

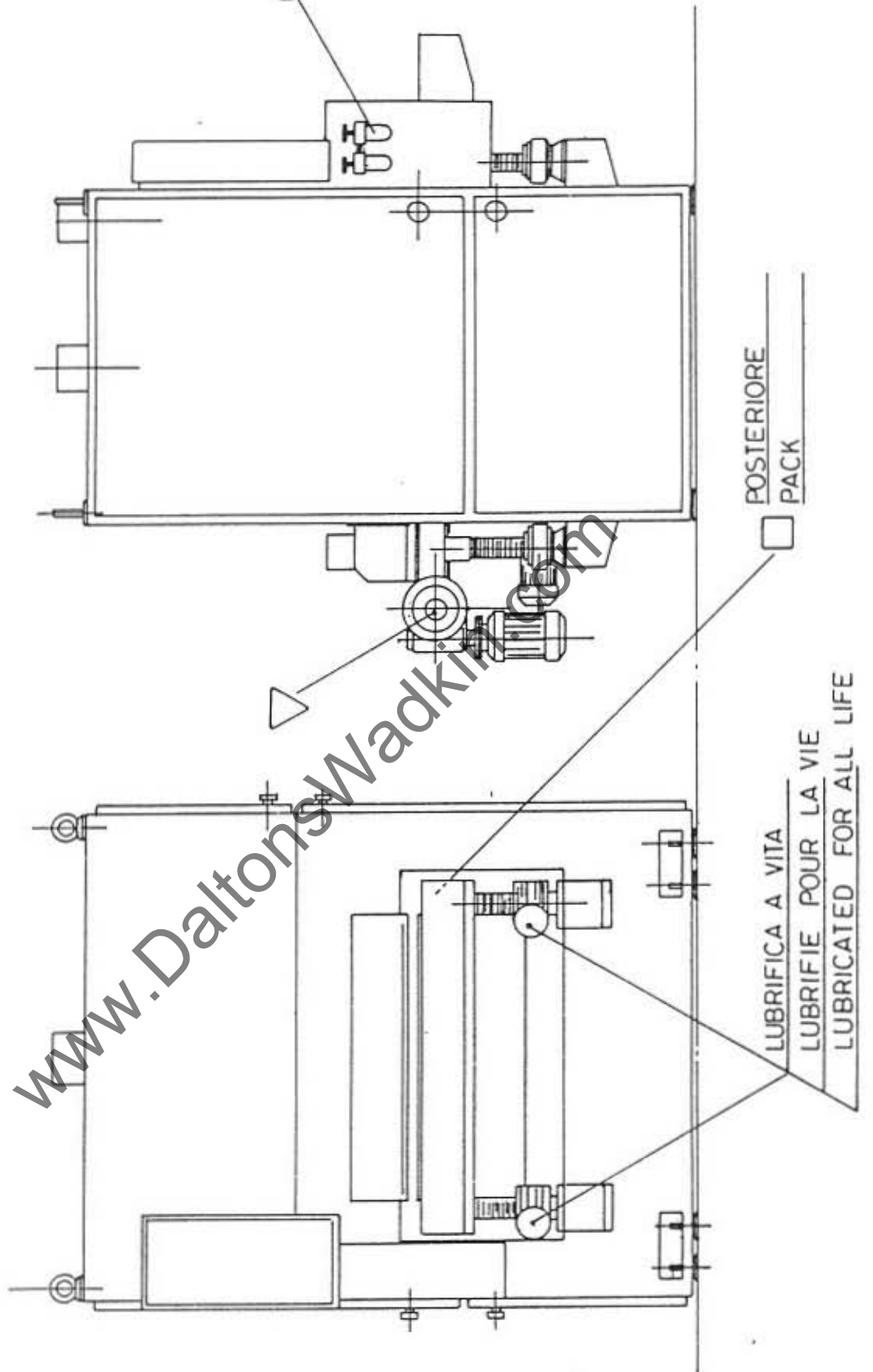
Operation

Intervals

Brand

PAG: 3

Operation	Intervals	Brand
▷ Check oil level and top-up Oil change	1500 hrs. 500 hrs.	AGIP REP 105
		SHELL MACOMA 68
		MOBIL COMPANUD 88
		ESSO SPARTAN EP 150
		BP ENERG GR 200 EP
○ Check oil and maintain level	8 hrs.	AGIP OSO 55
		SHELL TELLESOEL 29
		MOBIL VAC DTE 9
		ESSO NUTO H 68
		BP ENERGOL HLP 100
□ Grease	500 hrs.	AGIP GR - MU 2
		SHELL ALVANIA 2
		MOBIL MOBILUX 2
		ESSO BEACON 2
		BP ENERGREASE LS 2
● Grease	40 hrs.	FAG L 71 K-L 3K
■ Diesel Oil		



On the front side of the machine there is a console (pic. 2 n. 3) with the following controls (pic. 1 ):

