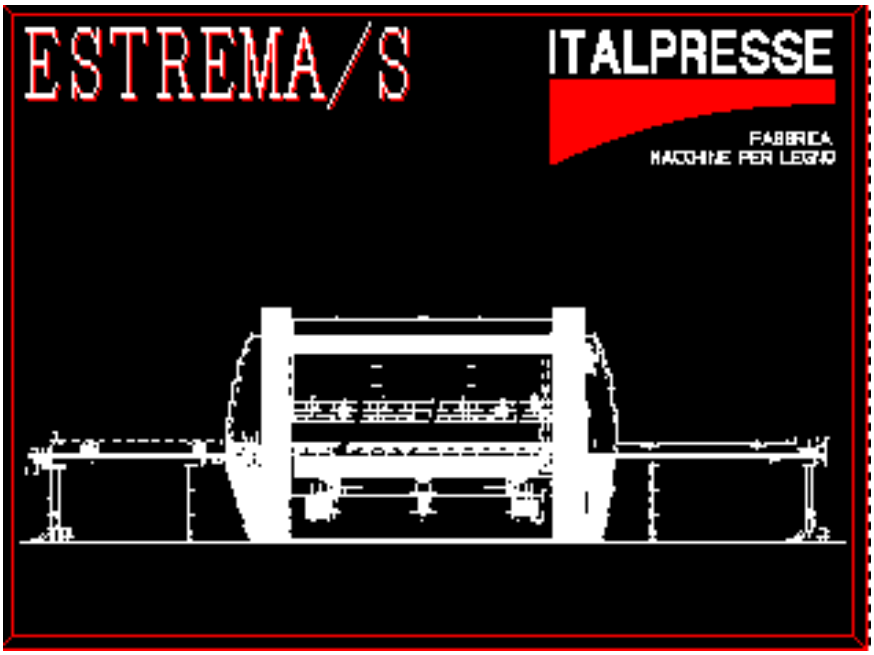
ITALPRESSE
FABBRICA
MACCHINE PER LEGNO

24060 Bagnatica (Bergamo)
Italia-Via delle Groane,15
Tel. 035/666341
Telefax 035/6663400
Mail:sales@italpresse.com

TYPE ESTREMA/S	P22995		PLANNER GERACE
			DESIGNER GERACE
	DRAW 4289E	DATE 09.10.2008	PAGE 32

Draw Reserved To Norm Of Law Of April 22 nd 1941 N°633. You/he/she cannot Have reproduced Or Divulged Without Our Authorization

TOUCH-SCREEN ESTREMA/S HANDBOOK



INDEX

1.MENU……..pag.3

2.WORK PAGE……pag.4

3.HEATING PAGE……pag.8

4.DAILY/WEEKLY TIMER SETTING ……pag.9

5.HOUR/ DATE SETTING……pag.10

7.LANGUAGE CHANGE……pag.11

8.STATE OF INPUT/OUTPUT ……pag.12

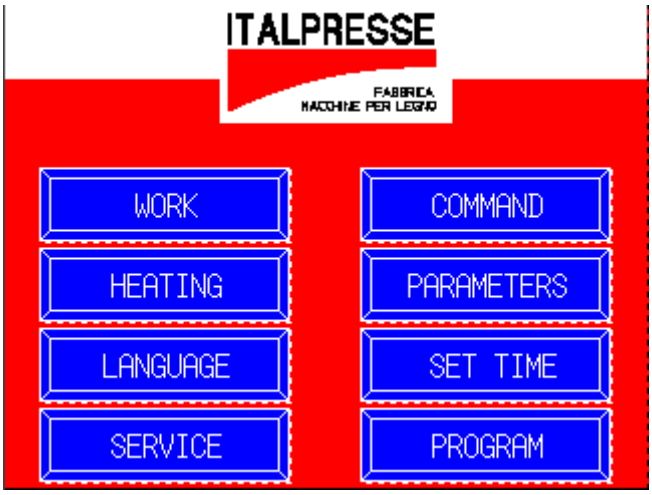
11.OPERATING ALARM……pag.13

12.PARAMETERS……pag.14

13.SERVICE……pag.17

14.PROGRAMMES……pag.18

MENU



The “main menu” page is used by the operator in order to select the desired service required.
The services available are:
-The “WORK” Menu : By using this page, one enters the main work page used by the operator during the pressing cycle. Here one finds all main functioning data when using the press.

