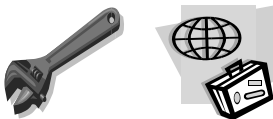
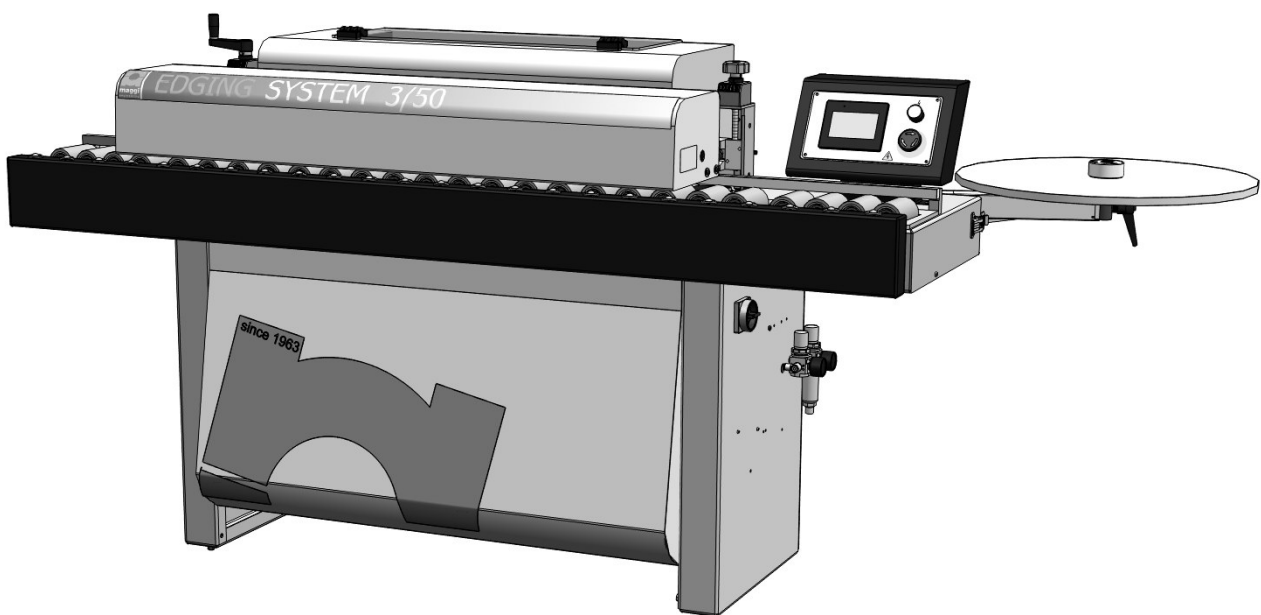




WOODWORKING MACHINERY



MACHINE CODE

MANUAL CODE
REV

18509101 / 18509102 /
18509111 / 18509118
00008323
07 09/2015



ALWAYS KEEP THIS MANUAL TOGETHER WITH THE MACHINE

EDGING SYSTEM 3/50

ORIGINAL USE AND MAINTENANCE MANUAL

WE WISH TO THANK YOU FOR CHOOSING ONE OF OUR PRODUCTS

All the information, advices and important warnings for a correct use of the machine, have been inserted into this manual. This manual also contains the rules for a correct periodical maintenance to keep this machine in perfect efficiency. We suggest that all the chapters of this manual are thoroughly read before you use the machine for the very first time.

INTRODUCTION

Some information and illustrations in this manual may differ from the machine in your possession, since all the configurations inherent in the machine complete with all the OPTIONALS are described and illustrated. Therefore, refer only to that information strictly connected with the machine configuration you have purchased. The manufacturer in his pursuit of a policy of constant development and updating of the product may make any modifications without any prior notice.

This manual has been drawn up exclusively for our customers' use, guaranteeing that at the date of issue it constitutes the latest update of the documentation related to use of the product. Use of this manual is on full responsibility of the user. The manufacturer does not grant any further guarantee for any imperfections, incompleteness and/or operating difficulties, expressly excluding any responsibility for direct or indirect damage deriving from use of this documentation. MAGGI TECHNOLOGY reserves the right to make any modifications to the product described in this manual at any time without prior notice.

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1. GENERAL INFORMATION



1.1 MANUFACTURER'S DATA

Manufacturer:	MAGGI TECHNOLOGY S.r.l.
Address:	Via delle Regioni, 299 - 50052
City:	CERTALDO (FI)
Nation:	ITALY
Tel.	+39 0571 63541
Fax.	+39 0571 664275
E-mail:	service@maggi-technology.com

1.2. MACHINE IDENTIFICATION

The data impressed in the plate placed on the left side of the machine (from the point of view of the operator) identify the machine itself. When you eventually order spare parts or ask for any suggestions for use or maintenance, you have always to transmit the model type and identification number contained in the plate.

It is absolutely forbidden to remove the plate or modify the data it contains.

	MAGGI TECHNOLOGY S.R.L. Via delle Regioni, 299 50052 Certaldo Firenze - Italy	
Type:		MADE IN ITALY
Serial n°:		
Year:		
V:	PH:	HZ:
KW:	A:	

1.3. RECOMMENDATION FOR USE AND MAINTENANCE

In this manual we put into evidence all the operations for a correct use and ordinary maintenance of the machine.

The machine must be used only by qualified users and personnel of age. The responsible for safety must be sure that users of the machine have read and understood all the information contained into this manual.

The personnel for both ordinary and extraordinary maintenance must be well prepared in mechanics and electricity.

Keep off any parts in movement of the machine. Keep particular attention to the finishing tools, the cutting tools, the feeding belt. Do not touch all the parts of the glue unit and the parts nearby: the unit work at very high temperature and there is high danger of burn.

We strongly recommend not to make any other type of work, repair or operation not suggested in this manual. All the operations concerning disassembling parts must be done to authorised technical personnel.

Always follow carefully all the instructions contained in this manual for a correct use of the machine. We suggest also to keep this manual in a place where the user can easily find and read it.

A careful and conscientious observance of all the instructions written in this manual will afford you to use safely and correctly the machine.



**ANY ADULTERATION OR REMOVAL OF SAFETY PROTECTION DEVICES CAN CAUSE SEVERE DAMAGE.
ANY REMOVAL, EXCLUSION OR MODIFICATION OF THESE DEVICES IS STRICTLY FORBIDDEN.
YOU MUST VERIFY AND GUARANTEE THE PERFECT RUNNING OF SAFETY DEVICES BY MEANS OF PERIODIC CHECKS. ANY DEFECT OR PROBABLE DRAWBACK MUST BE IMMEDIATELY RESOLVED.**

1.4. DECLARATION OF CONFORMITY



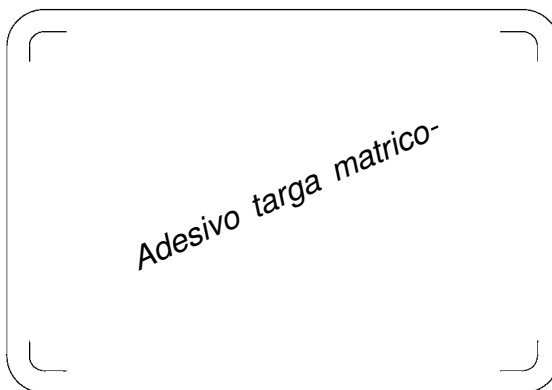
EC Declaration of Conformity

The manufacturer

Maggi Technology S.r.l.
Via delle Regioni, 299 - 50052 Certaldo (FI) ITALY

Declares that the machinery

<i>The machinery</i>	<i>EDGE BANDER</i>
<i>Model</i>	<i>EDGING SYSTEM 3/50</i>



complies with all relevant provisions of the directive:

2006/42/EC	(Machine)
2004/108/EC	(EMC)

and compile the technical file of the above machinery.

DATA

Certaldo
The General Manager

Giacomo Landi



2. SPECIFICATIONS

2.1. GENERAL DESCRIPTION OF THE MACHINE

The machine was designed and built to apply edges with automatic feeding on straight wooden panels (and/or made of similar material) having square faces. Here below you can find a brief summary of the main characteristics of the machine:

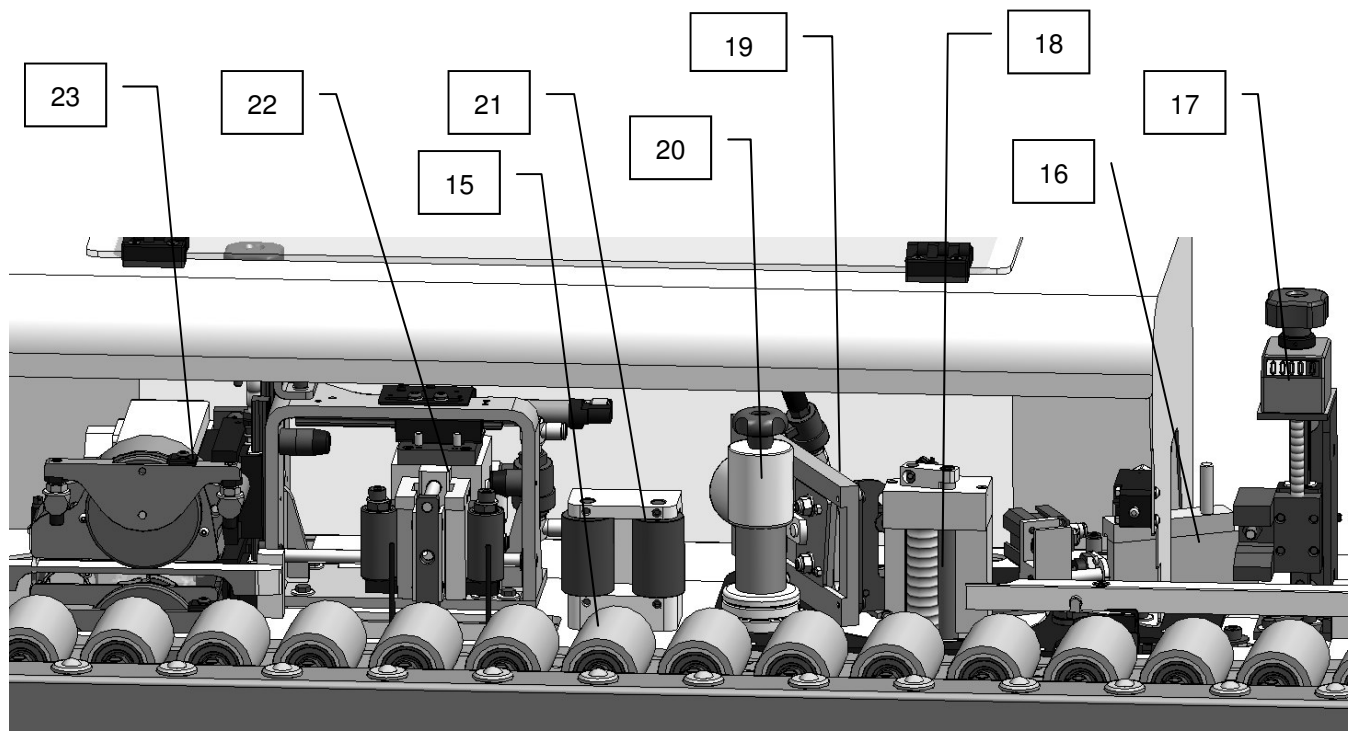
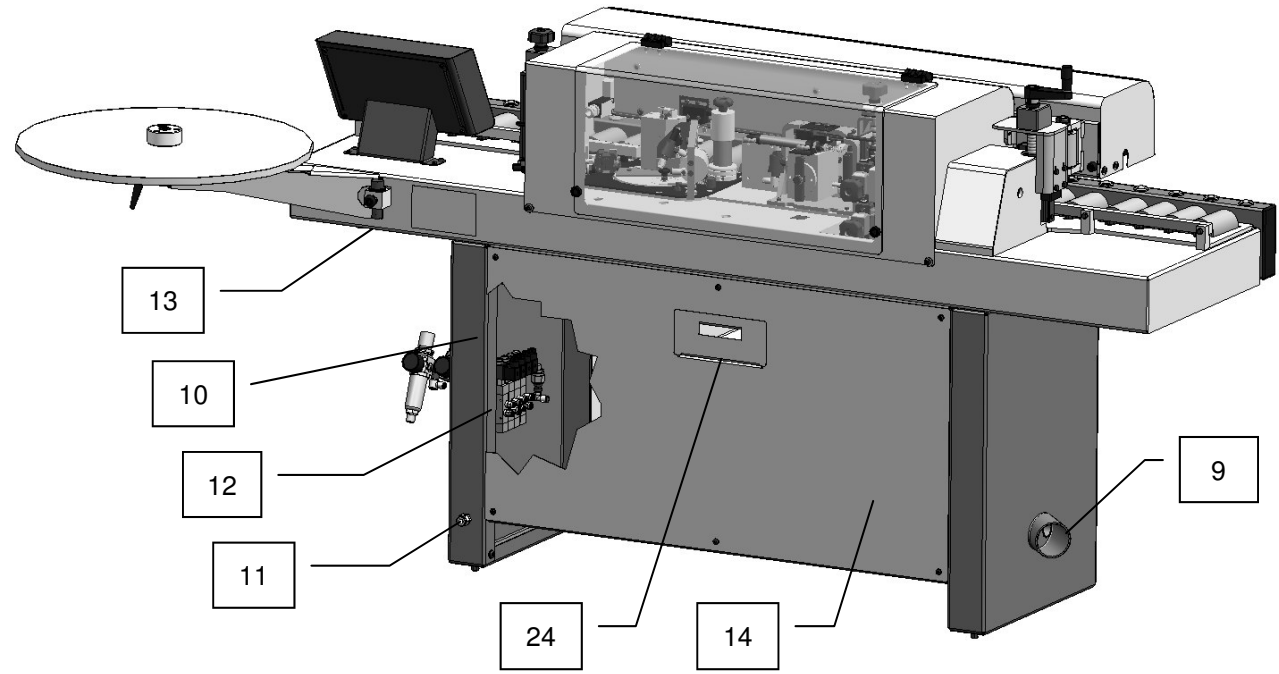
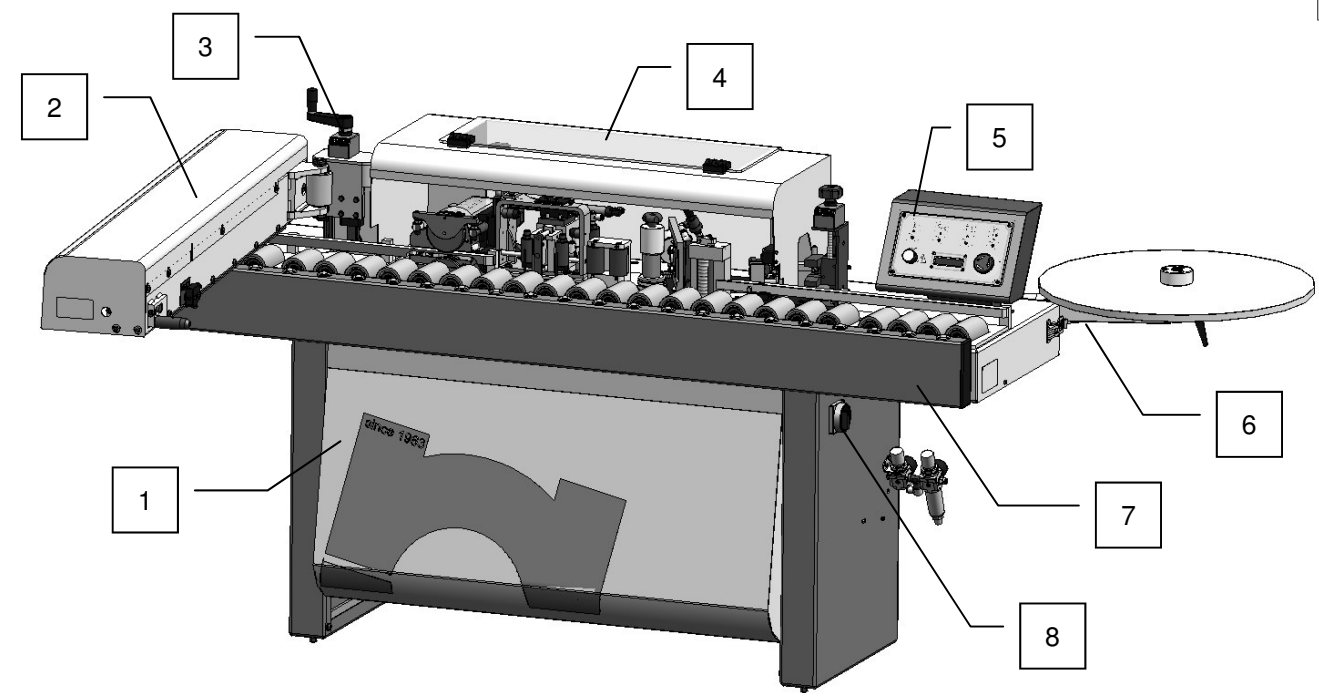
- Automatic edge banding machine for straight panels
- Glue pot with motorized glue roller
- Automatic guillotine with “with self-aligning system” for cutting the edge
- Electronic regulation of the maximum/minimum glue pot temperature
- Front/rear end-cutters with blades
- High-frequency edge-trimming tools with widia-made cutters
- Large copying disks assembled on ball-bearing
- Adjustable input guide for the edge
- Numerical counter for trimmers regulation
- EC standards

The main parts of the machine are:

- | | |
|---|--|
| 1. Steel frame | 13. Panel for inspection and maintenance |
| 2. Feeding belt for panels | 14. Roller-made working table |
| 3. Handwheel for adjusting height of feeding unit | 15. Edge banding inserting group |
| 4. Upper cover | 16. Locking system for feeding belt |
| 5. Control panel | 17. Edge gluing group |
| 6. Reel support | 18. Guillotine cutting unit |
| 7. Adjustable supporting for large panels | 19. Edge-feeder rubber roller |
| 8. Main switch | 20. Pressing rollers structure |
| 9. Suction hood | 21. End cutter unit |
| 10. Pneumatic connection | 22. Edge trimming unit |
| 11. Electric connection | 23. Drawer |
| 12. Pneumatic panel | |

2.3. TECHNICAL DATA

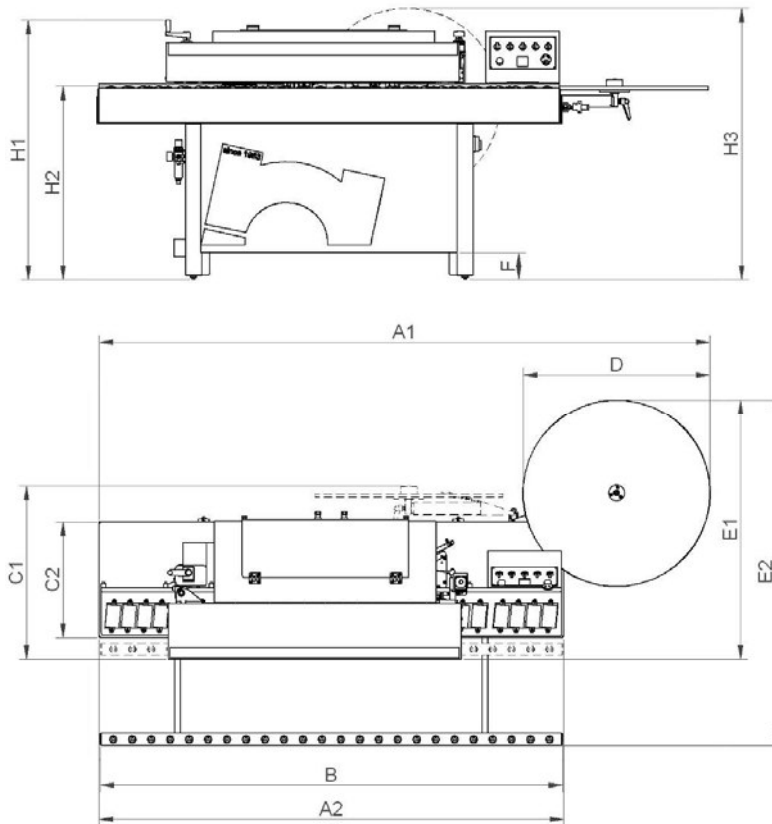
<i>CHARACTERISTIC</i>	<i>VALUE</i>
Dimensions of working plane	2000 x 250 (MAX 635) mm
Height of working plane	870 mm
Edge banding thickness (min/max)	0,4 / 3 mm
Working panel thickness (min/max)	12 / 50 mm
Motorized feeding belt speed	~ 6 m/min
Trimmer speed	10000 rpm
O.D. of edge trimmers (widia-made tool)	80 mm
O.D. of suction hood	80 mm
O.D. of reel	650 mm
Glue working temperature max	~ 210°C
Glue pot capacity	1,2 kg
Feeling belt motor power	0,18 kW
Edge trimmer motor power	2 x 0,37 kW
Glue roller motor power	0,18 kW
Total installed power	~ 2,4 kW
Net weight	330 kg
Working dimensions (max)	2650 x 1550 x 1200 (H) mm
Shipping dimensions (external)	2050 x 760 x 1200 mm



2.3. MACHINE DIMENSIONS

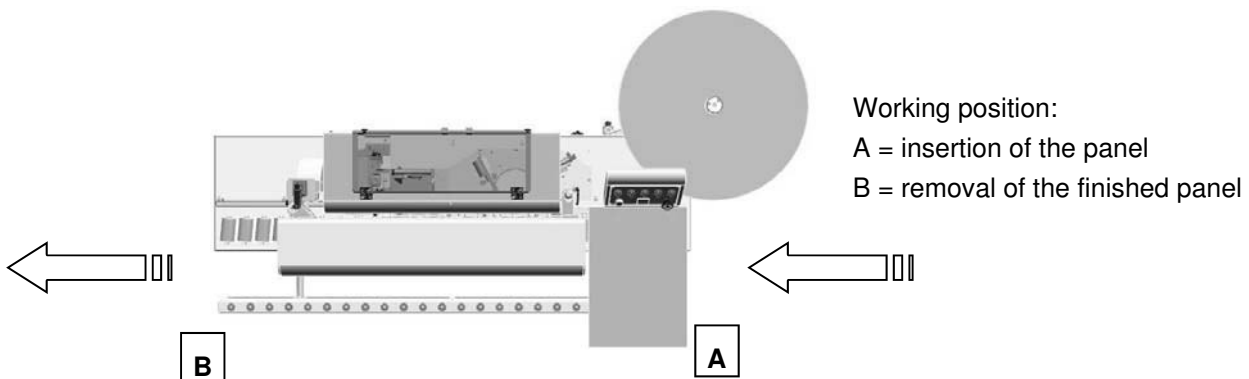
Below you can find the main working dimensions of the machine (dimension in mm)

A1	A2	B	C1	C2	D	E1	E2	F	H1	H2	H3
2550	2010	2000	750	500	615	1010	1400	118	1160	870	1120



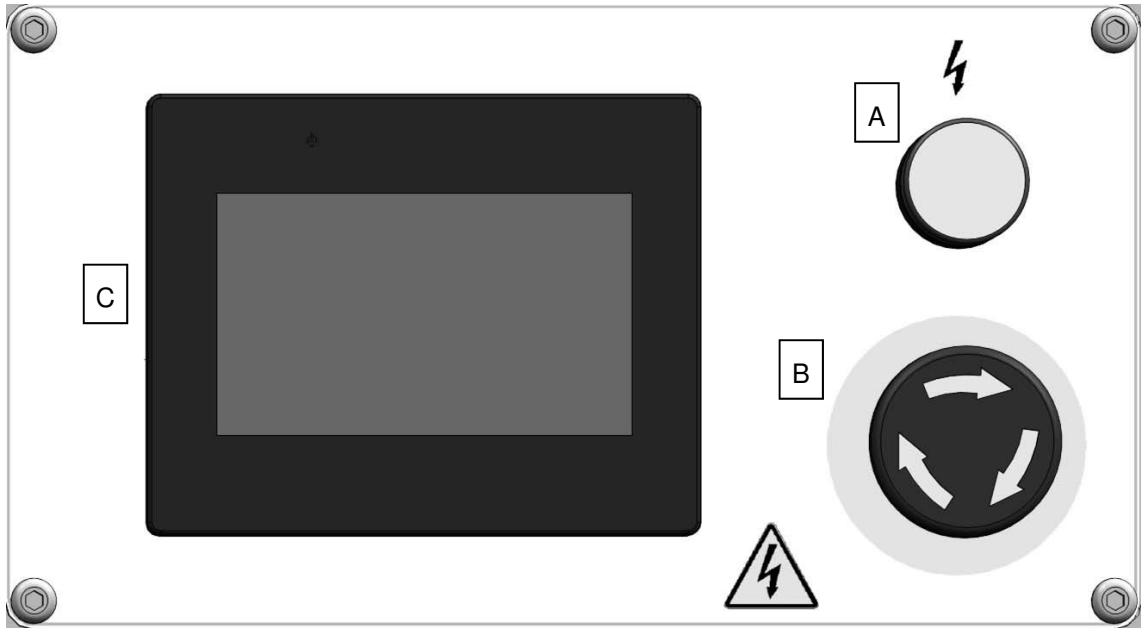
2.4. INTENDED USE

- All the materials not similar to wood are not allowed: the end user is directly responsible for any damage caused by a different use of the machine respect the one specified in this manual and with different materials respect the ones the machine was designed for.
- Always connect the machine to a well-dimensioned shaving suction system
- It is strictly forbidden to modify any protection devices and use the machine if all the protection devices are not correctly installed
- Any operation that does not comply with the instructions given herein is to be regarded as improper use.
- It is strictly forbidden to modify any parts of the machine. If modifications are made, the Declaration of Conformity is no longer valid.
- The data impressed in the plate placed on the left side of the machine identify the machine itself. When you eventually order spare parts or ask for any suggestions for use or maintenance, you have always to transmit the model type and identification number contained in the plate.
- The machine was designed to be used by one operator only.

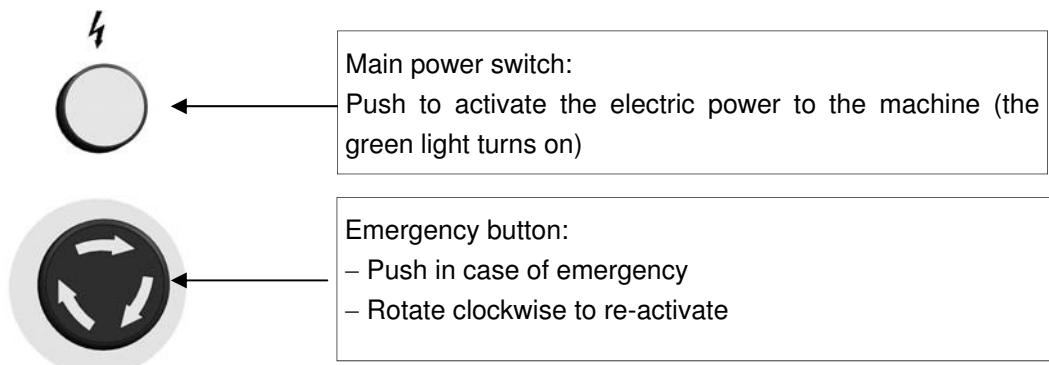


The manufacturer cannot be considered liable for any damage caused to people, animals or property resulting from improper use of the machine.

2.5. CONTROL PANEL



A	Main power switch
B	Emergency mushroom button - It is a mechanically-operated push-button, to disconnect the button pull and rotate it clockwise
C	Display touch screen



3. INSTALLATION



- Lifting and handling should only be carried out by skilled personnel specially trained to execute this kind of operations.
- Make sure that the area all around is free from obstacles and that no one is standing under the overhung load and/or within the system used to lift, move and/or transport the machine.
- During all the handling operations pay maximum attention to prevent danger of damages to persons, things and to the machine itself.

3.1 LIFTING AND TRANSPORTATION

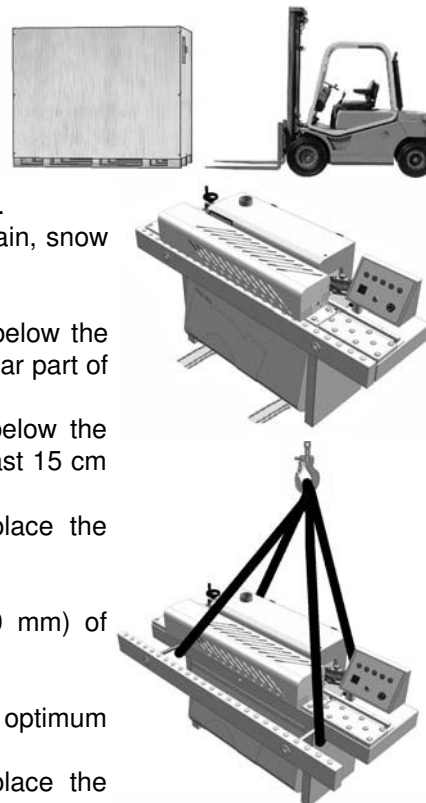
The boring machine is packed in a wooden box and/or in cardboard and nylon. It is possible to move it by means of forklift, bridge crane (or crane), transpallet. Before starting the manoeuvres, free the machine of all the parts used for transport or packaging that have remained on the machine. Check that the capacity of the hoisting means is greater than the gross weight of the machine (please see the chapter named TECHNICAL DATA). In case of stocking, the machine must be kept in dry places, away from rain, snow or humidity.

If you use a forklift or a transpallet to handle the machine:

- If the machine is still placed on the pallet, insert the forks for lifting below the upper surface of the pallet until they protrude at least 15 cm from the rear part of the pallet;
- If the machine is no more on the pallet, insert the forks for lifting below the central lower part of the frame of the machine until they protrude at least 15 cm from the rear part of the frame itself;
- lift carefully and slowly, without causing the load to swing, and place the machine in the selected setting.

If you use a bridge crane (or crane) to handle the machine:

- Use appropriate lifting belt of the same length (approximately 2000 mm) of suitable capacity;
- Fasten the slings to the bridge crane having adequate lifting capacity;
- Move the bridge crane by small steps to allow the slings to settle, until optimum stability conditions are reached;
- lift carefully and slowly, without causing the load to swing, and place the machine in the selected setting.



3.2. MACHINE PLACING

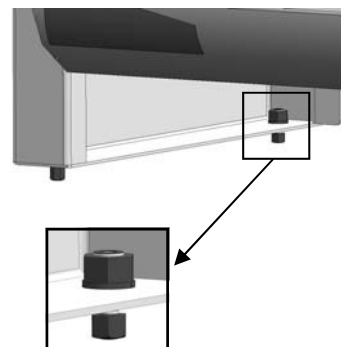
It must be installed inside an illuminated, ventilated and closed industrial building having a solid and levelled floor, capable to support the weight of the machine itself; any possible difference in height must be in conformity with building rules. When the machine has to be placed on raised plain surface (higher floor) the load-bearing slab must be adequate to the weight of the machine. Temperatures from 5° C to 40° C with a humidity of max. 40% at 40° or max. 90% at 20°.

Put the machine in the right place, as requested operative requirements, where it is easy to connect it to electrical and pneumatic power supply and to the suction system (if any). Put the machine in a place where there is enough lighting to see every part of the machine itself.

The lighting of the premises must comply with the law in force in the Country where the machine has been installed. Lighting must grant complete visibility, avoid dangerous reflections, permit reading of the control panels and individuation of the emergency push buttons and must not interfere with other devices eventually installed on the machine.

Adjust the levelling feet so that the machine is perfectly leaned on the floor, then align the working table of the machine by using a spirit level.

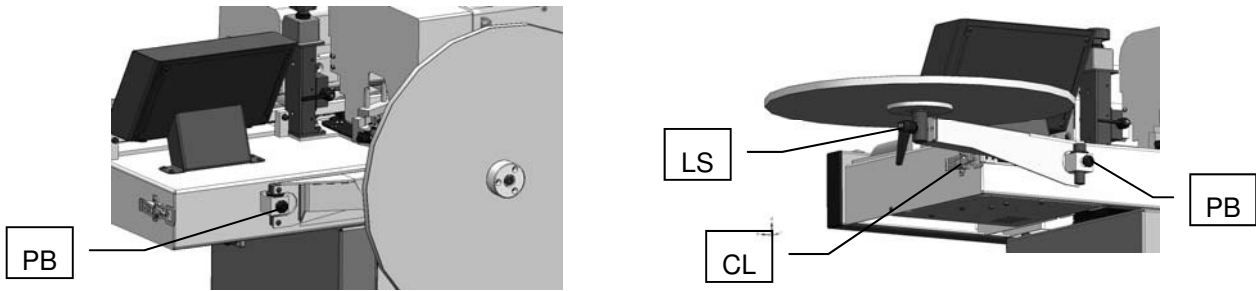
To clean the machine do not use any solvent as gasoline and diesel oil, because they can damage the paint, making it dull, or oxidize other parts.



3.3. ASSEMBLING PARTS

To reduce the size of the packaging and ensure a safer transit the machine is shipped partially disassembled so that all dismantled parts have to be fixed on the machine before installation. When unpacking the machine You have to check that no component got damaged during transport.

REEL SUPPORT: To position the reel support do unscrew the knob on the machine frame and turn the support by 90°. Collapse the support by using the click lever and turn it again by 90°, then lock it by using the over mentioned click-lever and fasten the knob on the machine frame.



3.4. CONNECTION TO THE ELECTRIC POWER SUPPLY

We recommend not to connect the machine to the electrical power supply until it is not correctly placed in the right place. Before connecting the machine to the electrical power supply, it is necessary to verify that the electrical system corresponds to the following necessary power and safety requirements:

- Make sure that the electrical circuit of the building where is placed the machine is correctly grounded and that the part of the circuit to be connected to the machine is perfectly working
- Make sure that a differential thermal circuit breaker has been fitted upstream from the mains section connecting the machine (safety switch)
- **The electrical power line must carry an efficient ground line** (grounded equipotential electrical system).
- Presence of fuses or protection switches against short circuits on every conducting cable R-S-T, except the grounded one
- The electrical power system must be in conformity with CEI 64.8 (CENELEC HD 384, IEC364-4-41) rules
- Check that the mains voltage (V) and frequency (Hz) are as those indicated.
- The tolerance of admissible voltage is +/-10%

Besides:

- **The cable for ground connection is yellow-green.**
- **Connect the phases to the R-S-T terminals, the neutral line to the N terminal and the ground line to the terminal with the ground-symbol**

For any further reference, please check the wiring diagram given together with this manual.

<i>descrizione</i>	<i>simbolo</i>	<i>colore</i>
messa a terra		giallo-verde
fase	R - S - T oppure L1- L2—L3	

WARNING: THE ELECTRICAL CONNECTIONS, THE CHECKING AND ALL THE MAINTENANCE INTERVENTIONS ON THE ELECTRIC CIRCUIT MUST BE DONE BY QUALIFIED TECHNICAL PERSONNEL ONLY.



BE CAREFUL WITH THE ELECTRICAL CONNECTION

- AN ERROR IN THE ELECTRICAL CONNECTION MAY CAUSE HAZARDOUS SITUATIONS FOR OPERATORS AND IRREPARABLE DAMAGE TO SOME MACHINE COMPONENTS

The manufacturer is not responsible for damages caused by a wrong electrical connection of the machine or by problems due to malfunctioning of the electric connection or the electric power supply.

Connect correctly the machine to the electric power supply, then start the machine and check that the feeding belt moves in the right direction (clockwise). If the feeding belt moves in the opposite direction, stop the machine, disconnect it to the power supply and invert two phases out of three in the electrical connection (R-S-T or L1-L2-L3); NEVER make modifications, for any reason, ground connections.



3.5. PNEUMATIC CONNECTION

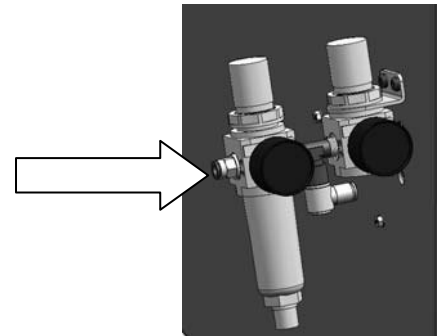
The required network pressure for the pneumatic system must be 6 bar at least. Use filtered, dehumidified, non-lubricated air to preserve all the pneumatic components of the machine from damage (lubrication damages the pneumatic system).

Connect the machine with the pneumatic supply using a rubber-made or nylon-made pipe having a minimum I.D. of 8 mm. If the connecting pipe is longer than 5-6 meters, we suggest you to use a larger pipe, with at least an I.D. of 10 mm.

We also suggest you to install a manual ON-OFF valve having an air-discharge system (if not given together with the machine) to easily disconnect the machine from the pneumatic air supply.

ATTENTION: to guarantee the correct working conditions for all the pneumatic components, the machine has a device prevents it from starting if the air pressure is lower than 6 bar.

<i>Supplying pipe dimensions</i>	<i>Air type</i>	<i>Supplied air pressure</i>
I.D. 8 mm (10 mm for pipes longer than 5 meters)	filtered, dehumidified, non-lubricated air	6 bar



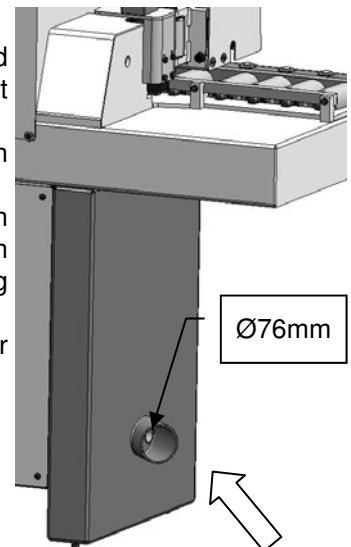
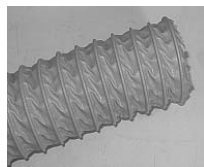
3.6. CONNECTION TO SUCTION SYSTEM

A proper suction reduces at the minimum the risks for the operator of dust and smoke (due to glue heating) inhalation, besides aids better and more efficient functioning of the machine.

Make sure that the suction system to which the machine has to be connected can guarantee a flow rate of at least 900 cu.m/h at a speed of about 20 m/s.