- 1 . "Stop" button
- 2 . key for power connection
- 3 . warning light (machine started)
- 4 . raising table push button
- 5 . lowering table push button
- 6 . feed mat stop push button
- 7 . 1st feed speed push button
- 8 . 2nd feed speed push button
- 9 . table position read-out (the last number is indicating the tenths of a millimeter)
10. warning light for relay activation
11. warning light for emergency micro-switch activation
12. warning light for compressed air lacking
13. warning light
14. abrasive belt stop push button
15. abrasive belt starting push button
16. timer for pad lowering
17. timer for pad raising
18. warning light
19. warning light
20. timer "on/off" switch, raise and fall pad
21. pressure reducer for pad inflation
22. pressure gauge for the reducer
23. switch for insertion of pressure gauge
24. pressure reducer for belt tension
25. pressure gauge for belt tension reducer
26. lever-operated valve for 1st belt tension
27. lever-operated valve for 2nd belt tension
28. switch for insertion 1st belt blowers
29. switch for insertion 2nd belt blowers

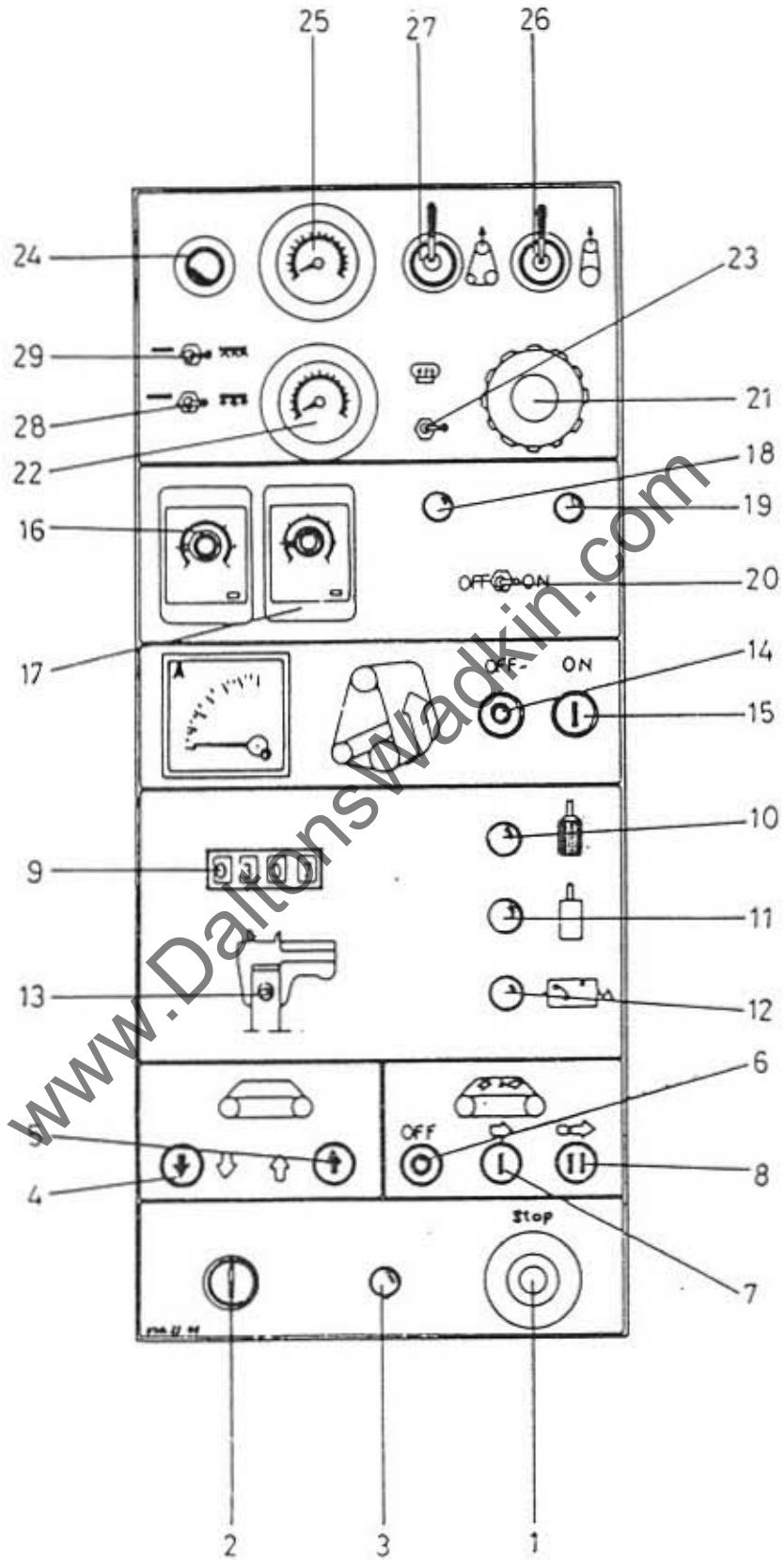


FIG 1

The machine has to be connected to a compressed air system or to a compressor of adequate power, which will give 6 atm. constantly.