-The “HEATING” menu : With this page one enters the setting commands of the heating boiler and all it’s options.

-The “LANGUAGE” menu : With this page one can change the language used by the panel operator.

-The “SERVICE” menu : This page allows to change the measuring scale type in order to visualize the temperature of the pressure (Password page).

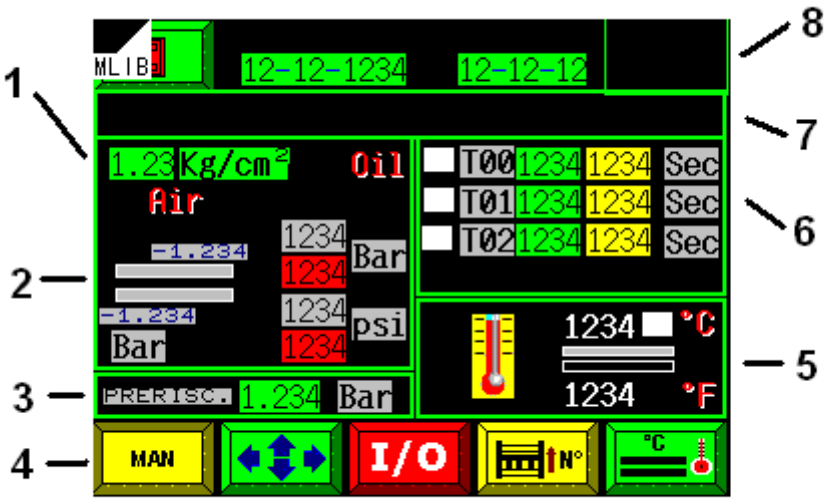
-The “COMMAND” menu : This page allows the operator to enter the auxiliary commands of the machine.

-The ”PARAMETER” menu : This page allows setting of the specifc values for the function of the machine. (Password page).

-The ”SET-TIME” menu : This page allows Date and Time setting.

-The ”PROGRAMME” menu : With this page one enters the menu with the possibility of setting 2 files of 100 programmes each.

LA OPERATION MENU PAGE



The " OPERATION " menu page contains all the main commands and settings for use of the press in operation mode.

1-By touching on the green tab, the required operation pressure settings can be entered. Said value will be used to work out the oil-hydraulic thrust pressure on the frame (red tab). The air thrust is instead equal to 1 kg / cm^2 =1 Bar;

2-The real-time thrust values and air vacuum values are displayed in the vicinity of the top and bottom work beds. A green arrow will light up corresponding to either bottom-up or top-down thrust.

3-PVC pre-heat value, i.e. the pressure exerted from the bottom-up on the PVC in order to heat it up.

4-Machine basic commands synoptic symbol bar: MAN-AUT(manual / automatic mode selector), COMMANDS (commands page), I/O (input/output status), PRESS CYCLE COUNTER, TEMPERATURE.

5-Top work bed heating activation control (green LED), real-time temperature display in °C and °F.

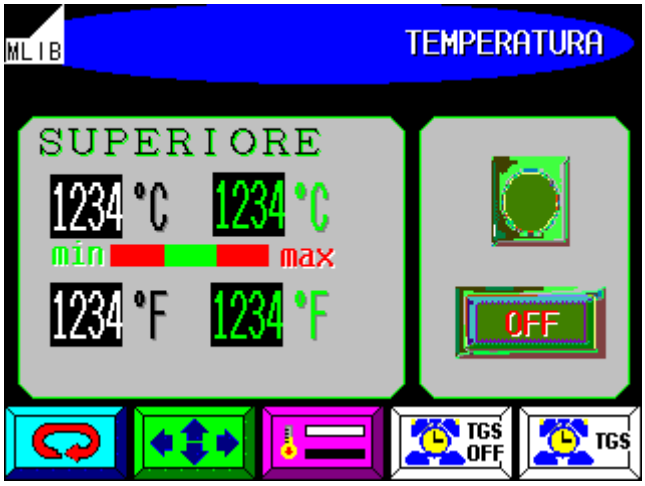
6-Settable values for cycle timer T00=PVC pre-heat time; T01=bottom vacuum wait time - top air thrust wait time ;T02=pressing timer.

7-Press cycle operation message display.

8-Alarm display. When the symbol comes up on screen, click on the triangle to access the error page!

-the PRESS CYCLE RECORD pushbutton allows for access to the press cycle counter page.