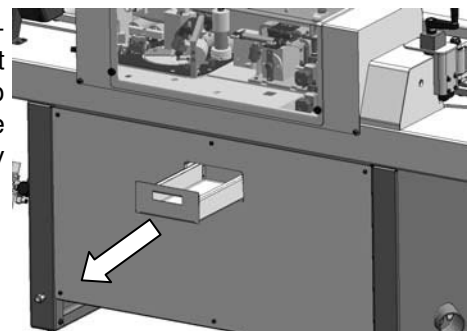
Connect the suction system to the machine with a flexible tube of a 80 mm I.D. on the left side of the machine; tighten the tube with clamps. Position the tube in such a way to not obstacle any movements of the operator during normal working operations.

The machine is delivered without exhaust system. The user has to install a proper exhaust fan depending on the type of use, the material and the timing of use of the machine. This system has to keep the dust concentration below the value allowed by the law of the country where the machine is installed.



3.7. DRAWER TO COLLECT END-CUTTING SCRAPS

Our edge-banding machine is equipped with a drawer to collect end-cutting scraps. The drawer is to be found inside the machine frame, just below the end-cutting unit. To take the drawer off you only need to open the right door in front of the machine and to draw it out; before doing that just make sure that the machine is off in order to avoid any collision and to prevent any damage to the machine.



ALWAYS WORK WITH THE MACHINE CONNECTED TO THE SUCTION SYSTEM AND WITH THE SUCTION SYSTEM ON

4. SET-UP

4.1. PNEUMATIC PRESSURE SET-UP

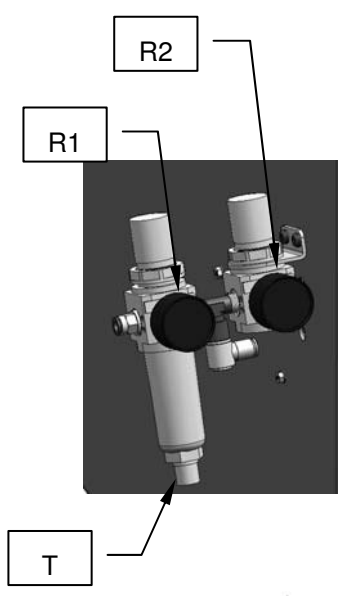
The working pressure has been already set on correct values by the technical personnel of the manufacturer. If necessary, you can operate on the handle of the pressure regulator to turn up/down the air pressure value.

On the machine there are two air regulator groups, one on the left (R1) and one on the right (R2):

R1 = pressure ±6 bar; it is connected to the electrovalves YV1 – YV2 – YV3 controlling the inserting edge cylinder (YV1), the cutting cylinder (YV2) and the end-cutting blades (YV3)

R2 = pressure 3 - 3,5 bar; it is connected to the electrovalve (YV4) which controls the pursuing phase of the end-cutter group.

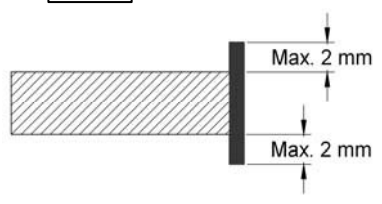
To unload condensation press upward the cap (T) of the left air regulator (R1).



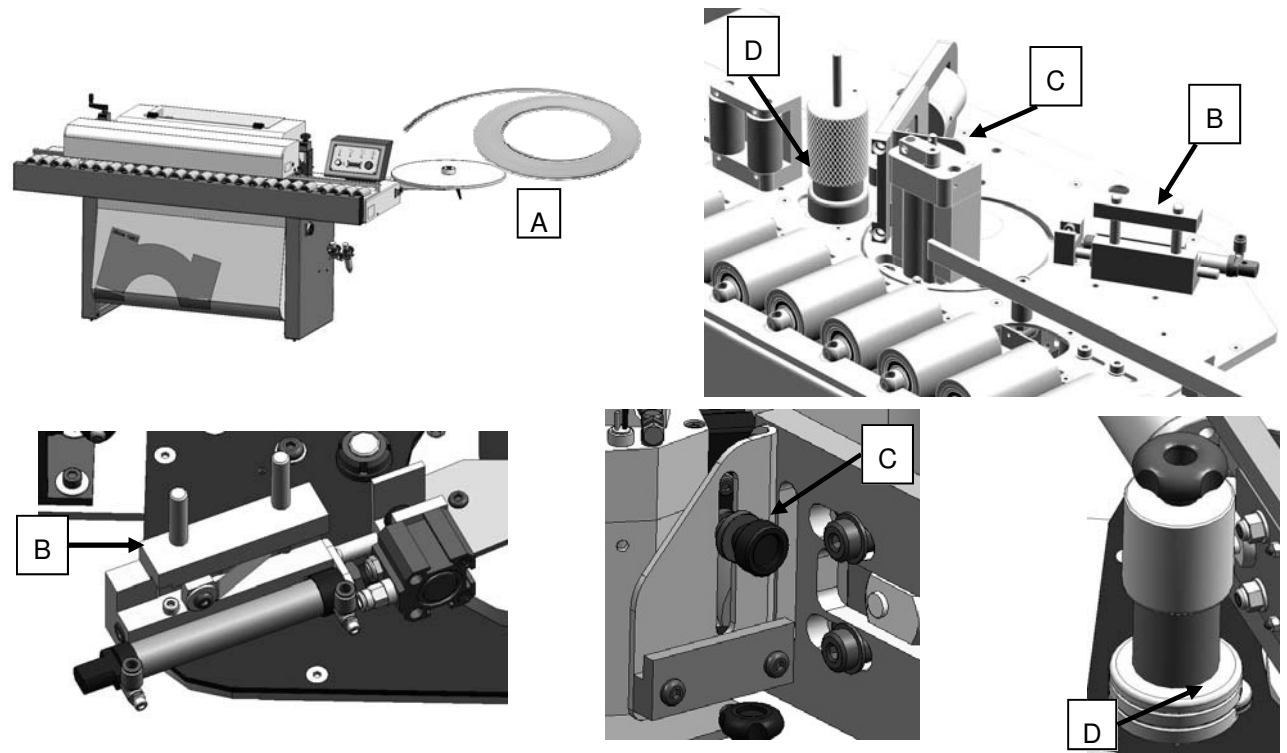
4.2. EDGE SET-UP

Check that the edge is of the right size for the thickness of the panel.

The edge must not overlap more than 2 mm on each size of the panel (respect to the thickness of the panel itself).

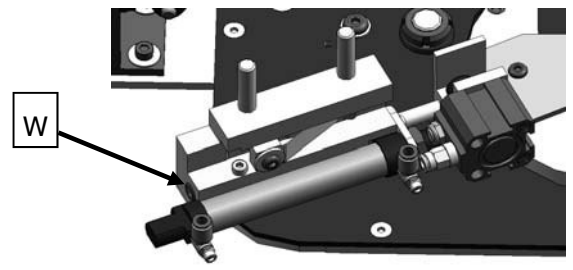


- Place the reel on the reel support as depicted in figure (A)
- Lift the edge-guide up to the maximum necessary height working on the handle (B)
- Lift the set-up washer (C) up to the maximum necessary height and lock it in position
- Insert the edge land et it move on until it is close to the edge feeding roller (D)
- Set-up the height of the edge-guide and then the set-up washer (leave room so that the edge can move freely), then lock in position.



For a correct work, it is important that the edge is properly guided and can move freely

Work on the screw (W) in the edge-pushing group to regulate the exceeding length of the edge respect to the front side of the panel. Tightening the screw you reduce the length of the edge respect to the panel.

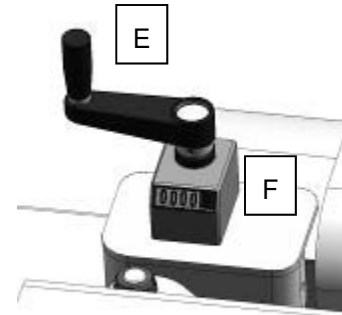
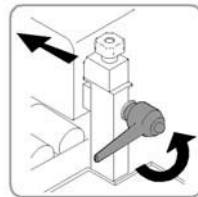
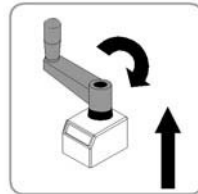
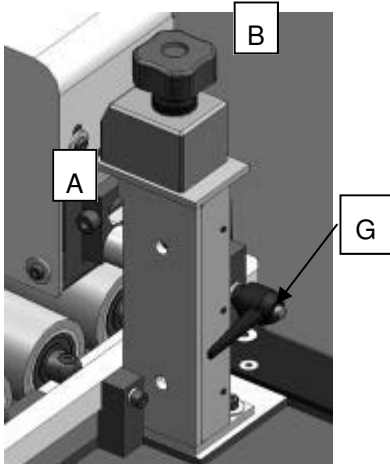


4.3. FEEDER SET-UP

Work on the handwheel (E) until you see on the display (A)(F) the same value of the thickness of the panel to be worked (number dx side = tens of millimetre).

To regulate the height of the feeder respect to the working plane:

- Unlock the feeder loosening the knob (G)
- rotate the handwheel (E and B) until you reach the desired height;
- Lock the feeder tightening the knob (G)



- Incorrect adjustment of feeder height may cause faulty panel feed, thus compromising machine performance and working results
- Always regulate the height of the feeder with the knob (G) loosened
- Tighten the knob (G) before start working

If you regulate the height of the feeder with the locking knob (G) not loosened can cause permanent misalignment and damage the feeding of the panel

Make sure that the feeder is well close and locked: the machine does not start working is the safety sensor placed on the feeder is not pressed.



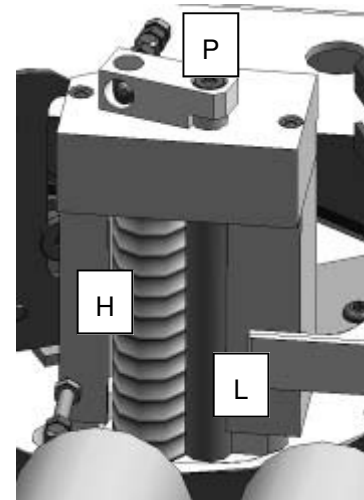
DO NOT LEAN ON THE FEEDING DEVICE WHILE THE MACHINE IS IN OPERATION

4.4. GLUE QUANTITY SET-UP

The glue is applied on the panel through the glue roller (H). To regulate the quantity of the glue to be applied on the panel rotate the glue-regulator shaft (L) respect to the glue roller (H)

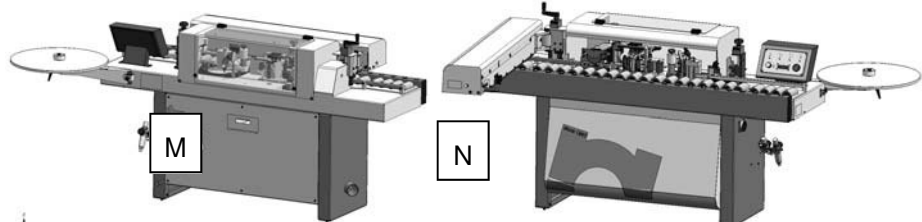
To regulate the glue work on the system (P): the glue-regulator shaft (L) rotates by screwing/unscrewing the set-up screw.

The system is very sensitive: with a small rotation of the glue-regulator shaft (L) we have a great variation on glue quantity.

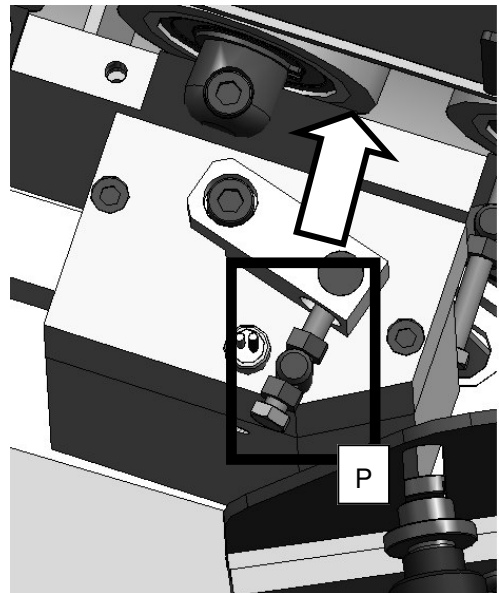
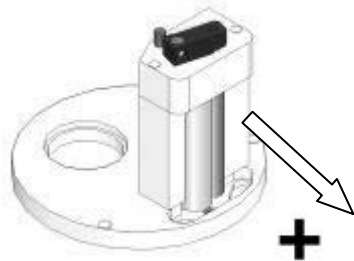


- **WARNING: DANGER OF BURN, ALWAYS WEAR PROTECTIVE GLOVES**
- **THE GLUE WORKING TEMPERATURE IS ABOUT 200°C, ALL THE COMPONENTS OF THE GLUE POT GROUP WORK AT HIGH TEMPERATURE**

To work easily on the glue regulation system can be useful remove the top polycarbonate-made cover (M) and/or open the feeder (N).



ALWAYS TURN OFF THE MACHINE BEFORE REMOVING THE TOP COVER



Before any working session check that in the glue pot there is enough glue, by lifting the top (Q)

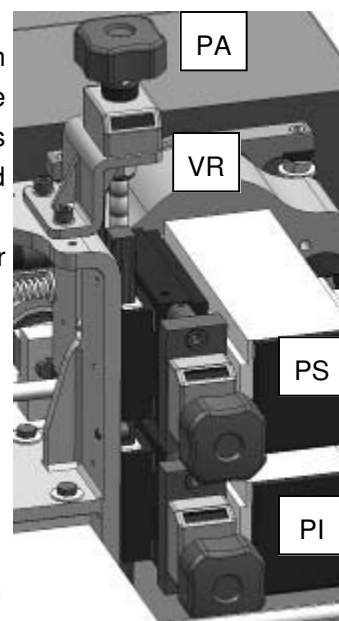
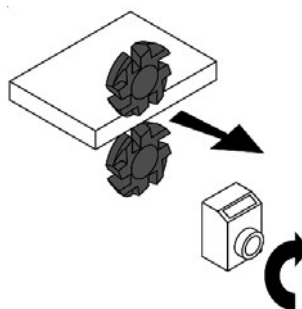
4.6. TRIMMING DEPTH SET-UP

Work on the handwheel (PA) until you see on the display (VR) the same value of the thickness of the panel to be worked (number dx side = tens of millimetre).

The edge-trimmers are tools designed to remove the excess edging strips on both sides of the panel, top and bottom. The depth of trimming must be regulated depending on the thickness of the edge: you move the edge-trimmers close / away respect to the edge, so determining the quality of the finished edge.

To adjust the trimming depth you work on the adjusting knobs placed on the rear part of the machine frame, close to the supporting column of the feeder.

Act on the upper knob (PS) to move the upper edge-trimmer, act on the lower knob (PI) to move the lower edge-trimmer. Rotate the knob clockwise to move away the trimmer from the edge, rotate the knob counter clockwise to move the trimmer close to the panel.



- The values depicted on the display are not equal to the thickness of the edge, they are used only as independent reference values
- To eliminate errors caused by mechanical play, always reach the required value by turning the knobs counterclockwise (for example to reach the value 10, turn back up to 5 then rotate the knob up to 10)



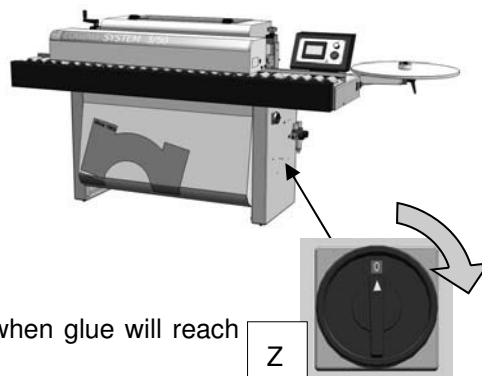
MADE ALL THE ADJUSTMENTS ONLY WITH THE MACHINE TURNED OFF

5. MACHINE USE

5.1 START AND STOP

STARTING MACHINE:

- Check if the feeder is closed and locked in right position and if the machine is connected to pneumatic system.
- Turn the general switch (Z) to start position “ON” or “I”.
- Press the start button (A) on control panel.
- Display (C) will show actual temperature. Machine will work only when glue will reach the requested temperature.

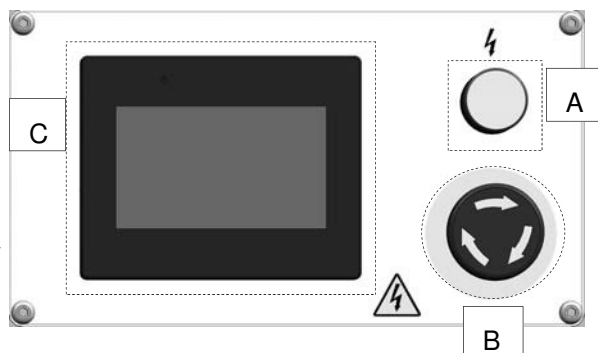


STOPPING MACHINE:

Turn the general switch (Z) on stop position “OFF” .

RE-STARTING MACHINE (if emergency stop (B) was pressed or feeder was opened):

- Reset the emergency stop button (B) (if previously pressed).
- Press the start button (A) on control panel.



The open of the feeder causes the stop of the machine, as if the emergency pushbutton was pressed

GLUE HEATING:

For optimal glue heating use ECO mode for 15 minutes, then turn off the stand-by to raise the temperature. You need to wait about 5 minutes to get the machine ready to work.

In case of temporary suspension of work for more than 20 minutes we recommend to switch to “Energy saving” mode by pressing “ECO” button on control panel.

Glue will be maintained at a lower temperature 40° lower than the working temperature, in order both to quickly re-start working and save the integrity of the glue itself.

The value of the temperature can vary by $\pm 5^\circ$.



After that the machine is ready to work, we suggest you to make preliminary edging tests on panels to verify that all the parameters and settings are correct



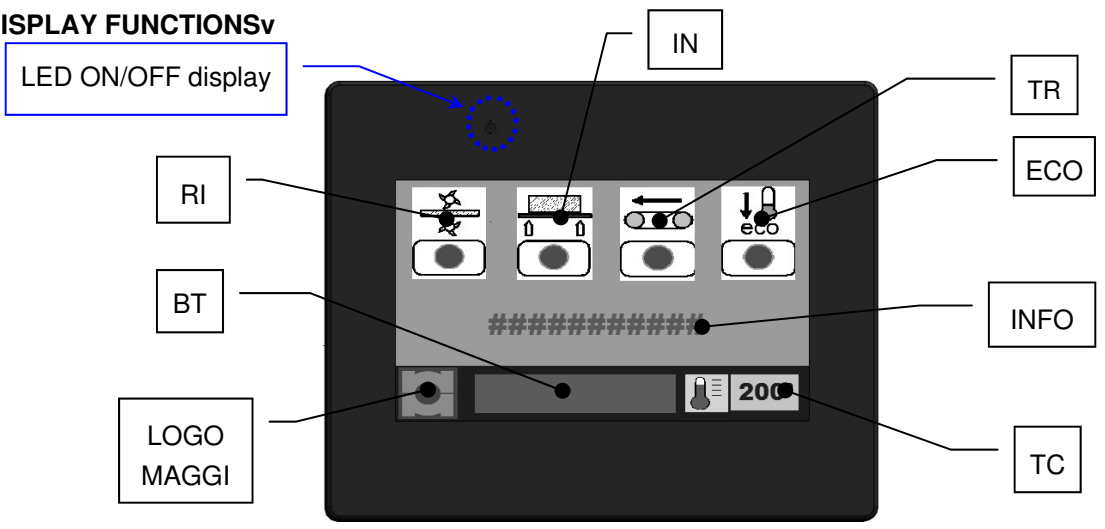
The machine is ready to work only when the actual glue temperature reaches the target temperature

5.2 EDGE BANDING PANELS

When the machine is ready to work, you can go on working and edging the panels:

- Put the panel on the working table in the entrance side of the machine and move it in contact to the entrance guide. Move gently the panel below the feeding belt and put it always against the entrance guide.
- The machine feeds automatically the panel, applies the edge, cuts the edge and finishes it until the panel ends its paths in the ending part of the working table, at the end of the feeder.
- Take the panel from the working table
- Go on applying the edge on the other sides of the panels (those without the edges) replying the procedure inserting the panel below the feeding belt, keeping always the panel against the guide.

5.3 DISPLAY FUNCTIONS^v



5.3 DISPLAY FUNCTIONS

To switch working groups press the relative picture: feeder (**TR**), end cutting unit (**IN**), edge trimming unit (**RI**), for ECO energy saving mode press the relative picture (**ECO**); control is on with green light and off with red light.

The display shows:

- the working status of the machine (**INFO**);
- a status bar of the temperature (**BT**);
- glue temperature in °C (**TC**).

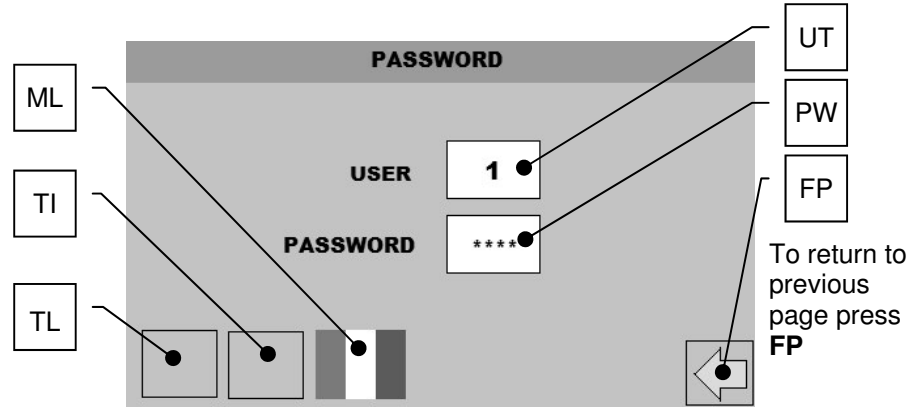
To enter the machine service parameters press the picture **MAGGI LOGO** for 5 seconds, the window will change to (**PASSWORD**). Select user :**1 (UT)** and password :**1234 (PW)** .In service parameters mode all working groups and resistances are turned off.

- PASSWORD

For language selection press **ML**

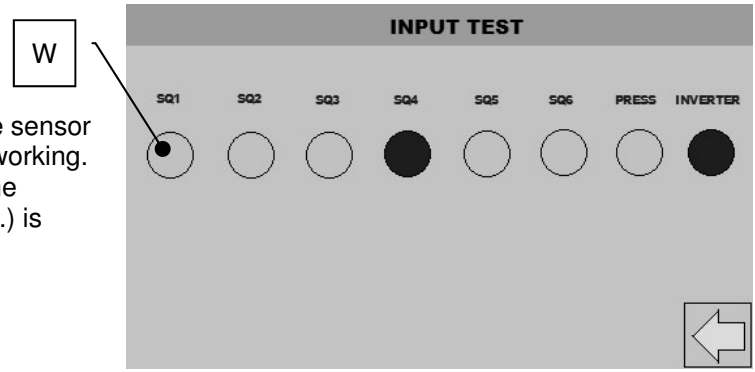
To open "INPUT TEST", press **TI**

For "WORKING TEMPERATURE", press **TL**



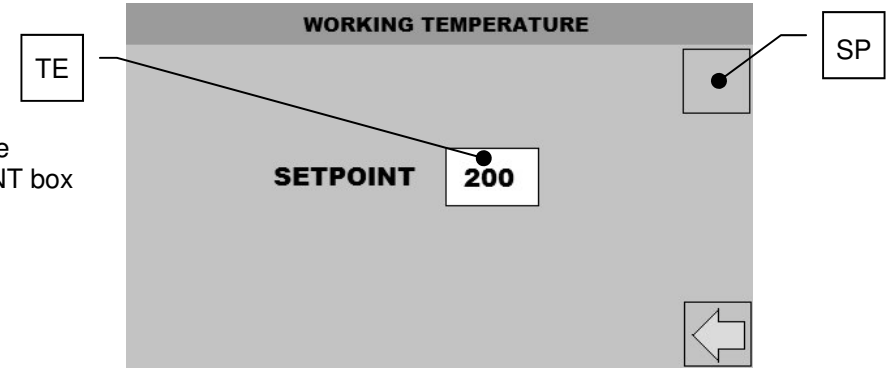
- INPUT TEST

In this window you can see if the sensor inputs to the control board are working. The image **W** changes color if the concerned sensor (SQ1, SQ2, ...) is activated.



- WORKING TEMPERATURE

For temperature setting enter the requested value in the SETPOINT box by pressing **TE** and using the keyboard. Press **SP** to save.



- ALARMS



With the feeder open or in lack of pressure ALARM window will open and show the relative information. The window will close as soon as the alarm is deactivated.



5.4 SUGGESTIONS FOR USE

To obtain good edge results it is necessary control many factors and variables occurring in the edging process, all of them can be classified into three categories:

- PANEL TO BE EDGED:
 - * Use as much as possible good quality panels, with a sufficiently high density;
 - * The cut must be sharp, of high quality, without any chips, with a high quality of rectilinearity (at least $\pm 0,1$ mm per linear meter);
 - * The cut of the panel must be square (90°): the surfaces of the panel must be squared both compared with surface and to the thickness;
 - * The surface to be edged must be clean, free from dust and humidity;
 - * The panels must be stored at work room temperature, with no humidity.
- HEAT-FUSIBLE GLUES
 - * Check that the glue is spread homogeneously along all the surface to be edged (along the thickness and the length of the panel);
 - * Use only heat-fusible glue suitable for the characteristics of the machine, of the edge and of the panel;
 - * Change the quantity of glue respect to the thickness and porosity of the panel;
 - * The glue deteriorates and losses its characteristics over time. If you use the machine only now and then, we suggest you to fill the glue pot with few glue and replace the glue with new one if and when necessary.
- MACHINE SET-UP

Start the machine, start the suction system and make the preliminary tests before start working, thus verifying thus following points:

 - * The height of the feeder is the same as the thickness of the panel;
 - * Set-up of pneumatic pressure (if necessary);
 - * Check the quantity and quality of the glue in the glue pot;
 - * Glue working temperature;
 - * Adjust the quantity of the glue according to the kind of work to be done;
 - * Correct edge positioning;
 - * The height of the edge-trimmer;
 - * Set-up of the edge-trimming depth;
 - * Check that the edging strip sticks to the panel correctly.

6. SAFETY DEVICES AND RESIDUAL RISKS

6.1. INTRODUCTION

The risk analysis and all the relative considerations in this chapter are based on:

- knowledge of normal conditions and intended use of the machine, as described in this manual;
- supposition that the machine is to be used to make single or multiple longitudinal cuts on wooden boards or composite panels;
- supposition that all the workers have been correctly trained about residual risks of the working environment, as requested by current laws and regulations;
- supposition that any other persons except workers, and especially non adult persons, are not allowed to go inside the working environment

6.2. GENERAL PRECAUTION

- The operator assigned to the machine must be well trained on its correct use, its safety protection devices and its accessories.
- The machine devices must be correctly blocked and adjusted.
- The whole machine must undergo ordinary and extraordinary maintenance procedures, following the scheduled timing.
- Before using the machine, make sure to have read and understood this user manual.
- Before making any operation with the machine, verify that the entire working area is free of persons and of any obstacles which could be potentially source of danger.
- Verify that the connecting cable to the electrical power supply is safe, well stretched out and not rolled up.

- Any intervention on the machine can be done only after that electrical and pneumatic connections are off.
- Do not put any inflammable substances nearby the machine because of risk of explosion and/or fire due to possible sparks production.
- The operator must think carefully about possible consequences before approaching with his hands the most dangerous areas of the machine.
- Keep always the machine turned off when not in use; in case of not use for a long time disconnect the machine from electric and pneumatic power supply.
- Avoid contact with hot parts

The use of the following personal protections is also suggested for the operator, to prevent risks during placing, installation, set-up, use, ordinary and extraordinary maintenance:



**A machine of this type can be dangerous if it is not used properly.
We strongly recommend that the operator comply with the following safety guidelines**

- gloves (for example for handling parts and replacing blades)
- anti-crushing and anti-sliding safety shoes (for moving heavy and/or sharp parts)
- goggles or shields (for protection against dust, shavings and residues in general, during working on cleaning the machine)
- anti-dust masks

Moreover, the clothes must be suited to avoid danger of:

- catching, dragging, crushing, sliding, abrasion
- It is forbidden the use of contact lenses

Besides, the operator must fulfil the main obligations that are listed hereunder:

- keep the machine and the area around the machine clean and neat;
- provide appropriate containers and/or defined areas for the storage of both the pieces to be machined and those already machined;



**All safety measures discussed in this handbook exclusively refer to the correct use of the machine authorised by the manufacturer.
The use refers to the preparation, running and maintenance operations of the machine.
Furthermore, it is strictly forbidden to use the machine for purposes other than those permitted by the manufacturer and to modify the machine and/or its parts without the manufacturer's prior authorisation.**

- do not use the machine if you are not in a good state of health;
- do not wear rings, necklaces, chains or bracelets as they could cause injuries;
- use the personal protections mentioned in this handbook according to the operations to be carried out;
- do not remove or modify the data plates installed on the machine by the manufacturer;
- do not remove or bypass the safety devices of the machine.

6.3. SAFE WORKING OPERATIONS

It is of basic importance that all the operators:

- know perfectly the use, set up and maintenance operations to be performed on the machine;
- know perfectly all the factors influencing the exposition to noise
- know perfectly all the factors influencing the exposition to dust, for example:
 - * type of material to be worked,
 - * importance of dust extraction,
 - * correct setting of dust extraction devices;
- that the dust extraction plant has to be turned on before start working.

It is important that:

- the floor of the area around the machine has to be plain, clean and neat;
- lighting must grant complete visibility the working area;
- raw material and finished parts are to be located close to working position of the operator.

It is of basic importance for the operators:

- use when necessary all the personal safety devices; this could mean:
 - * safety protections for ear to reduce risk of deafness,
 - * safety mouth mask to reduce the risk of breathing dangerous dust,
 - * safety protection gloves to handle blades (blades should be put into specified tool holders),
- stop the machine when not attended;
- report immediately any defect or failure, especially for safety guards or blades;
- use safety procedures for cleaning and maintaining the machine, remove regularly and frequently chips and dust to avoid risk of fire;

- follow the instructions of the constructor, the settings and repairing of the blades;
- do not remove scraps or other residuals from the working area when the machine is turned on;
- be sure that all the safety guards and the other safety devices are in position, in good conditions and subjected to correct maintenance.

6.4. RESIDUAL RISKS

Despite all adopted safety protection devices, the following situations may be dangerous:

- Contact with tools and/or blades
- Contact with moving parts of the machine (chains, gears...)
- Tool insert ejection
- Electrocution from contact with live parts
- danger due to incorrect tool installation
- danger due to dust inhalation in case of working without suction system
- danger of burns in case of contact with glue or other parts of the machine at high temperature, especially all around the area of the glue pot group (the glue pot and the glue roller, where there are the heating resistances, and all the parts nearby). The working temperature of the glue is about 180-200°C, all the parts close to the glue pot are at a decreasing temperature going from the glue pot to outside.



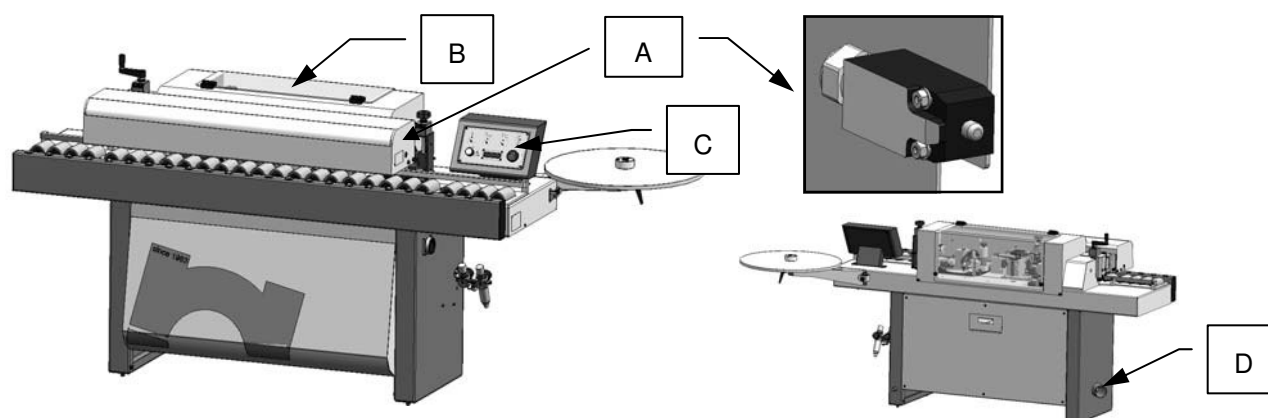
Never touch, either directly or indirectly, any moving parts of the machine while in operation.

Make sure that the machine is disconnected from the main power source before doing any cleaning, lubrication, maintenance, repair, adjustments, or part replacements.

The operator should never leave the machine unattended when in use.

6.5. CHECKING OF THE SAFETY PROTECTION DEVICES

WORK PLACE: before starting any work, check that the machine and the area surrounding it are clean and with no dust and/or scraps. Check that the working area is well enlightened and that the place for the parts to be worked and the ones already worked are tidy and close to the operator.



FEEDER SAFETY SWITCH: the machine is equipped with a safety micro-switch (see A) that is turned on when the feeder is opened and stops all the operations of the machine. Check periodically the integrity of the device and its correct work.

UPPER PROTECTION COVER: the upper cover reduces the access to the functional groups of the machine (see B) so avoiding the operator to touch the main dangerous parts of the machine. Check periodically the integrity of the cover and of the polycarbonate-made door, replace them if necessary.

EMERGENCY PUSHBUTTON: it is placed in the control panel (see C). Check periodically its correct working.

CHIP, DUST AND SMOKE COLLECTION: the machine is equipped with a hood (see D) for the connection with the suction system. Check periodically that the collecting hoods are complete and correctly connected with the suction system.

6.6. RISK DUE TO NOISE EMISSION LEVELS

The machine has been designed so as to reduce at the source the noise emission level. The noise levels of the machine are the following:

Reference standard ISO 7960	Machine on, not working, suction system off	Machine is regularly working
Level of soundpower released LW dB W (A)	83,8	91,3
Level of sound pressure at operator position Lop dB (A)	70,4	81,2

NOTE

The indicated noise levels are emission levels and do not necessarily represent safe operation levels. Even though there is a relation between emission levels and exposure levels, it cannot be used in a reliable way to determine whether additional precautions are to be taken. The factors that determine the exposure level that

manpower is subjected to include the length of the exposure, the characteristics of the working place, other sources of dust and noise, etc., that is the number of machines and other adjacent processing. Allowed exposure levels may vary from country to country. In any case, this information will help the user of the machine to better evaluate danger and risks. To not exceed the noise level it is necessary following strictly these rules:

- check and replace periodically all the cutting tools and their fixing devices;
- clean and lubricate all the parts of the machine as suggested in this manual.

6.7. RISK DUE TO DUST AND SMOKE EMISSION

The machine is designed to work in close environment, so it is necessary to connect it to a suitable dust extraction system which complies with the EN 12779 regulation.

To not exceed the dust emission level it is necessary following strictly these rules:

- always turn on the dust extraction system before start working with the machine;
- clean regularly (as written in this manual) the parts of the machine;
- check regularly that the dust extraction system works properly;
- check that the parts of the machine are not damaged or closed by dust and/or scraps.

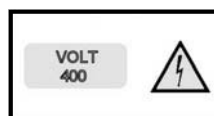
6.8. RISK DUE TO VIBRATIONS

The vibration level is not so high to cause danger for the operator, during normal and correct use of the machine, as written in this manual.

6.9. PLATES AND PICTOGRAM



**Always check that figures, colours, words of the safety signs are in good state.
If damaged or worn, It is necessary to replace them suddenly and call the responsible of the manufacturing plant of your firm.**



7. MAINTENANCE



- The operator must disconnect the machine from the power source (electric and pneumatic) before executing any maintenance operation.
- Always wear personal protection devices

An adequate maintenance is a crucial factor to obtain optimal working condition and a longer life of the machine.

Always follow the procedures and recommendations described in this manual

7.1. CLEANING

Regular cleaning of all machine parts and the surrounding environment means greater operating safety and a prolonged machine's life.



Before making any kind of cleaning, be sure that all the parts are cold (or at room temperature)

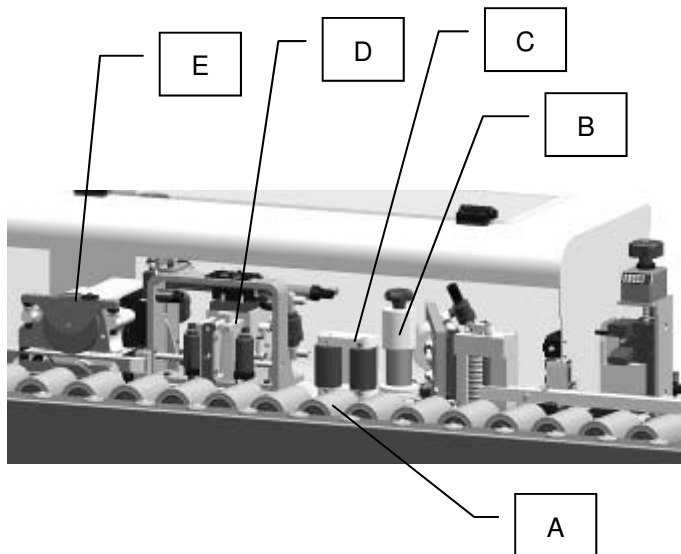
AFTER EACH WORK CYCLE AND AT THE END OF WORK PERIOD

Accurately clean the machine and all its components, removing with a suction hood chips and dust. Use compressed air only when strictly necessary, using protective glasses and a mask. It is very important that the following parts of the machine are as clean as possible from glue residues:

- Sliding rollers and working table (A)
- Edge-feeding roller (B)
- Edge-pressing rollers (C)
- End cutter (D)
- Copying disks and tools, end-trimming unit (E)

We suggest you to protect the cutting parts of the end-trimming unit and of the end-cutting unit using a unlocking spray in order to reduce as much as possible the deposit of glue residuals.