The machine is in fact provided with a pressure switch (pic. 5 n. 1) which stops or prevents the feeding of the machine whenever the air pressure is less than 4 atm.

For the pneumatic connection, proceed as follows:

1. take the deviator (pic. 1 n. 25) to the lower position.
2. insert the compressed air tube to (pic. 4 n. 3) the connection of the filter cleaner (pic. 4 n. 4).
3. check that the pressure gauge (pic. 4 n. 5) of the filter cleaner indicates a pressure of 6 atm.

The electric equipment is in a cabinet situated on the machine.

For the connection open the door (pic. 4 n. 1) and connect the line cables to the letters "R-S-T" and earth of the terminal (pic. 5 n. 2).

1. Turn the switch (pic. 4 n. 2) situated on the outside of the electrical equipment cabinet, thereby giving power to the machine.
2. Insert the key (pic. 1 n. 2) on the control board and observe the lighting of the warning light (pic. 1 n. 3).
3. Push the belt starting button (pic. 1 n. 15).
4. Press the feed belt starting button (pic. 1 n. 7)  
For the machines with two feed speeds, press the button (pic. 1 n. 8), for the 1st feed speed and then the button for the second feed speed.
5. For machines equipped with feed speed variator, press the button (pic. 1 n. 7) and using the handwheel (pic. 12 n. 1) adjust the feed speed.

To introduce the abrasive belt, proceed as follows:

1. Open the door situated on the left hand side of the machine (pic. 4 n. 6)
2. Operate the lever valve (pic. 1 n. 25) taking the top roller (pic. 6 n. 1) to the lowest position.
3. Loosen the locking handle (pic. 6 n. 2).
4. Unscrew the handle (pic. 6 n. 3) and pull the rod toward the outside (pic. 6 n. 4).
5. Introduce the abrasive belt.
6. Execute the above mentioned operations backward i.e.: replace the rod, screw the handle, block the other handle, operate the lever valve taking the roller to its highest position.
7. Check that the abrasive belt tension is enough; if not, operate on the pressure reducer (pic. 1 n. 27) increasing or reducing the pressure.

The electronic system for the oscillation of the abrasive belts includes:

Fork (pic. 9 n. 1) with its electronic sensors placed inside the fork

Piston (pic. 7 n. 2);

Pneumatic valve (pic. 9 n. 2);

Feeder also placed in the fork.

The abrasive belt, during the oscillation on the idle roller (pic. 7 n. 3), goes to interrupt the electric signal between the sensors, controlling the solenoid valve (pic. 9 n. 2), which will give the consent to the piston (pic. 7 n. 2) to move back and forward.

We recommend to keep clean and lubricate every day the piston rods.

The abrasive belt swings between well determinate limits.

In case the belt runs off these limits, it is going to operate some micro-switches (pic. 6 n. 5 - n. 6) which will control the brakes and blok the belt rotation, avoiding this way the breaking of the belt.



The brake system consists of a disc brake (pic. 8 n. 1) activated by compressed air, by means of the solenoid valve (pic. 10n. 1).

The brake, with the key inserted in the control board, operates when;

1. the abrasive belt breaks, by means of the micro (pic. 7 n. 1)
2. the abrasive belt tends to come off the rollers, by means of the micro (pic. 6 n. 5 and pic. 6 n. 6).
3. the air pressure goes under the limit fixed by the pressure switch (usually 4 atm.).
4. the "stop" button on the control board is pressed.
5. the red emergency plate on the front side of machine is operated.

The thickness of the new pads of the calipers is mm. 15. The maximum wear allowed is 7 mm.

As soon as insufficient breaking is noted, the thickness of the pads must be checked and if the wear is more than 7 mm., they must be replaced.

The replacement is done as follows:

1. remove the caliper from the machine operating on the screws (pic. 8 n. 2).
2. open the caliper by means of the screws (pic. 8 n. 3) and replace the two pads.
3. reassemble all the parts, operating backward.

The change of the abrasive belt speed, allows a great sanding of veneered and lacquered surfaces.

There are the following speeds of the belt:

9 - 18 m/ps

fitting the "V" belt on the different grooves, as shown on pic. 23.

To do this, proceed as follows:

1. Take the lever of the valve (pic. 10 n. 2) to the relief position so that the cylinder (pic. 10 n. 3) for the belt tension, returns to the rest position.
2. Take the "V" belt (pic. 10 n. 4) and making it turn on the pulleys, place it on the groove of the chosen speed.
3. After this is done, reset the tension of the cylinder operating on the valve.