HEATING



In the heating page, one may set the heating parameters of the upper and lower level (eventual) of the press.
The visualisation and setting is done in double scale °C-°F. In the right hand frame, clicking on the numbers, we can set the desired temperature, on the left we can visualize the current temperature of the programme.

If the programme is in the heating phase the ON led will light up, if on the contrary the temperature exceeds the set programme the OFF led will light up. If the current temperature exceeds the programme set, an emergency circuit will be activated to protect the programme and bring back the original working temperature.

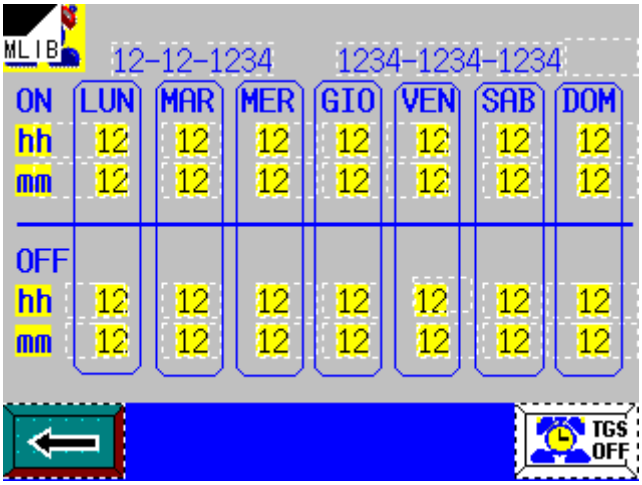
To start up the programme click on the green OFF button, it will change status. If the light above the said button starts flashing, the daily weekly timer is activated and will block the heating from starting up.

Instead the TI> button is used to enter the lower level setting page.

On the same page, by touching the button on the lower right, it is possibile to programme the boiler heating daily-weekly on/off timer, by touching the same button at the top of the page, one is able to activate o deactivate the timer.
By touching this button, the operating panel will allow us to enter the page below.

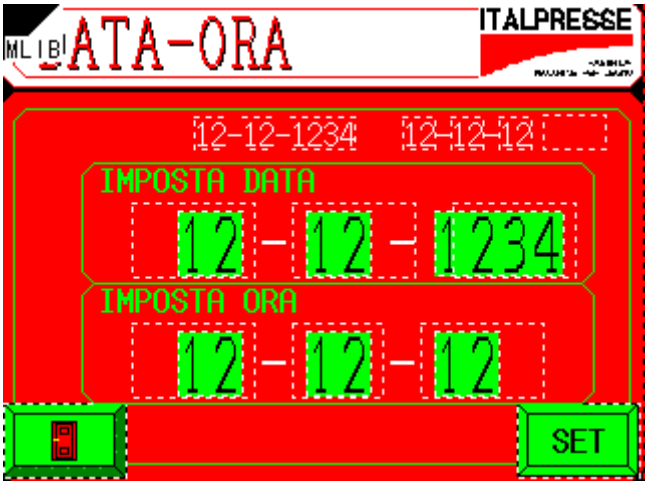
Within this page, one finds the following buttons:, these allow the operator to return to the desired main pages.

DAILY/WEEKLY TIMER.



-The upper part allows us to set the hour and minutes for each week day in which we want the heating to start up.
-The lower part, on the contrary, allows us to set the time and minutes for the desired weekday in which we want the heating to switch off.
-To deactivate the automatic on/off option for the heating, press the OFF button on the said page or use the button with the clock in the central part of the HEATING page.

DATE/HOUR SETTING



In this page one enters the date and time setting of the operator.

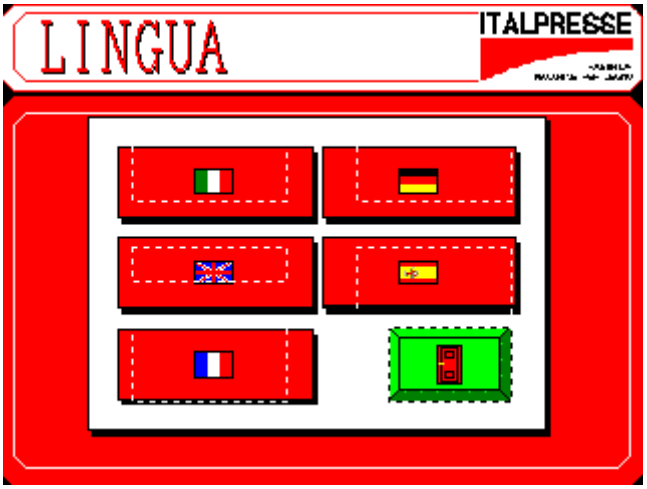
SET DATE: To change date in DD-MM-YYYY format, click on the three options, a small keyboard will appear. Insert your desired values and click on ENTER.