Ask your glue supplier for any information regarding this unlocking spray. Always remember to wear a protective mask when using spray.



7.2. GLUE REPLACEMENT

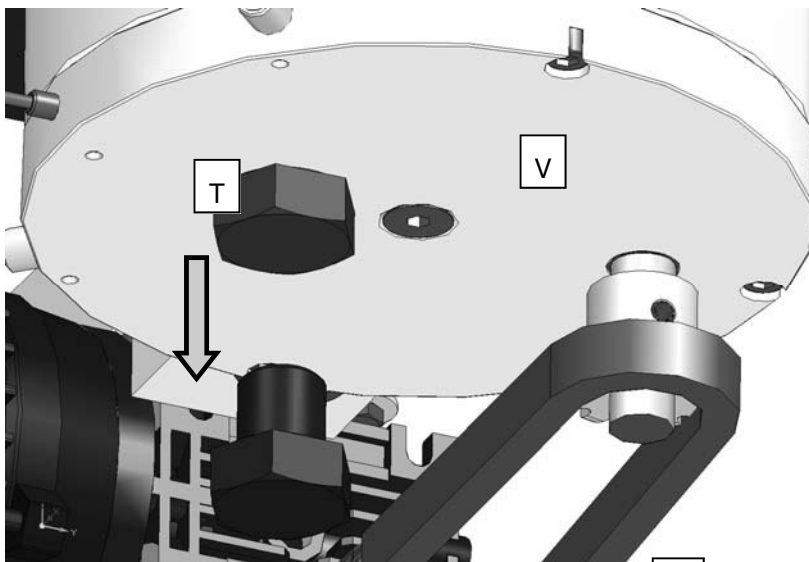
The glue loses its adhesive properties and deteriorates over time. It is necessary to replace the glue to be sure to obtain first quality products. It could be also necessary to replace the glue when edging different materials or with other characteristics (edges and/or panels).



Always wear protective gloves to not burn your hands

EMPTYING OUT PROCEDURE:

- When the machine is cold, loose the emptying top (T) located in the bottom part of the glue pot (V)
- Put a capable container just below the glue pot
- Turn on the machine and activate the heating of the glue pot (F) turning the selector to "I"
- Wait for the glue reaches the target temperature: the solid glue melts gradually when the temperature goes up and pours down into the container through the emptying hole
- Remove the top cover (Q) and clean with a wooden or plastic spatula glue scraps eventually remained inside the glue pot. Please be carefully in using the spatula: do not damage the protective material of the glue pot
- Clean carefully the area where the emptying top (T) is screwed
- When the glue pot is empty and clean, screw the emptying top in the bottom part of the glue pot (please remember to perform the operation when the glue pot is not cold: if any glue residuals are solidified, it is very difficult to tighten again the emptying top in its seat)



7.3. TOOLS REPLACEMENT

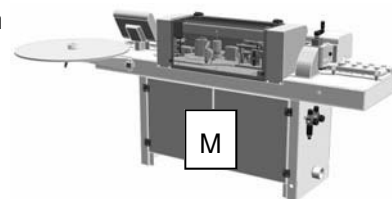
- Do not use metallic tools o clean the glue pot to preserve the protective material of the glue pot from damages
- Unscrew the emptying top from the bottom of the glue pot when the glue pot is cold before starting the emptying procedure
- Tighten the emptying top only before that the glue pot is empty and that the seat of the top is completely clean

Check periodically the sharpness of tools, if necessary re-sharpen or substitute them. To get access to tools it is



- **Always wear protective gloves to handle tools**
- **Disconnect the machine from the pneumatic air supply and turn of the machine before going on replacing tools**

necessary to open the feeder (N) and in some cases the upper protection cover (M).



ALWAYS TURN OFF THE MACHINE BEFORE REMOVING THE UPPER COVER

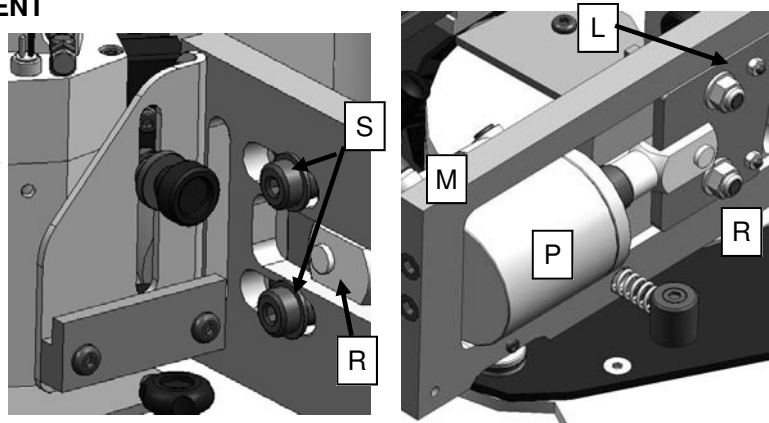




ALWAYS TURN OFF THE MACHINE

7.3.1. FIRST CUTTING BLADE REPLACEMENT

- Unscrew and remove screws, springs and washer (S)
- Disconnect the blade (L) from the cylinder rod (P) removing the connecting fork (R)
- Replace the blade and mount again the parts following the previous procedure from bottom to top

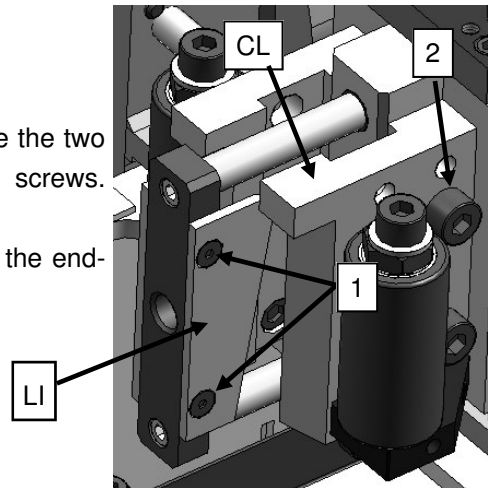


The screws (S) are not to be tightened, they have to be screwed gently for the length useful for the blade to slip on the counter blade (M) without excessive plays.

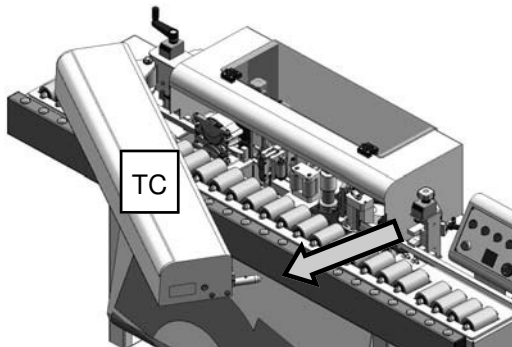
7.3.2. END CUTTING BLADE REPLACEMENT

To replace the blade (LI) of the end-cutter unit, unscrew and remove the two screws (1), replace the blade, then screw again and tighten the screws. Repeat the same procedure for the other blade.

Never work on the screws (2) used to fix the counter blade (CL) of the end-cutter unit to the support.

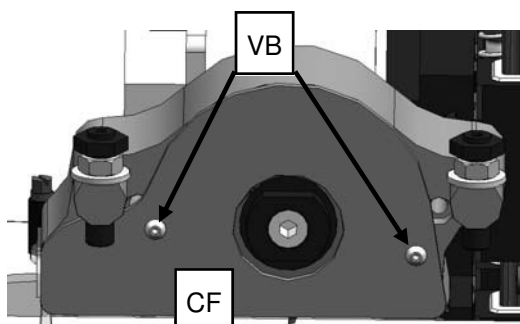
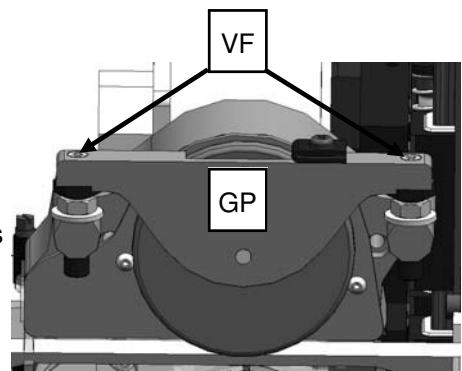


7.3.3. REPLACING INSERTS OF END-TRIMMERS



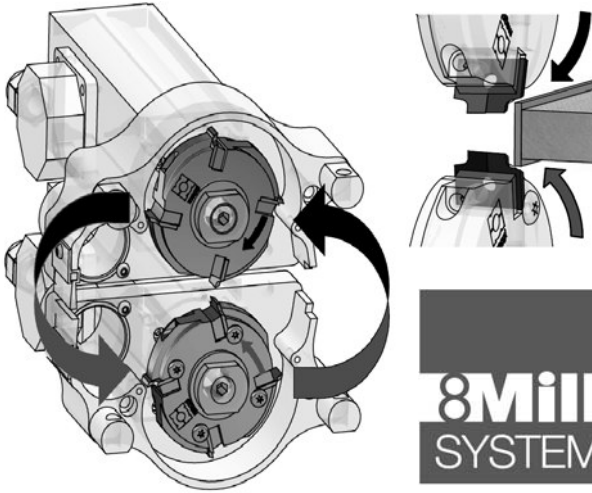
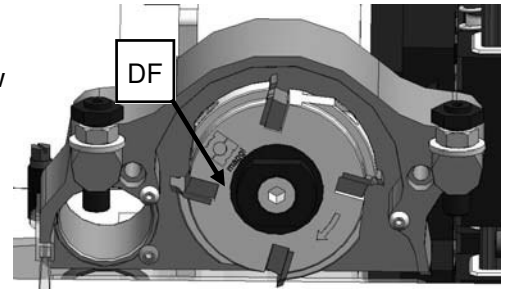
- To change inserts of the end-trimmers you have to open the feeder (TC).

- Remove the end-trimming disk unit (GP) unscrewing the screws (VF) which fix it to the support and lift up the disk unit.

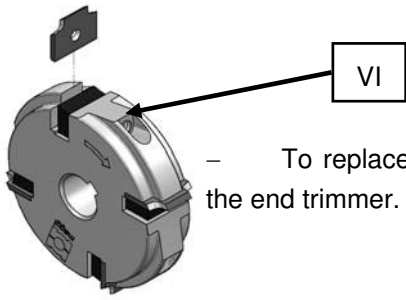


- Remove the cover (CF) unscrewing the two screws (VB) which fix it to the support end-trimmer.

- Remove the body of the end-trimmer after you have unscrew the nut (DF)



- With the system 8 MILL SYSTEM reversing cutters (the upper cutter with the lower one), you can use the two sides of the cutter before replacing the plates.



- To replace the inserts you have to unscrew the locking screws (VI) from the body of the end trimmer. The inserts of the end-trimmer must be replaced all together

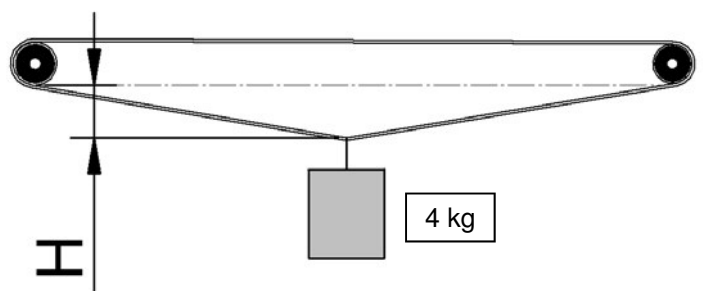
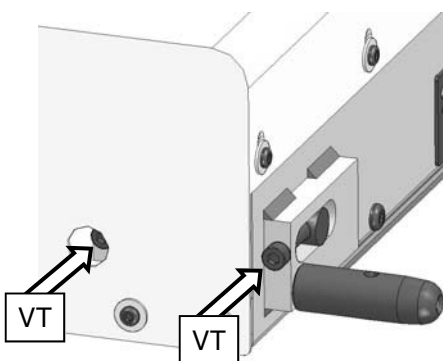
7.4. ADJUSTING TENSION OF FEEDING BELT

Check the tension after the first 20 working hours and periodically after every 150 working hours.

To check the tension follow these instructions:

- Loose the locking knob and open the feeder
- Hang up a weight of 4 kg in the middle of the feeding belt, check that belt stretch (H) is between 20 and 30 mm

If necessary regulate the tension of the belt working on the tensioning screws (VT): act on the two screws in the same manner, rotate them with the same number of revolutions to keep the correct alignment of the tensioning roll.



8. TROUBLESHOOTING



WARNING: BEFORE MAKING ANY INTERVENTION YOU MUST DISCONNECT THE MACHINE FROM ELECTRIC AND PNEUMATIC POWER SUPPLY

PROBLEM	CAUSE	SOLUTIONS
THE MACHINE DOES NOT START WHEN IT IS TURNED ON OR STOPS DURING A MACHINING CYCLE	<ol style="list-style-type: none"> Lack of line voltage Fuses blown Emergency on Safety microswitch on Overload thermal switch triggered because of: <ul style="list-style-type: none"> Power supply cable cross-section too small Drop in voltage due to cable power supply too long Short circuit in the electric system Air pressure supply too low Glue temperature below 190°C (or too low respect the working target temperature) 	<ol style="list-style-type: none"> Check with a tester that there is power on the three phases Check that fuses are complete; if necessary replace them Disconnect the emergency pushbutton pulling and rotating it counter clockwise Check that the feeder is completely and correctly closed: if it is opened, the safety microswitch is turned on and the machine stops The overloads in the electric panels work as thermal protection for the motors. Solve the cause for the machine stop and press the button to re-activate the overloads The machine is equipped with a pressure switch that prevent it from starting if the air pressure is below 5 bar. Restore the correct value of the air pressure supplied (7-8 bar) The machine is ready to start working only when the glue temperature has reached the target working temperature (about 190°C). If the glue can not reach this temperature in 25 minutes or so, you have to check if the electric components are undamaged.
THE PANEL DOES NOT SLIDE	<ol style="list-style-type: none"> Feeder height setting non correct respect panel thickness Feeder not parallel to the working table in direction of panel feed 	<ol style="list-style-type: none"> Adjust the height of the feeder respect to panel thickness, check the value on the display of the handwheel. During adjusting operations the locking knob must be loosen. Tighten again the locking knob at the end of the adjustment procedure. Repeat the adjustment of feeder height making sure that the locking knob is loosened
THE EDGE IS NOT FED	<ol style="list-style-type: none"> Incorrect panel insertion Jammed edge Edge not correctly inserted 	<ol style="list-style-type: none"> Insert the panel keeping against the entrance guide and accompanying it until it is not fed by the feeder Check that the edge is free to move and slide along the path and that is correctly guided (there must be a play of at least 0.5 mm between the edge and the guiding structure) Check that the edge is correctly inserted in the edge-guiding support and it has been fed by the edge-feeding system
THE EDGE IS NOT CLOSE-FITTING AND PROPERLY GLUED	<ol style="list-style-type: none"> The panel has edges that are not linear or not perpendicular The edge is not glued in the entrance part of the panel and there is too much glue There are traces of humidity and/or dust on the edges of the panel The temperature of the panel is too low The panel is too large Not enough glue applied onto the panel The glue is deteriorated The glue pot is empty 	<ol style="list-style-type: none"> The cut must be net, of high quality, with no chips, with high rectilinearity (at least $\pm 0,1$ mm for linear meter). The cut must be squared (90°): the faces of the panel must be perpendicular both respect the surface and the thickness. Check that the edge is not too thick (max 2 mm). Adjust the entrance guide respect the edge thickness to apply. The panels must be stored in dry and clean environment, with no humidity. The panel must be stored at room working temperature Support panels and accompany them until the end of the working path Set-up the quantity of glue: increase the quantity of glue as the total edge-banding area of the panel increases The glue losses its characteristics and deteriorates overtime: it is necessary to replace it Add glue in the glue pot

9. ELECTRIC DIAGRAM AND ELECTRIC COMPONENTS

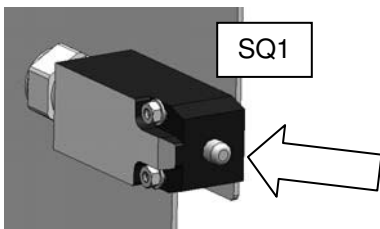
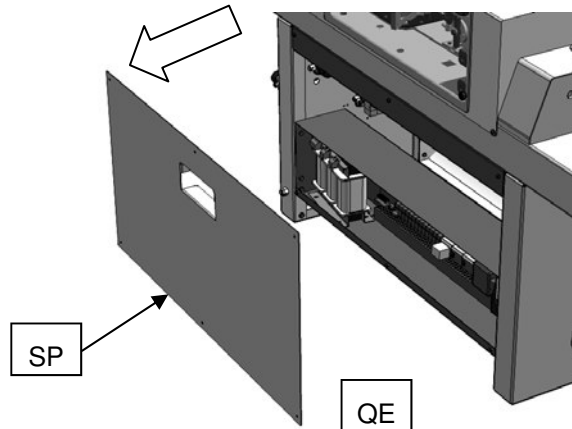
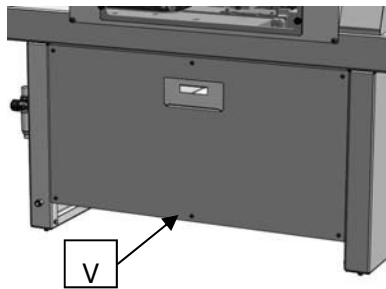
For the wiring diagram please see the document attached with this manual.
In the following pages you can find a description of the main electric components of the machine.



WARNING: BEFORE MAKING ANY INTERVENTION YOU MUST DISCONNECT THE MACHINE FROM ELECTRIC AND PNEUMATIC POWER SUPPLY

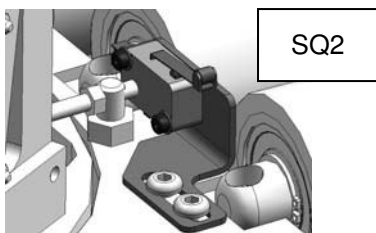
To enter the electric panel (QE):

-unscrew the 6 screws (VP) and remove the panel for inspection and maintenance (SP)



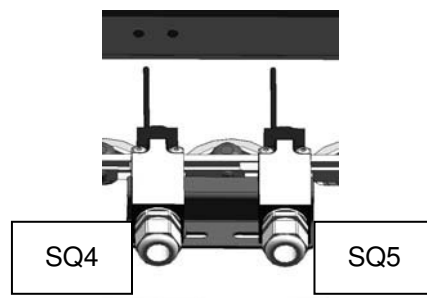
SAFETY SWITCH

SQ1 = safety switch to detect that the feeder is correctly closed: if its NOT correctly pressed, the machine DOES NOT start; if you open the feeder when the machine is working (so the safety switch is not pressed) the machine stops

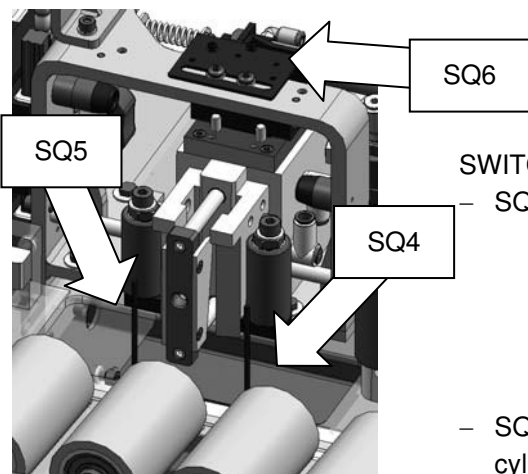


SWITCH OF THE CUTTING GROUP

- SQ2 = presence switch to detect that the panel has passed; it regulates the timing of the inserting group and the cutting group
- SQ3 = presence switch to detect that the panel has passed; it is connected to timers and controls the action of the edge insertion group and the cutting group



SWITCHES OF THE END-CUTTING GROUP

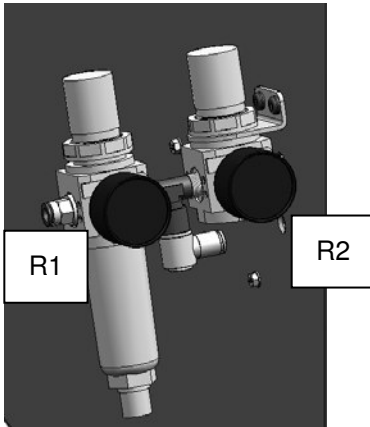


- SQ4 = it has two main functions:
1. if it is pressed, allow the YV3 electrovalve to cut the edge (cutting group)
2. if it is pressed and also SQ5 is still pressed, the YV4 electrovalve can not allow the moving cylinder to move the cutting group to reach the panel
- SQ5 = if it is pressed, the YV4 electrovalve allow the moving cylinder to move the end-cutting group to reach the panel
- SQ6 = end-stroke sensor

10. PNEUMATIC DIAGRAM AND PNEUMATIC COMPONENTS

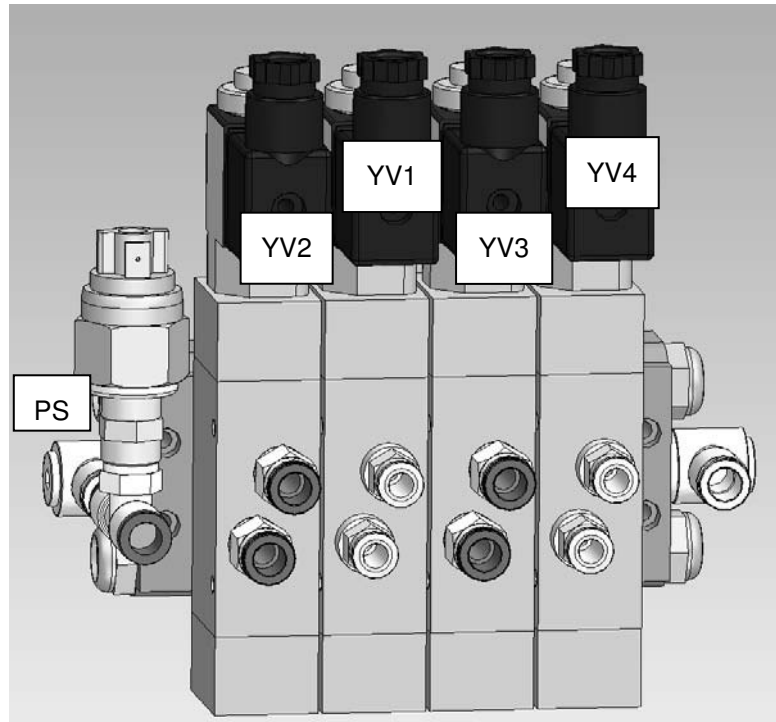
For the pneumatic diagram please see the document attached with this manual. In the following pages you can find a description of the main pneumatic components of the machine.

INLET PRESSURE REGULATOR



R1 = air pressure ± 6 bar, It is connected to the electrovalves named YV1 – YV2 – YV3

R2 = air pressure 4 bar, It is connected to the electrovalve named YV4 which controls the cutting unit



ELECTROVALVES

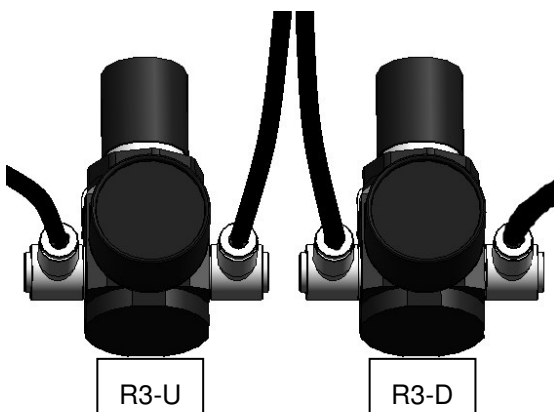
YV1 = it controls the cylinder for edge insertion (black $\text{\O}6$ pipes)

YV2 = it controls the cylinder for edge cutting (orange $\text{\O}8$ pipes)

YV3 = it controls the cutting cylinder (which moves the cutters) of the cutting group (orange $\text{\O}8$ pipes)

YV4 = it controls the moving cylinder of the cutting group (black $\text{\O}6$ pipes)

PS = pressure switch; if there is no (or low) pressure the machine does not start



PRESSURE REGULATOR (R3)

R3 D= regulates the pressure of approaching of the cutting group on the panel.

R3 U= regulates the pressure of the return of the piston of the cutting group.

11. DISMANTLING

Waste and refuse produced during machining must be collected, recycled or eliminated according to the regulations in force of the country where the machine has been installed. Waste produced during machining on this machine are:

- raw material scrap (chips, shavings, etc.).
- dust

When machine has to be put out of service, please carefully follow our instructions in order to safeguard the safety of people and of environment.

- Separate all plastic-made parts to be disposed as differentiated materials following the current rules and laws
- The mechanical component parts, built of steel, aluminium etc. or alloys shall be sorted in order to facilitate the process by which these are either sent to storage or to recycling
- Dismantle electric and pneumatic components so that you can re-use them after a check or a revision
- Do not waste in the environment non-biodegradable products, lubricant oils and non-ferrous components (rubber, resins,...)
- Call a specialized company to rescue and eliminate solid and liquid materials; dispose all the collected materials following the current rules and laws



COUPON TO BE FORWARDED TO THE MANUFACTURER



GUARANTEE AND LOOK-OVER COUPON

Model.....Serial number.....
 Name.....
 Address.....
 ZIP Code.....City.....
 Date of purchase..... Dealer.....

Owner's signature

.....

The purchaser states to accept all the terms of guarantee and to have checked the machine to work well

12. TERMS OF GUARANTEE

Maggi Technology S.r.l. guarantee the mechanical parts of their machines against faulty construction for a period of 12 (twelve) months after the date of despatch of the machines.

The guarantee is limited to the obligation to repair or replace free of charge any parts that prove to be faulty. The transportation cost is charged by the customer. All motor, electric and electronic equipment are excluded from the guarantee. It is understood that, in all cases, the guarantee does not entitle the customer, to any refund for damages, interruption of work or any indirect damage caused to person or things.

All parts to be replaced must be sent carriage paid to our works at Certaldo and any parts that have been made faulty due to Inexpert use of the operators, to deterioration caused by lack of lubrication or to normal wear and tear, will not be replaced.

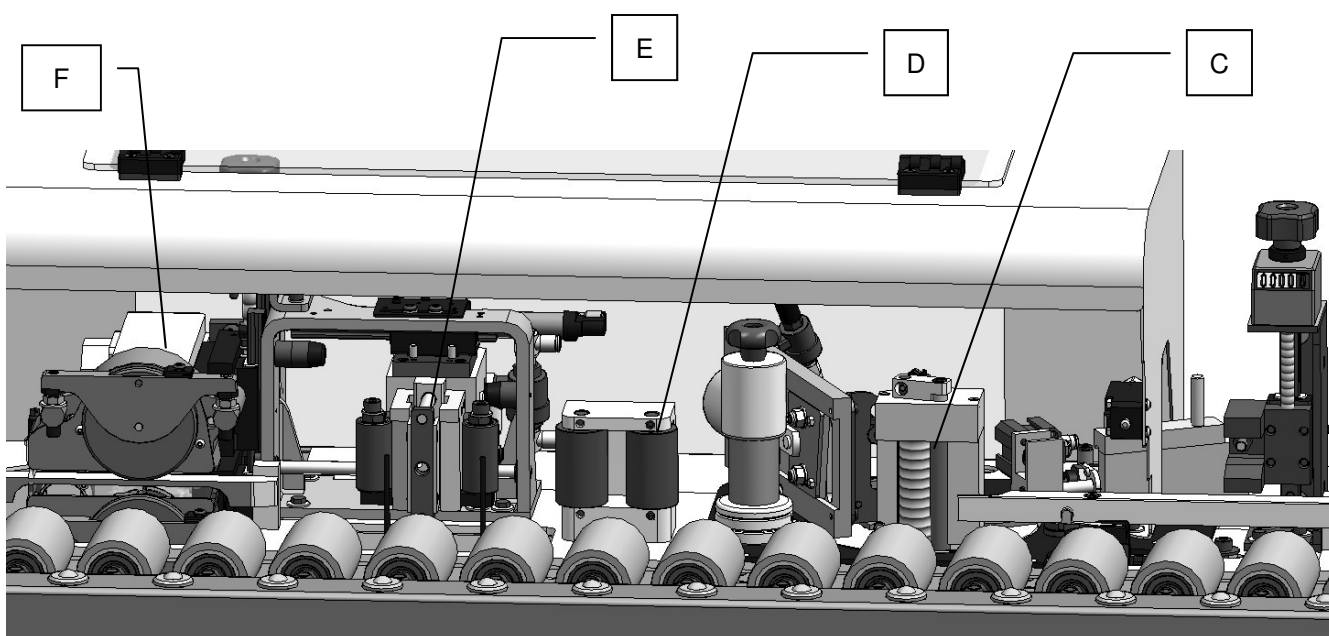
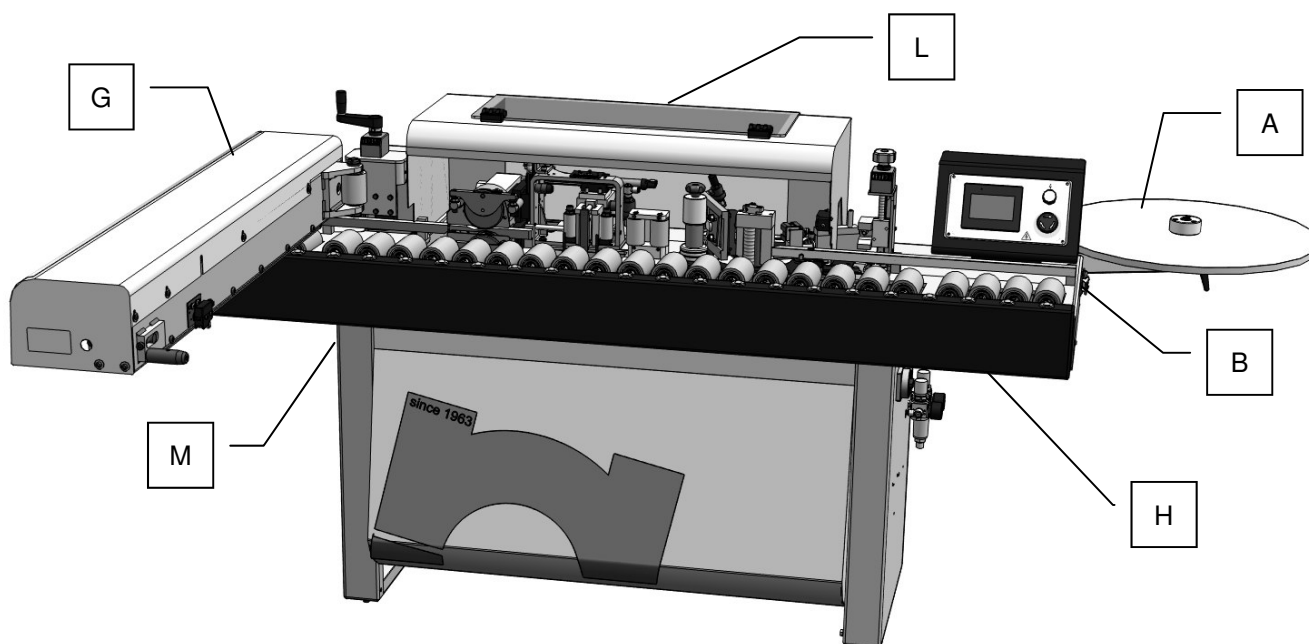


Spedire a:

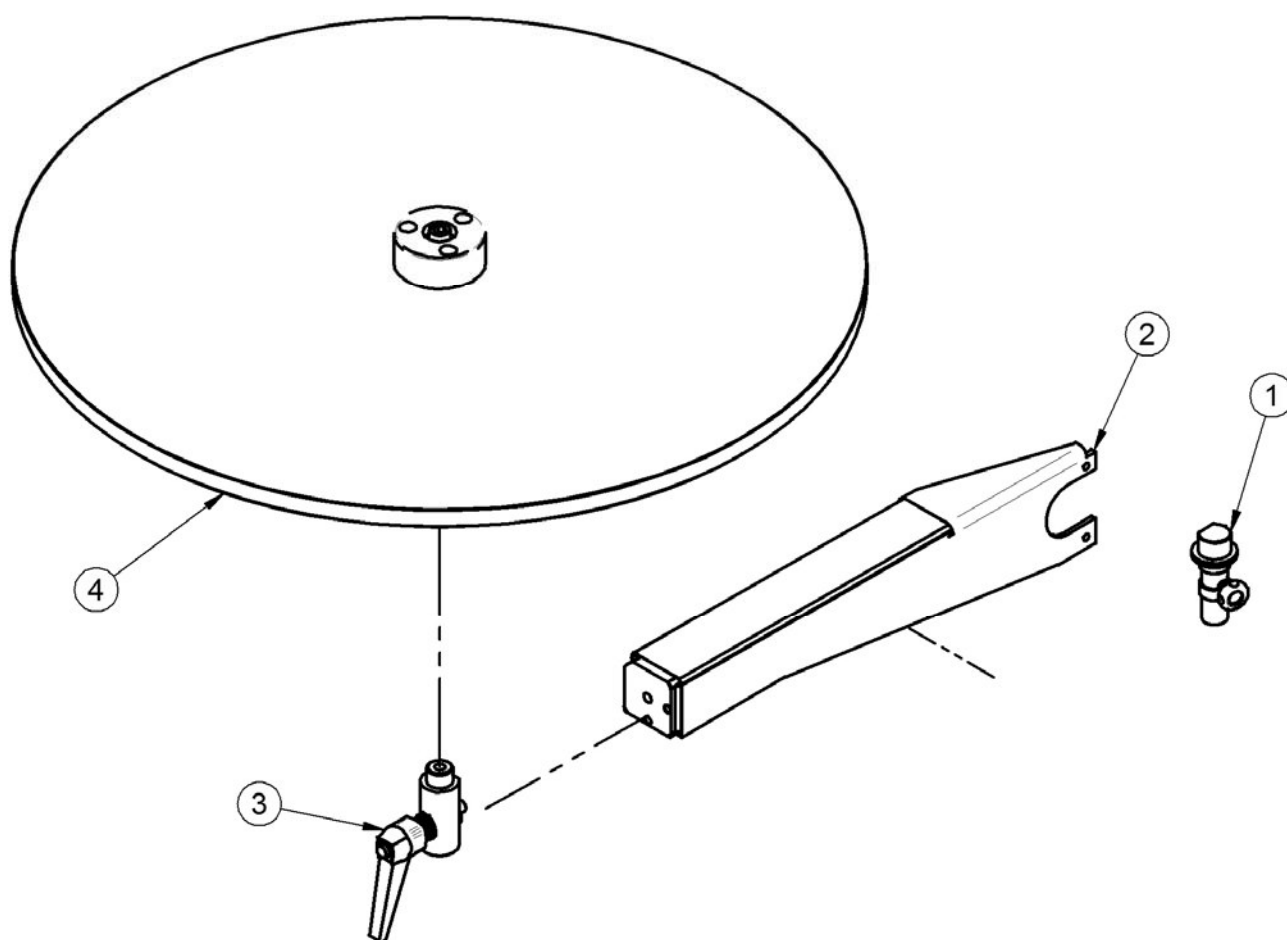
MAGGI TECHNOLOGY s.r.l.
Vendita ed Assistenza Tecnica
Via delle Regioni n°299
50052 CERTALDO (Fi)
ITALIA

13. PARTI DI RICAMBIO / SPARE PARTS

POS.	DENOMINAZIONE / DESCRIPTION	COD.
A	PORTABOBINA / REEL SUPPORT	28509306
B	PIANO / PLANE	28509100
C	VASCACOLLA / GLUE TANK	28506600
D	PRESSABORDO / PRESSURE ROLLER	28505608
E	INTESTATORE / END CUTTER	28509700
F	RIFILATORE / TRIMMING	28509200
G	TRASCINATORE / FEEDER	28509501
H	RULLIERA / SUPPORTING ROLL	28509901
L	CARTER SUPERIORE / UPPER COVER	28505008
M	TELAIO / FRAME	28507000

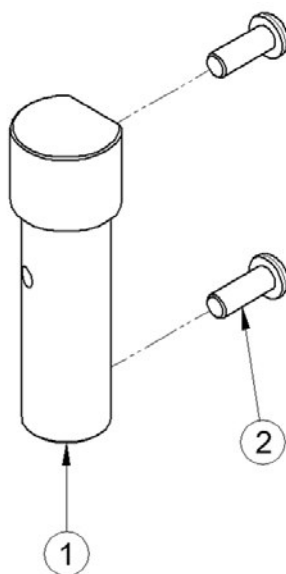


A - cod. 28509306 PORTABOBINA / REEL SUPPORT



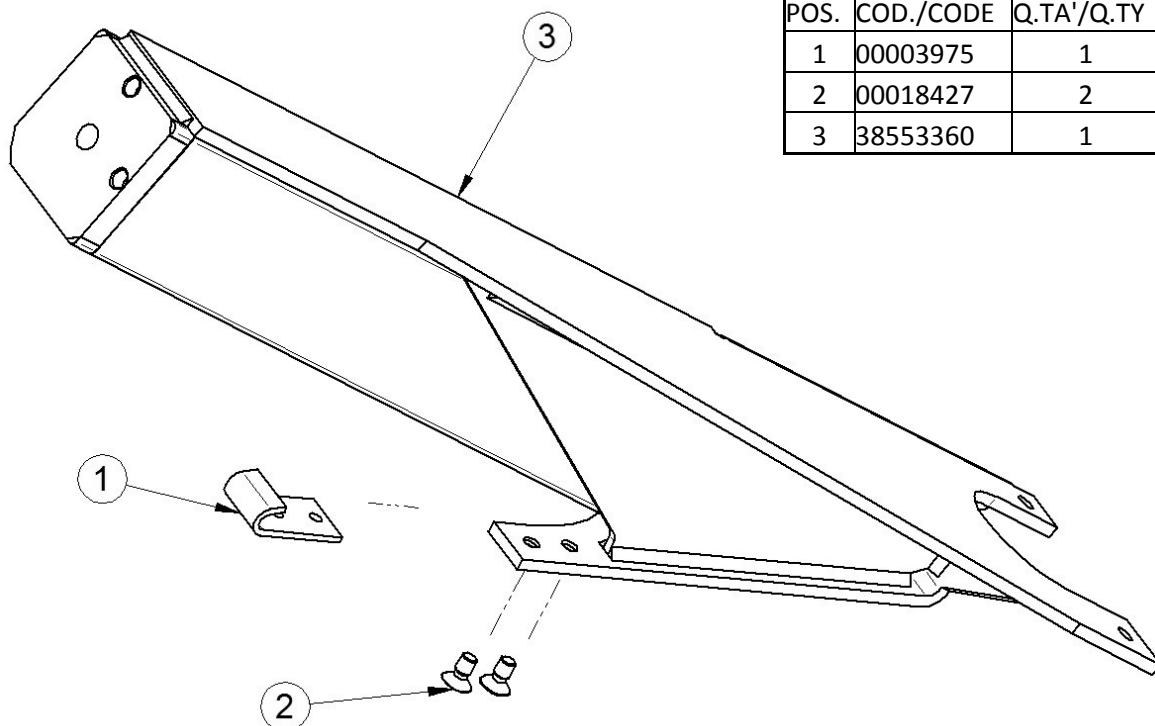
POS.	COD./CODE	Q.TA'/Q.TY
1	28509330	1
2	28504331	1
3	28509332	1
4	28504333	1