UNIT: TENSION AND TRACKING

STEMAC

OF THE FEED MAT

PAG: 12

FOR 2 K A - 1 0 and 2 K A - 1 1

The tension and the tracking of the feed mat is done by the screw nuts placed on the rear ends of the tension supports of the mat front roller, and under the infeed support.

The centering is done by two nylon rollers, placed under the table, which force the feed mat to keep the central position.

FOR 2 K A - 1 3

The tension and the tracking of the fee mat is done automatically by a small wheel placed on the bottom side of the table.

This small wheel is only one piece with the valve (pic. 25 n. 0).

It is usually constantly contacting the mat. As soon as the mat tends to go away from the small wheel owing to the stretching and the side movement of the mat, losing the contact, this will operate the valve (pic. 25 n. 1) which sends the air to the membrane (pic. 25 n. 2).

It moves the axis of the roller until it does not bring the mat in the exact working position contacting the small wheel.

UNIT :

MAT FEED SPEED

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STEMAC

PAG : 13

On the rear side of the machine and on the left hand side of the mat, there is the feed speed reducer (pic. 11 n. 1).

There are two feed speeds of the mat, they are obtained by pressing the buttons (pic. 1 n. 7 and n. 8).

Usually, the 1st speed is used for calibrating of plywood and solid wood, the 2nd speed is used for calibrating and sanding at the same time, or for sanding only with the pad.

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The table is automatically moved by means of buttons (pic. 1 n. 4 and n. 5), situated on the control panel board. (pic. 11 n. 2 - n. 3) Two limit stop switches situated on the back side of the machine limit the runout of the table.

#### READ-OUT OF TABLE RAISING AND LOWERING

=====

On the control board you can find the read-out for the position of the table (pic. 1 n. 9). The last number to the right indicates tenths of a millimeter, while the other numbers are the millimeters.

#### SETTING THE READ-OUT FOR TABLE POSITIONING PIC. 1 N. 9

=====

This is an operation that must be done, for example, every time that the feed mat is rectified.

Proceed as follows:

1. Adjust the machine for calibrating.
2. fit a 60 grit abrasive belt and calibrate a wooden plank approx. 40 cm. wide, on both sides.
3. without moving the table, after having calibrated the second side of the plank, measure the exact thickness of the plank.

\*/. ...

UNIT :

RAISING AND LOWERING

STEMAC

OF THE TABLE

PAG : 15

4. Unscrew the locking nut fixing the Victor sheath (pic. 2 n. 1) to the raising reducer.
5. After having unscrewed the locking nut, with a screwdriver, operate on the inside slot of the sheath, until on the Victor appears the same numbers as the thickness of the calibrated plank.
6. Reconnect the sheath and tighten, but not too tight, the locking nut.

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For this operation proceed as follows:

1. fit a 60 grit abrasive belt
2. remove the fence that activates the micro-switch (pic. 11 n. 2/3) so that the table can rise until it touches the contact roller.
3. Lower the contact roller for calibrating.
4. operate the feed mat and the main motor
5. raise the table until the abrasive belt begin to touch the feed mat
6. continue to raise the table by 0.1 mm. at a time until the whole feed mat has been rectified.
7. lower the table and tighten the fence mentioned at the position 2. (pic. 11 n. 4).

Note

The fence (pic. 11 n. 4) must operate on the high run-off micro-switch, stopping the raising of the table at 3 mm. from the contact roller, adjusted for calibrating.

All the above mentioned operation must be done strewing on the mat some talc in order to reduce the friction between the mat and the belt.



The table must always be parallel to the idle roller of the pad. (pic. 16).

After having established the side of the table to correct, for the adjustment proceed as follows:

1. lower the folding protection (pic. 16 n. 1)
2. unscrew the two conic point dowels situated on the bended side of the support (pic:16 n. 2 n. 3).
3. turn the big screw n. 3 carefully for not damaging the thread.
4. screw one of the two dowels.
5. make the slot for the second dowel and screw it
6. unscrew the first dowel, make the slot and screw it again.

The semiautomatic positioner is a device (pic. 2 n. 2) suitable for positioning the table according to the thickness of the panel to be sanded.

This device is placed on the side of the machine, opposite to the control board.

The measure of the panel to be worked is done introducing the panel under the positioner (pic. 2 n. 2), then the table raises till the panel operates the microswitch (pic. 12 n. 1), which lights up the red warning light (pic. 1 n. 13), stops the raising of the table showing on the Victor the exact thickness of the panel to be sanded.

#### Note

This device is used only for sanding the veneered and lacquered surfaces.

The platens must always be parallel to the idle roller of the pad.

The control has to be done after having carefully clean the feed mat.

Place the comparator on the feed mat under an idle roller of the pad (pic. 13 n. 1).

After having done the reading along all the length of the roller, you must repeat the same operation on all the platens (the reading has to be done on the flat part under the point of the platen).

