

INSTRUCTION MANUAL

Speedy T - Automatic Folding Machine



TRANSLATION OF ORIGINAL INSTRUCTION

Version Nr 002

Date 01/07/2016



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Dear client,

Congratulations on your choice. Selecting this product you join the large number of users of Chioffi e Cavazzuti products. With this equipment you can achieve excellent quality results. To that end, we ask that you read carefully this instruction manual before using the machine.

Chioffi e Cavazzuti s.r.l boasts over ten years of experience in the manufacturing of automated machinery. The technological expertise that the company has built up over years of research, closely tied to its international manufacturing and distribution activities, is the best guarantee of quality that Chioffi e Cavazzuti s.r.l can provide.

WARNINGS:

The manufacturer does not provide warranties of any kind with regard to this manual.

The company will not be responsible for errors in this manual, or for accidental or consequential damages resulting from providing this manual and from its use.

This document contains proprietary information.

This manual cannot be photocopied or reproduced without prior authorization in writing by the manufacturer.

The information in this manual is subject to change without notice.

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GENERAL NOTICES

The Operator must read carefully and understand fully all the information given in this Manual and especially all the safety precautions given in this section.

Keep the machine and its work area clean and tidy.

Do not remove or alter the plates and stickers attached to the machine by Manufacturer.

DO NOT REMOVE OR BY-PASS THE SAFETY SYSTEMS INSTALLED ON THE MACHINE.

SCHEDULED USE

The machine has been designed and built to facilitate the folding of garments such as T-shirts.

It can be adapted to fold other kinds of garments provided Manufacturer checks the adaptation in advance.

OPERATOR

The personnel required to operate the machine must possess (or achieve the required competence through adequate training programmes) the ability detailed below and have read and understood the content of this Manual and all the information on safety matters.

General and technical education at a level sufficient to understand the content of this manual and interpret the Figures, diagrams and schematics correctly.

Knowledge of safety, industrial accident prevention and technical regulations.

Know how to act in an emergency, where to find individual protection equipment and how to use it correctly.

Maintenance Engineers, in addition to the abilities detailed above, must also possess adequate technical training.

IMPROPER USE

The machine must not be:

Used for purposes other than those detailed.

Exposed to the weather.

Used to fold material not suitable for its characteristics such as paper or other stiff materials.

Operated by children or untrained personnel.

SAFETY DEVICES

The machine cannot be completely protected since in this condition its operation would be impeded.

Therefore, pay special attention to prevent hands from being crushed.

The low level pressure used reduces the risk of serious personal injury to a considerable extent.

The manufacturer:

Chiossi e Cavazzuti s.r.l
Via Costituzione 50/D
42015 Correggio (RE)
ITALY

DECLARES THAT THE MACHINE:

Serial Number
Manufacturing year:
Trade name: "Speedy-T 2005"
Description: Automatic folding machine
Intended use: Folding and bagging garmints made from fabric.

Complies with the applicable directives:

European Parliament and Council Directive 2004/108/CE of December 15, 2004 concerning the alignment of member nations laws in regard to electromagnetic compatibility.

European Parliament and Council Directive 2006/95/CE of December 12, 2006 concerning the alignment of member nations laws in regard to electrical materials intended for use within certain voltage limits.

Legislative Decree No. 81 of 4/09/2008, consolidation on healthcare and safety in the workplace.

Reference to harmonized standards:

EN 12100-1; EN 12100-2; EN 60204-1

And authorizes


Ugo Chiossi
Via Costituzione 50/D
42015 Correggio
Italy

To set up a representative technical file

Correggio on ___/___/_____

For the manufacturer

Ugo Chiossi
Legal representative



The warranty of this material is one year from the date of purchase.

The warranty covers replacement of parts acknowledged as defective, with the exception of parts subject to normal wearing (fuses, lamps, reflecting dishes, casters, power cord, etc.).

All replaced parts must be returned within fifteen days, if not returned by then we will need to invoice them.

All service is done at our facilities.

No compensation can be claimed in case of machine downtime, regardless of the cause.

In case of dispute, the only court having jurisdiction is the Court of Reggio Emilia (I).

WARRANTY CERTIFICATE

This must be sent for all service requests.

This product was tested and packaged with the outmost care.

In case of malfunction we ask that you quickly send this certificate with a detailed description of the problem.

MACHINE MODEL

SERIAL NUMBER

PURCHASE DATE

SOLD FROM:

CUSTOMER ADDRESS:

COMPANY

ADDRESS

TEL.

Address where the Warranty Certificate is to be sent:

Chiossi e Cavazzuti s.r.l.
Via Costituzione 50/D
42015 Correggio (RE)
ITALY

Tel: +39 0522 637224
Fax: +39 0522 631180
Email cc@chiossiecavazzuti.com
web www.chiossiecavazzuti.com

Indispensable for fast and uniform folding of the T-shirts.

Can be adapted to suit all shapes and sizes available on the market.

The blades, which can be easily adjusted and are interchangeable, make it possible to suit the fold to the required size in a few seconds, so that it is possible to fold baby t-shirts as well as extra large sizes. Speedy T 2005 can operate in two ways:

- with stacker: the folded T-shirt is placed neatly on a stacker which descends thanks to a photocell making it possible to form a stack;
- packing upside down : when the selected work cycle ends, the t-shirt is folded on the last blade on which it can be easily packed in a bag.

The electronic control device allows the following functions:

- choice of 10 folding programs
- customization of folding programs which can be saved in memory;
- self-diagnostics of anomalies and/or faults;
- count of t shirts produced, indicating when the preset number of pieces is reached;
- hourly production programming, with acoustic signal for productions below minimum threshold setting;
- language selection (Italian, French, English, Spanish, German);
- programming protected by means of access code;
- reset function which restores default programs.

TECHNICAL DATA

VALUES

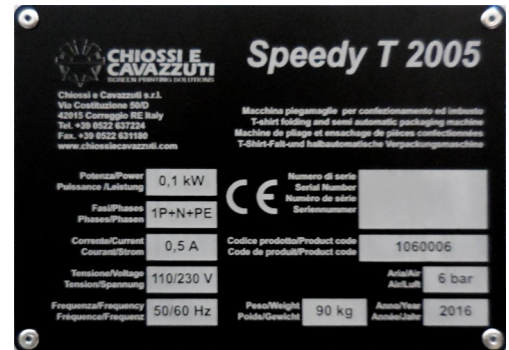
POWER SUPPLY	230/115 V + PE
REQUIRED INPUT (max)	230 W
REQUIRED AIR PRESSURE	6 bar
AIR CONSUMPTION (max)	50 l/min
TOTAL WIDTH	710 mm
LENGTH WITH/WITHOUT STACKED LIFTED (min / max)	1150 / 1500 mm
T-SHIRT FOLDER WIDTH (min / max)	150 / 350 mm
T-SHIRT FOLDER LENGTH (min / max)	180 / 400 mm
WEIGHT	90 kg
PRODUCTION WITH STACKER (max)	500 pieces/h
PRODUCTION WITH PACKAGING (max)	350 pieces/h
NUMBER OF PROGRAMS	10

MACHINE IDENTIFICATION

The identification plate is on the front of the machine.