A1 - cod. 28509330 ROTAZIONE / ROTATION



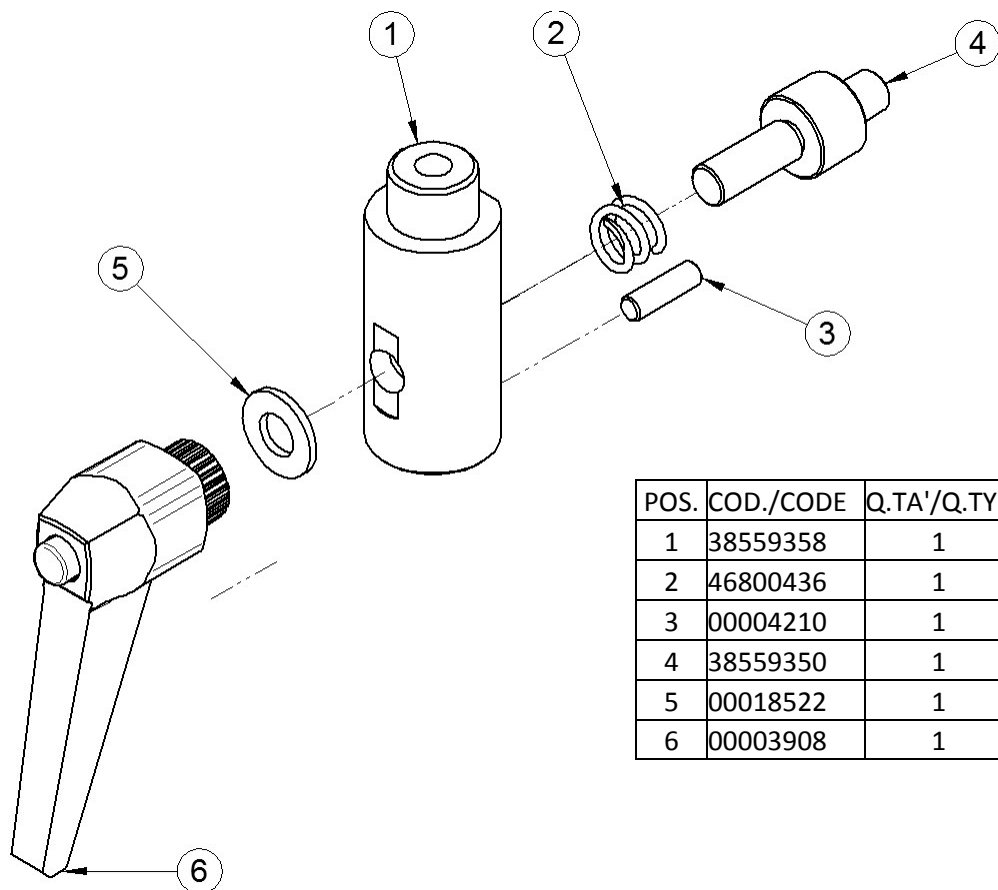
POS.	COD./CODE	Q.TA'/Q.TY
1	38509332	1
2	00018462	2

A2 - cod. 28504331 SUPPORTO / SUPPORT



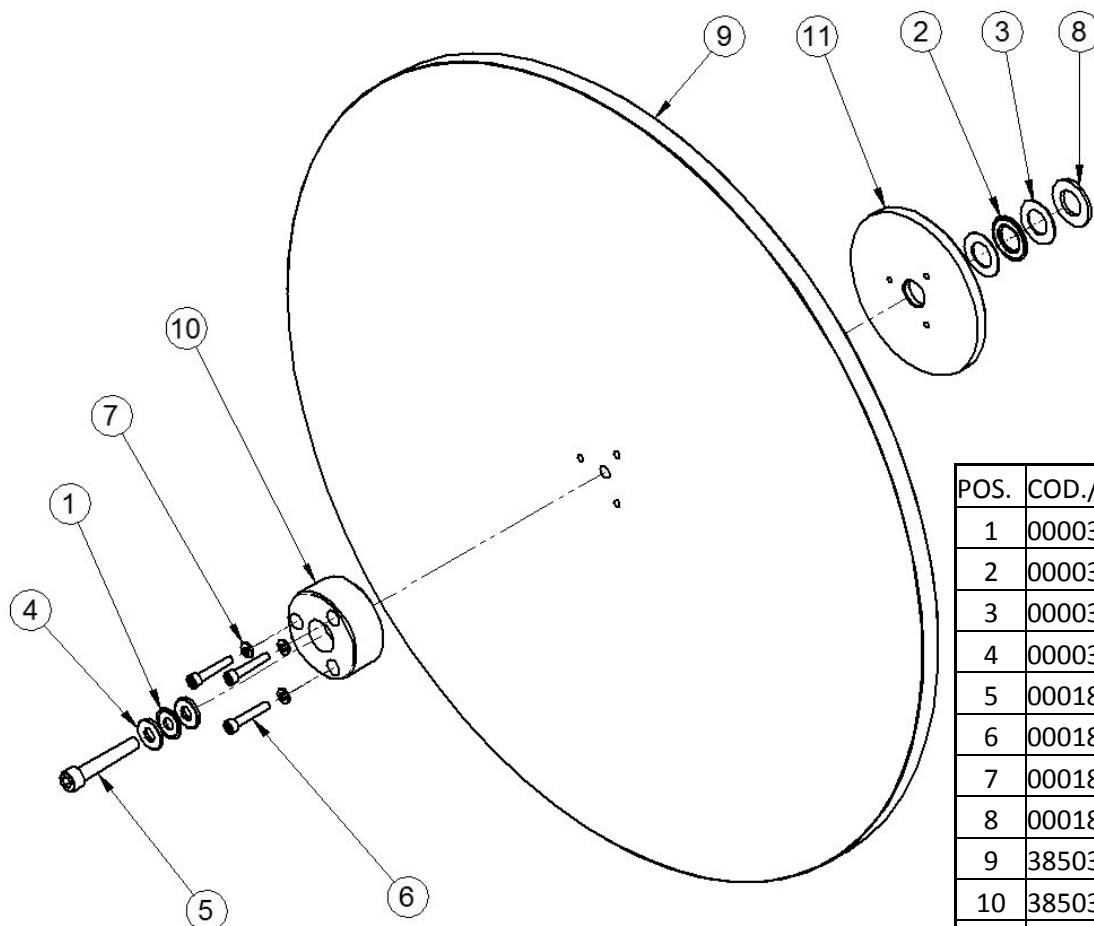
POS.	COD./CODE	Q.TA'/Q.TY
1	00003975	1
2	00018427	2
3	38553360	1

A3 - cod. 28509332 RIBALTAMENTO / OVERTURNING



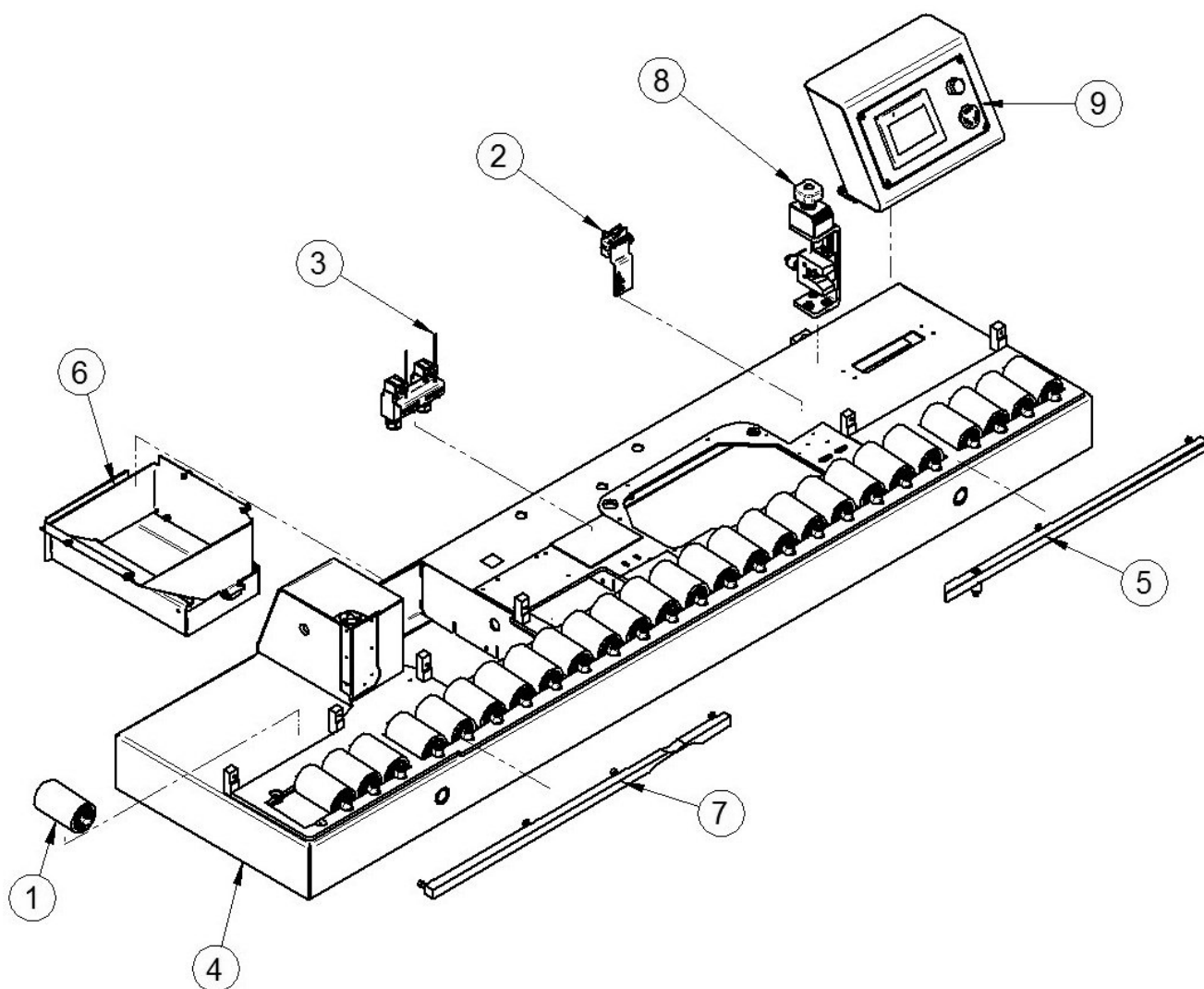
POS.	COD./CODE	Q.TA'/Q.TY
1	38559358	1
2	46800436	1
3	00004210	1
4	38559350	1
5	00018522	1
6	00003908	1

A4 - cod. 28504333 DISCO / DISK



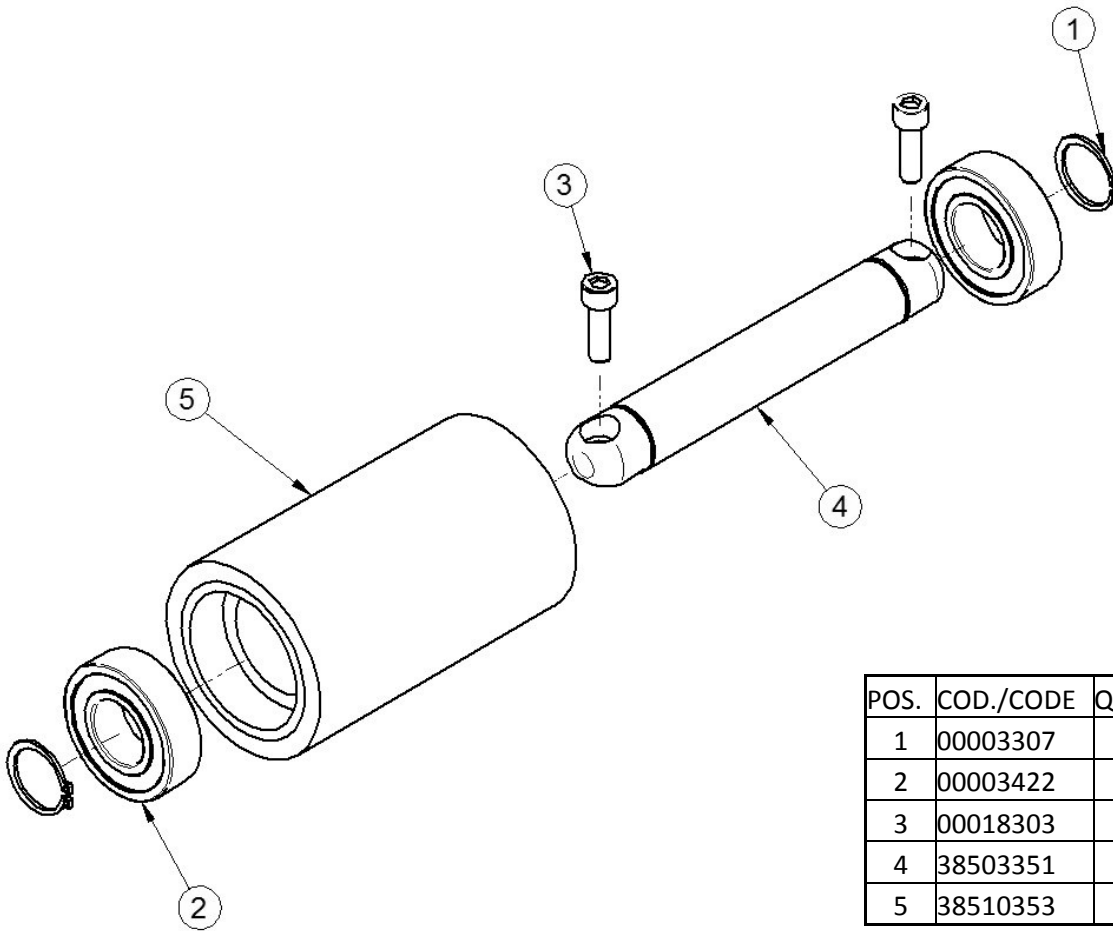
POS.	COD./CODE	Q.TA'/Q.TY
1	00003460	1
2	00003462	1
3	00003463	2
4	00003464	2
5	00018312	1
6	00018335	3
7	00018520	3
8	00018590	1
9	38503337	1
10	38503340	1
11	38553359	1

B - cod. 28509100 PIANO / PLANE



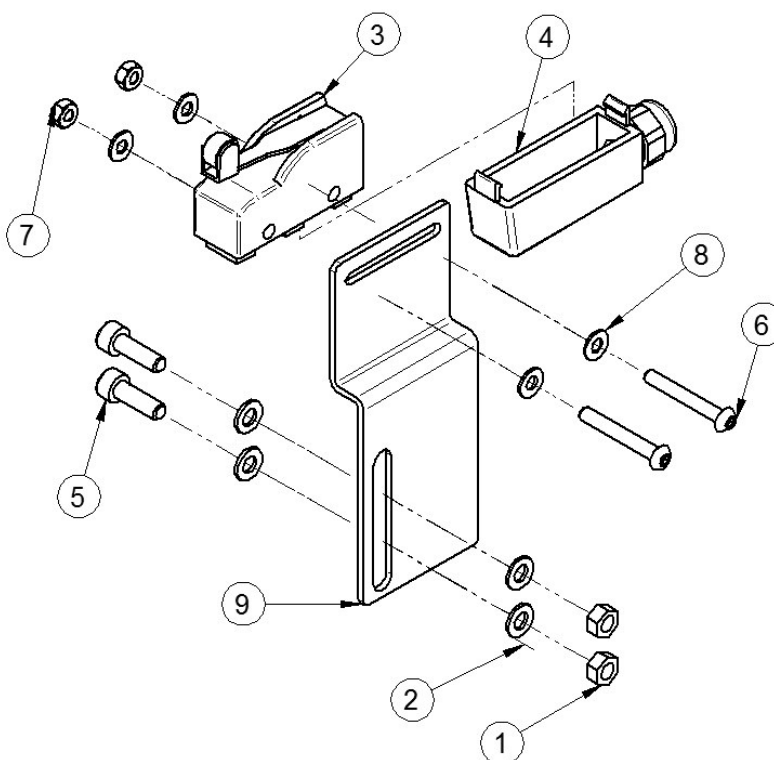
POS.	COD./CODE	Q.TA'/Q.TY
1	28503356	26
2	28506104	1
3	28506105	1
4	28507101	1
5	28507102	1
6	28507307	1
7	28509103	1
8	28509310	1
9	28557006	1

B1 - cod. 28503356 RULLO / ROLLER



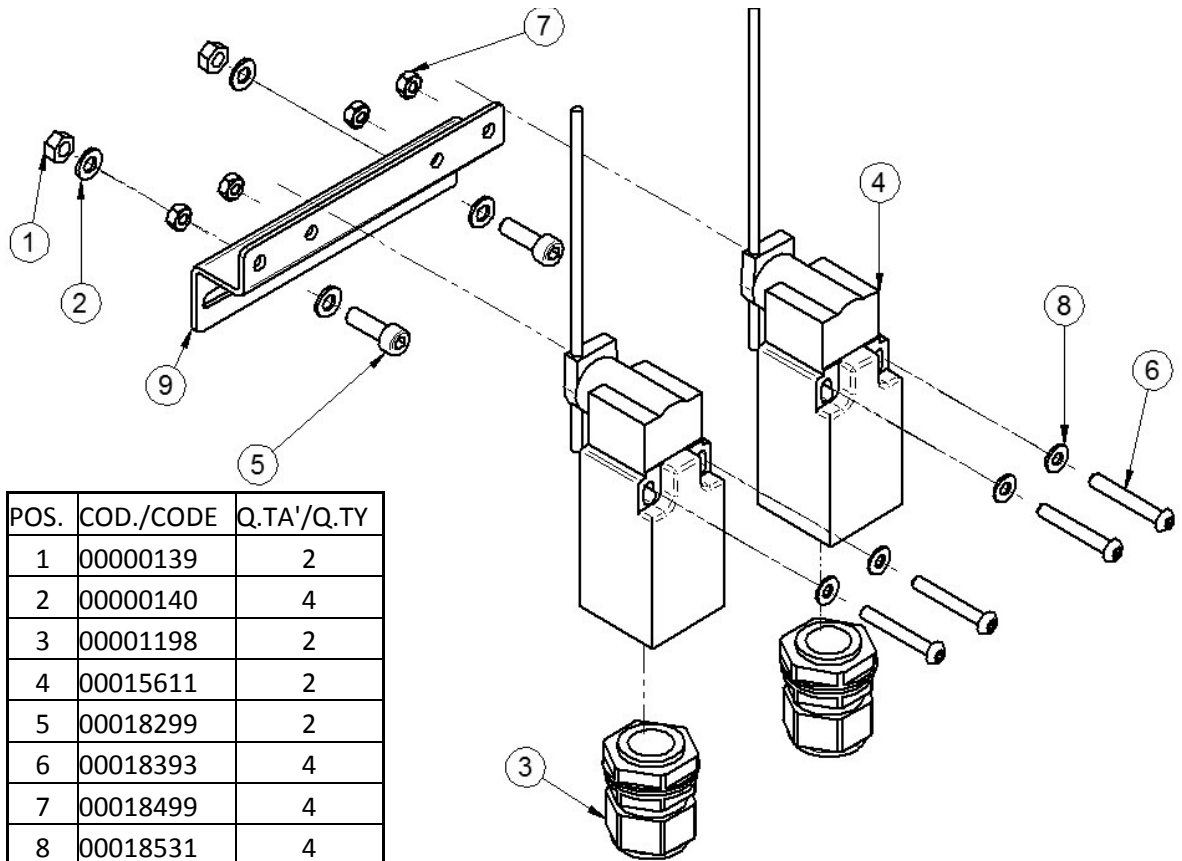
POS.	COD./CODE	Q.TA'/Q.TY
1	00003307	2
2	00003422	2
3	00018303	2
4	38503351	1
5	38510353	1

B2 - cod. 28506104 SENSORE VASCA/ SENSOR INPUT



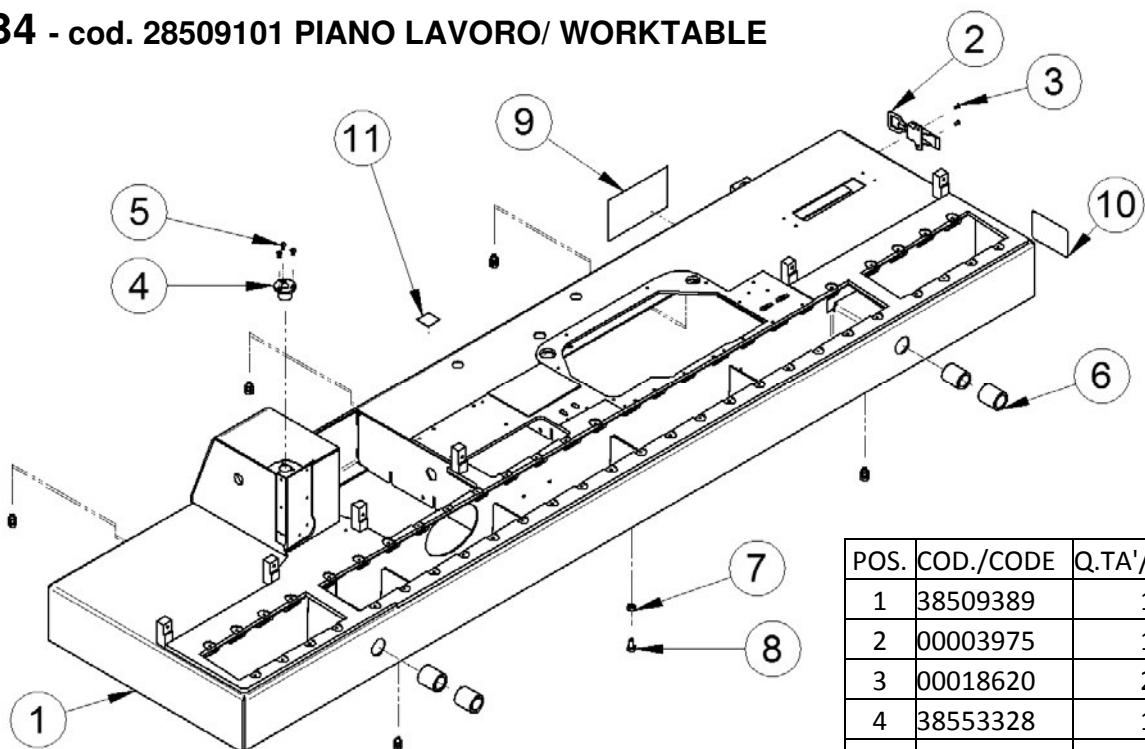
POS.	COD./CODE	Q.TA'/Q.TY
1	00000139	2
2	00000140	4
3	00015612	1
4	00015613	1
5	00018299	2
6	00018393	2
7	00018499	2
8	00018531	4
9	38505391	1

B3 - cod. 28506105 SENSORE INTESSTATORE / SENSOR TRIMMING



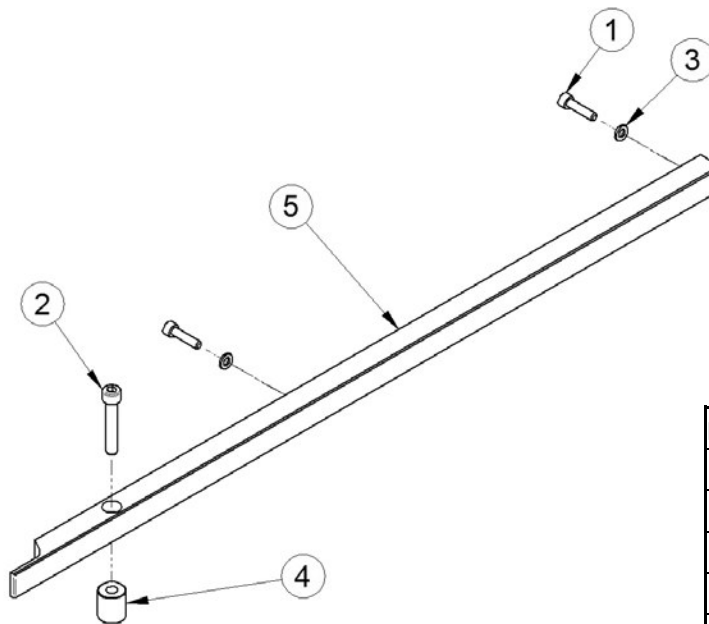
POS.	COD./CODE	Q.TA'/Q.TY
1	00000139	2
2	00000140	4
3	00001198	2
4	00015611	2
5	00018299	2
6	00018393	4
7	00018499	4
8	00018531	4
9	38504390	1

B4 - cod. 28509101 PIANO LAVORO/ WORKTABLE



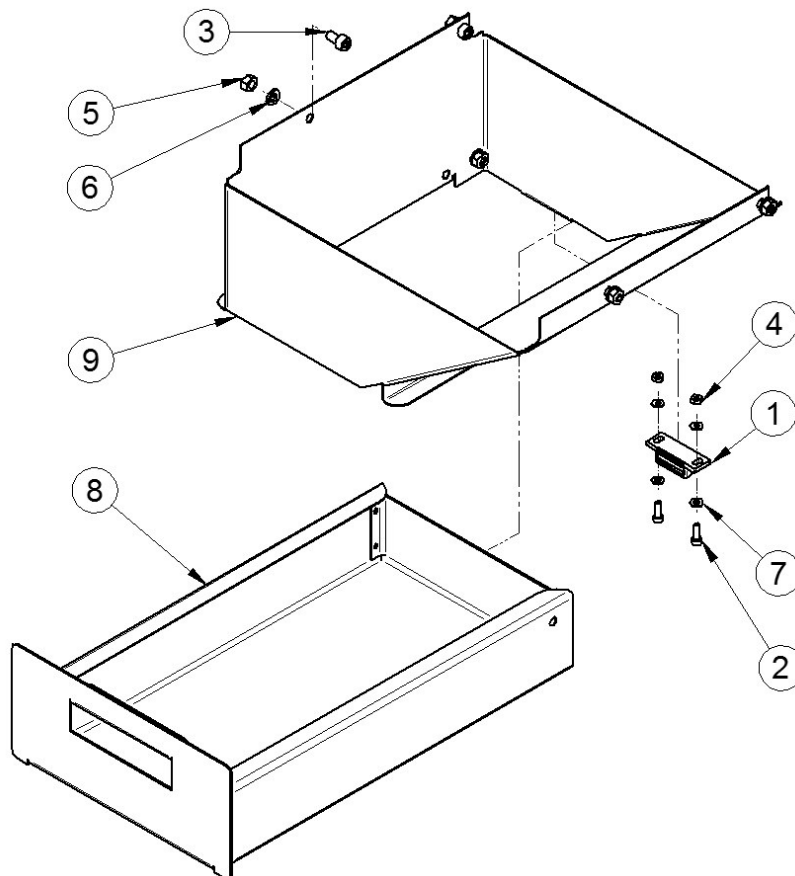
POS.	COD./CODE	Q.TA'/Q.TY
1	38509389	1
2	00003975	1
3	00018620	2
4	38553328	1
5	00018427	3
6	00003033	4
7	00000146	6
8	00018405	6
9	36054016	1
10	40000035	1
11	36054019	1

B5 - cod. 28507102 GUIDA INGRESSO/ INFEED GUIDE



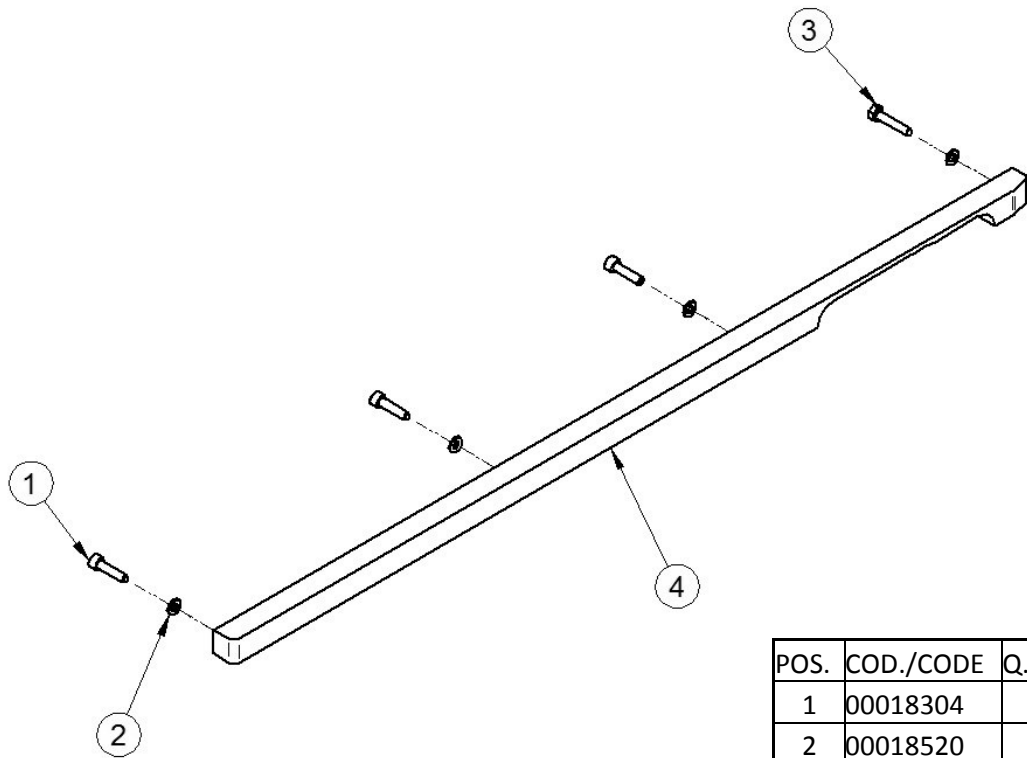
POS.	COD./CODE	Q.TA'/Q.TY
1	00018304	2
2	00018378	1
3	00018520	2
4	38500368	1
5	38507364	1

B6 - cod. 28507307 CASSETTO / DRAWER



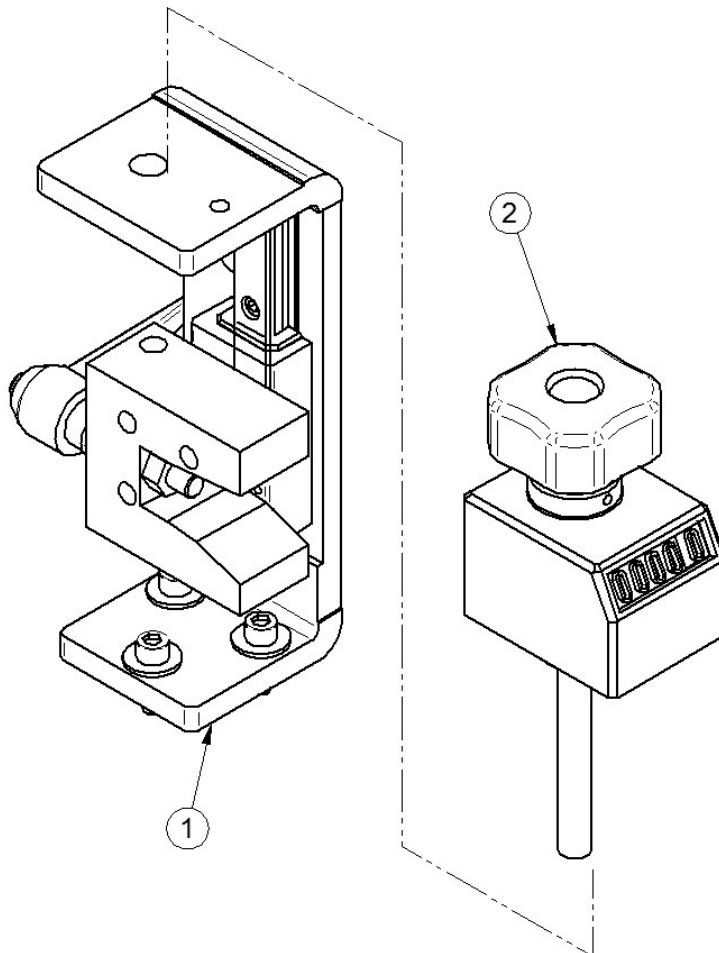
POS.	COD./CODE	Q.TA'/Q.TY
1	00003150	1
2	00018290	2
3	00018333	6
4	00018499	2
5	00018500	6
6	00018520	8
7	00018531	4
8	38557332	1
9	38557335	1

B7 - cod. 28509103 GUIDA USCITA/ OUTFEED GUIDE



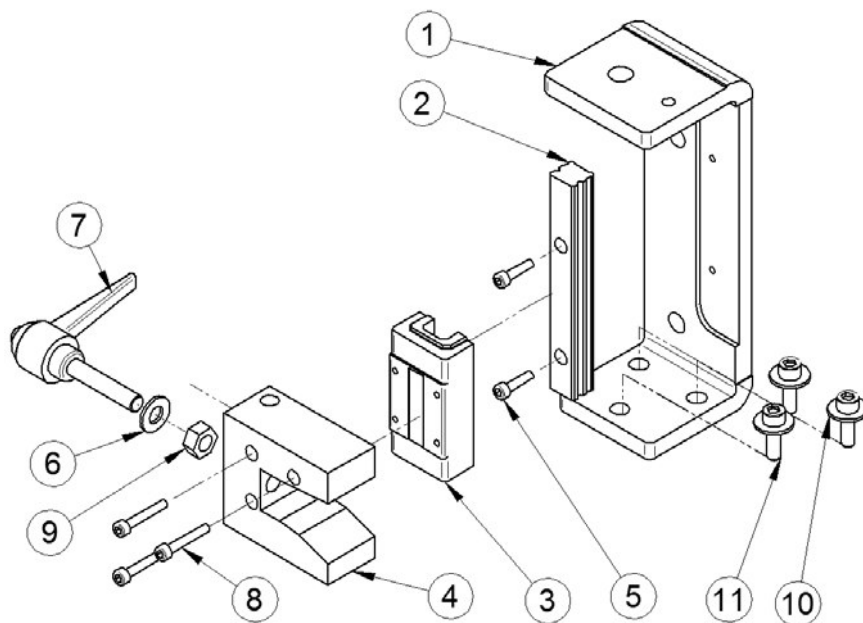
POS.	COD./CODE	Q.TA'/Q.TY
1	00018304	3
2	00018520	4
3	00018814	1
4	38509363	1

B8 - cod. 28509310 BLOCCAGGIO TRASCINATORE/ BLOCKING BELT



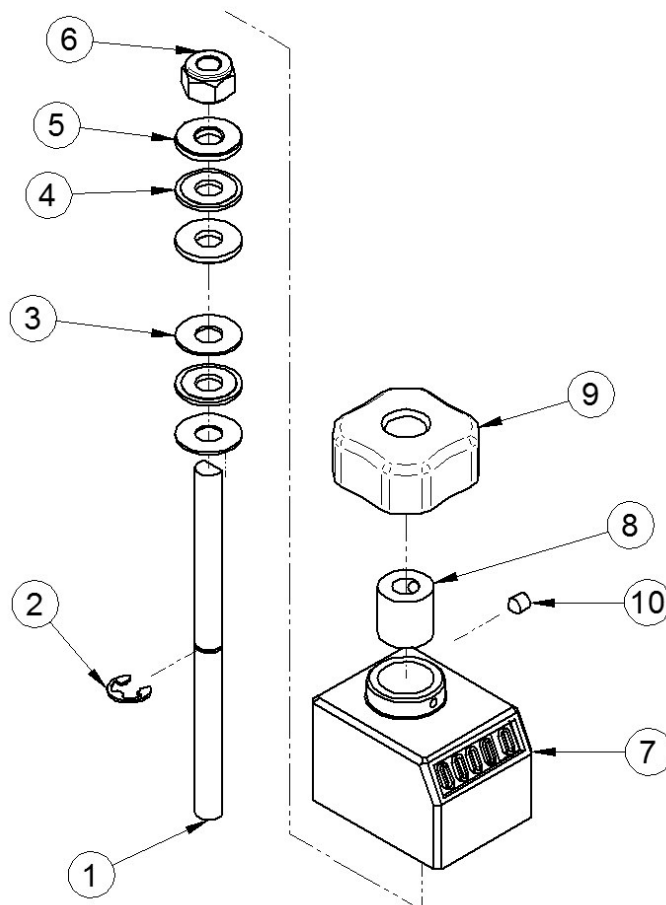
POS.	COD./CODE	Q.TA'/Q.TY
1	28509313	1
2	28509314	1