SET TIME: To change the time in HH-MM-SEC format, click on the three options, a small keyboard will appear, insert your desired values and click on ENTER.

When the 6 options have been inserted click on SET to modify the current value.

Click HOME to exit.

LANGUAGE CHANGE



This page allows one to set the language desired.

Clicking on the corresponding flag one enters the desired language, when one exits the frame, the operator will be able to use the programmed modified language.

Click on HOME to exit.

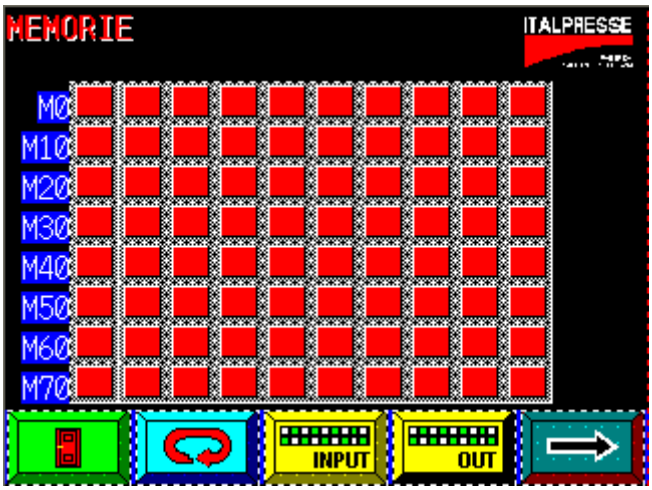
CONDITION OF INPUT/OUTPUT

In this section of signal diagnostics the condition of the input and output signals are visualized by the controller as in the following table.

If the input is activated, the box corresponding to the said input will light up and become green; on the contrary if the input is not activated the box will remain red.
The button with the arrow allows one to scroll the page backwards and forwards.

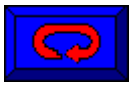
If the output is activated the box corresponding to the said output will become green; on the contrary if the output is not activated, the box will remain red.
The arrow button allows one to scroll the page backwards and forwards.

Click on HOME to exit.

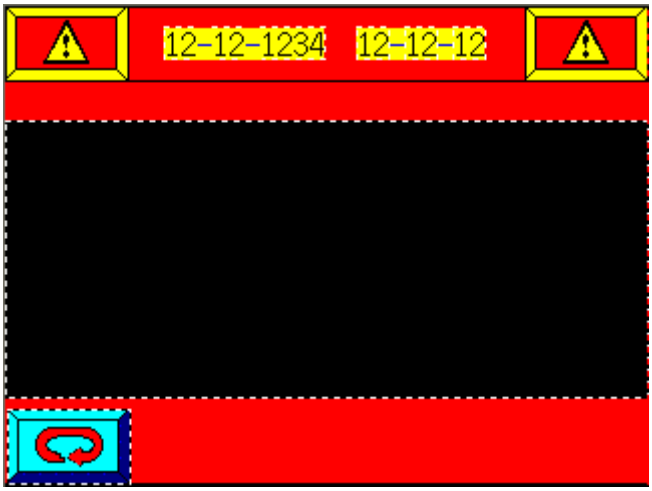


SYSTEM MEMORIES

When the system memory is active, the relative corresponding signal field lights up in green. On the contrary, when the memory is NOT active, the relative corresponding signal field will stay OFF.
The arrow keys allow us to scroll through the pages backwards and/or forwards.

Click on the HOME key to exit, click on  to return to the main operation page or click on the INPUT or OUTPUT keys to change menu page.

ALARM MANAGEMENT PAGE



This is the system diagnostics page. To activate the relative functions, click on the error signal key that is located in the top right corner.

TOP WORK BED TEMP. ALARM

Inspect the connection between the thermistor and the temperature controller (TGS) located internally to the control panel and check they are working correctly.

BOTTOM WORK BED TEMP. ALARM

Inspect the connection between the thermistor and the temperature controller (TGI) located internally to the control panel and check they are working correctly.