It gives the following information:

- Machine model
- Serial number
- Power supply voltage rating
- Power installed
- Mains frequency
- Power draw in Amperes
- Weight



HOW THE MACHINE WORKS

The Speedy t 2005 folding machine comprises a work top with mobile air-operated blades used to fold and prepare fabric garments (as such T-shirts) for packing. The article will be spread by hand on the work table. The stacker (optional as detailed in the price list) will hold a 200 mm high stack of folded T-shirts.

MAIN COMPONENT PARTS

The machine is made up of the following main parts: Base - Runners and regulating screws - Compressed air drives - Stacker (optional) - Set of folder blades - Compressed air plant - Electric system - Electronic control board - Mobile "start/stop" box

STANDARD EQUIPMENT

The machine is supplied complete with:

Start pedal and emergency STOP button installed on a pedestal - Blade adjustment can be made from the outside - Four casters of which two have brakes - Compressed air equipment made by Messrs "PNEUMAX" - Dual voltage (230v 115 v 50 or 60 Hz) with external voltage switch - Operating Manual - One set of standard blades for bag format: 220mm width x300mm length - One centre blade and an expelling blade (blade 4 and 5) for bag format 170 mm width x 220 mm length - One centre blade and an expelling blade (blade 4 and 5) for bag format 350 mm width x 400 mm length - 10 standard folding programs.

Display languages: Italian, French, German, English and Spanish.

OPTIONAL EQUIPMENT

The machine can be supplied with the following optional equipment:

Compressed air components from Messrs. "SMC" - More powerful acoustic signals - Other bade sets - Other voltages - Display messages in other languages - Stacker - Mobile start pedal unit with emergency STOP button on handle.

It is hereby understood that any modification to the machine or added accessory must be explicitly approved and made by manufacturer.

ENVIRONMENTAL CONDITIONS

The machine does not need any special environmental conditions. It should be installed in a well lighted and ventilated factory building with a level floor designed to handle the weight of the machine. Working area temperature range: 5°- 40° C, with humidity not above 50% at 40°C or not above 90% at 20° C.

AREA LIGHTING

The lighting in the work area must be in compliance with the current regulations in the country where the machine is installed and must guarantee good visibility over the entire area without creating dangerous reflection.

VIBRATION

Under working conditions in compliance with the instructions for correct use of the machine, no annoying levels of vibration will be encountered.

NOISE LEVEL

The machine is designed and built to reduce the noise generated as much as possible. The machine's noise level is:

Noise level Lwa = 75 dB (as measured)

Declared constant K = 4 dB

NOTE: The noise level mentioned above is the actual noise level measured and does not necessarily mean a safe noise level. Though noise level and noise exposure level are related, the measured noise level in itself cannot be used as an entirely reliable method for determining whether or not additional ear protection devices should be used. The factors that determine the noise level to which the workers are exposed include: exposure duration, characteristics of the work area and other sources of noise (number of machines, near by manufacturing processes, etc.). Furthermore, noise exposure levels can differ from country to country. In any case, the information given in this manual will enable the owner of the machine to make a better appraisal of the hazards and dangers the machine generates.

ELECTROMAGNETIC ENVIRONMENT

The machine has been designed and built to work correctly in an industrial environment. It falls within limits for Emission and Immunity required by the following Harmonised Standards:

EN 50081-2 Electromagnetic compatibility. General emission standards, Part 2. Industrial Environment - (1993).

EN 50082-2 Electromagnetic compatibility - General Immunity standards - Part 2 - Industrial Environment - (1995).

PACKING AND SHIPPING

Transport must be done by professionally qualified personnel. The machine must be transported in such a way as to prevent any damage to its parts. Depending on the type of transport vehicle, the machine must be protected against any type of impact or strain. The machine is delivered on a pallet and can then be moved with a forklift truck or transpallet. The machine can also be shipped in a plywood box invoiced at cost.

Shipping dimensionson

a pallet (wheels dismantled)	1200 x 750 x 880 (h) mm	weight 108 Kg
normal crate (wheels dismantled)	1220 x 770 x 900 (h) mm	weight 130 Kg
low crate (stacker feet and cylinder dismantled)	1220 x 770 x 630 (h) mm	weight 125 Kg

Damage to the machine during transport are NOT covered by warranty.

Repair or replacement of such damaged parts will be charged to the customer.

STORING

If the machine is to be inactive for a long time, it must be put into storage with all the precautions needed for the storage site and the length of time. Store the machine in a covered area. Grease all non-painted parts. Protect the machine against bumps and strain. Protect the machine against humidity and very high or very low temperature. Keep corrosive substances well away from the machine.

SUITABLE WORK SITES

The folding machine must be installed in a sufficiently large area with enough space around it to allow the operators to move easily about it. The floor must be level and sufficiently strong to hold the weight of the machine.

PRELIMINARY CHECKS

Before running the machine, a number of checks and tests should be made to eliminate errors or accidents during commissioning. Check to make sure the machine has not been damaged during transport. Check to make sure that all the blades are lowered and the stacker platform (if installed) is in its working position.

THE WORK TABLE MUST BE CLEAR OF EVERYTHING EXCEPT THE GARMENT TO BE FOLDED. Check if there is compressed air in the supply circuit. Check to make sure the mains voltage is the same as that shown on the voltage change jumper sticker.

ASSEMBLY

When the volume of the transport box has considerable incidence on the cost of the transport (paid by the customer), it can be delivered with the feet and the stacker cylinder (if ordered) disassembled to reduce the shipping volume by about 30%. In this case, the assembly instructions will be enclosed.

STACKER

If the machine is equipped with a "Stacker", its platform must be raised and the support bow should be snapped into its seating.

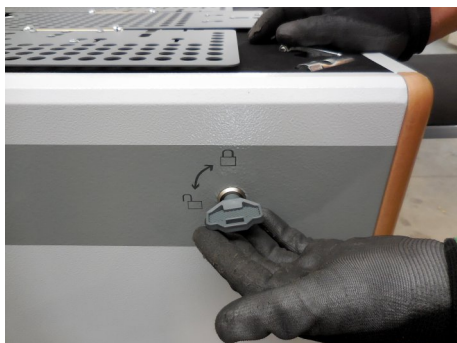
FOOT PEDAL

- 1-Remove the foot pedal and Start and Stop button from inside the machine
- 2-The Start and Stop button can be attached on every side of the machine.
- 3-Connect the power cord to a power socket.



REMOVING THE SIDE PANELS

The side panels snap into place. Once the retainers have been removed with a spanner, lift the panel up to free it from the machine. The spare blades are inside this panel retained by an elastic.



ELECTRIC HOOK UP

To eliminate problems when the machine is commissioned, follow the instruction given below:
The electric hook up is customer's responsibility.

The machine must be connected to the electric mains using the cable supplied in the installation kit.

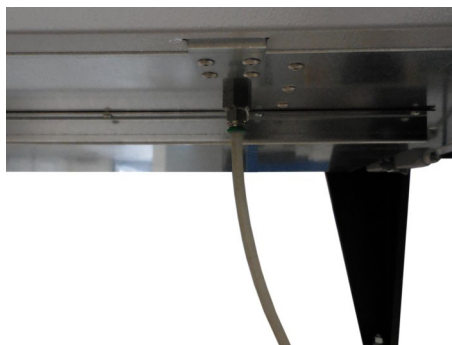
Voltage SINGLE-PHASE 230 V.ac +/- 10% or 115 V.ac +/- 10% . In this latter case, the voltage change jumpers will have to be moved as shown in the figure.