B8-1 - cod. 28509313 COLONNA BLOCCAGGIO / SUPPORT BLOCK



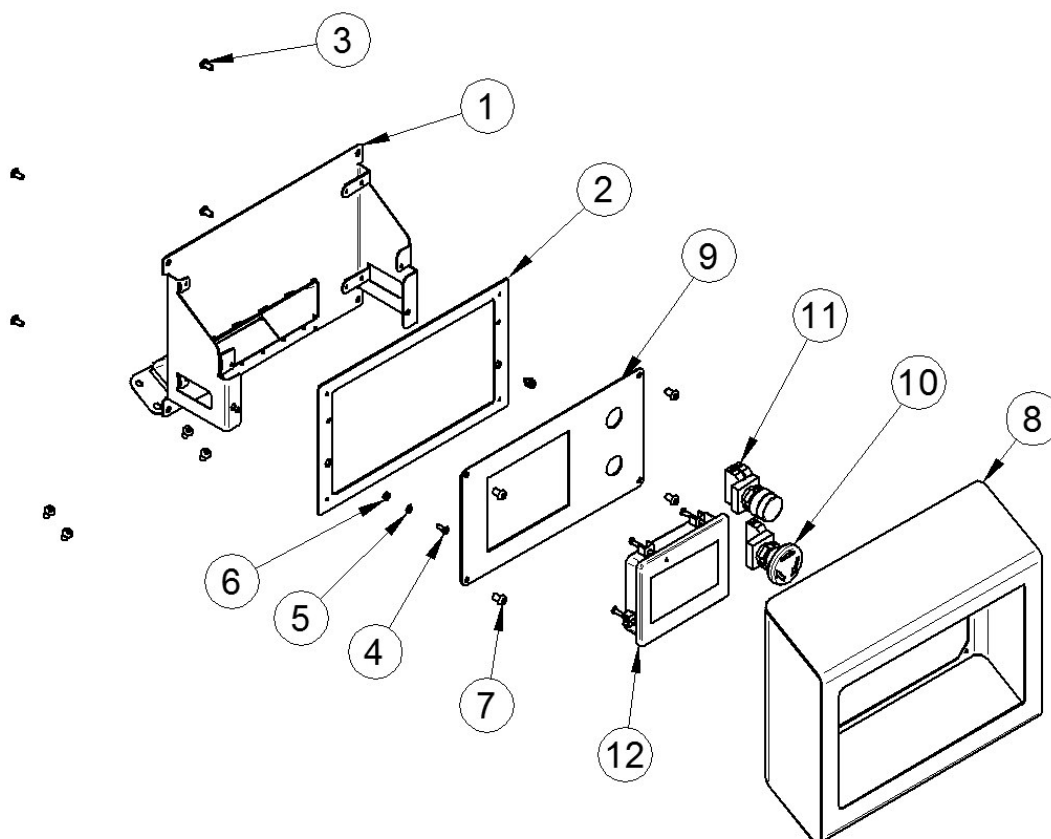
POS.	COD./CODE	Q.TA'/Q.TY
1	38509361	1
2	38509110	1
3	00003038	1
4	38559357	1
5	00018380	2
6	00018521	1
7	00004020	1
8	00018381	3
9	00018501	1
10	00018526	3
11	00018303	3

B8-2 - cod. 28509314 ALZATA BLOCCAGGIO/ SCREW BLOCK



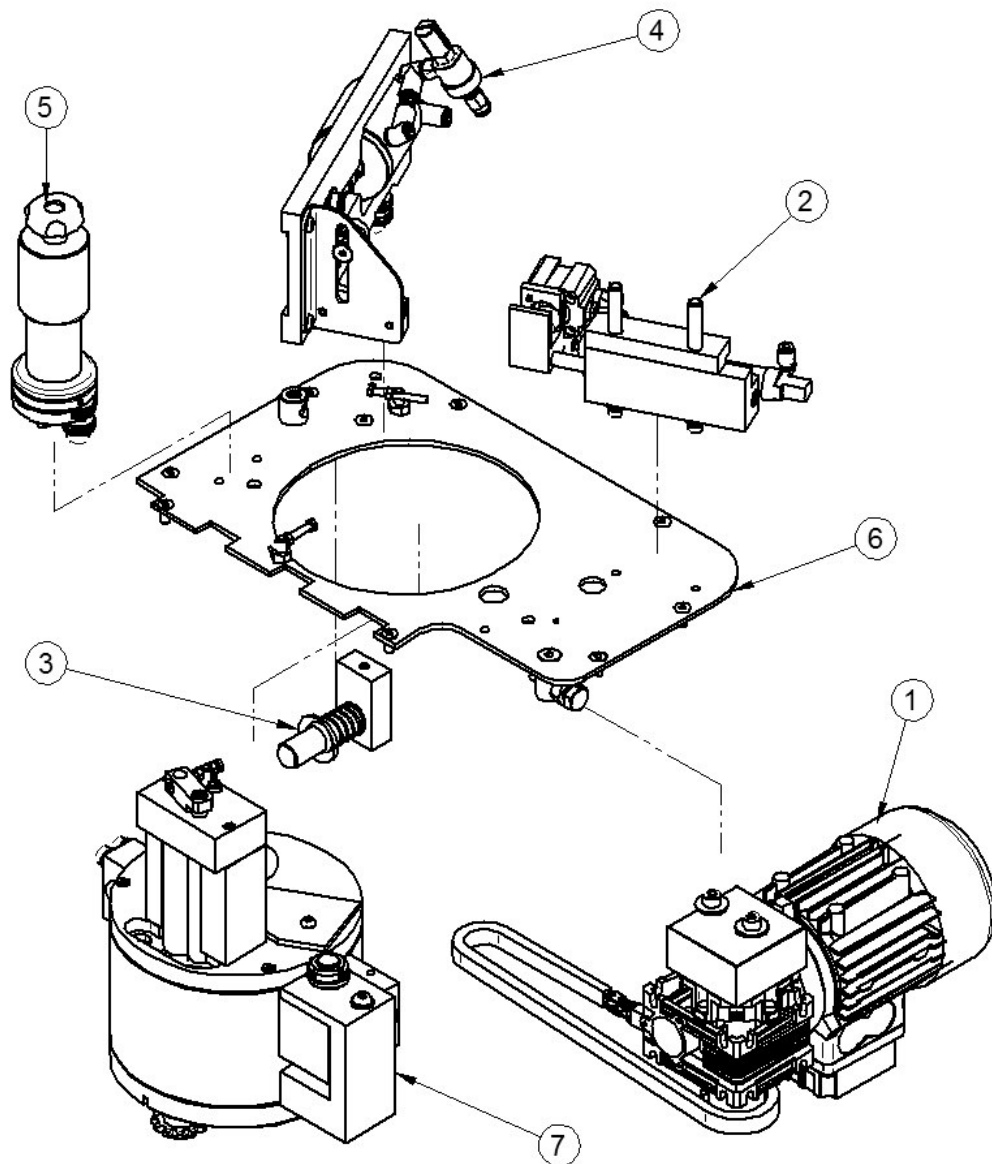
POS.	COD./CODE	Q.TA'/Q.TY
1	38559347	1
2	00003321	1
3	00003461	2
4	00003460	2
5	00003464	2
6	00000152	1
7	00003972	1
8	38554368	1
9	38500239	1
10	00160010	1

B9 - cod. 28557006 GRUPPO PANNELLO COMANDI



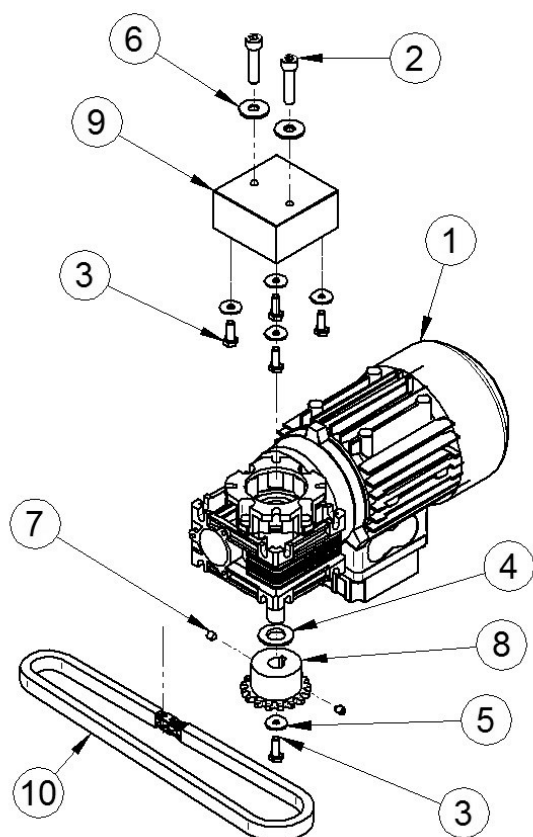
POS.	COD./CODE	Q.TA'/Q.TY
1	38507018	1
2	38507016	1
3	00018558	4
4	00018420	2
5	00018531	2
6	00018499	2
7	00018441	8
8	38507015	1
9	38508017	1
10	00005070	1
11	00005751	1
12	00005149	1

C - cod. 28509600 VASCACOLLA/ GLUE POT



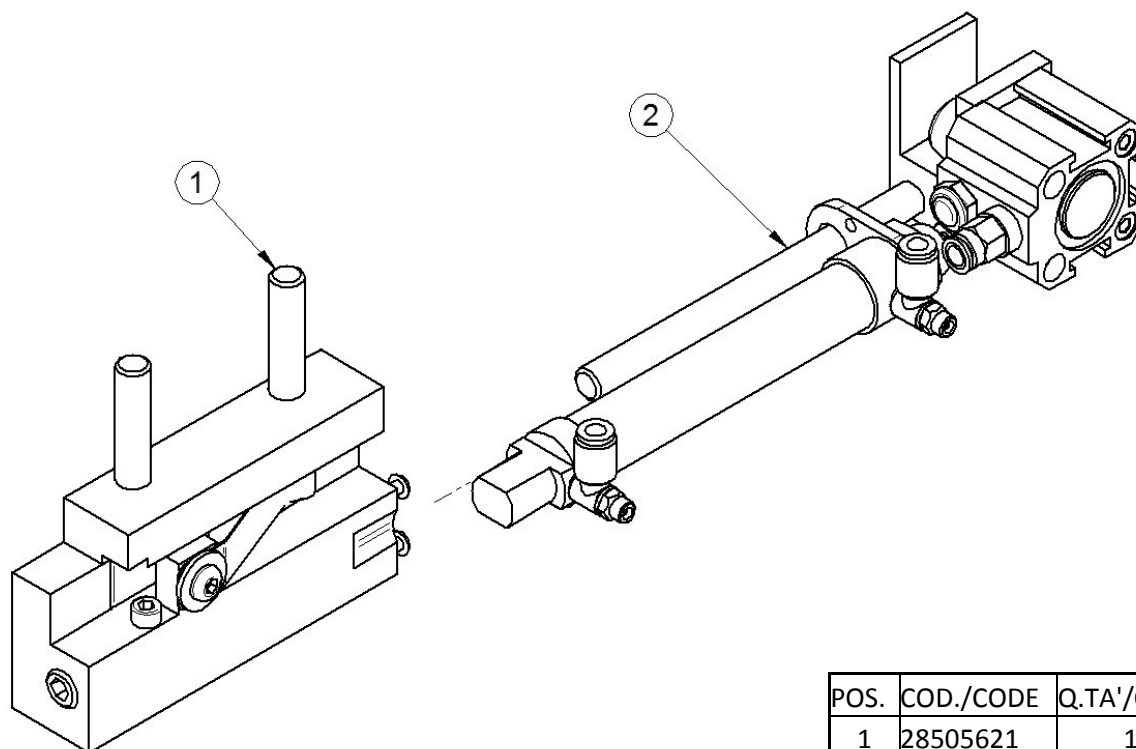
POS.	COD./CODE	Q.TA'/Q.TY
1	28504602	1
2	28505601	1
3	28505605	1
4	28505606	1
5	28505607	1
6	28509609	1
7	28507623	1

C1 - cod. 28504602 MOTORE / MOTOR GLUE POT



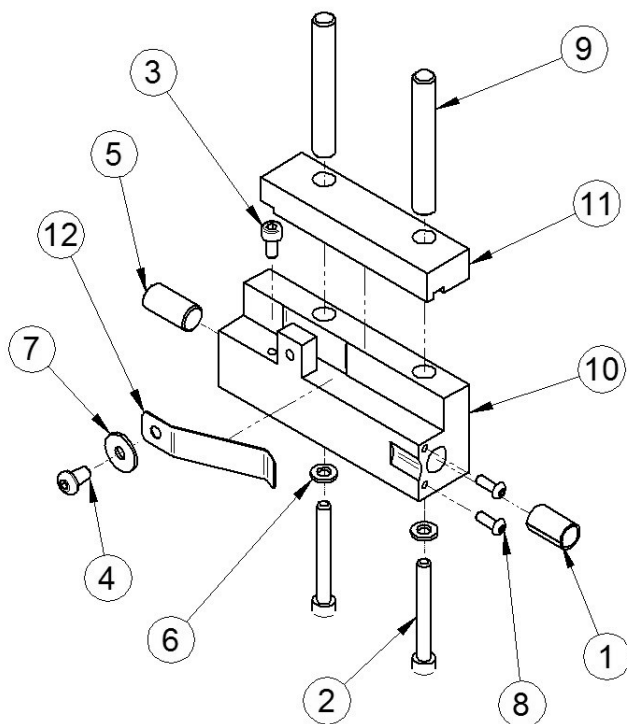
POS.	COD./CODE	Q.TA'/Q.TY
1	00014308	1
2	00018327	2
3	00018473	5
4	00018525	1
5	00018526	5
6	00018527	2
7	00160010	2
8	38500665	1
9	38504657	1
10	48500001-(50Hz)	
10*	48500002-(60Hz)	1

C2 - cod. 28505601 SCORRIMENTO BORDO / EDGE BANDING INSERTING



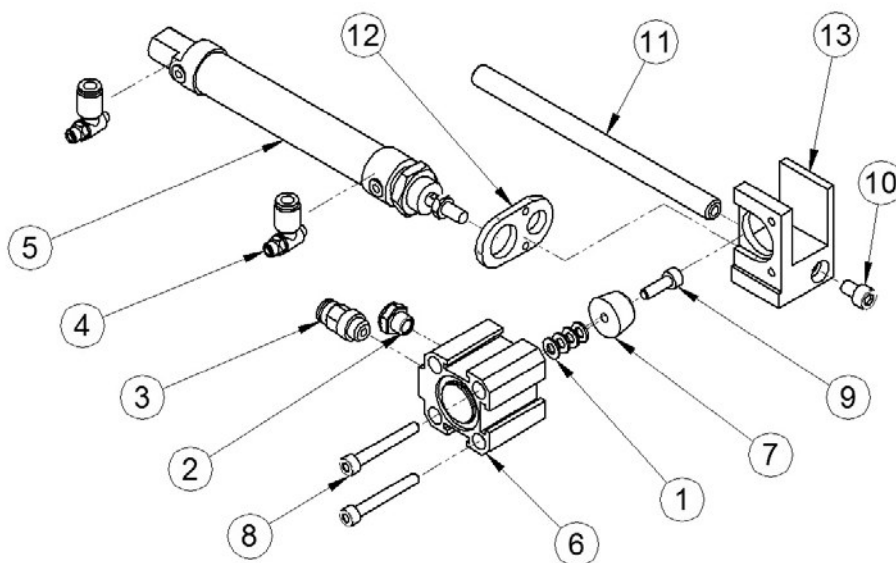
POS.	COD./CODE	Q.TA'/Q.TY
1	28505621	1
2	28505622	1

C2-1 - cod. 28505621 GUIDABORDO / EDGE GUIDE



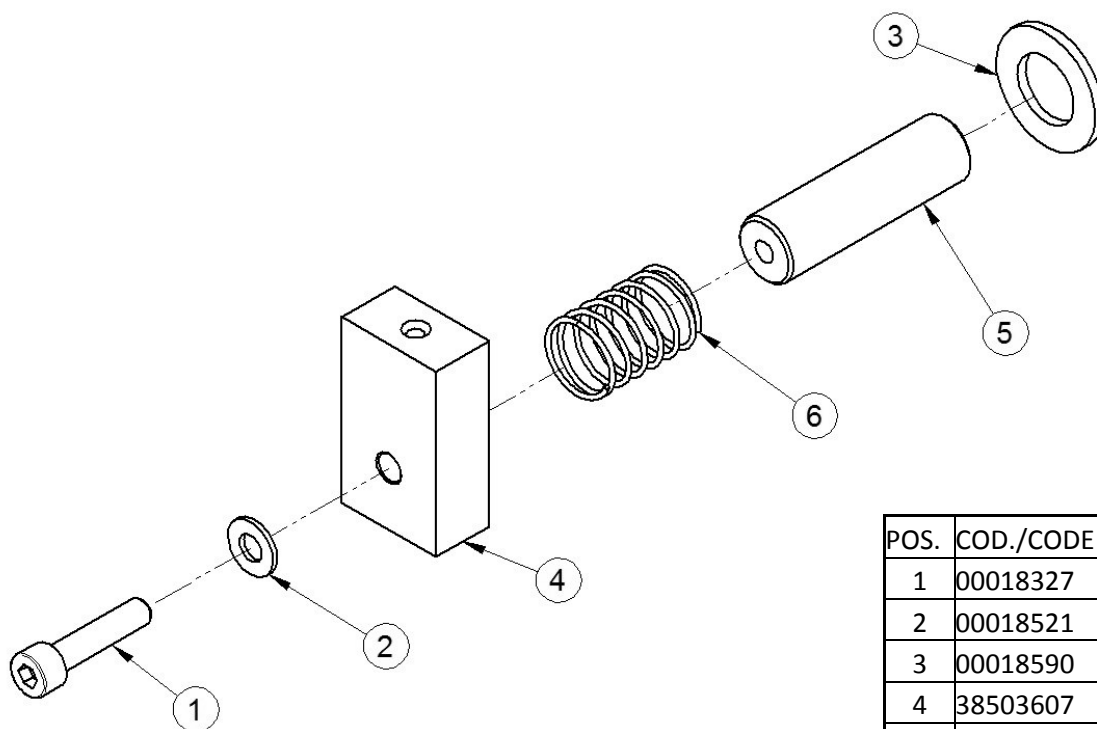
POS.	COD./CODE	Q.TA'/Q.TY
1	00006080	1
2	00018321	2
3	00018382	1
4	00018441	1
5	00018454	1
6	00018520	2
7	00018526	1
8	00018619	2
9	38503605	2
10	38505601	1
11	38505627	1
12	38505676	1

C2-2 - cod. 28505622 PORTABORDO / MOBILE EDGE GUIDE



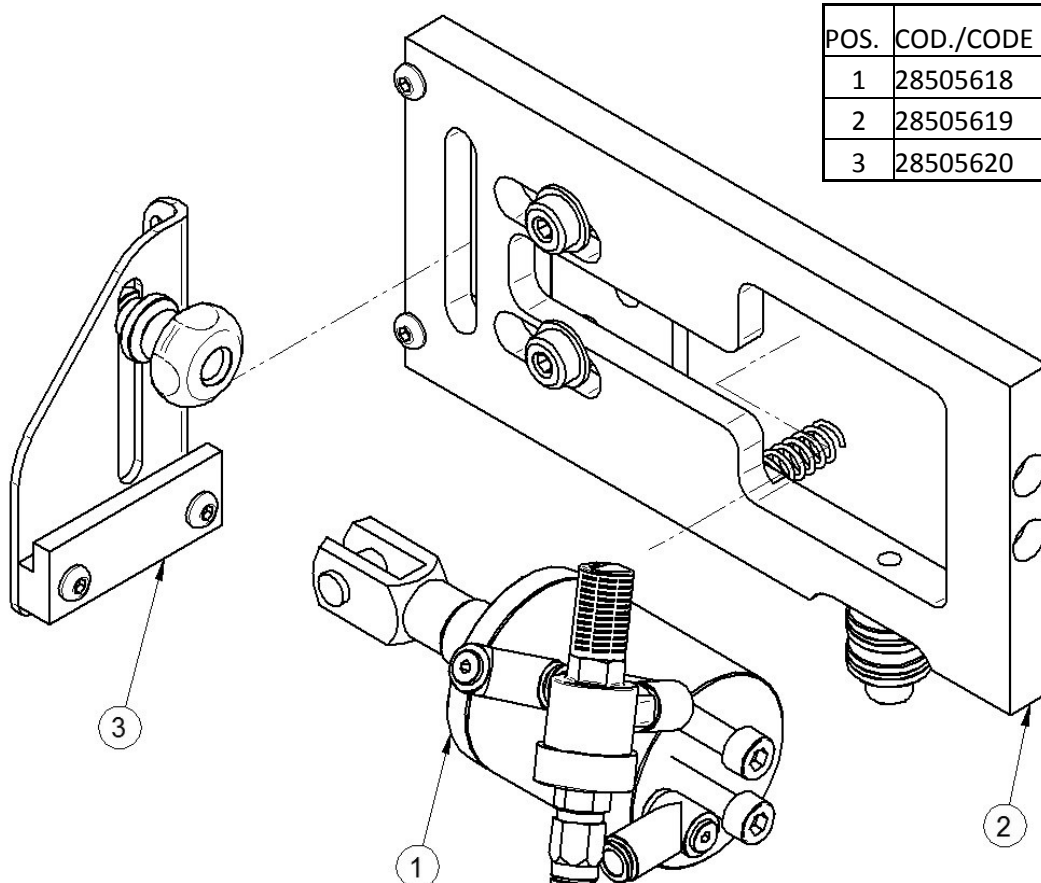
POS.	COD./CODE	Q.TA'/Q.TY
1	00000140	4
2	00001109	1
3	00001167	1
4	00001175	2
5	00001185	1
6	00004014	1
7	00005201	1
8	00018292	2
9	00018299	1
10	00018302	1
11	38503604	1
12	38503630	1
13	38504632	1

C3 - cod. 28505605 MOLLEGGIO / SPRING OF THE GLUE POT



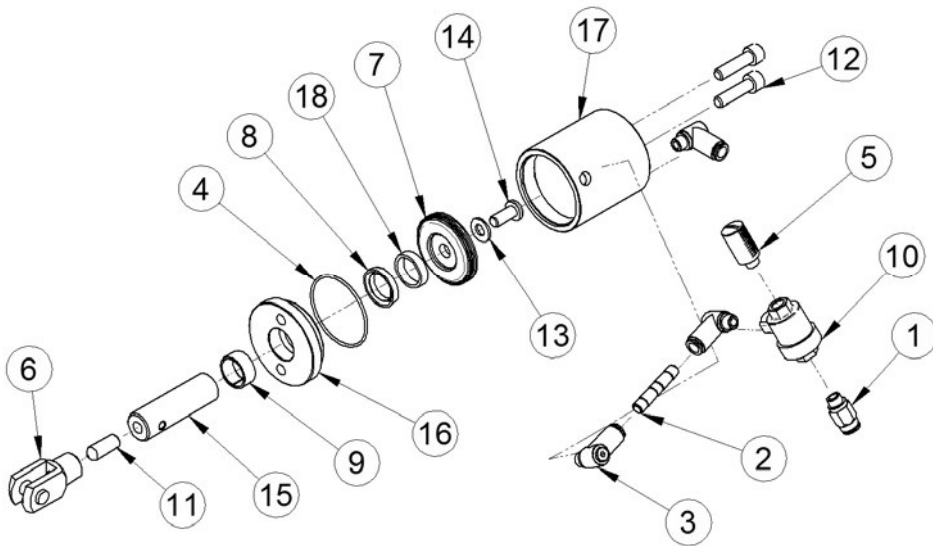
POS.	COD./CODE	Q.TA'/Q.TY
1	00018327	1
2	00018521	1
3	00018590	1
4	38503607	1
5	38504610	1
6	38505576	1

C4 - cod. 28505606 TAGLIERINA / INFEEED CUTTER



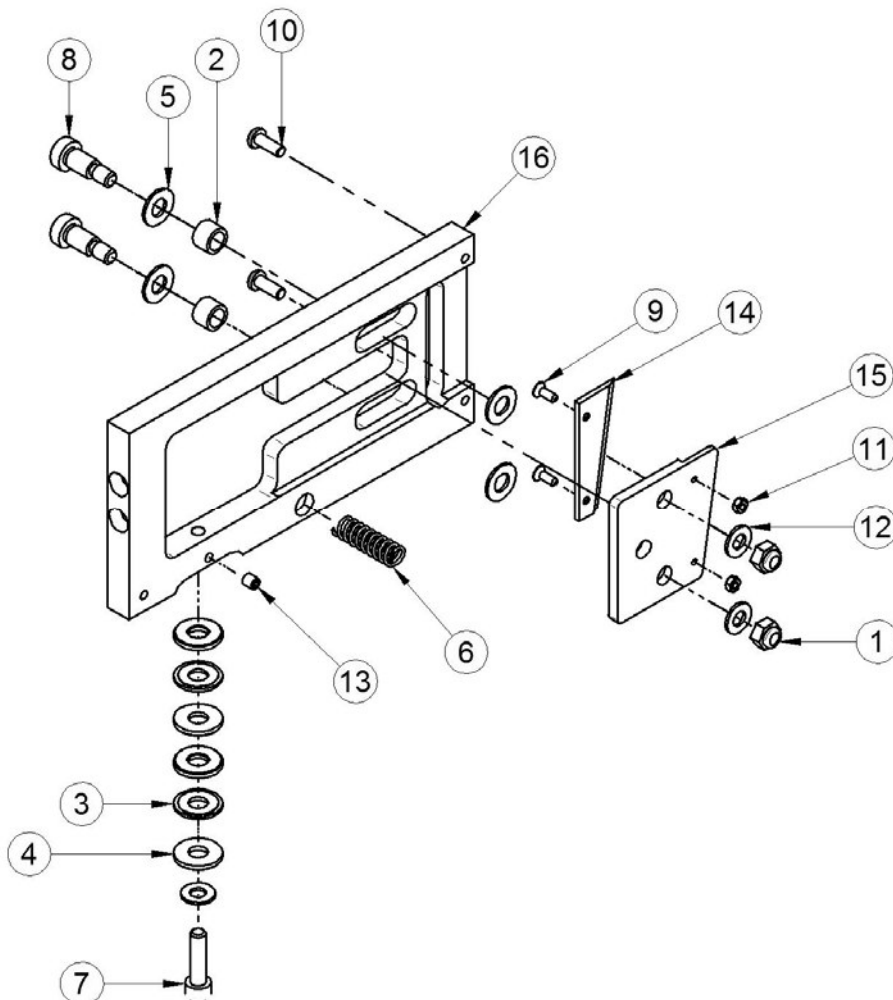
POS.	COD./CODE	Q.TA'/Q.TY
1	28505618	1
2	28505619	1
3	28505620	1

C4-1 - cod. 28505618 PISTONE LAMA / CYLINDER CUTTER



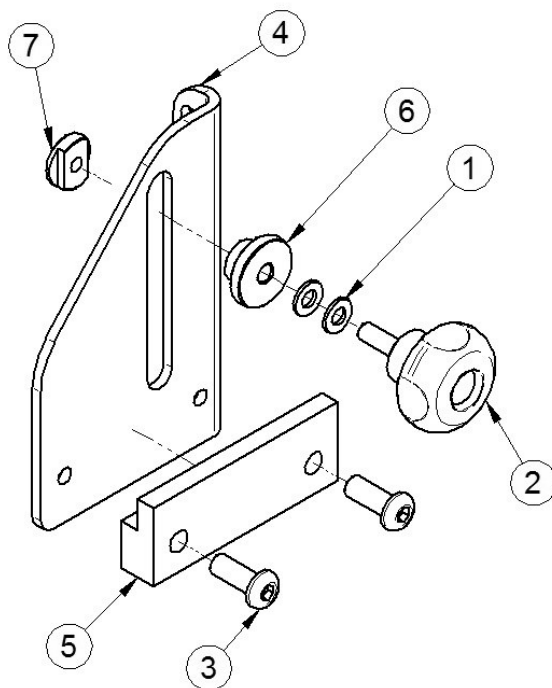
POS.	COD./CODE	Q.TA'/Q.TY
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3	00001105	3
4	00001121	1
5	00001190	1
6	00001212	1
7	00001213	1
8	00001501	1
9	00005095	1
10	00015279	1
11	00017998	1
12	00018308	2
13	00018521	1
14	00020450	1
15	38503634	1
16	38503635	1
17	38503641	1
18	38520718	1

C4-2 - cod. 28505619 SUPPORTO TAGLIERINA / SUPPORT CUTTING



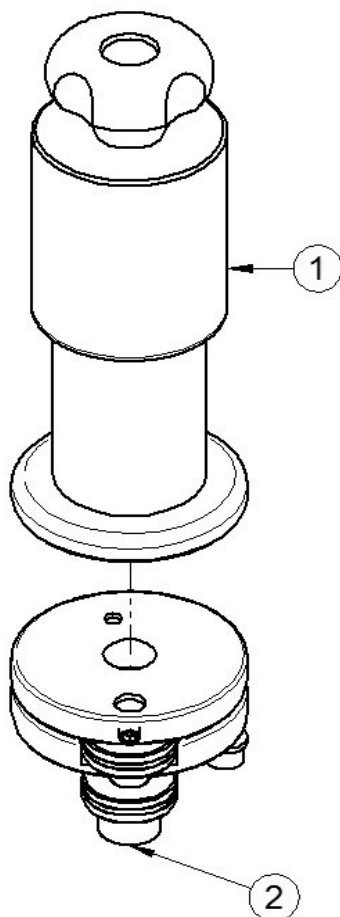
POS.	COD./CODE	Q. TA'/Q. TY
1	00000145	2
2	00003027	2
3	00003460	2
4	00003464	4
5	00003471	4
6	00004998	1
7	00018308	1
8	00018345	2
9	00018420	2
10	00018462	2
11	00018499	2
12	00018521	3
13	00160010	1
14	38500716	1
15	38503633	1
16	38505606	1

C4-3 - cod. 28505620 INVITO BORDO / EDGE SHEET



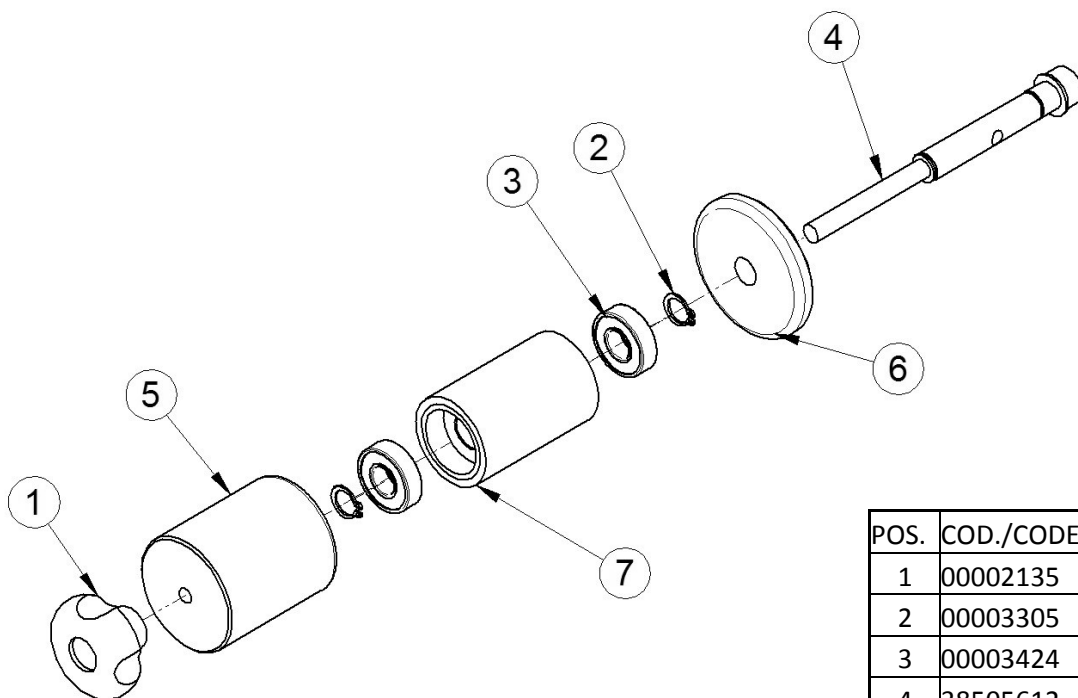
1	00000140	2
2	00003101	1
3	00018462	2
4	38505624	1
5	38505637	1
6	38505669	1
7	38505674	1

C5 - cod. 28505607 TRASCINABORDO / EDGE FEEDER ROLL SHEET



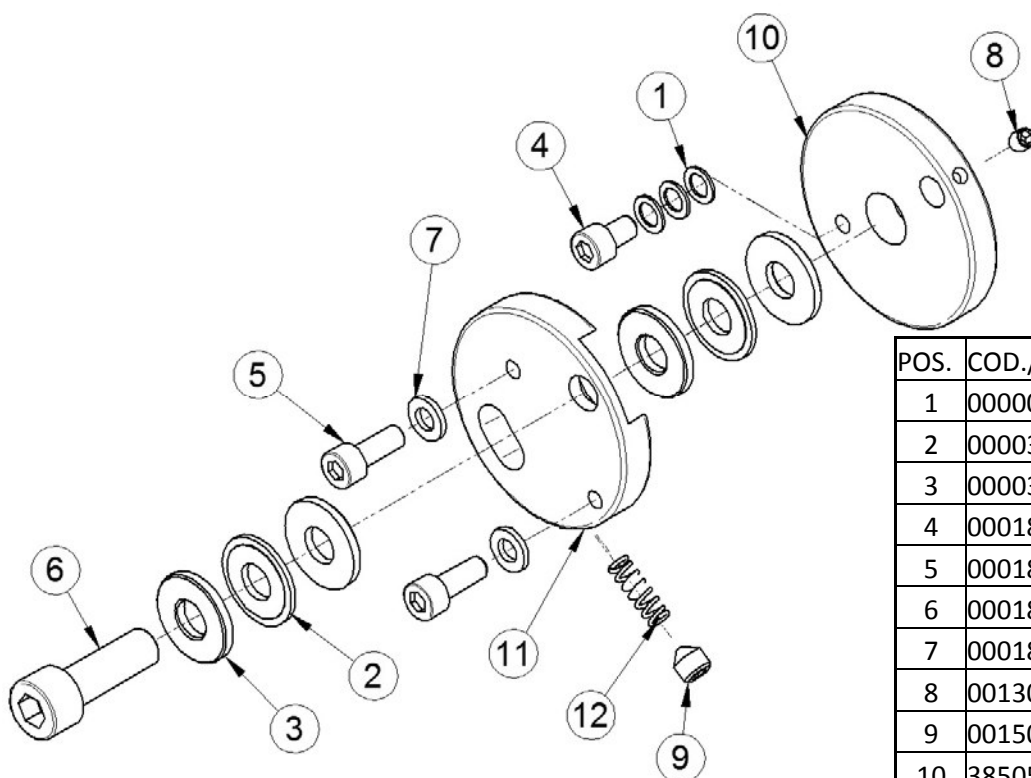
POS.	COD./CODE	Q.TA'/Q.TY
1	28505624	1
2	28505625	1

C5-1 - cod. 28505624 RULLO TRASCINABORDO /EDGE ROLLER



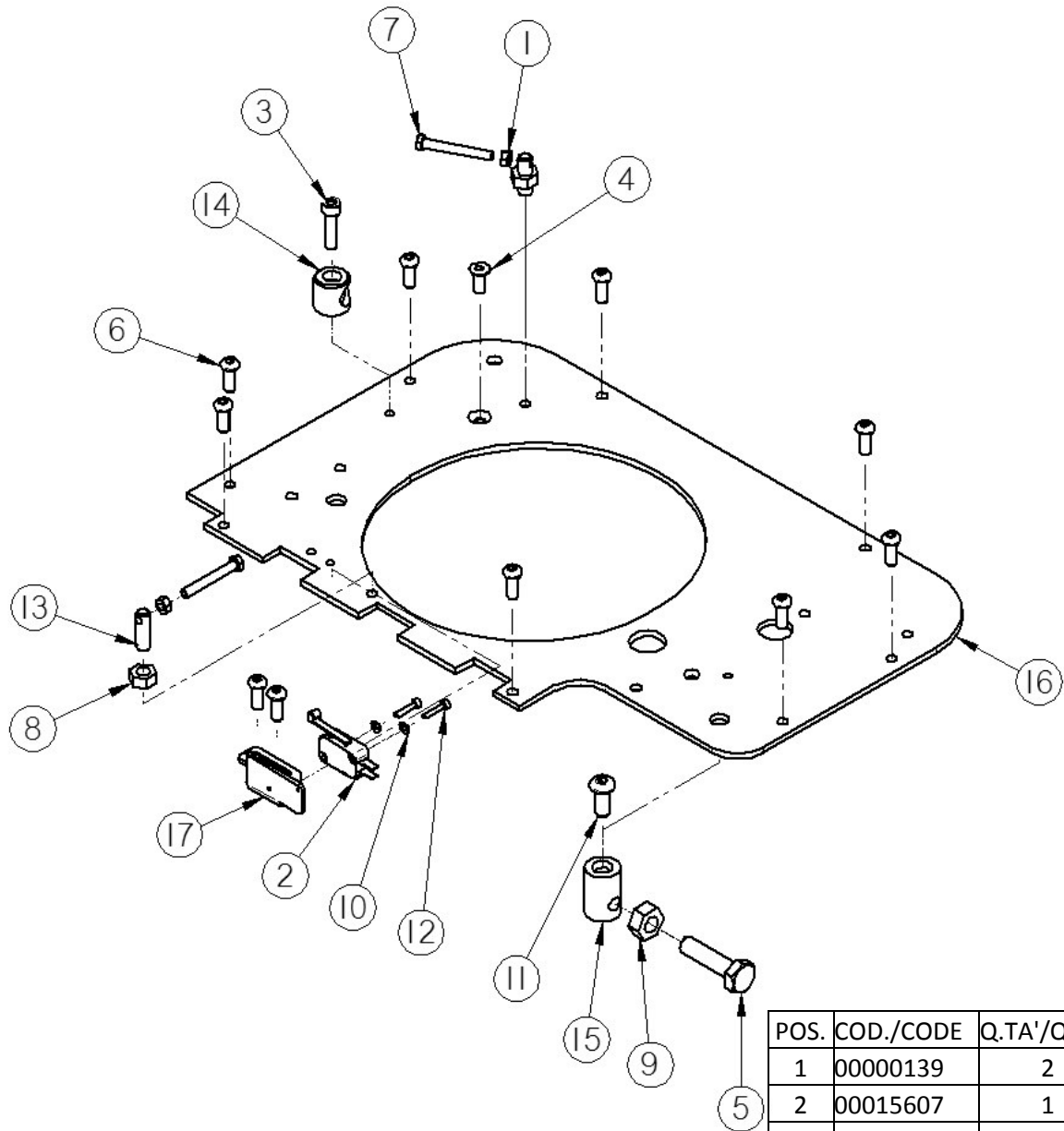
POS.	COD./CODE	Q.TA'/Q.TY
1	00002135	1
2	00003305	2
3	00003424	2
4	38505612	1
5	38505667	1
6	38505668	1
7	38505678	1