After having found which is the platen in the wrong position and having established the side to correct, loosen the lock nut and operate on the screw (pic. 14 n. 2) or (pic.13 n. 2), until the comparator verify the parallelism of the platen.

Tighten the lock nut and move of the same measure the screw (pic.13 n. 3) or (pic.14 n. 3), in order to have the same preloading of the spring (pic. 13 n. 4) or (pic.14 n. 4).

UNIT : ADJUSTMENT OF THE CALIBRATING ROLLERSTEMACREFERRED TO THE IDLE ROLLER OF THE PADPAG : 20

The calibrating roller must always be parallel to the idle roller of the pad.

The control has to be done after having carefully clean the feed mat.

1. Place the comparator on the feed mat under the idle roller (pic. 13 n. 1). After having done the reading along all the length of the roller, repeat the same operation on the calibrating roller (pic. 13 n. 5) to find which is the wrong position of the roller.
2. Loosen the screws of the joint (pic. 15 n. 1) which blocks the toothed gear (pic. 15 n. 2); if the error is on the opposite side, you must loosen the handle (pic. 15 n. 6).
3. It depends on which side to correct, you turn the flange (pic. 15 n. 7) or (pic. 15 n. 3) until the comparator verify the parallelism of the roller.
4. When this is done, tighten the screws of the joint or the locking handle.

If the machine is equipped with the cleaning brush, this must always be parallel to the idle roller of the pad.

For its adjustment proceed as follows:

1. Get a calibrated board and measure the thickness with a caliper gauge.
2. Bring the table to the same thickness of the board.
3. Disassemble the brush protection plate (pic. 24 n. 1).
4. Get the board and place it under the brush.
5. Loosen the screws (pic. 17 n. 1) and lower the brush until it touches with the hair the board.
6. Repeat this operation along all the length of the brush.
7. When this is done, tighten the screws and replace the protection plate.

The pad (pic. 18) is composed of an aluminium profile (pic. 18 n. 1) with a very hard strip of rubber glued to one side (pic. 18 n. 2) covered with felt (pic. 18 n. 3) and graphite cloth (pic. 18 n. 4).

To assure a proper functioning of the machine, the pad must be perfectly rectilinear and must be thinner on the back side, outfeed of the panel (see pad drawing).

Using the contact roller it is possible to make the pad rectilinear and profile it in the correct way.

Proceed as follows:

1. glue the chosen piece of rubber to the aluminium profile.
2. fit on the machine a 100 grit abrasive belt.  
Set the calibrating position on the machine.  
Calibrate the rubber until the total thickness of the rubber plus the aluminium profile is 48 mm.
3. prepare a wooden strip a little longer than the pad, 18 mm. wide by 18 mm. thick.
4. Place the wooden strip under the aluminium profile as shown in pic. 21 and pass it a few times under the contact roller, until the surface of the rubber is sanded, but leaving an area of 20 mm. wide not sanded, on the opposite side to the one where was placed the wooden strip.

\*/. ...

5. Place one of the metal strips (pic. 20 n. 1), under the other side of the pad, as it is shown in pic. 21, and pass again the pad under the contact roller, until the width of 20 mm. is rectified.
6. apply some bostik to the two extreme ends of the pad and glue a strip of felt to the rubber. The felt must be perfectly calibrated and reduced to a thickness of 3 mm.
7. wrap the pad with the graphite cloth as is shown in pic. 18.

GRUPPO:

PNEUMATIC PAD

STEMAC

PAG.24

The pneumatic pad (pic. 19) is composed of:

1. aluminium profile
2. air tube
3. two angle shaped aluminium profile, screwed to the main profile.
4. flexible steel
5. felt
6. graphite cloth
7. inner felt.

The dimensions are shown on pic.19 .

The profiles n. 3 must be screwed with precise parallelism of 0.1 mm.



If a sander with this type of pad shows some signs of unevenness, the problem can be caused by a deformation of the felt which is glued to the flexible steel of the pad.

In this case it is necessary to calibrate the felt proceeding as follows:

1. take out the flexible steel from the head of pad
2. remove the felt which is glued to the side of the flexible steel, contacting the inner air tube.
3. remove the graphite cloth from the outside of the felt.
4. nail the flexible steel onto a calibrated board.
5. rectify the felt passing it under the contact roller.
6. glue the rectified felt to some graphite cloth, spreading bostik only on the sides.
7. re-glue the old felt to the other side of the flexible steel.
8. re-assemble the whole pad.

FOR MACHINE WITH ONE OR TWO FEED SPEEDS OF THE MAT  
=====

This pad functions correctly when, after the air tube is inflated, the pad lowers itself and begins to work when the front edge of the panel is already under the pad, and it raises before the panel is out of the pad.

The start and finish of working of the pad is regulated by means of timers (pic. 1 n. 16 and n. 17).

Every time the feed speed is changed it is necessary to adjust the timers.

If the pad tends to damage the front and rear edges of the panel, the adjustment of the timers is wrong.