Nominal frequency: .50 - 60 Hz



COMPRESSED AIR HOOK UP

The machine must be supplied with clean, dry compressed air delivered by a compressor capable of providing at least 100 l/min of compressed air at 6 bar. The connecting point shown in the Figure is a tapped 1/4" gas fitting to which the required hose connector can be fitted. The inside diameter of the air hose must be at least c 6 mm. Best not use a spiral hose. Best use rubberised canvas hoses with a good thickness. The hoses should be subject to crimping or pinching.



REGULATING THE MACHINE

The machine is fully factory tested before being shipped and therefore no regulations need be made.

When the machine is started for the first time, the compressed air pressure should be adjusted as follows:

Pull the air pressure regulating knob up to release it.

Turn the knob until the pressure gauge needle is on 5 bar.

Push the knob back down to lock it in this position.



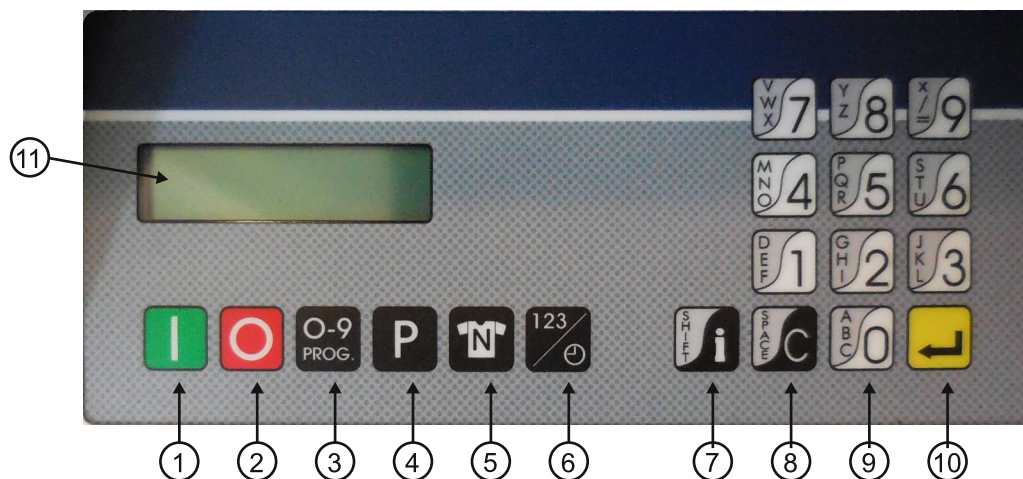
CONTROL AND STATUS INDICATION PANEL

The following devices are found on the control panel:

Main switch with fuse, voltage change jumper, power socket. Control and programming keyboard.

Back-lit liquid crystal display to read current settings and any fault messages.

Built in beeper.



- 1) Start key - starts work cycle (same as start pedal).
- 2) Stop key- stops work cycle.
- 3) Program key - when pressed you can select the program number on the number pad.
- 4) Programming key - (with the access code) is used to modify standard programs.
- 5) Counter - used to set the number of items to be folded.
- 6) Total counter - shows the number of items folded since the last reset and the number set. If pressed twice, it will show total working time and total machine strokes.
- 7) Shows the hourly production set or, depending on the context, alternates upper case and lower case.
- 8) Cancels the last operation executed or, depending on the context, puts a space between two letters.
- 9) Number key or, depending on the context, alphanumeric key.
- 10) Confirmation key (Enter)
- 11) Liquid crystal display. Displays information or messages on machine operational status.

OPERATING THE MACHINE

The garment to be folded is spread on the work table with the back up and the neck towards the stacker. Press the pedal (or key 1) and the machine will execute the active folding cycle (from now on called program) and will then stop. This cycle will be repeated for each garment to be folded.

PROGRAMS

The different work programs are divided into 3 distinct operating modes described below. If the machine is not equipped with a stacking device, Stacker Mode is disabled.

PACKAGING MODE

When the machine starts, blade 5 lifts to 45°. The stacker is not needed and should be unhooked and folded over at the bottom.(fig. 5-1). A garment is spread on the work table. At cycle start, blade 5 will lower and the garment will be partially under it. As the cycle continues, the garment will be folded over the blade. At the end of the cycle, the blade will lift again to 45° with the garment folded around it. The operator or a second operator can then slip the bag on the garment and remove it from the blade. Special notches have been made in the blade to facilitate grip.

STACKER MODE

The stacker must be installed on the machine and raised to its working position.

The garment is placed on the work table as described above. The selected folding program starts and, at its end, blade 5 will rotate almost 180° and the folded garment on it will be tipped onto the stacker platform. Stacker level will automatically adjust to garment thickness. As the work cycles continue, a stack of garments will be made until full travel (200 mm) has been reached. The machine will stop and the stacker will lift off completely. The display will show the message "Stacker full". The machine can only be restarted when the stacker has been emptied.

TIPPING MODE

This an extra cycle offered by the machine. It is used particularly on machines without stackers combined with a bagging machine. In practice, the program works exactly like stacker mode but tipping will be onto any work table or machine taking the place of the stacker. This is not a standard program and will have to be created specially.

SELECTING A PROGRAM

The machine has 10 standard programs. Follow these steps to select a program:

- press the Stop key (2 Page 10)
- press key "0-9 program" (3 Page 10)
- press the number key for the program you want (0-9)
- press "Enter" (10 Page 10)

The Table below describes the 10 standard programs. Programs 5 to 8 require the use of the stacker. In the Figures, the black rectangle represents the blade making the movement.

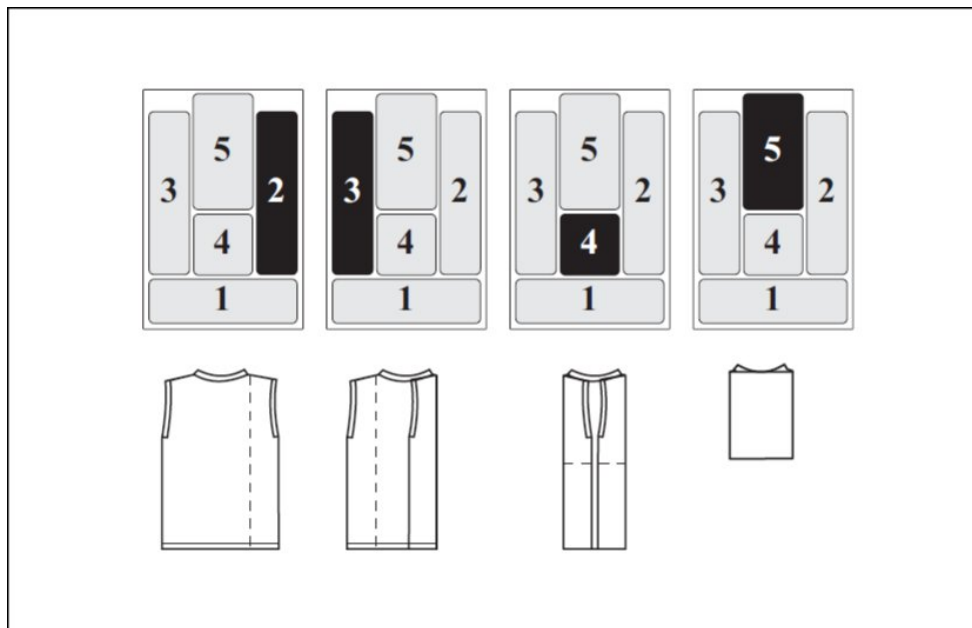
Black rectangle = blade making the movement

Dashed line = next folding line

FOLD SEQUENCE N°0

Name: SHORT BAGGING

Used for small or sleeveless garments or medium weight articles (fleece sweaters or pullovers) using large bags and where sleeves, if any, are hand folded. It is the fastest program.