C5-2 - cod. 28505625 BASE TRASCINABORDO / BASE ROLLER



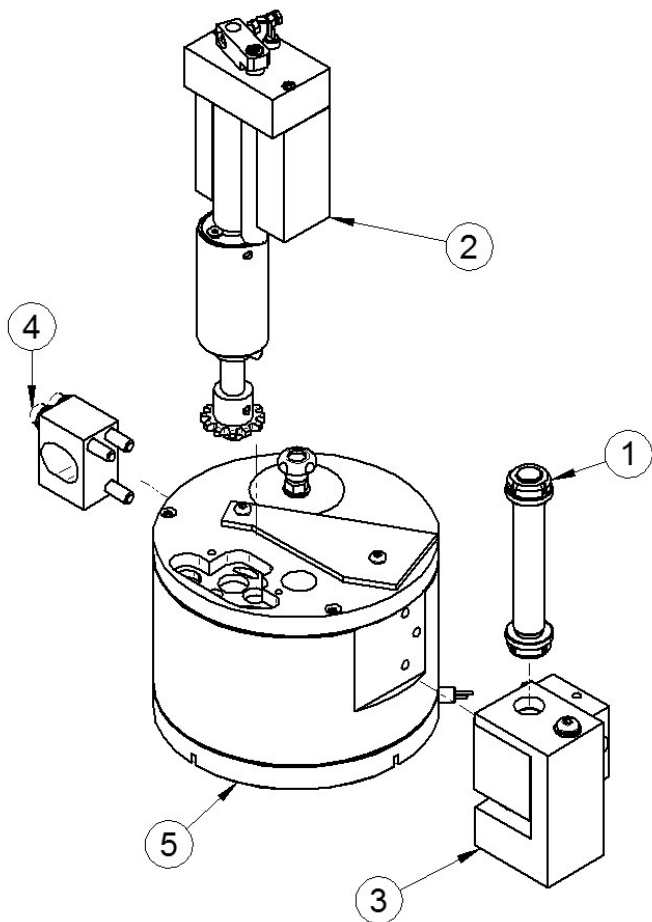
POS.	COD./CODE	Q.TA'/Q.TY
1	00000041	3
2	00003460	2
3	00003464	4
4	00018302	1
5	00018325	2
6	00018360	1
7	00018520	2
8	00130501	1
9	00150802	1
10	38505611	1
11	38505679	1
12	40500008	1

C6 - cod. 28509609 PIANO VASCACOLLA /GLUE POT PLATE



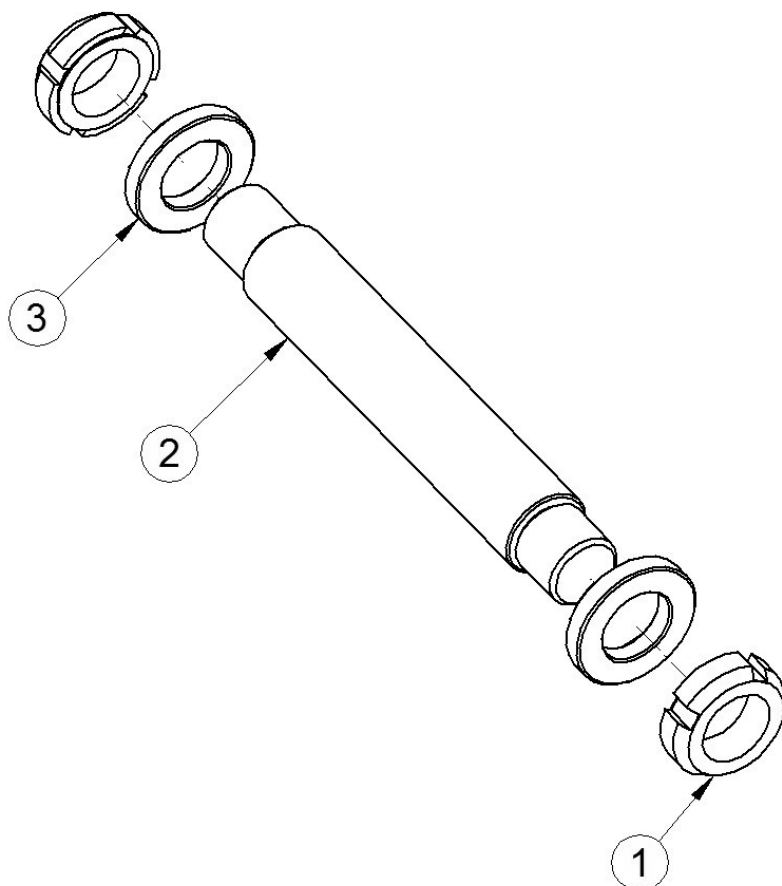
POS.	COD./CODE	Q.TA'/Q.TY
1	00000139	2
2	00015607	1
3	00018304	1
4	00018422	1
5	00018448	1
6	00018462	10
7	00018468	2
8	00018501	2
9	00018503	1
10	00018532	2
11	00018608	1
12	00020500	2
13	36001078	2
14	38500658	1
15	38500664	1
16	38505622	1
17	38509681	1

C7 - cod. 28507623 INCOLLAGGIO/ EDGE GLUING



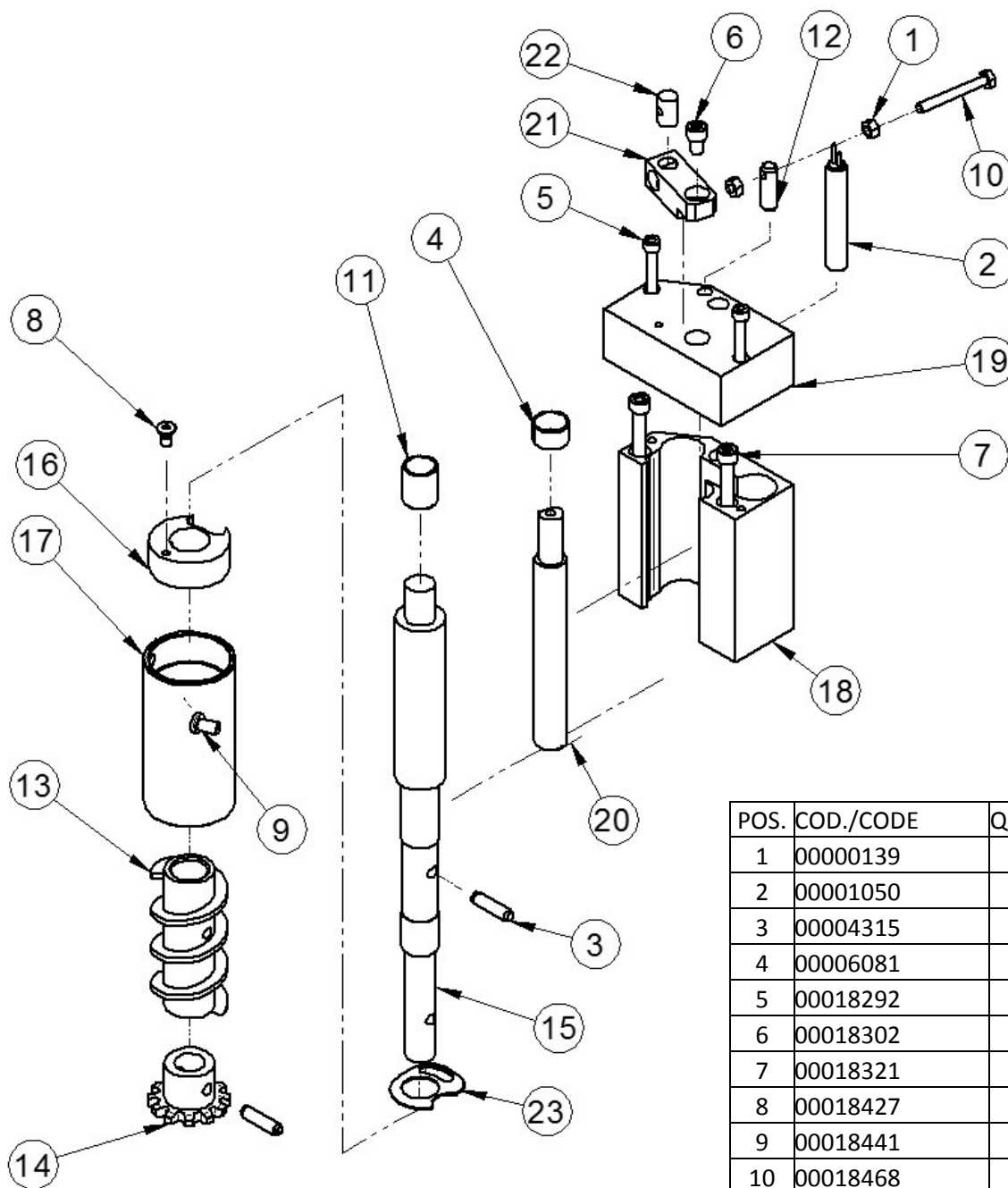
POS.	COD./CODE	Q.TA'/Q.TY
1	28504512	1
2	28505603	1
3	28505610	1
4	28505611	1
5	28507604	1

C7-1 G2 - cod. 28504512 ASSE ROTAZIONE / AXLE ROTATION PIN



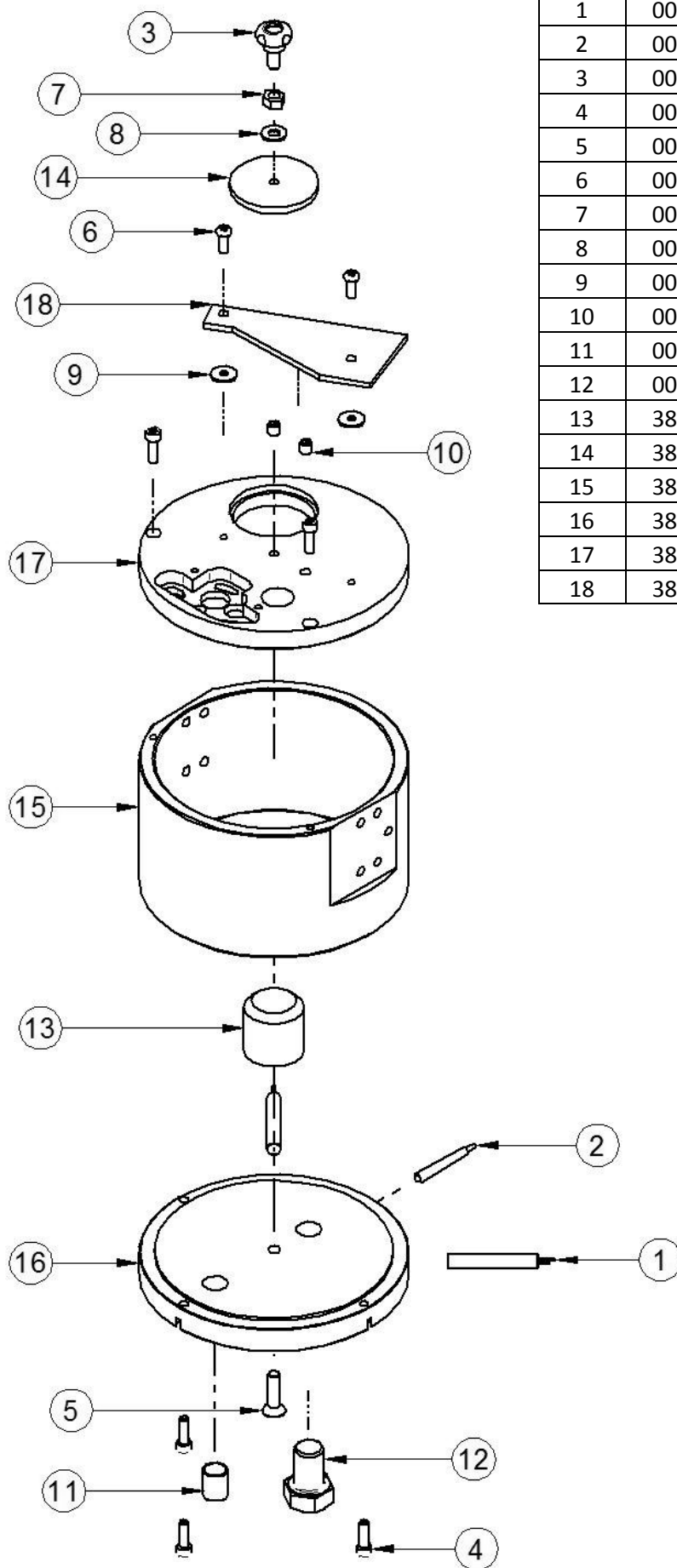
POS.	COD./CODE	Q.TA'/Q.TY
1	00000168	2
2	38503557	1
3	38503560	2

C7-2 - cod. 28505603 SPALMACOLLA / GLUE SPREADER



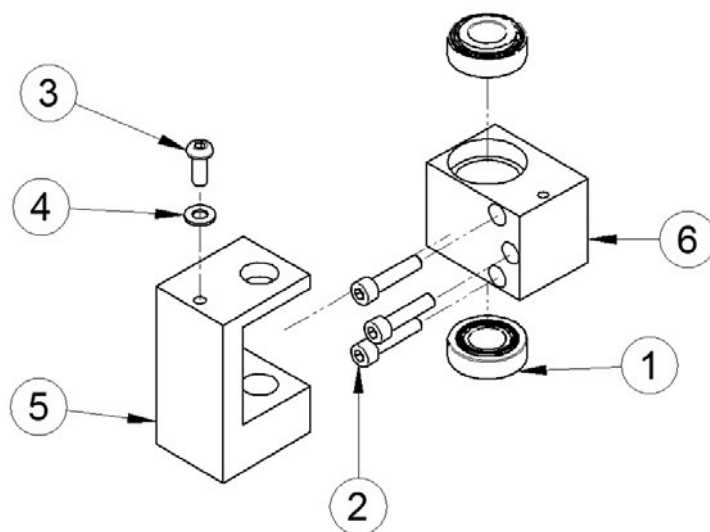
POS.	COD./CODE	Q.TA'/Q.TY
1	0000139	2
2	00001050	1
3	00004315	2
4	00006081	1
5	00018292	2
6	00018302	1
7	00018321	2
8	00018427	1
9	00018441	1
10	00018468	1
11	00150827	1
12	36001078	1
13	38500660	1
14	38500661-(50Hz) 38500666-(60Hz)	1
15	38503614	1
16	38503620	1
17	38503648	1
18	38504639	1
19	38504640	1
20	38505638	1
21	38505659	1
22	38505671	1
23	38509680	1

C7-5 - cod. 28506604 VASCA COLLA/ POT GLUE



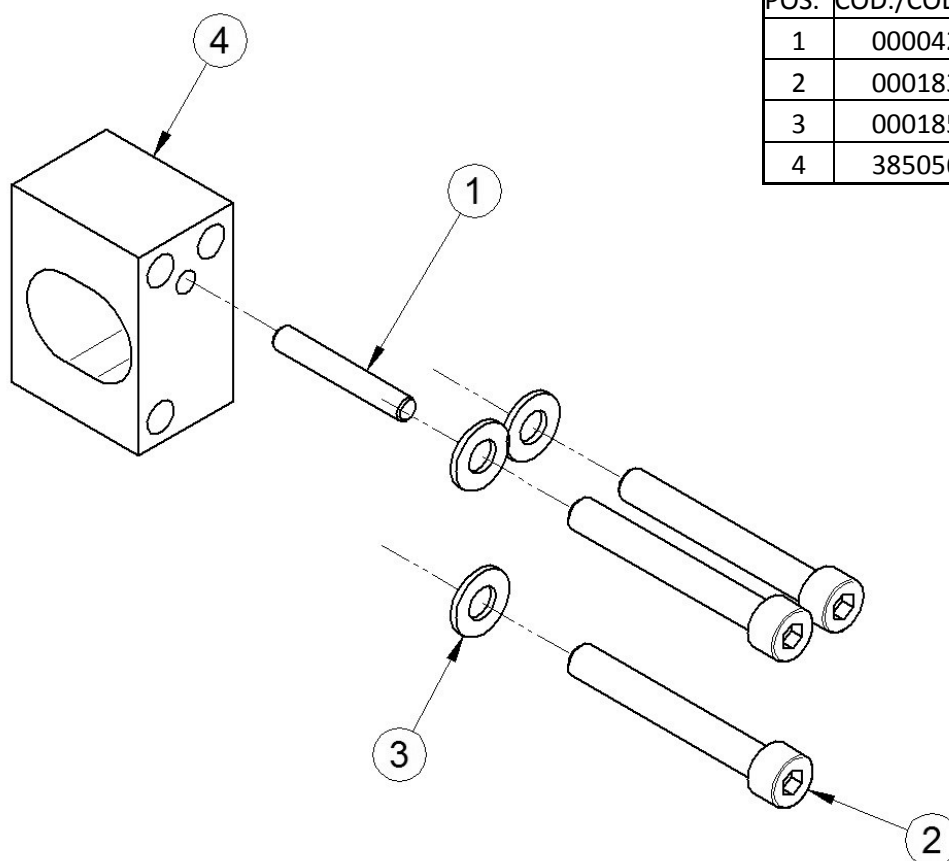
POS.	COD./CODE	Q. TA'/Q. TY
1	00001050	2
2	00001051	1
3	00003104	1
4	00018303	5
5	00018424	1
6	00018462	2
7	00018501	1
8	00018521	1
9	00018526	2
10	00150800	2
11	00150827	1
12	00330520	1
13	38503615	1
14	38503618	1
15	38503626	1
16	38503629	1
17	38504625	1
18	38505677	1

C7-3 - cod. 28505610 ROTAZIONE VASCA / ROTATION GLUE POT



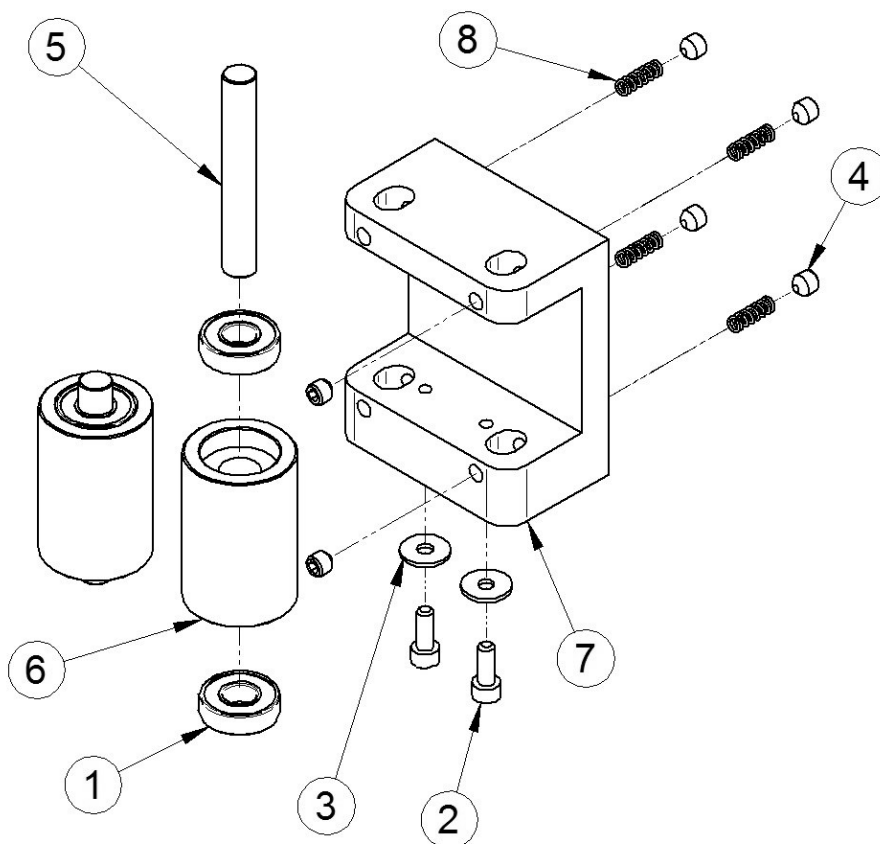
POS.	COD./CODE	Q.TA'/Q.TY
1	00003475	2
2	00018327	3
3	00018418	1
4	00018521	1
5	38505672	1
6	38505673	1

C7-4 - cod. 28505611 SOSTEGNO / MOVEMENT SUPPORT



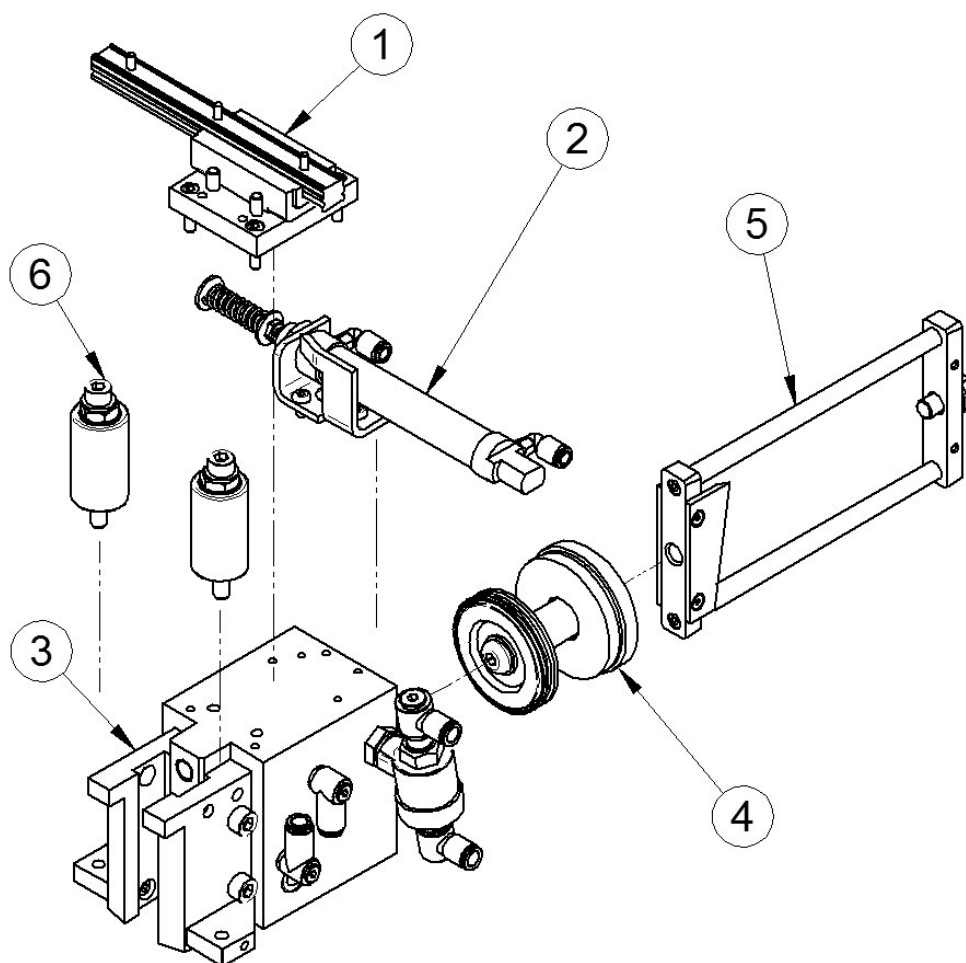
POS.	COD./CODE	Q.TA'/Q.TY
1	00004250	1
2	00018323	3
3	00018521	3
4	38505628	1

D - cod. 28505608 PRESSABORDO / EDGE-PRESSING ROLLERS



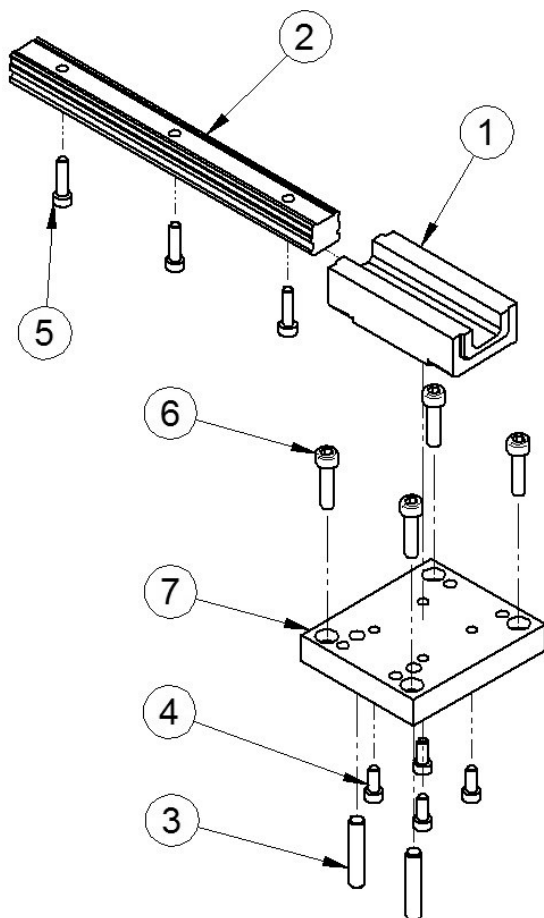
POS.	COD./CODE	Q.TA'/Q.TY
1	00003424	4
2	00018325	2
3	00018526	2
4	00150802	6
5	38503621	2
6	38504643	2
7	38505642	1
8	40500008	4

E - cod. 28509700 INTESTATORE/ END CUTTER



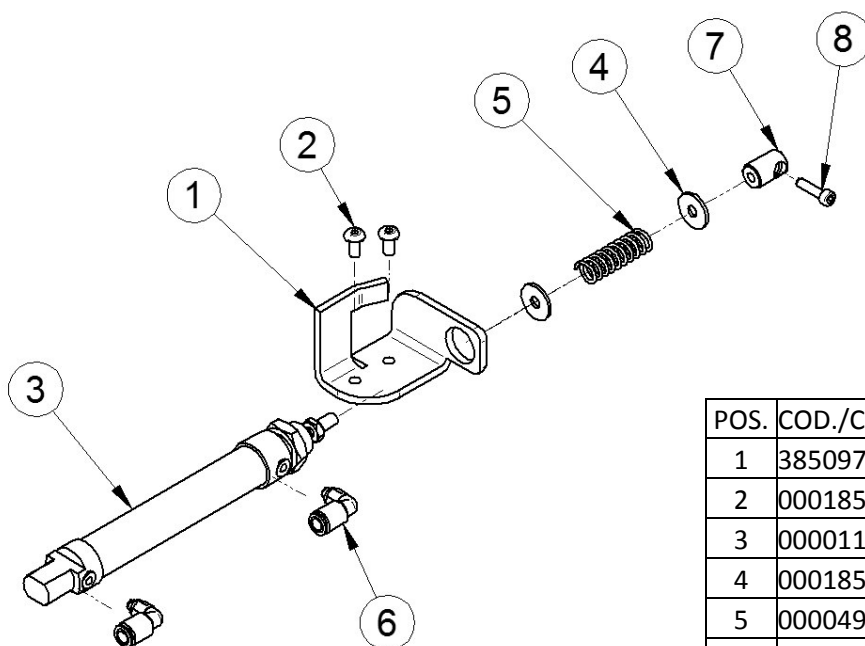
POS.	COD./CODE	Q.TA'/Q.TY
1	28505702	1
2	28509704	1
3	28505703	1
4	28505705	1
5	28505706	1
6	28507707	2

E1 - cod. 28505702 CARRELLO INTESATORE / END-CUTTER CARRIAGE



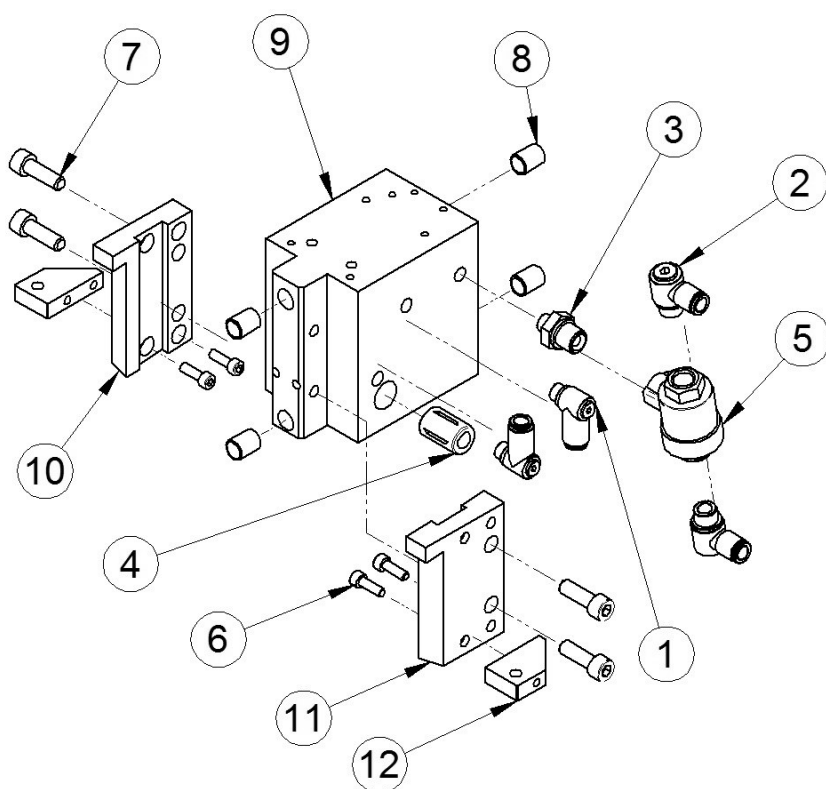
POS.	COD./CODE	Q.TA'/Q.TY
1	00003038	1
2	00003067	1
3	00004212	2
4	00018300	4
5	00018380	3
6	00040512	4
7	38503258	1

E2 - cod. 28509703 PISTONE RINCORSA / CYLINDER MOVIMENT CUTTER



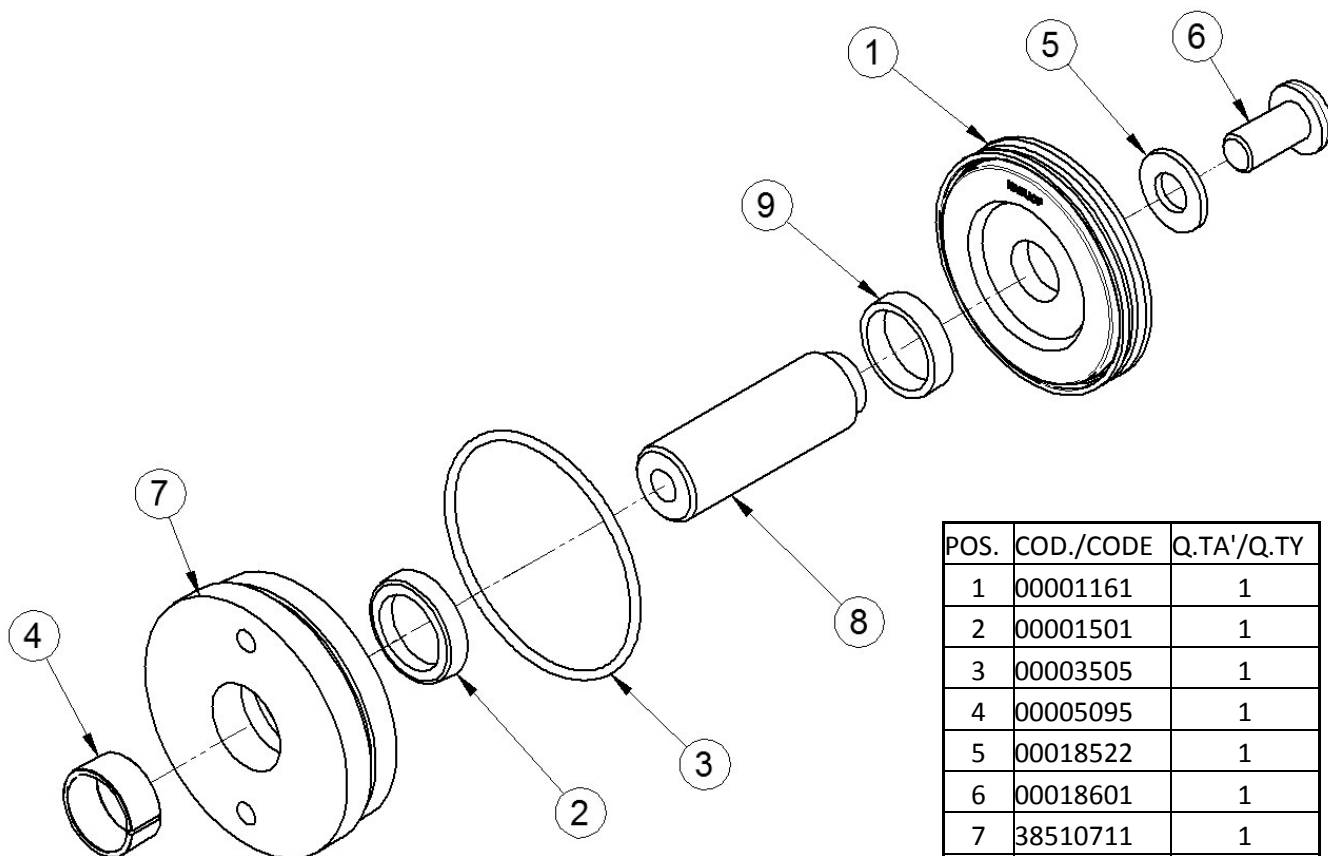
POS.	COD./CODE	Q.TA'/Q.TY
1	38509709	1
2	00018558	2
3	00001185	1
4	00018526	2
5	00004998	1
6	00001193	2
7	38509727	1
8	00018399	1

E3 - cod. 28505704 CORPO INTESTATORE / END-CUTTER BODY



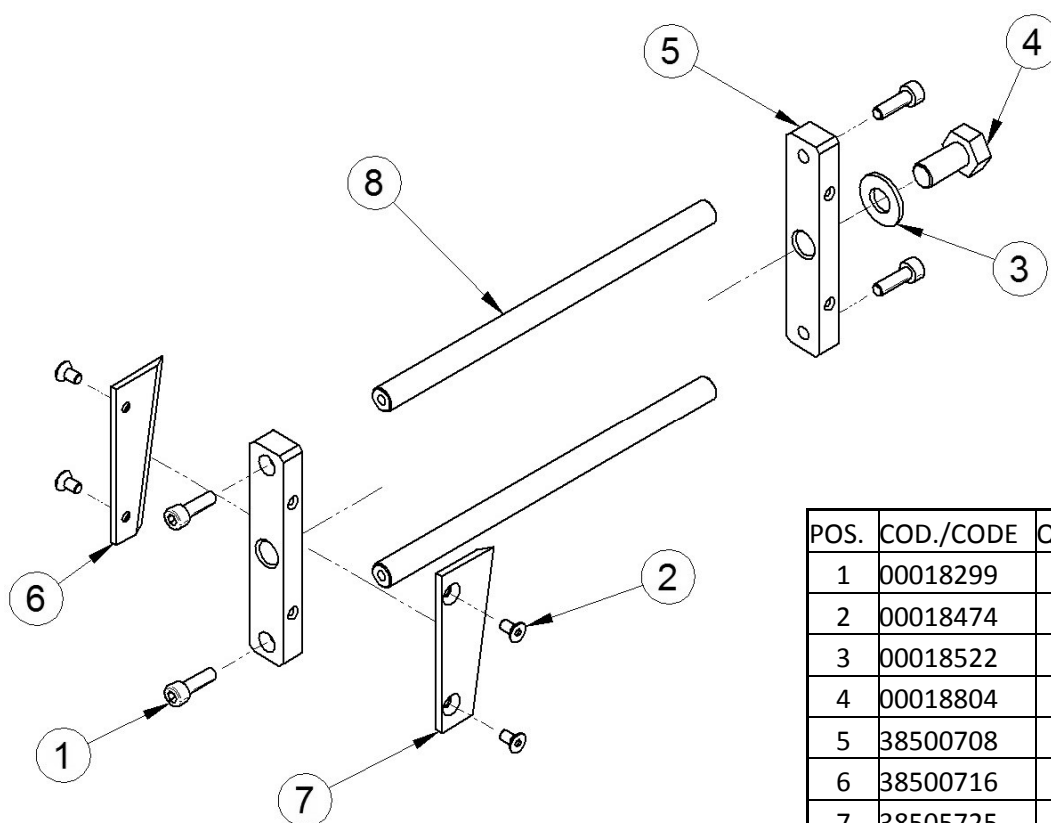
POS.	COD./CODE	Q.TA'/Q.TY
1	00001105	2
2	00001108	2
3	00001119	1
4	00003030	1
5	00015276	1
6	00018325	4
7	00018340	4
8	00150824	4
9	38503702	1
10	38505703	1
11	38505726	1
12	38520707	2