If the pad tends to damage the side edges of the panel this means that the pad is too soft or the removal is excessive.

The pressure gauge (pic. 1 n. 22) indicates the inflation pressure, this must never exceed 0,4 atm.; the switch (pic. 1 n. 23) is for the exclusion of the pressure gauge after having adjusted the pressure.

The pressure reducer (pic. 1 n. 21) adjusts the pad inflation pressure.

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GRUPPO: TIME-OPERATED PNEUMATIC PAD

STEMAC

WORK STARTING AND ENDING ADJUSTMENTPAG. 27

The switch (pic. 1 n.20), is for the connection or the exclusion of time-operated pneumatic pad function.

The control for the rise and fall of the pad (inflation and deflation of the air tube) is given by the panel being worked which raising the roller (pic. 12 n. 2) operates the micro.

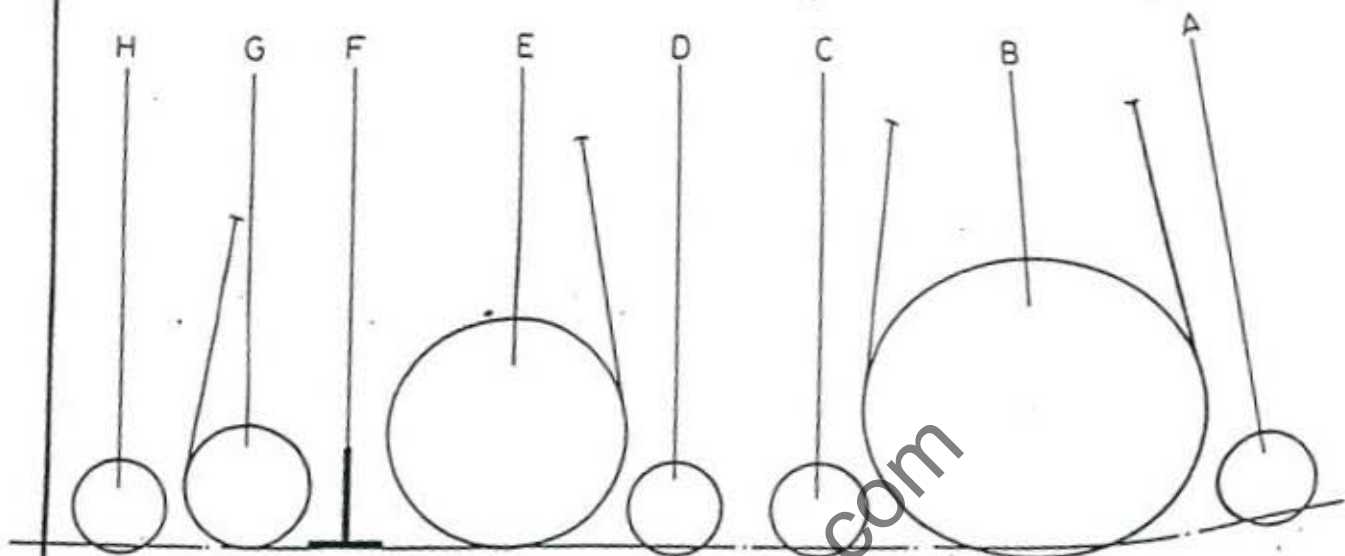
The delayed control of the timing system is transmitted to a solenoid valve situated on the back side of the box.

GRUPPO: EMERGENCIES

STEMAC

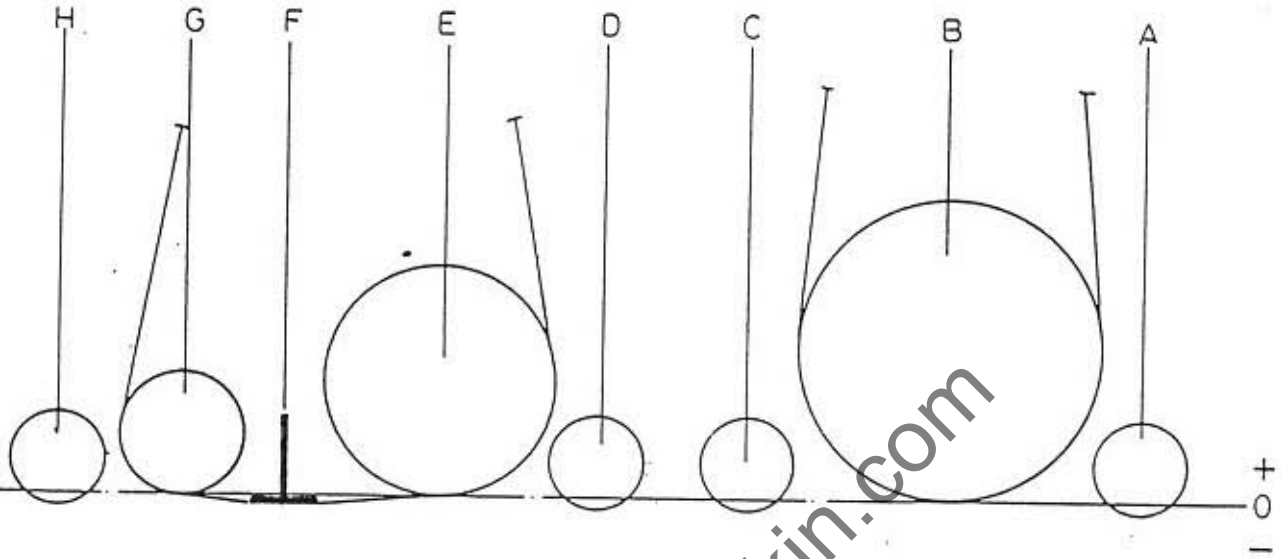
PAG. 28Emergencies on the machine.