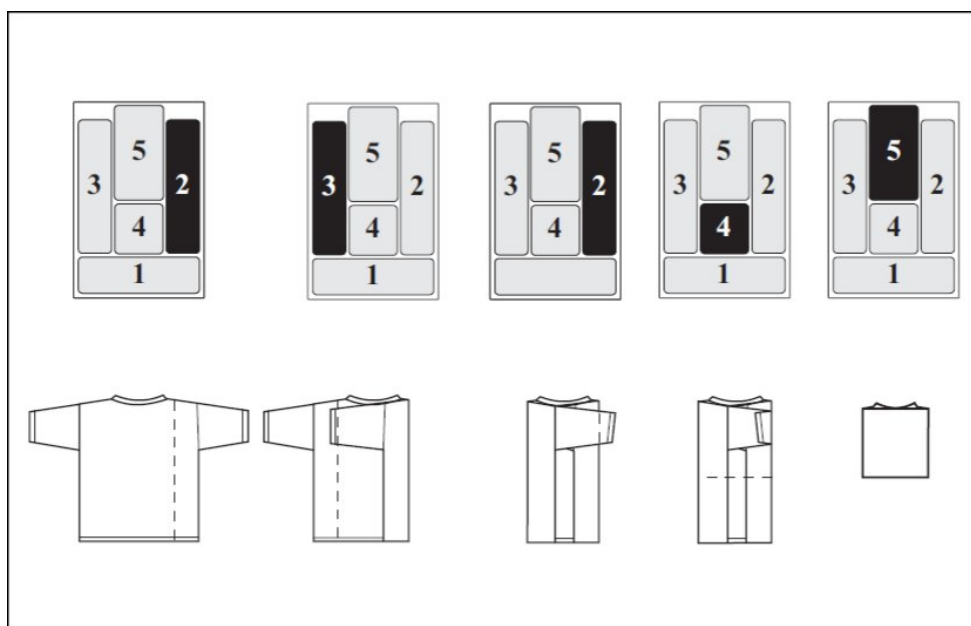


FOLD SEQUENCE N°1

Name: WIDE BAGGING

In addition to the fold program "0", it adds a second side fold.

Used if a sleeve protruted from the fold line.

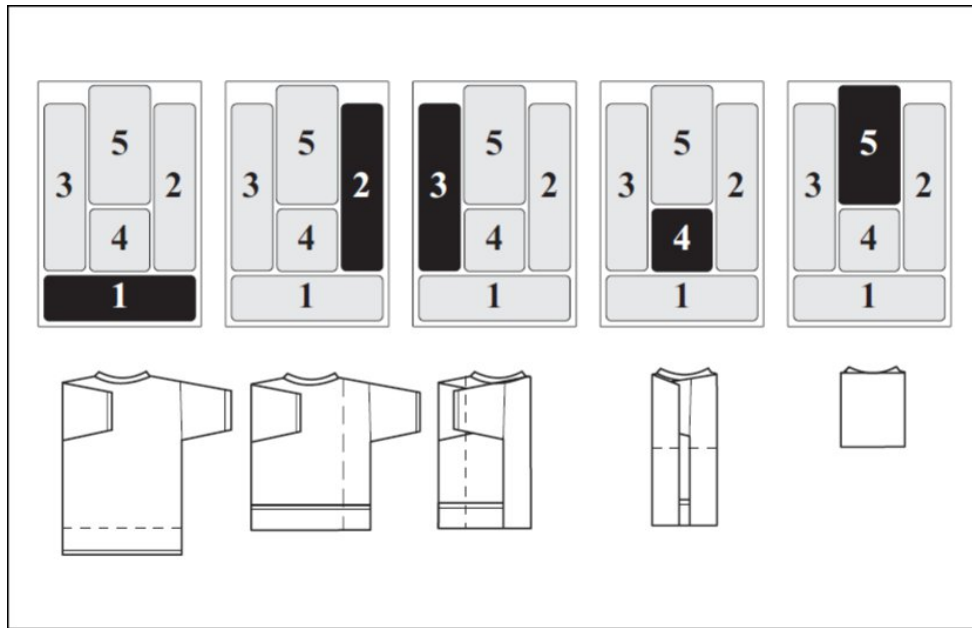


FOLD SEQUENCE N°2

Name: NARROW BAGGING

In addition to the folds in program "0", it adds a bottom fold.

Used for long garments or short bags.

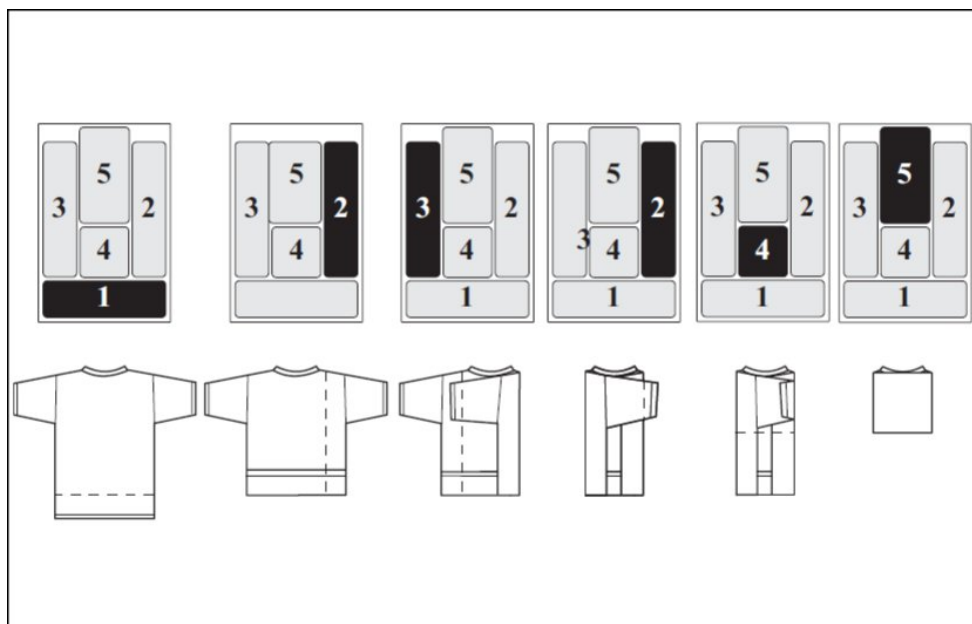


FOLD SEQUENCE N°3

Name: NORMAL BAGGING

Combine programs 1 and 1.