E4 - cod. 28505705 PISTONE INTESTATORE / CYLINDER CUTTER



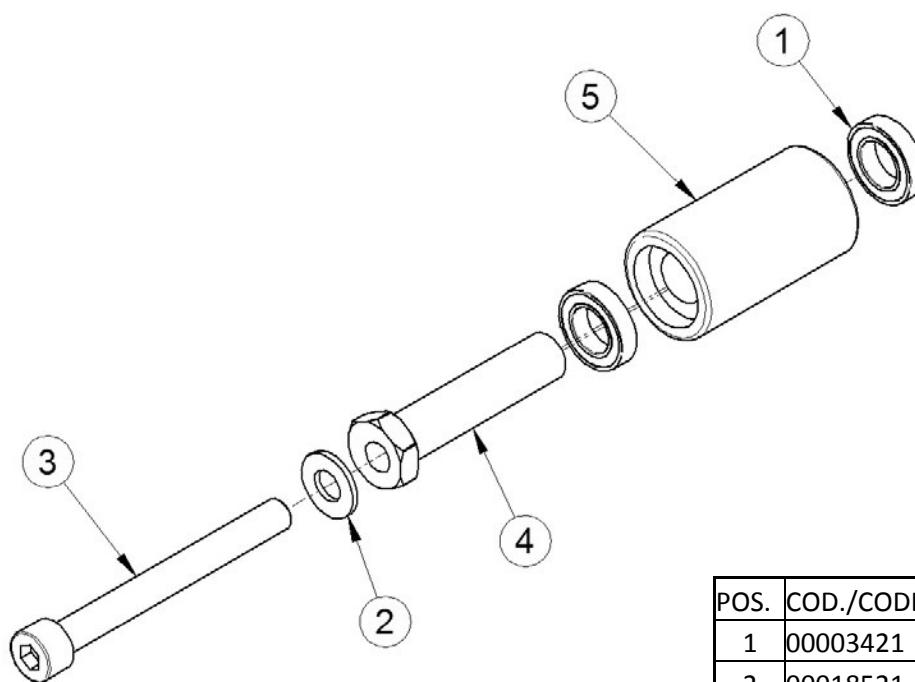
POS.	COD./CODE	Q.TA'/Q.TY
1	00001161	1
2	00001501	1
3	00003505	1
4	00005095	1
5	00018522	1
6	00018601	1
7	38510711	1
8	38510713	1
9	38520718	1

E5 - cod. 28505706 LAMA INTESATORE / END-CUTTER BLADE



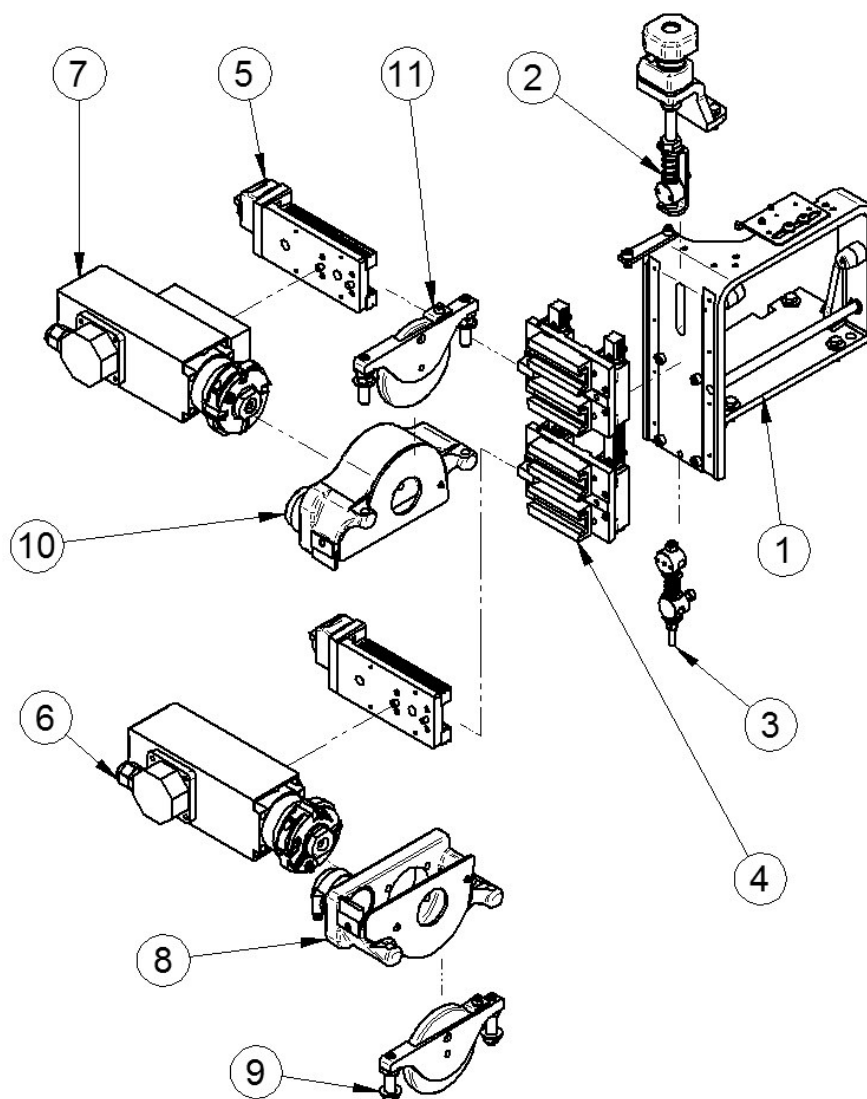
POS.	COD./CODE	Q.TA'/Q.TY
1	00018299	4
2	00018474	4
3	00018522	1
4	00018804	1
5	38500708	2
6	38500716	1
7	38505725	1
8	38510712	2

E6 - cod. 28507707 RULLO INTESATORE / END-CUTTER ROLL



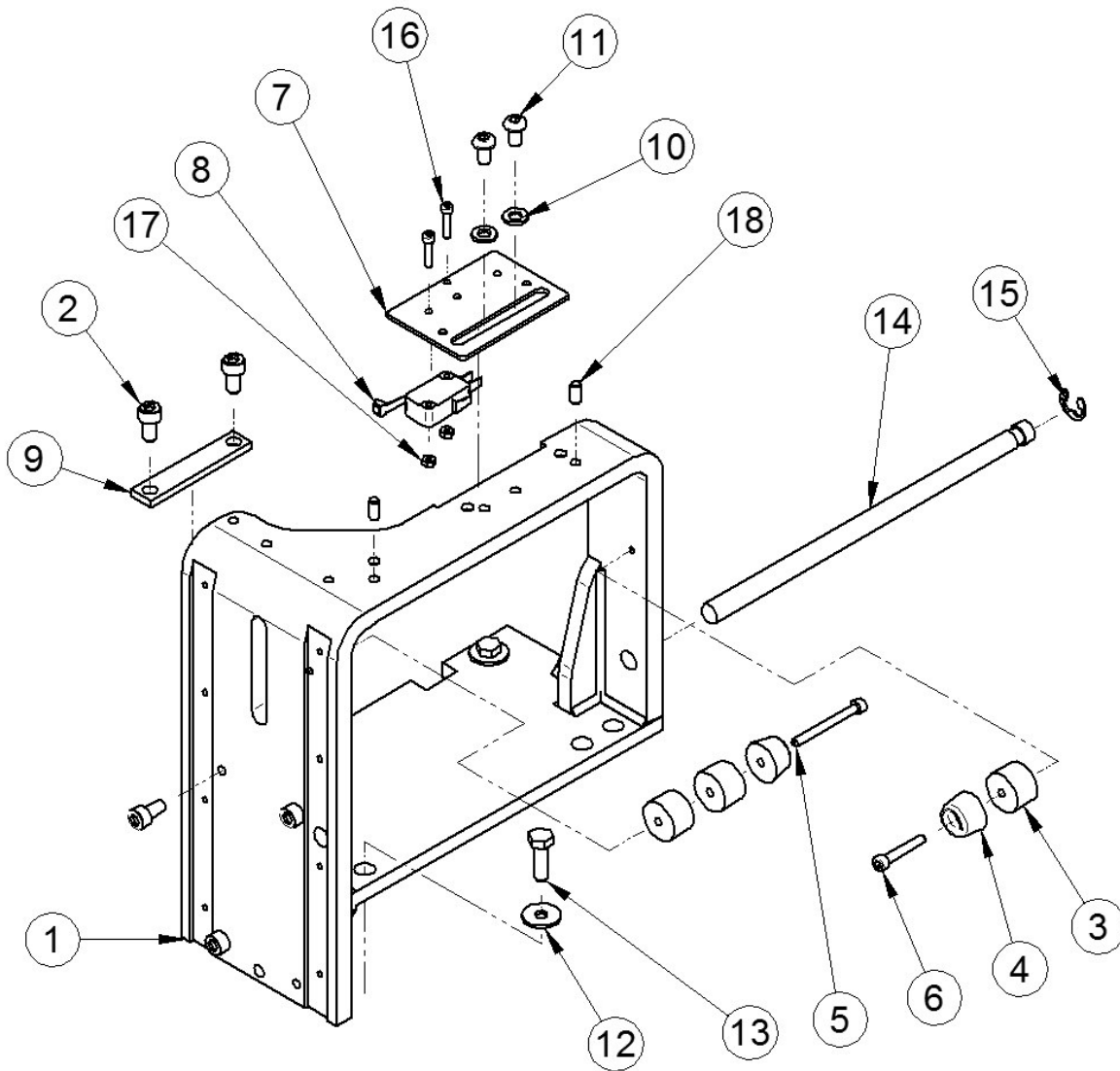
POS.	COD./CODE	Q.TA'/Q.TY
1	00003421	2
2	00018521	1
3	00050812	1
4	38507705	1
5	38507722	1

F - cod. 28509200 RIFILATORE / END-TRIMMING



POS.	COD./CODE	Q.TA'/Q.TY
1	28509210	1
2	28509211	1
3	28503212	1
4	28509213	1
5	28509225	2
6	28509215	1
7	28509217	1
8	28509222	1
9	28505226	1
10	28509223	1
11	28505216	1

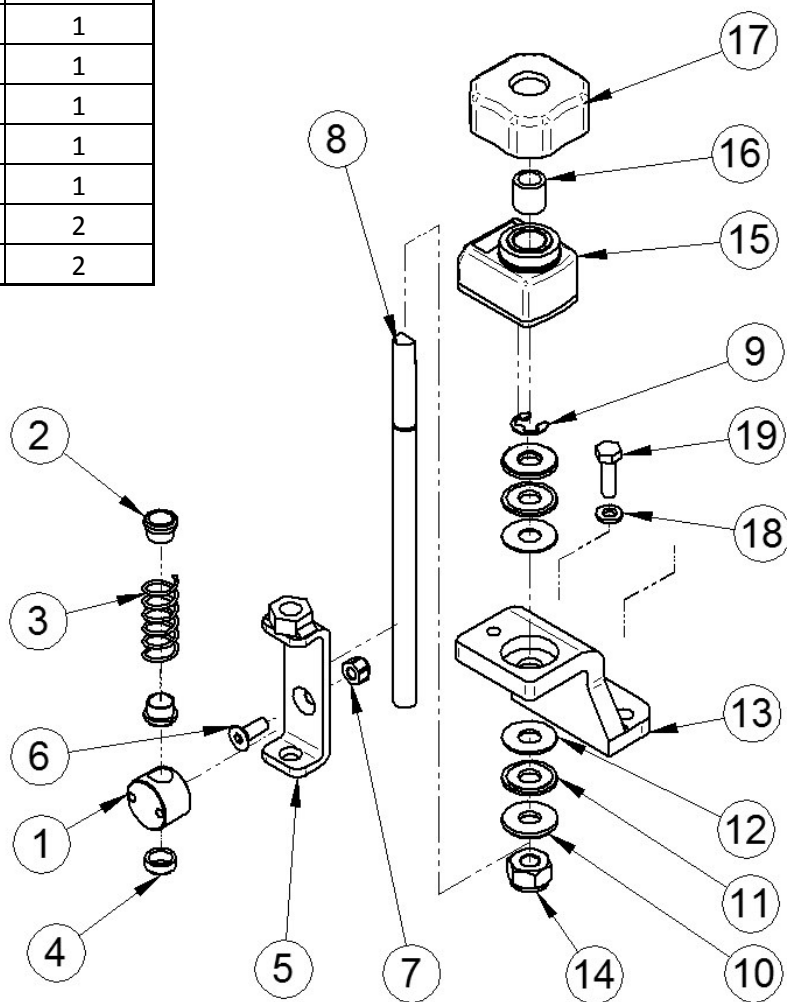
F1 - cod. 28509210 SUPPORTO RIFILATORE / SUPPORT TRIMMING



POS.	COD./CODE	Q.TA'/Q.TY
1	38509201	1
2	00018333	6
3	38503259	3
4	00005201	2
5	00018289	1
6	00018381	1
7	38503706	1
8	00015607	1
9	38503256	1
10	00018520	2
11	00018441	2
12	00018526	4
13	00018399	4
14	38504704	1
15	00003321	1
16	00020500	2
17	00018511	2
18	00003653	2

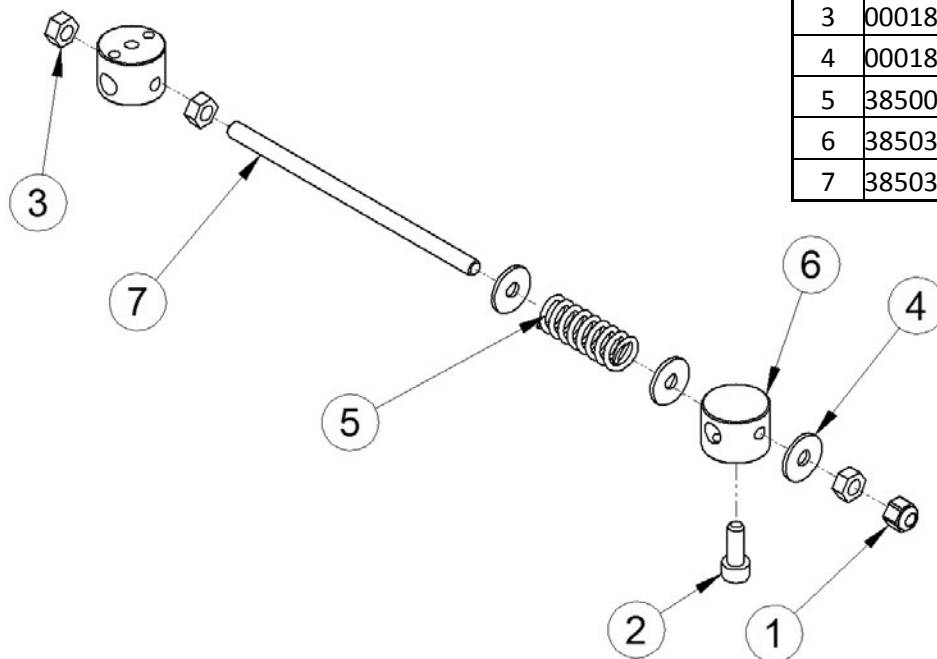
F2 - cod. 28509211 VITE ALZATA RIFILATORE / MOVING UP TRIMMING

POS.	COD./CODE	Q.TA'/Q.TY
1	38503252	1
2	38503255	2
3	38503254	1
4	38503251	1
5	38503253	1
6	00018422	1
7	00000144	1
8	38503250	1
9	00003321	1
10	00003464	2
11	00003460	2
12	00003461	2
13	38509249	1
14	00000152	1
15	00003988	1
16	00005015	1
17	38500239	1
18	00018520	2
19	00018399	2

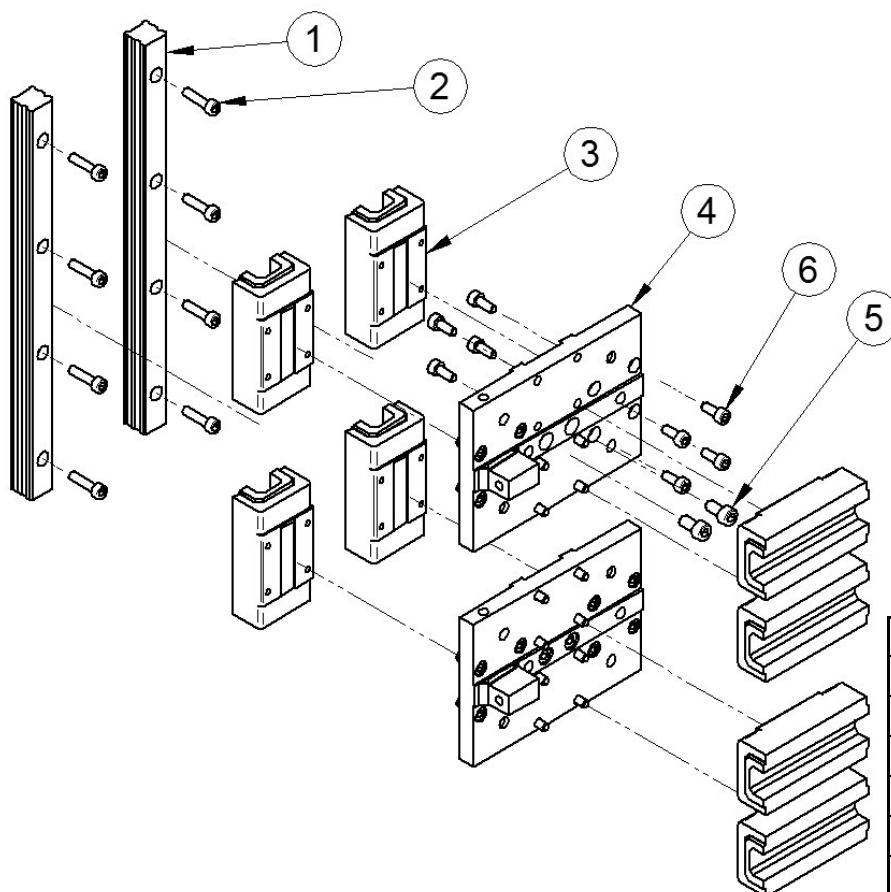


F3 - cod. 28503212 MOLLEGGIO INF RIFILATORE / MOVING DOWN TRIMMING

POS.	COD./CODE	Q.TA'/Q.TY
1	0000144	1
2	00018325	1
3	00018500	3
4	00018526	3
5	38500233	1
6	38503214	2
7	38503269	1

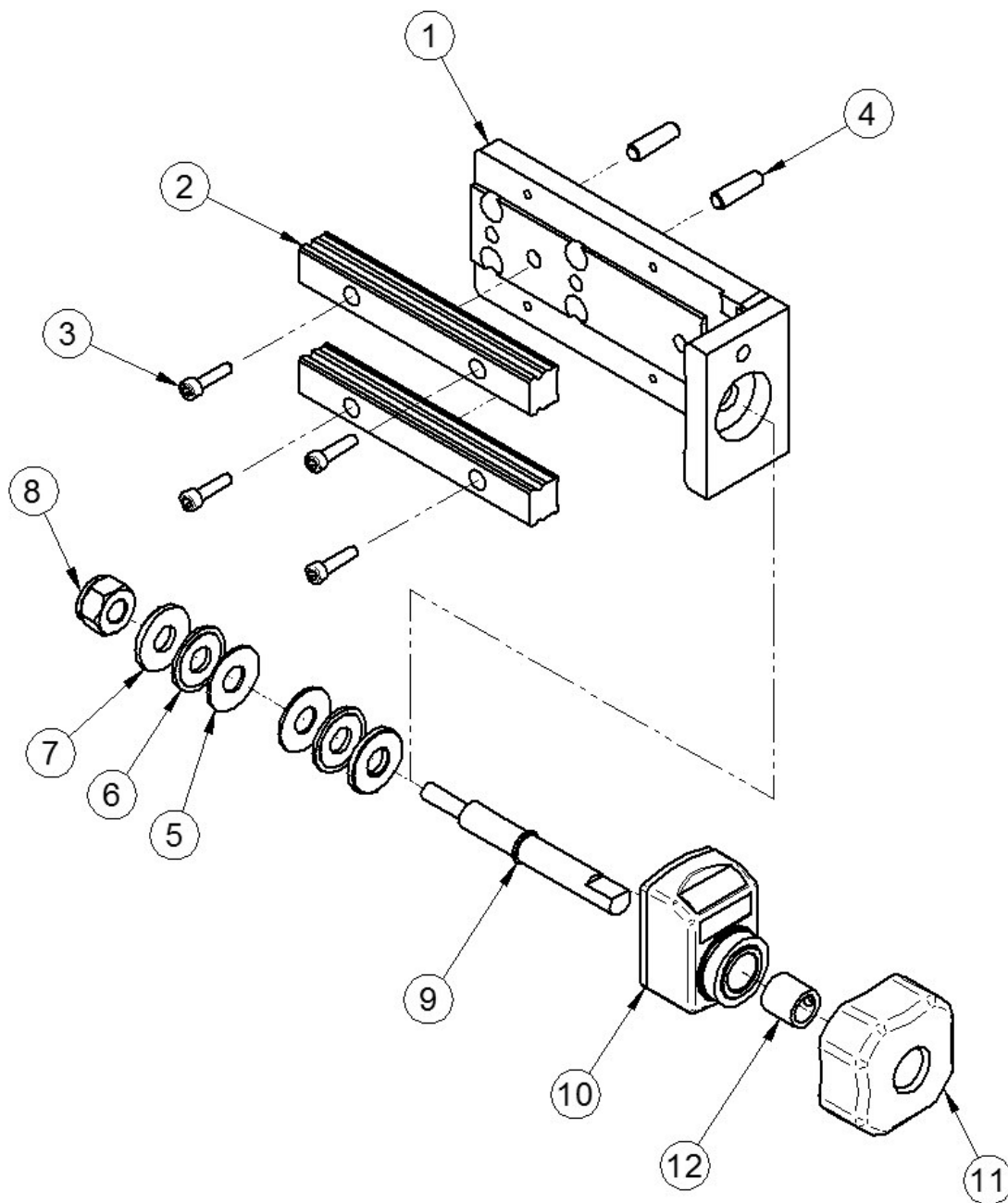


F4 - cod. 28509213 SLITTA RIFILATORE / CARRIAGE TRIMMING



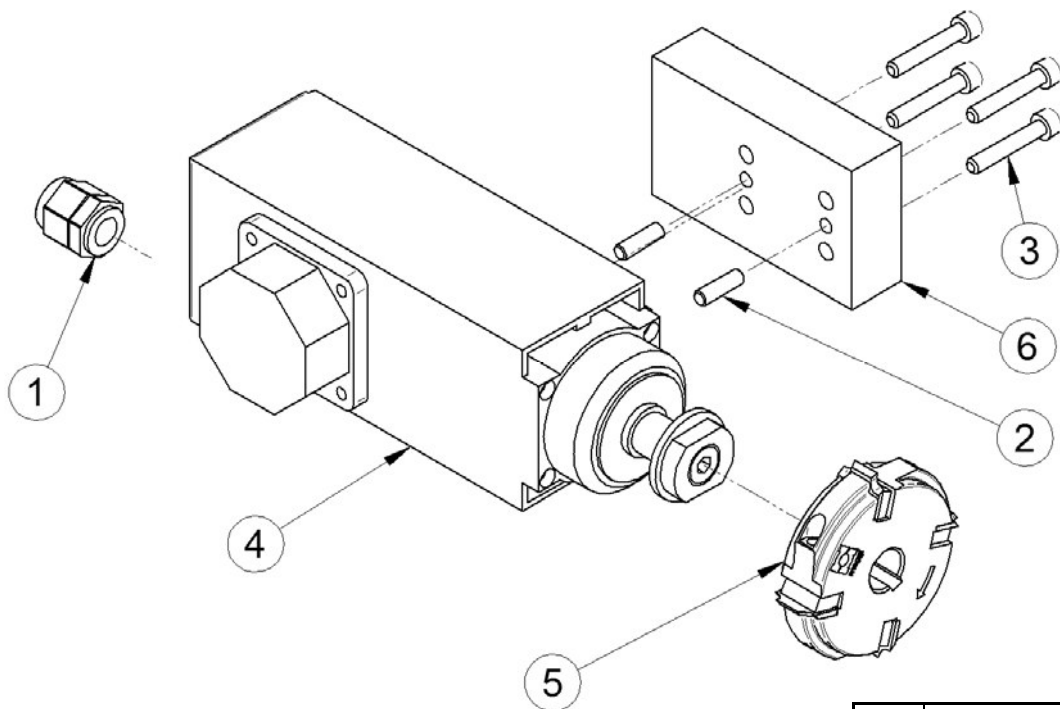
POS.	COD./CODE	Q.TA'/Q.TY
1	38500210	2
2	00018380	8
3	00003038	8
4	38509233	2
5	00018382	4
6	00018300	32

F5 - cod. 28509225 VITE RIFILATORE / MOVEMENT TRIMMING



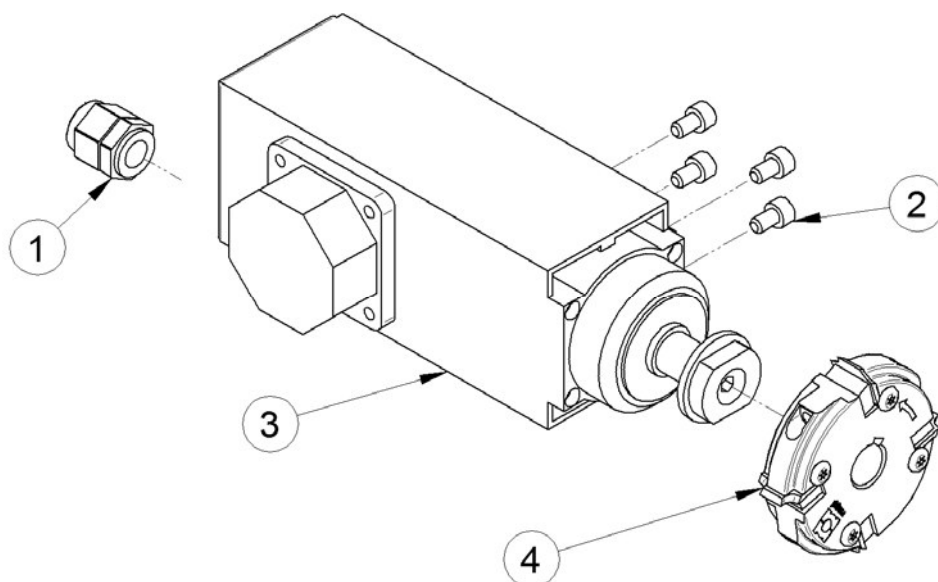
POS.	COD./CODE	Q.TA'/Q.TY
1	38509234	1
2	38509275	2
3	00018380	4
4	00004210	2
5	00003461	2
6	00003460	2
7	00003464	2
8	00000150	1
9	38509207	1
10	00004036	1
11	38500239	1
12	38509273	1

F7 - cod. 28509217 MOTORE RIFILATORE SUP / MOTOR TRIMMING UP



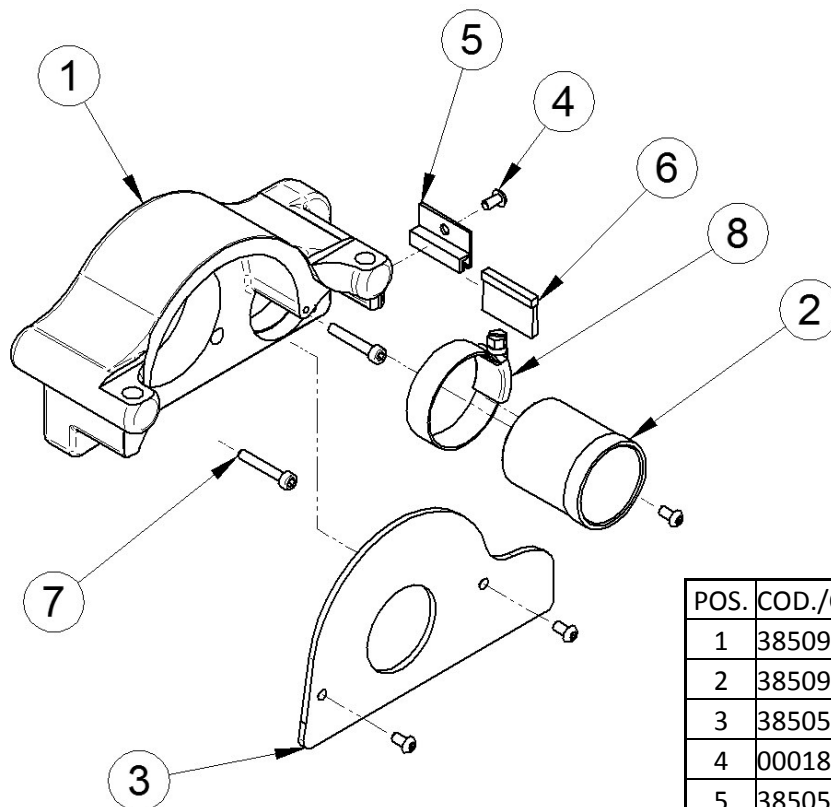
POS.	COD./CODE	Q.TA'/Q.TY
1	00001188	1
2	00004210	2
3	00018335	4
4	28500205	1
5	38500100	1
6	38508274	1

F6 - cod. 28509215 MOTORE RIFILATORE INF / MOTOR TRIMMING DOWN



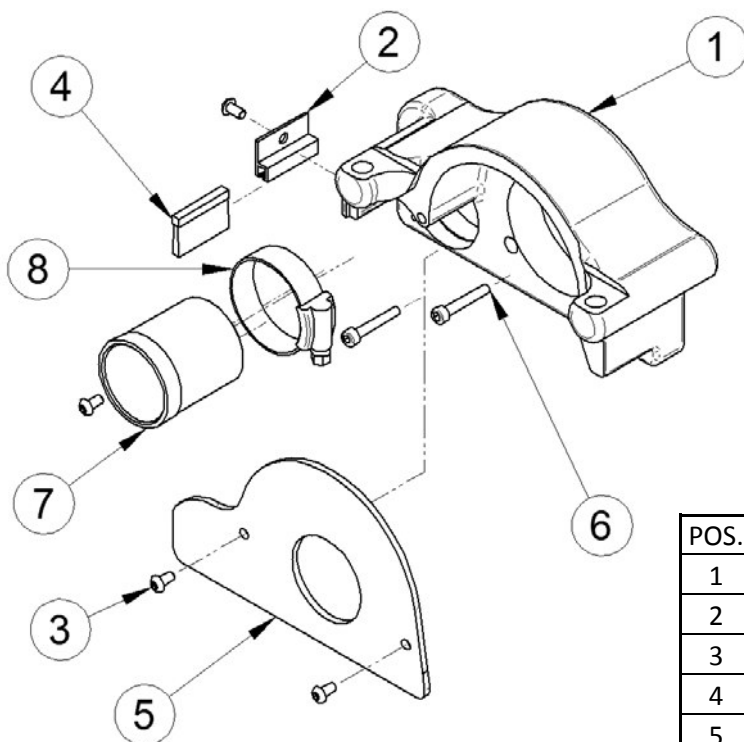
POS.	COD./CODE	Q.TA'/Q.TY
1	00001188	1
2	00018302	4
3	28500204	1
4	38500100	1

F8 - cod. 28509222 CARTER RIFILATORE INF/ COVER TRIMMING DOWN



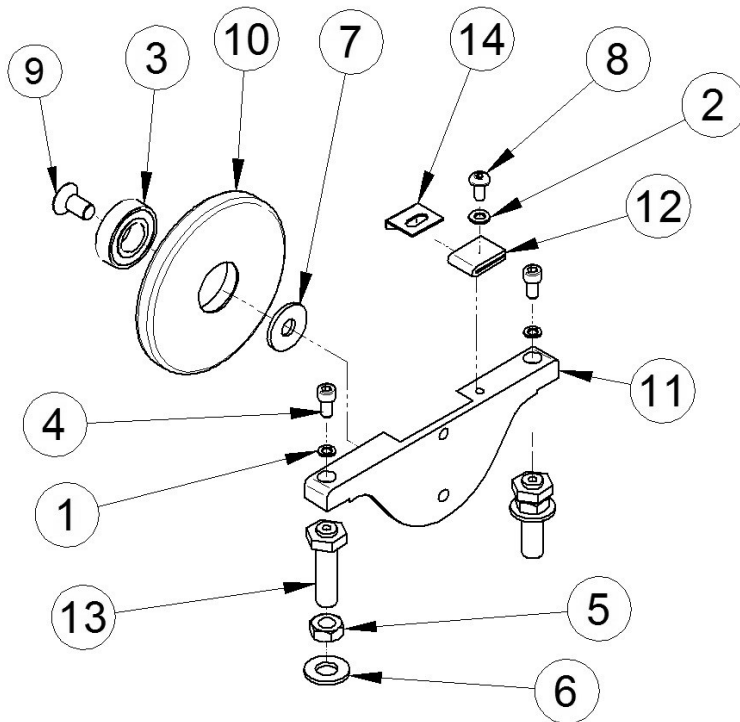
POS.	COD./CODE	Q.TA'/Q.TY
1	38509261	1
2	38509265	1
3	38505263	1
4	00018620	4
5	38505236	1
6	38505237	1
7	00018381	2
8	00009918	1

F10 - cod. 28509223 CARTER RIFILATORE SUP / COVER TRIMMING UP



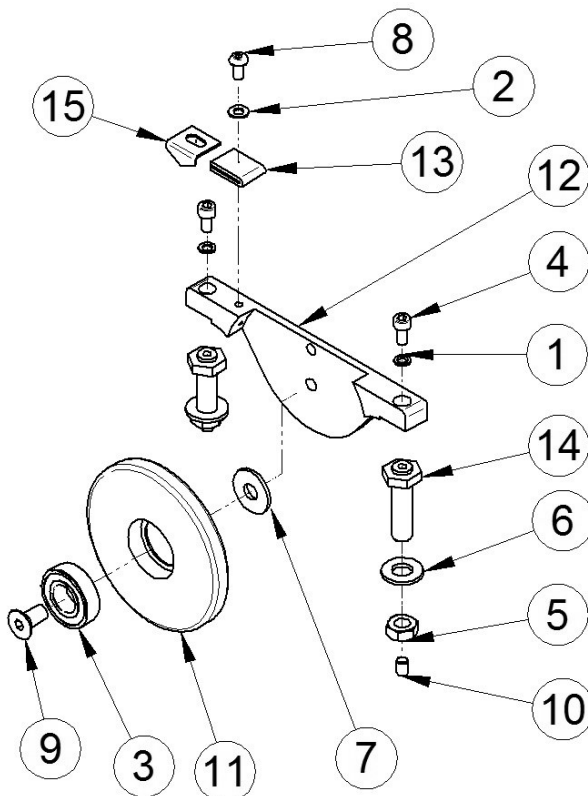
POS.	COD./CODE	Q.TA'/Q.TY
1	38509262	1
2	38505236	1
3	00018620	4
4	38505237	1
5	38505263	1
6	00018381	2
7	38509265	1
8	00009918	1

F11 - cod. 28505216 COPIATORE SUP / TRIMMING DISK UP



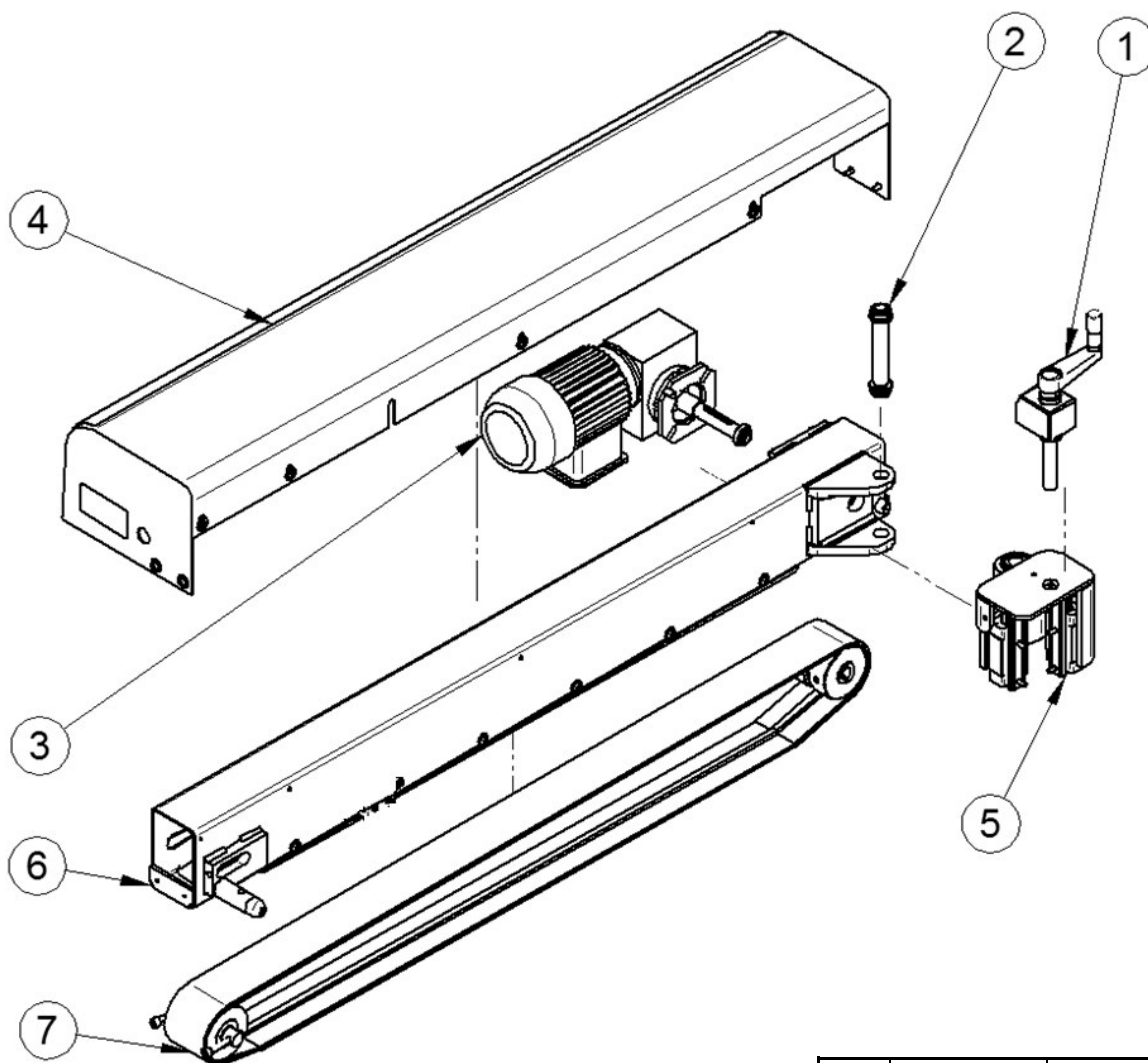
POS.	COD./CODE	Q.TA'/Q.TY
1	00000043	2
2	00000140	1
3	00003429	1
4	00018382	2
5	00018515	2
6	00018522	2
7	00018527	1
8	00018558	1
9	00018702	1
10	38505209	1
11	38505244	1
12	38505246	1
13	38505271	2
14	45400027	1