1. "STOP" button on the control board  
(pic. 1/a, 1/b n. 1)
2. Security bar (pic. 2 n. 4)
3. micro-switch for exit of abrasive belt  
(pic. 6 n. 5 and n. 6).
4. micro-switch for breakage of abrasive belt  
(pic. 7 n. 1)
5. micro-switch for open door - on the abrasive  
introduction side of the machine (only on  
machines for Italian market) (pic. 6 n. 8).



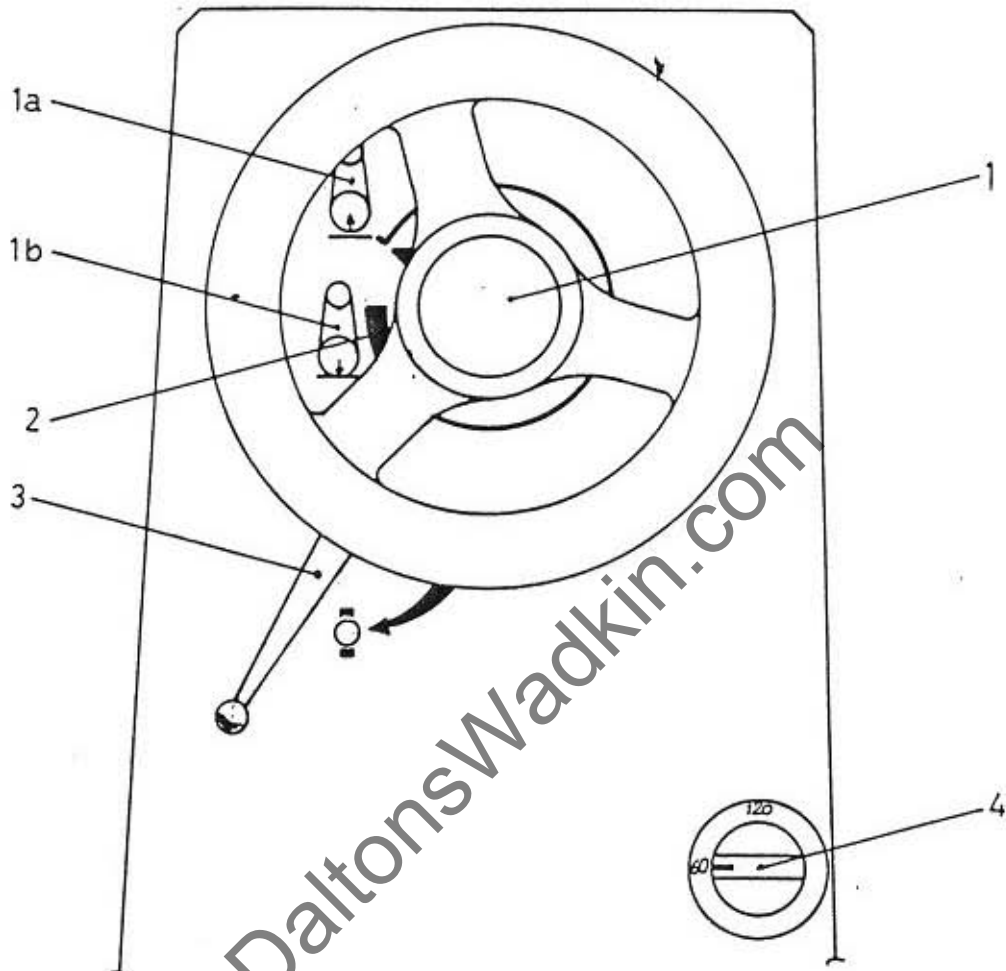
- A) PRESSURE ROLLER - 4 mm.
- B) CALIBRATING ROLLER - 3 (thick grit)
- C) PRESSURE ROLLER - 4 mm.
- D) PRESSURE ROLLER - 4 mm.
- E) IDLE ROLLER 0
- F) PAD 0
- G) IDLE ROLLER 0
- H) PRESSURE ROLLER - 4 mm.