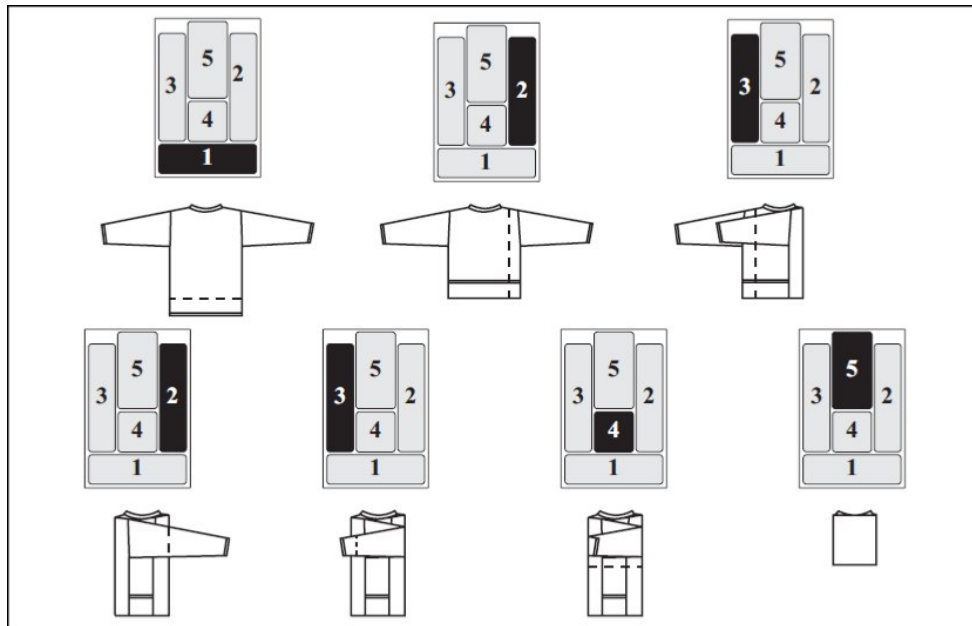
The most commonly used program to pack short-sleeved T-shirts and Polo shirts (or long-sleeved version with hand sleeved folding).



FOLD SEQUENCE N°4

Name: LONG SLEEVE BAGGING

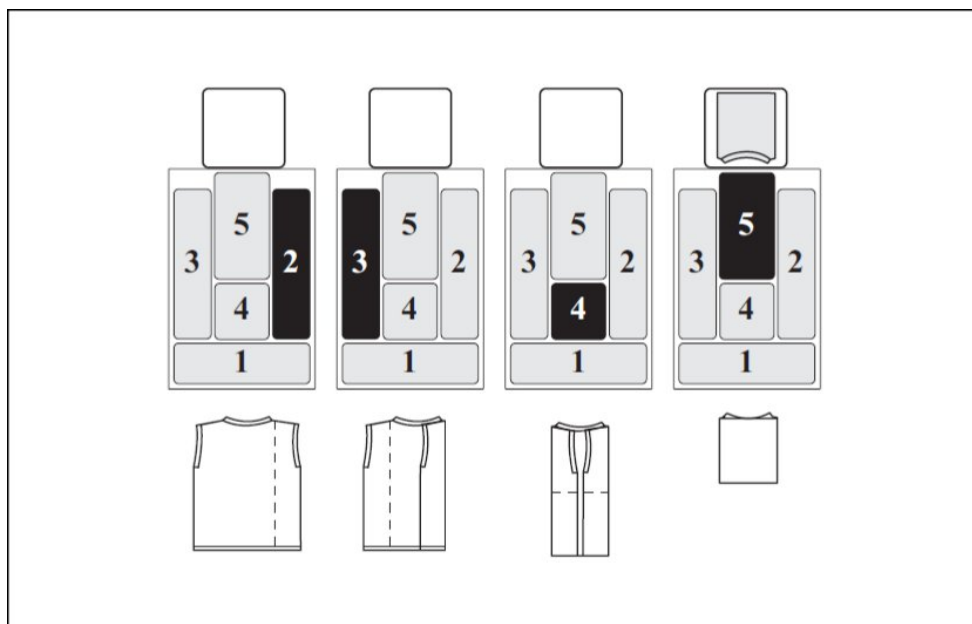
In addition to the folds in program "3", this adds a third fold on the left side. Used with a long-sleeved garment if you only want to fold one sleeve by hand. Handles only light-weight fabrics and when you want speed rather than fold quality.



FOLD SEQUENCE N°5

Name: SHORT STACKER

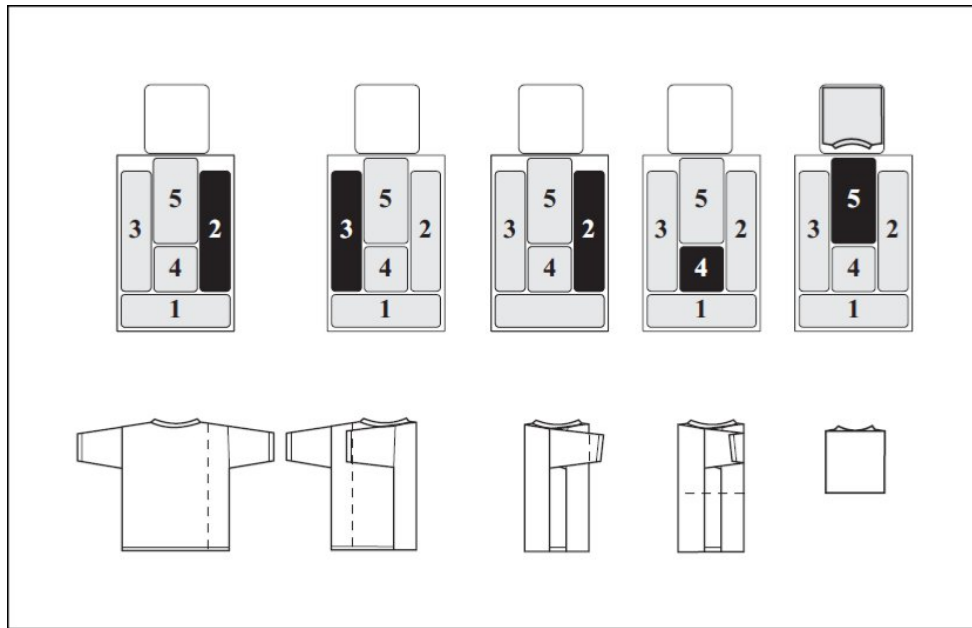
The two sides and centre are folded. Used for small or sleeveless garments or medium weight items (fleece or pullovers) with large bags and hand folding any sleeves. It is the fastest program but not always the most used because if the bottom of the garment is not folded it can come undone when tipped over.