VACUUM ANOMALY ALARM

Check to make sure that the vacuum pump is on and that the press's vacuum system is working correctly.

GENERAL EMERGENCY

Reset all the emergencies and press the green general auxiliary switch start pushbutton located on the panel.

TOP AIR PRESSURE ALARM

Inspect the top air thrust/pressure system to check that it is working and is calibrated correctly.

BOTTOM AIR PRESSURE ALARM

Inspect the bottom-up air thrust/pressure system to check that it is working and is calibrated correctly.

OIL PRESSURE ALARM (PH01)

The maximum pressure safety switch has tripped on. Open up the machine and ensure that the oil-hydraulic system is working correctly.

PRESSURE TRANSDUCER ANOMALY (TPR)

Inspect connection of the (TPR) pressure transducer located on the system valve bank, and ensure it is working correctly.

OIL-HYDRAULIC PUMP THERMIC TRIP-OFF (RT1)

The thermal magnetic switch located internally to the electric control panel is on standby, due to a oil-hydraulic power pack motor failure or overload.

PVC DAMAGE ALARM

Check the material being processed by the press. It may be damaged and will therefore lead to automatic press opening.

MOBILE WORK BED STROKE ALARM

The mobile work bed stroke end detector has tripped off. This safety feature prevents the oil hydraulic pistons from running over the stroke limits.

OIL-AIR THRUST CONTROLLER ALARM

This safety feature is tripped off when the press's oil-hydraulic thrust is not capable of balancing the top-down air thrust. The press cycle is blocked and the press then needs to be opened.

PARAMETERS

In this section all basic values are set for the correct functioning of the press. For obvious reasons only the producer is authorized to enter this section.

Maximum pressure	3.50 kg/cm2
1 pressure step	120 Bar
2 pressure step	180 Bar
1 upper air level	1 Bar
1 lower air level 0 bar	0.020 Bar
DELTA T.S	1 °C
DELTA T.I	1 °C
Delta P.O	5 Bar
Delta P.A.I	0.1 Bar
Max upper platen	130 °c
Max lower platen	130 °c

Oleodinamic pressure curve:

6280	0
32000	400

Contr.min. 8 Contr.max. 200

Upper and lower air pressure curve:

UPPER AIR DATA

6326	0
32000	9.999

Contr.min. 20 Contr.max. 200

LOWER AIR DATA

7945	0
32000	3.000

Contr.min. 20 Contr.max. 200

In the parameter section a TIMER button is active so as to delay all functions of the machine.

This is the schedule with the time settings for a correct functioning:

T06	0
T09	60
T10	60
T11	10
T12	10
T13	0
T14	0
T15	30
T20	350
T21	30
T22	0
T23	130
T25	10
T26	10
T28	30
T29	350
T31	10
T49	100
T50	0
T51	0
T52	1
T53	0
T55	9999
T60	1
T80	10
T95	1
T97	0
T24	10

SERVICES

In this section all basic values are set for a correct functioning of the press. For obvious reasons only the producer is authorized to enter this section.

PROGRAMMES

Click on 0 : file 1
Click on 1 : file 2
Depending on the file selected numbers from 0 to 99 will appear.

Click on a number of your choice (each number is a programme that one can set up):

Insert the data, click on the desired value and set:
T00 : preheating timer
T01 : Upper air pressure timer
T02 : pressing timer
PREAHEATING PRESS: preheating timer
OIL PRESSURE : oleodinamic pressure function
UPPER TEMP. : Upper level temperature
LOWER TEMP. : Lower level temperature

Click on save

To insert a name to a programme click on PROG. NAME, then on the programme number, a keyboard will appear where you can insert the name.

Type name.

Send.

Click once on PROG.NAME to deselect.

- TO SELECT A PROGRAMME AND ENTER

Click on 0 : File 1
Click on 1 : File 2

Depending on the file selected, numbers from 0 to 99 will appear.

Click on the programme number desired and click CHARGE (CARICA)
The data on screen will appear then click on PLC.>
Click on YES (SI)

- TO SELECT A PROGRAMME AND SAVE THE DATA SET MANUALLY FROM THE WORK PAGE:

Click on 0 : File 1
Click on 1 : File 2

Depending on the file selected, numbers from 0 to 99 will appear.

Click on the programme number desired.

Click on MEMORY (MEMORIA) and then say YES (SI)

The data set manually will appear on screen.

Click on SAVE (SALVA)