F9 - cod. 28505226 COPIATORE INF / TRIMMING DISK DOWN



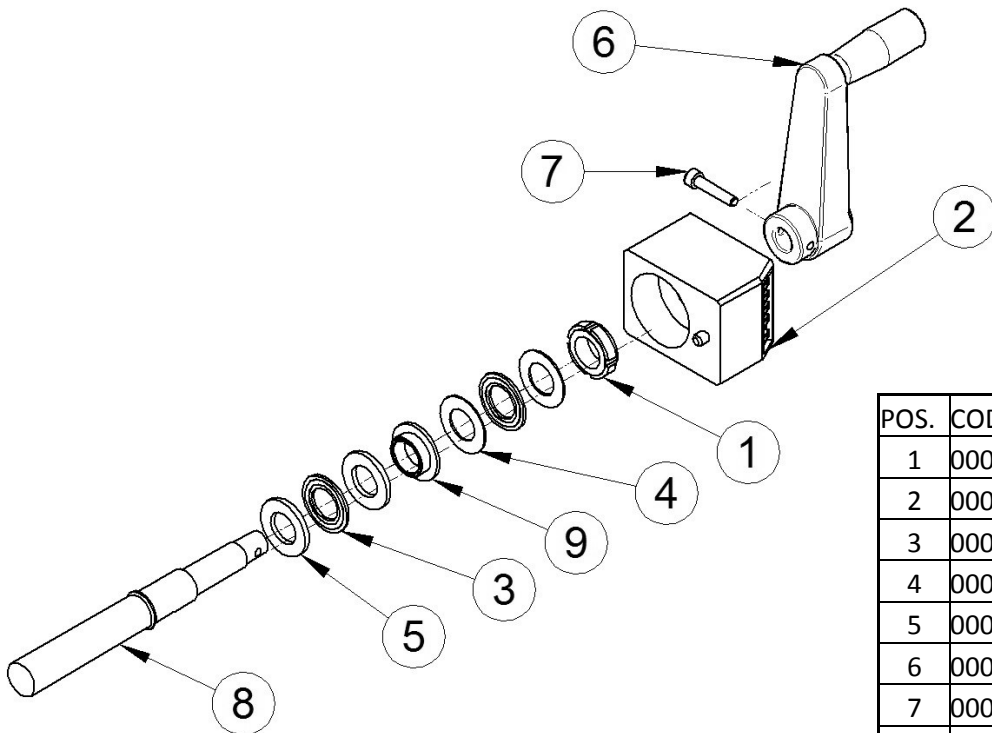
POS.	COD./CODE	Q.TA'/Q.TY
1	00000043	2
2	00000140	1
3	00003429	1
4	00018382	2
5	00018515	2
6	00018522	2
7	00018527	1
8	00018558	1
9	00018702	1
10	00160009	2
11	38505209	1
12	38505245	1
13	38505246	1
14	38505271	2
15	45400027	1

G - cod. 28509501 TRASCINATORE / FEEDING UNIT



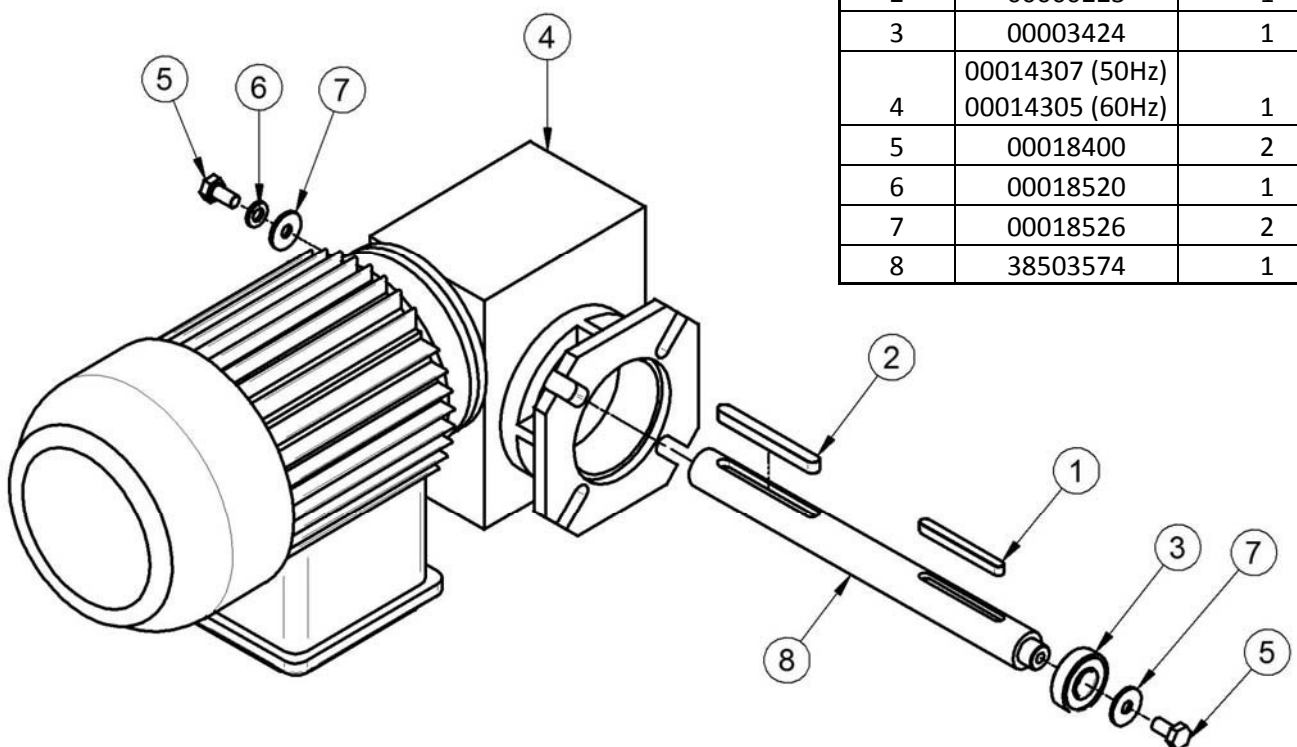
POS.	COD./CODE	Q.TA'/Q.TY
1	28504511	1
2	28504512	1
3	28504514	1
4	28504516	1
5	28505510	1
6	28509513	1
7	28509515	1

G1 - cod. 28504511 SOLLEVAMENTO TRASCINATORE / FEED UNIT LIFTING



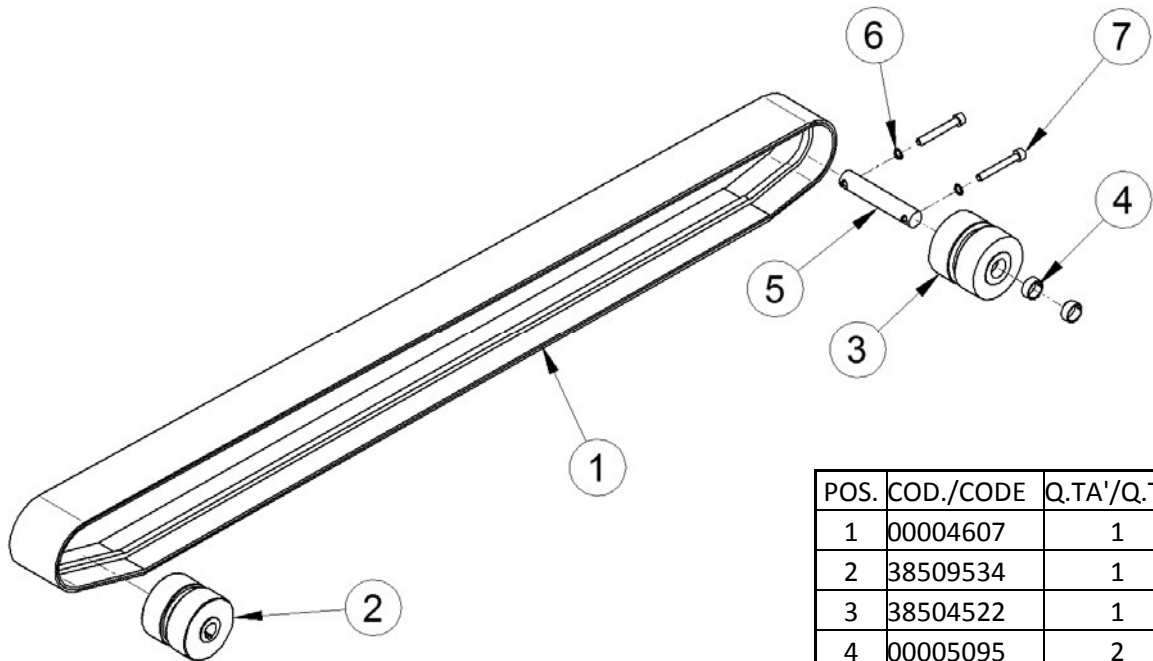
POS.	COD./CODE	Q. TA'/Q. TY
1	00000168	1
2	00003130	1
3	00003455	2
4	00003456	2
5	00003459	2
6	00003942	1
7	00018383	1
8	38503573	1
9	41600004	1

G3 - cod. 28504514 MOTORE / MOTOR FEEDING UNIT



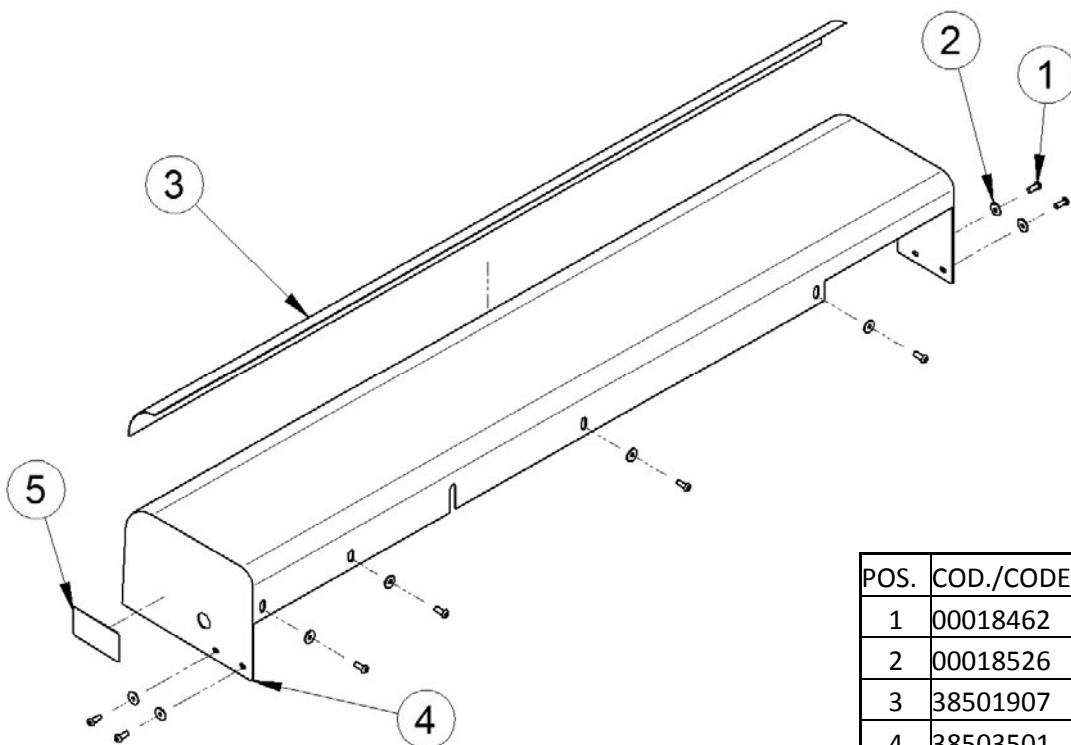
POS.	COD./CODE	Q. TA'/Q. TY
1	00000222	1
2	00000223	1
3	00003424	1
4	00014307 (50Hz) 00014305 (60Hz)	1
5	00018400	2
6	00018520	1
7	00018526	2
8	38503574	1

G7 - cod. 28509515 TRASCINAMENTO / FEEDING BELT UNIT



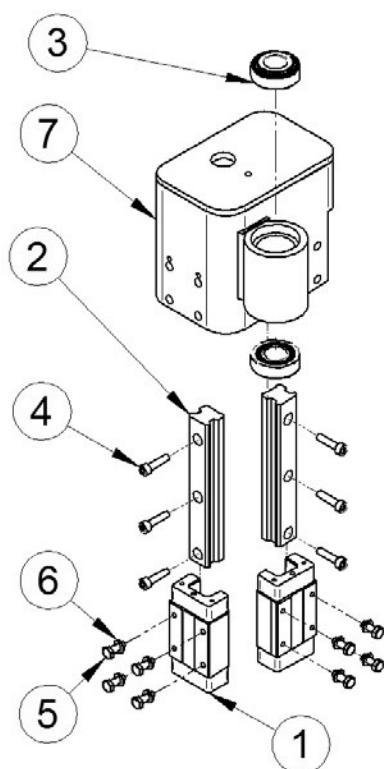
POS.	COD./CODE	Q.TA'/Q.TY
1	00004607	1
2	38509534	1
3	38504522	1
4	00005095	2
5	38500520	1
6	00000042	2
7	00018323	2

G4 - cod. 28504516 CARTER / COVER FEEDING UNIT



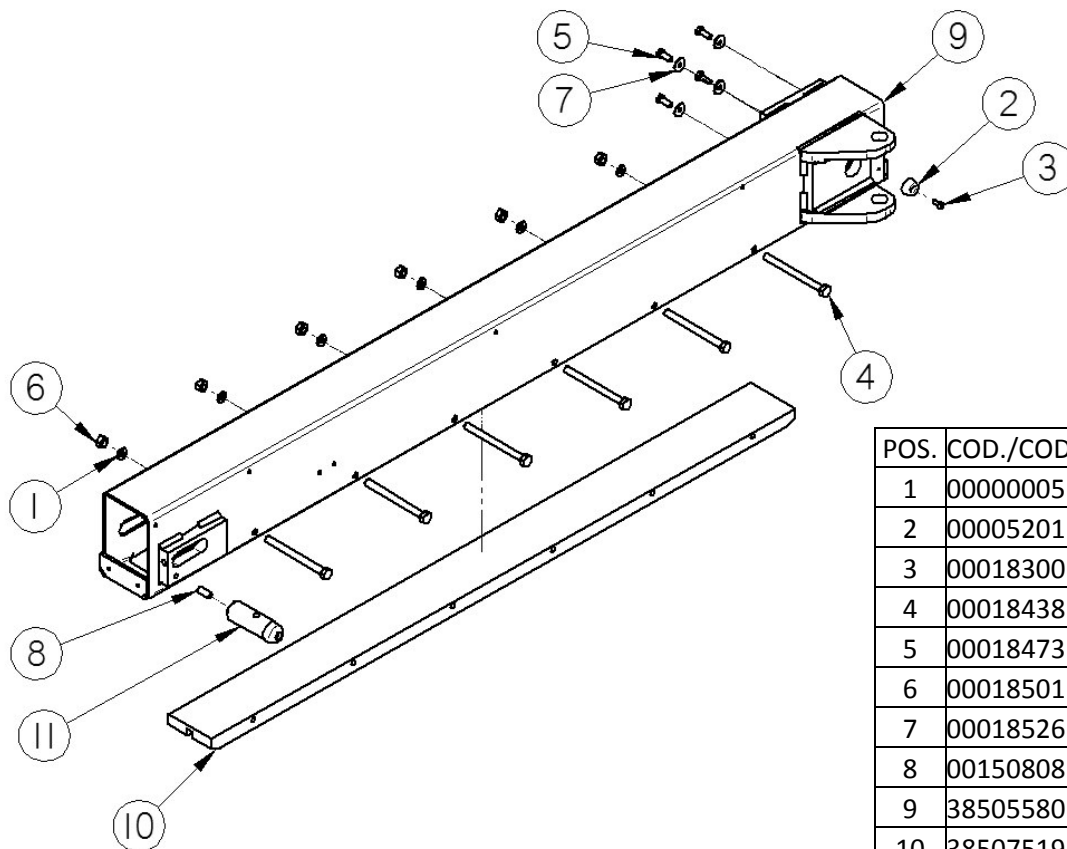
POS.	COD./CODE	Q.TA'/Q.TY
1	00018462	8
2	00018526	8
3	38501907	1
4	38503501	1
5	38503543	1

G1 - cod. 28505510 BLOCCO MOVIMENTO / FEED UNIT MOVEMENT



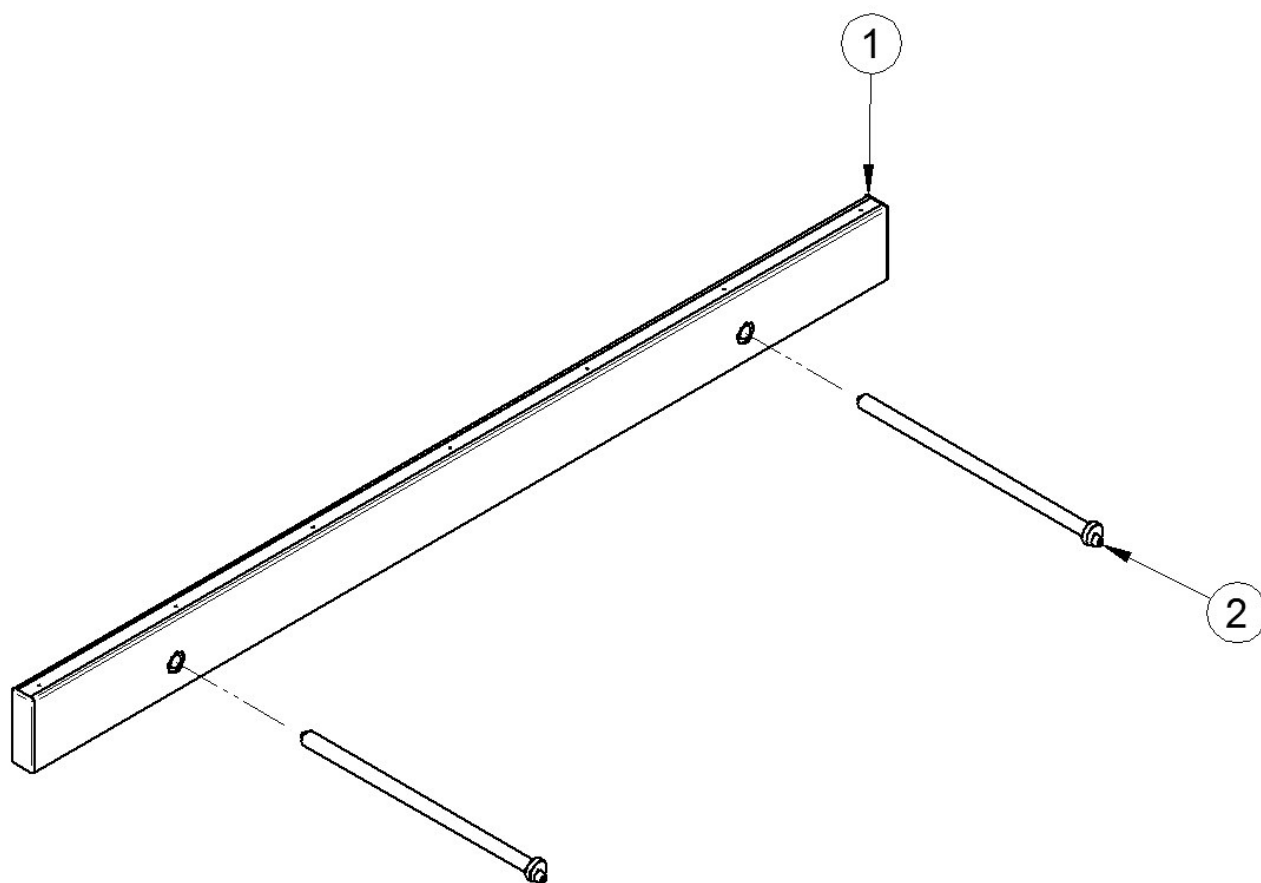
POS.	COD./CODE	Q.TA'/Q.TY
1	00003047	2
2	00003068	2
3	00003475	2
4	00018304	6
5	00018473	8
6	00018520	8
7	38505564	1

G6 - cod. 28509513 TRAVE / SUPPORT FEEDING UNIT



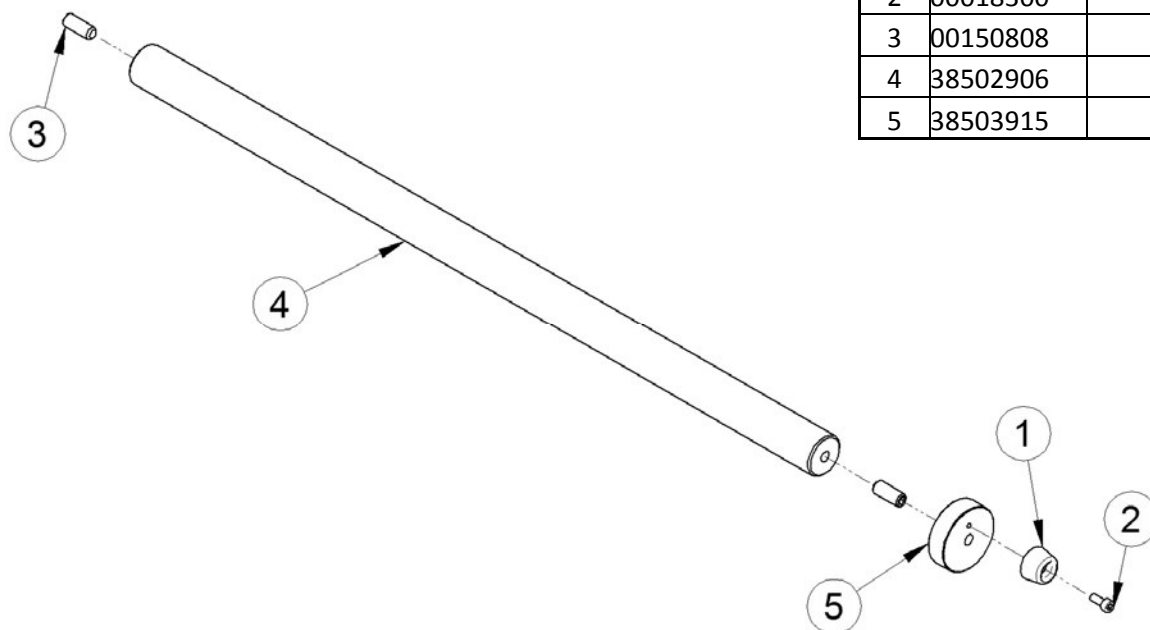
POS.	COD./CODE	Q.TA'/Q.TY
1	00000005	6
2	00005201	1
3	00018300	1
4	00018438	6
5	00018473	4
6	00018501	6
7	00018526	4
8	00150808	1
9	38505580	1
10	38507519	1
11	38554367	1

H - cod. 28509901 APPOGGIO AUSILIARE / SUPPORTING ROLL



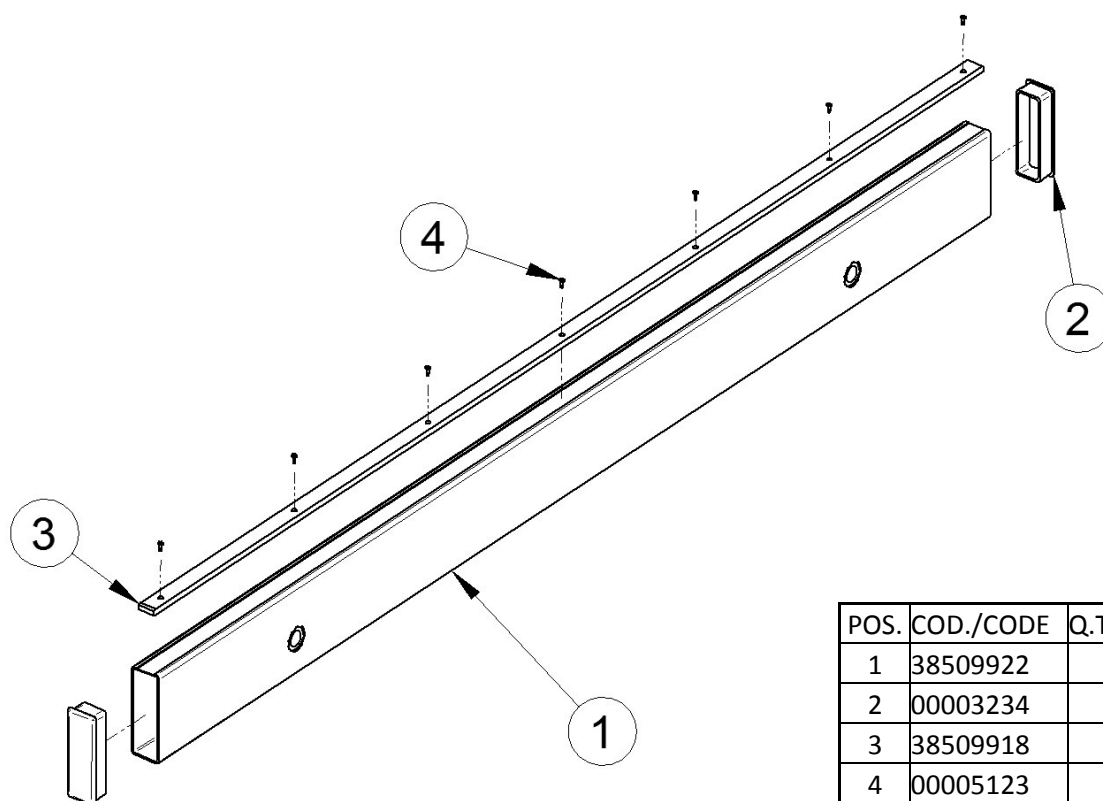
POS.	COD./CODE	Q.TA'/Q.TY
1	28509905	1
2	28503806	2

H1 - cod. 28505806 GUIDA / GUIDE UNIT



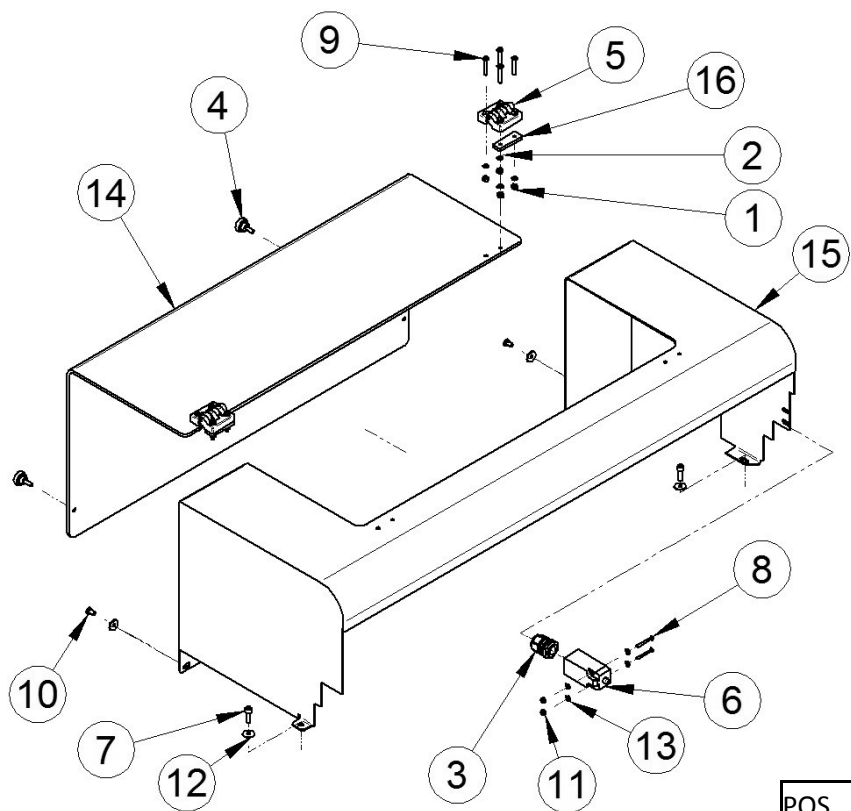
POS.	COD./CODE	Q.TA'/Q.TY
1	00005201	1
2	00018300	1
3	00150808	2
4	38502906	1
5	38503915	1

H2 - cod. 28509905 APPOGGIO



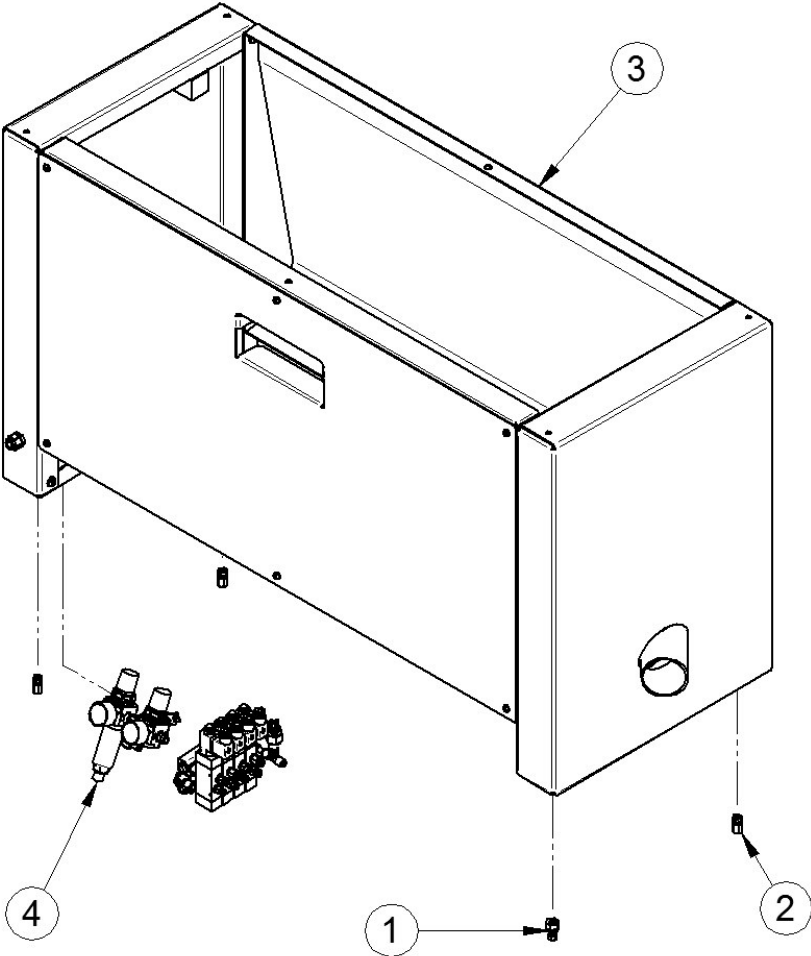
POS.	COD./CODE	Q.TA'/Q.TY
1	38509922	1
2	00003234	2
3	38509918	1
4	00005123	7

L - cod. 28505008 CARTERATURA SUP / UPPER CASSING UNIT



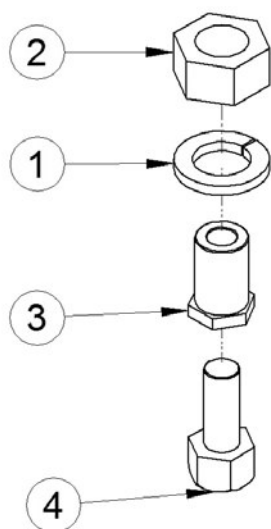
POS.	COD./CODE	Q.TA'/Q.TY
1	00000139	8
2	00000140	8
3	00001198	1
4	00003101	2
5	00004004	2
6	00015604	1
7	00018303	2
8	00018393	2
9	00018428	8
10	00018441	2
11	00018499	2
12	00018526	4
13	00018531	4
14	38504342	1
15	38505357	1
16	38510346	2

M - cod. 28509000 TELAIO / FRAME



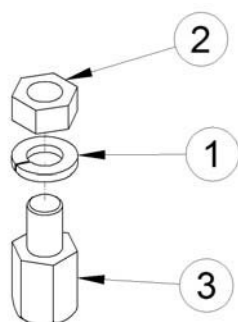
POS.	COD./CODE	Q.TA'/Q.TY
1	28500009	1
2	28500011	3
3	28557012	1
4	28509013	1

M1 - cod. 28500009 PIEDE REGOLABILE / LEVELING FEET



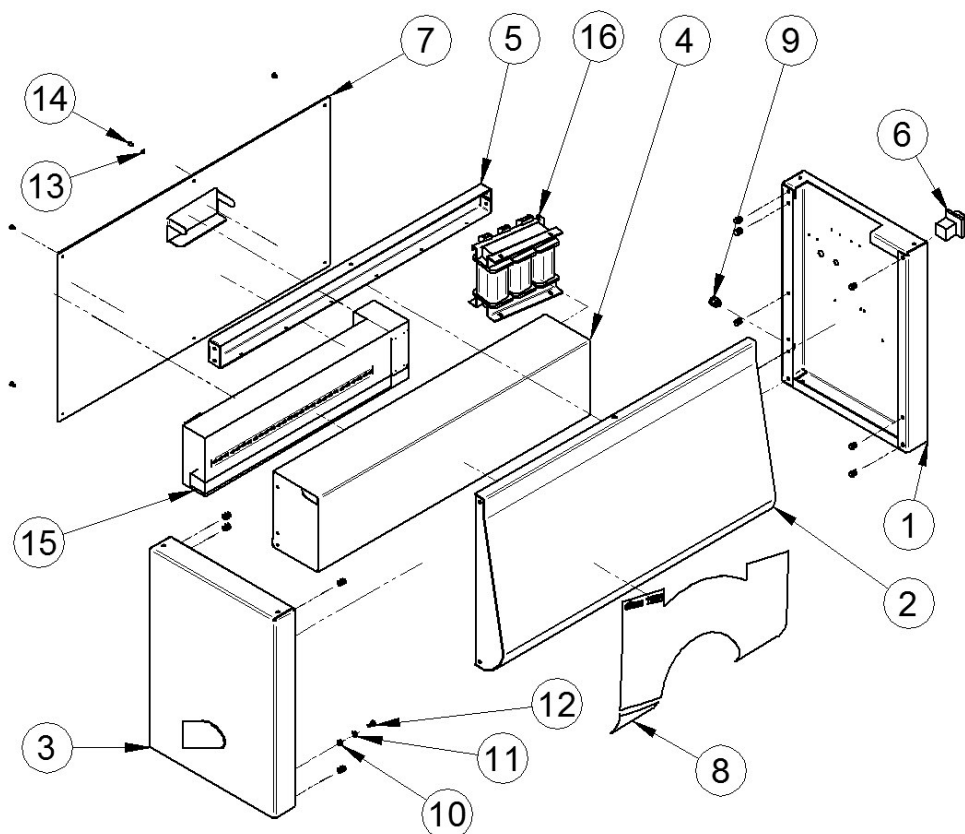
POS.	COD./CODE	Q.TA'/Q.TY
1	00000005	1
2	00018501	1
3	36030001	1

M2 - cod. 28500011 PIEDE APPOGGIO / FEET



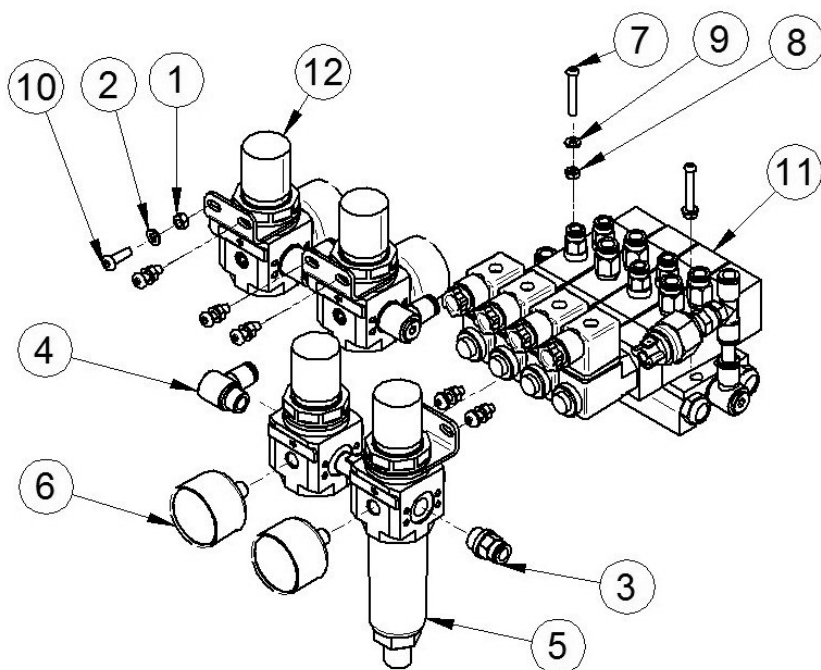
POS.	COD./CODE	Q.TA'/Q.TY
1	00000009	1
2	00018507	1
3	36030002	1
4	36030005	1

M3 - cod. 2857012 BASAMENTO/BASE



POS.	COD./CODE	Q.TA'/Q.TY
1	38507303	1
2	38507394	1
3	38507308	1
4	38507377	1
5	38507309	1
6	00005013	1
7	38557327	1
8	38510306	1
9	00001188	1
10	00000146	16
11	00018521	16
12	00018405	16
13	00018520	6
14	00018441	6
15	28509014	1
16	00005038	1

M4 - cod. 28509013 PNEUMATICA IN/ PNEUMATIC IN



POS.	COD./CODE	Q.TA'/Q.TY
1	00000139	6
2	00000140	8
3	00001013	2
4	00001108	1
5	00001264	1
6	00015219	2
7	00018393	2
8	00018499	2
9	00018531	2
10	00018609	6
11	28509010	1
12	28500025	2



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