FOLD SEQUENCE N°6

Name: WIDE STACKER

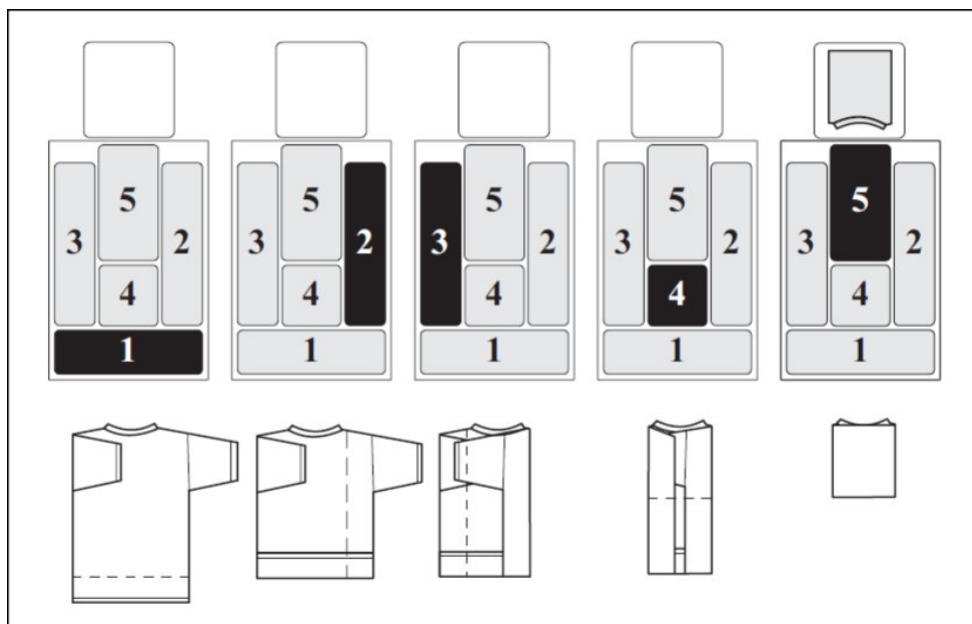
In addition to the fold in program "5", this adds a second fold on the side. Used if a sleeve protudes beyond the fold line. It cannot always be used because, if the bottom is not folded, the garment can come apart when tipped over.



FOLD SEQUENCE N°7

Name: NARROW STACKER

In addition to the folds in program "5", it adds a bottom fold. Used for long garments or short bags.

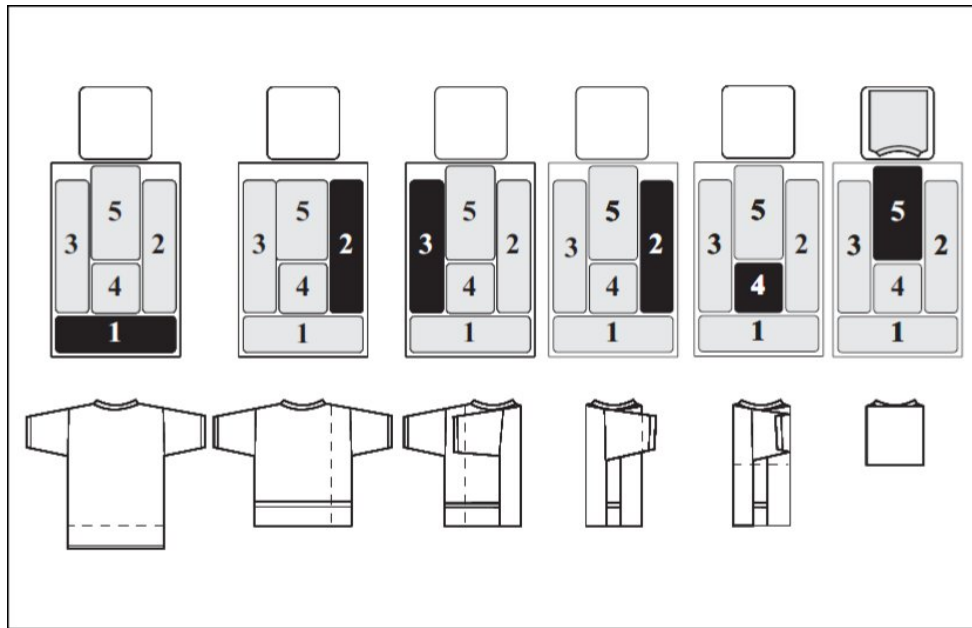


FOLD SEQUENCE N°8

Name: NORMAL STACKER

This combine programs "6 and 7".

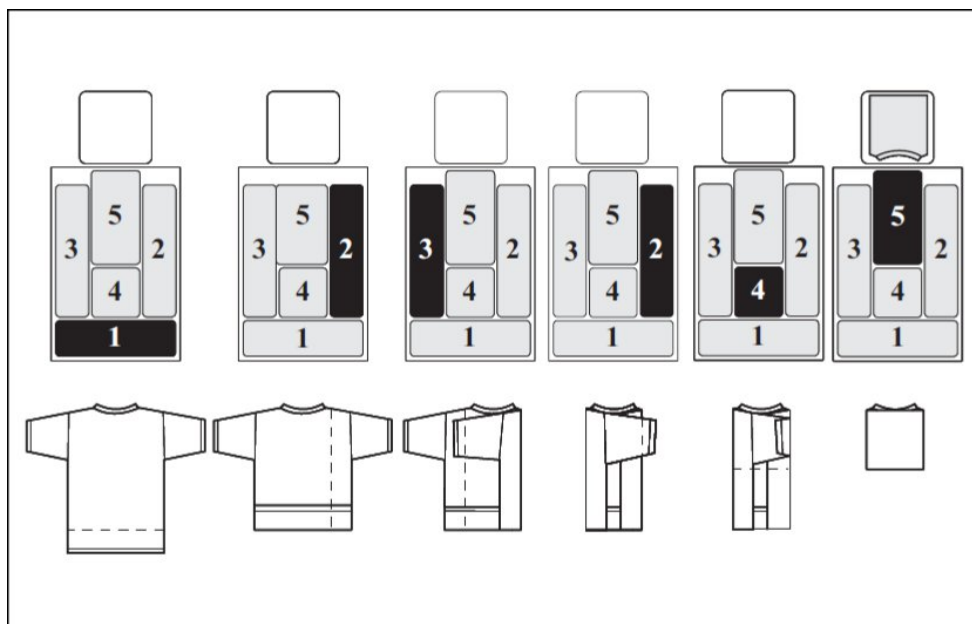
This is the program most used to fold short-sleeved T-shirts and Polo shirts (or long-sleeved ones with manual sleeve folding).



FOLD SEQUENCE N°9

Contains a copy of program 8.

USE THIS PROGRAM TO CHECK OUT YOUR CUSTOMISED FOLDING PROGRAMS



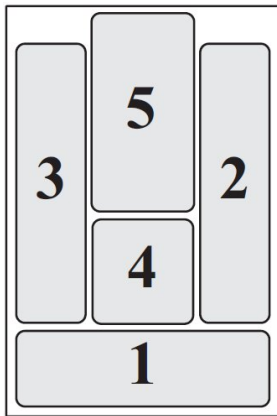
OTHER PROGRAMS

To handle special folding needs, each program can be modified by the user following the instructions given in the specific "Electronic Instrument" manual. The name of the program can also be changed. These operations should only be done by expert personnel. We recommend using program N° 9 as the base for any modifications. If errors are made, a simple command will cancel all the changed and reset the 10 standard programs.

SELECTING FOLDING BLADES

Blade numbering:

as a convention the blades are numbered as highlighted in Figure and these numbers will always be used when referring to blades.



Blade 4 defines the size of the folded garment which must be 2-4 cm less than the bag used.
Blades 4 and 5 must have the same width.

OPERATOR WORK STATION

STACKING MODE:

The operator can work to one side of the machine or in front of it. Working from the side can be more convenient especially when folding sleeved garments. The operator in this position does not have to bend forward to spread the garment on the work table.



BAGGING MODE:

If the job is done by a single operator, the work station will be behind the machine. In this case, fold the stacker downwards so it is not in the way.

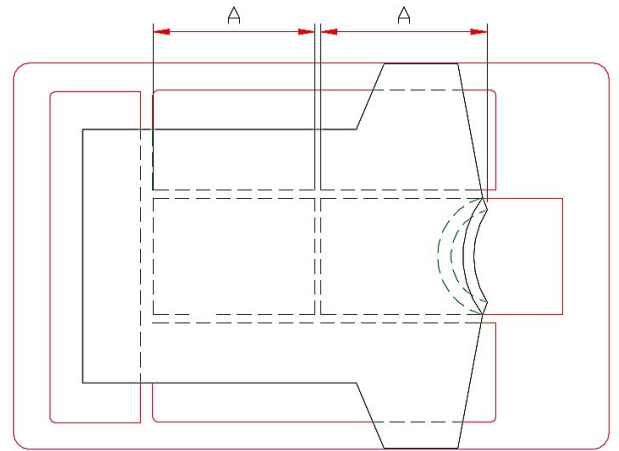
The machine can be run by two operators. In this case, the operator who is to spread the garment on the work table, will be at the side or in front of the machine. The operator who positions the bag and removes the bagged garment, should stand behind the machine.



POSITIONING THE GARMENT TO BE FOLDED

Some basic rules for placing the garment on the work table must be followed to guarantee good folding results. To simply matters, let's use a sleeveless article such as a T-shirt to illustrate these rules.

- Place the T-shirt with the front against the folding table.
- Centre the T-shirt on the table.
- To define the position for the neck, mark a point from the free edge of blade 5 edge equal to the length of blade 4. The mark can be made with a strip of paper adhesive tape on which you can trace the line of the neck for greater precision in positioning.



REGULATING THE BLADES

When blades are changed, their position will have to be adjusted as needed. The machine is designed to facilitate a wide range of regulations so that different format blades can be used. Blades are regulated by screwing the adjusting screws in holes on the front and right panels in or out. The machine's tool kit includes a special spanner for doing this. Symbols near the holes describe their functions.

- Always switch the machine off to prevent it from being started by accident.
- Do not force the screws. If, when you turn them in one direction you encounter resistance, try turning them in the opposite direction (the screw is probably all the way in or out).

The blades should be 5-15 mm apart. If they are closer, they can interfere with each other and fold quality will be less.



REGULATING BLADE POSITION

- Always switch the machine off to prevent it from being started by accident.
- Do not force the screws. If, when you turn them in one direction you encounter resistance, try turning them in the opposite direction (the screw is probably all the way in or out).

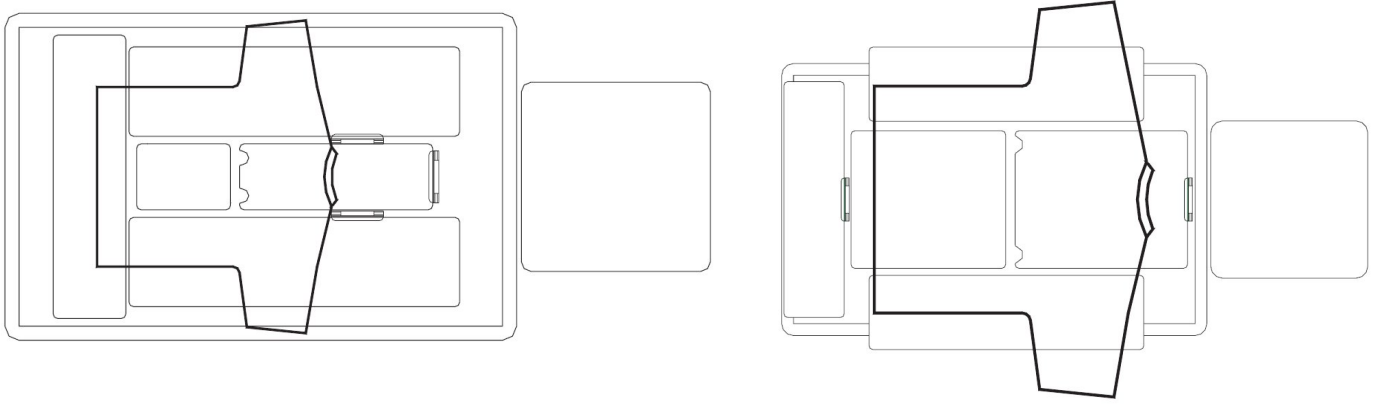
Let's presume that our machine is configured with medium type blades (220 x 300 bag).

To install the small blades follow these steps:

- 1- If installed, remove the support table used for bagging mode.
- 2- Change blades 4 and 5 .
- 3- Move blade 4 close to 1.
- 4- Move blade 5 closer to 4.
- 5- Move blades 2 and 3 closer to 4 and 5.
- 6- If bagging mode is to be used, replace the top for the new format.

To install the large blades follow these steps:

- 1- If installed, remove the top used for bagging mode.
- 2- Spread blades 2 and 3 as far apart as possible
- 3- Move blade 5 to the end of the machine. move blade 1 away change blades 4 and 5 .
- 4- Move blade 4 away from 5 to leave the right amount of space (See 7.3)
- 5- Move blade 1 closer to 4.
- 6- Move blades 2 and 3 close to 4 and 5.
- 7- Remove blades 2 and 3 and reinstall them at the correct distance from blade 1
- 8- If the machine is to be in bagging mode, place the top for the new format the figure shows that blade 1 does not need to move.
- 9- The program best suited for this job is : 0-1-5-6



STOPPING THE MACHINE

Turn the power supply switch to "0" (OFF). This will also discharge the air from the pneumatic cylinders.

Emergency Stop. This will shut the machine down immediately and discharges the air from the pneumatic cylinders. It works when the red mushroom shaped button on the START pedal pedestal. The fact that the emergency button is on the control console ensures that it is always within easy reach of the operator whatever work position is adopted.

MAINTENANCE

DISCONNECT THE MACHINE

Before any kind of service, maintenance or repair work, disconnect the machine from its power sources by removing the plug from the power socket and disconnecting the compressed air hose.

SPECIAL PRECAUTIONS

When doing service, maintenance or repair work, follow these recommendations:

Do not use solvents or flammable substances.

Do not stand on any part of the machine as it has not been designed to hold the weight of a person.

At the end of the work, replace the guards and casings removed or opened and fix them correctly.

CLEANING THE MACHINE

It is good standard operating practice to clean the machine on a regularly scheduled basis (frequency will depend on how and how much the machine is used). Clean the machine throughout using a vacuum cleaner and compressed air.

Disconnect all machine power sources.

Before cleaning the machine the operator must be equipped with all suitable protective clothing and devices.

ROUTINE MAINTENANCE

The simple design of the machine reduces routine maintenance to checking retainer tightening performance regularly since vibration can have caused them to slacken off. The compressed air fittings use special seals that do not require lubrication. The air filter condensation collecting jar automatically drains when the circuit is depressurised.

Weekly: depressurise the "speedy t 2005". Clean the stacker photocell with compressed air.

EXTRAORDINARY MAINTENANCE

The operations for which reference should be made to Authorised Technical Assistance Centres are listed below. However, they can also be done by qualified Service Engineers authorised by Manufacturer.

Extraordinary maintenance includes work needed because of unusual events such as:

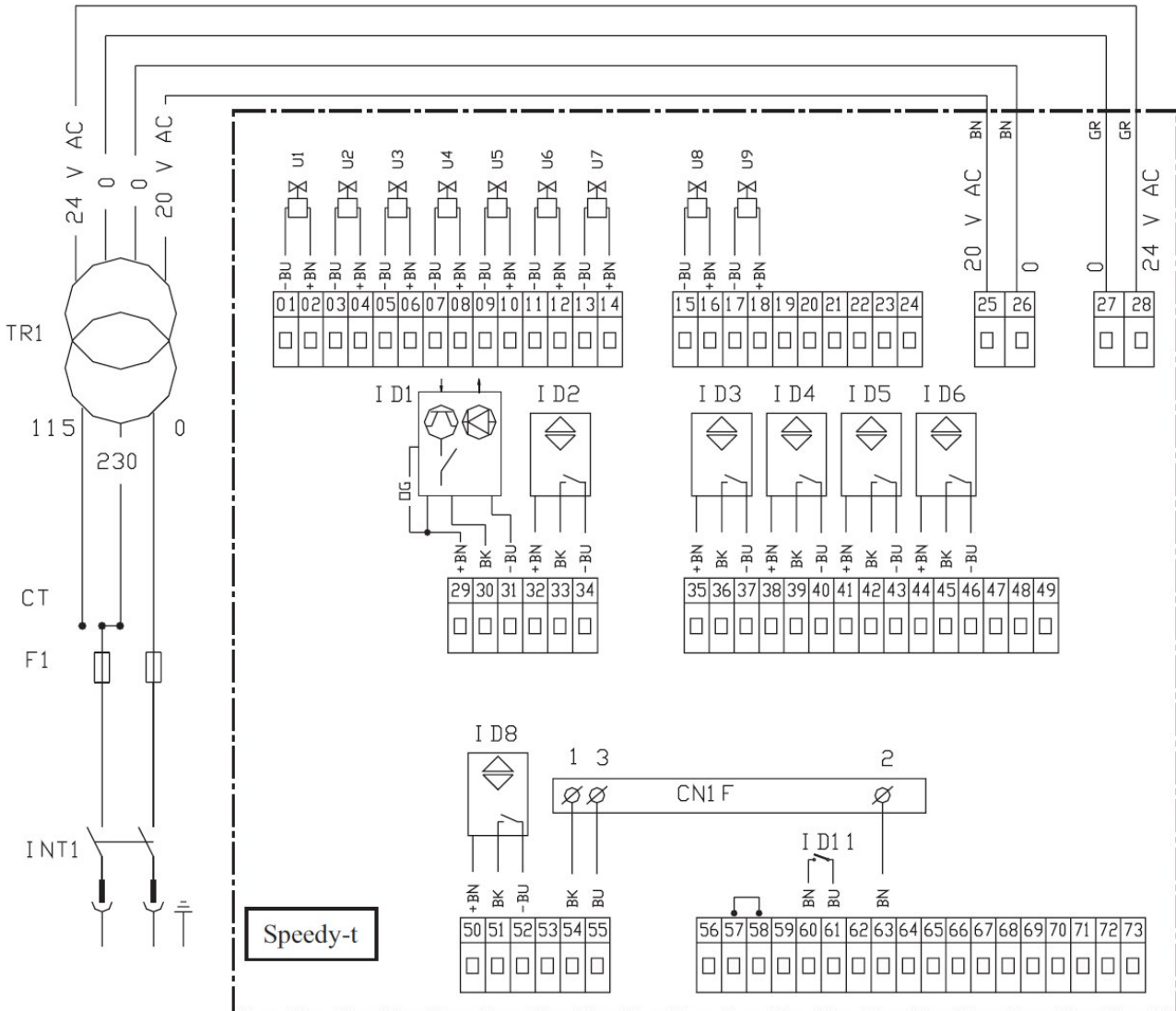
Breakage
Overhauls

MAINTENANCE	DESCRIPTION	MACHINE STATUS
Change a solenoid valve	Remove the two screws retaining the control panel and open the panel. Find the defective solenoid by means of the wire it is connected to. Detach the air hoses and the electric connector, remove its retainer screws and change the solenoid. Make sure the seals are positioned correctly.	Unplug the machine from the power socket and disconnect the compressed air hose.
Change a cylinder proximity sensor.	Remove the cylinder runner. Remove the regulating screw plate. Disconnect the air hose supplying the cylinder and the sensor pin. Remove the assembly from the machine. Change the sensor moving the head of the screw that energises it to about 1 mm from the sensor. Replace everything.	Unplug the machine from the power socket and disconnect the compressed air hose.
Change an air cylinder	Disconnect the air hose from the cylinder. Remove the retainer screws on the bottom pin plate. Remove the clips on the fork on the cylinder piston. Remove the cylinder and change it.	Unplug the machine from the power socket and disconnect the compressed air hose.
Changing a power supply fuse.	Remove the voltage change jumper using a screwdriver. Change the blown fuse. IMPORTANT: before switching the machine back on, find out why the fuse blew. Likely causes are: defective transformer, a short circuited solenoid or a faulty wire.	Unplug the machine from the power socket

DEMOLITION

When demolishing the machine, separate the plastic parts and the electric components which will then be disposed of correctly in compliance with current solid urban waste disposal regulations covering the country when the machine is installed.

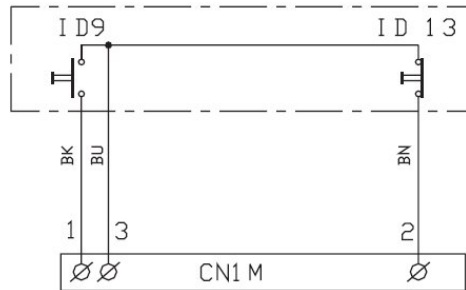
The metal structure of the machine should be separated into steel, alloys and other metals so that they can be correctly recycled.



GRUPPO START-STOP

COLORI

- BN = BROWN (MARRONE)
- BK = BLACK (NERO)
- BU = BLUE (BLU)
- OG = ORANGE (ARANCIO)
- GR = GREEN (VERDE)



LEGENDA

INT 1	=	POWER SUPPLY SWITCH.
F1	=	GLASS FUSE 5 X 20 2 A.
CT	=	CHANGING VOLTAGE DEVICE.
TR1	=	TRASFORMER 30 VA PRIMARY 115/230 V SECONDARY 20/24. V
Speedy-t	=	MICROCOMPUTER.
CN1F	=	CONNECTOR 4 POLES TONGUE.
CN1M	=	CONNECTOR 4 POLES GROOVE.
U1	=	ELECTROVALVE MAIN.
U2	=	ELECTROVALVE BLADE 1.
U3	=	ELECTROVALVE BLADE 2.
U4	=	ELECTROVALVE BLADE 3.
U5	=	ELECTROVALVE BLADE 4.
U6	=	ELECTROVALVE BLADE 5 STROCKE 25mm.
U7	=	ELECTROVALVE UPSTROCKE OF STACKER.
U8	=	ELECTROVALVE DOWNSTROCKE OF STACKER.
U9	=	ELECTROVALVE BLADE 5 STROCKE 50.
ID1	=	PHOTOCELL STACKER CONTROLL.
ID2	=	PROXIMITY SWITCH' BLADE 1.
ID3	=	PROXIMITY SWITCH' BLADE 2.
ID4	=	PROXIMITY SWITCH' BLADE 3.
ID5	=	PROXIMITY SWITCH' BLADE 4.
ID6	=	PROXIMITY SWITCH' BLADE 5.
ID8	=	PROXIMITY SWITCH' STACKER DOWN.
ID9	=	PEDAL START.
ID11	=	SENSOR OF PRESSURE TONGUE.
ID13	=	EMERGENCY STOP.