N.B. The measure of the pad must be done fitting a fine grit of abrasive belt.



- |                              |           |
|------------------------------|-----------|
| A) <u>PRESSURE ROLLER</u>    | - 4 mm.   |
| B) <u>CALIBRATING ROLLER</u> | 0         |
| C) <u>PRESSURE ROLLER</u>    | - 4 mm.   |
| D) <u>PRESSURE ROLLER</u>    | - 4 mm.   |
| E) <u>IDLE ROLLER</u>        | 0         |
| F) <u>PAD</u>                | - 3,5 mm. |
| G) <u>IDLE ROLLER</u>        | 0         |
| H) <u>PRESSURE ROLLER</u>    | - 4 mm.   |

N.B. The measure of the pad must be done fitting a fine grit of abrasive belt.



1) Hand-wheel for roller adjustment

1a) Position of roller exclusion

1b) Position of roller working

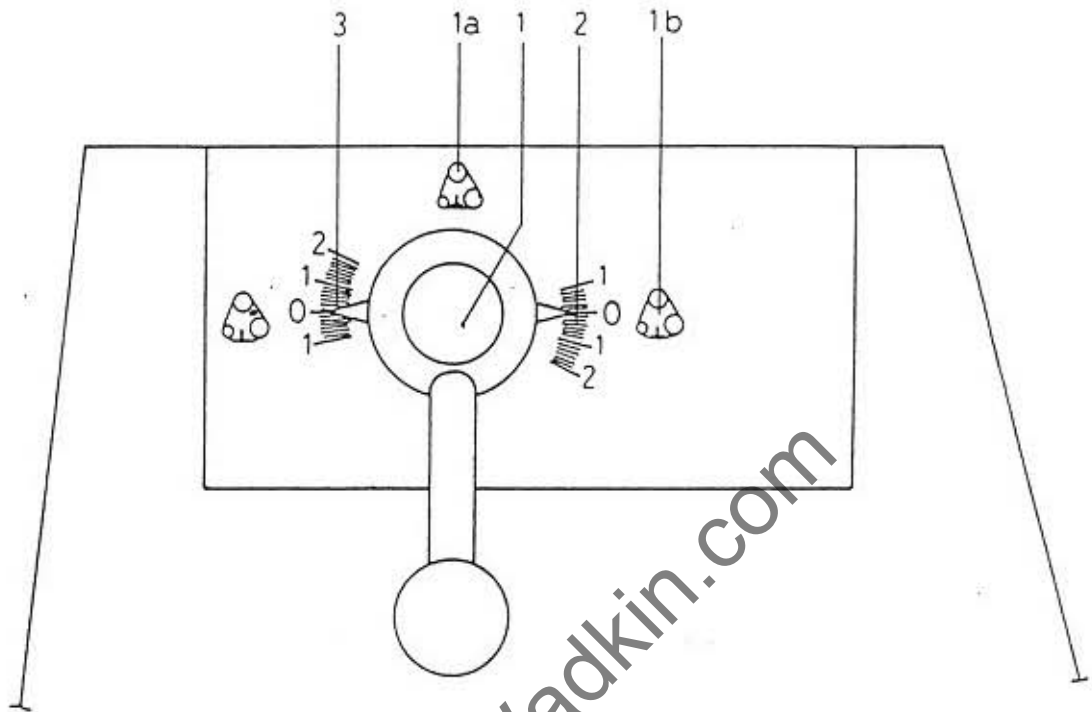
2) Sector of roller working more or less remove

3) Roller locking lever after positioning

4) Knob for two positions of roller

60 and 120 grit of paper.

CONTROLS FOR PAD ADJUSTMENTS



1) Pad adjustment handle (before moving unlock the handle) (pic. 6 n. 7)

1a) Position of pad exclusion

1b) Position of pad working

2) Scale for hard rubber pad working position

3) Scale for pneumatic pad working position



REMEDIES	CAUSES	FAULTS
<p>To determine the causes, see instruction manual.</p> <ul style="list-style-type: none"> <li>- delay the fall of the pad</li> <li>- correct the timing</li> <li>- use good abrasives, i.e. not humid and badly joined.</li> <li>- anticipate its rising</li> <li>- check the pneumatic and electric controls</li> <li>- use good abrasives, i.e. not humid and badly joined.</li> <li>- check the setting of the thickness; if necessary lower the table.</li> <li>- the setting of the thickness must be checked; if necessary raise the table.</li> </ul>	<ul style="list-style-type: none"> <li>- lack of compressed air</li> <li>- lack of electrical power</li> <li>- abrasive belt has come off</li> <li>- relays of motor overload have functioned.</li> <li>- wrong timing of the pad</li> <li>- wrong timing of the pad</li> <li>- possibility of faulty abrasive</li> <li>- the pad rises late</li> <li>- the pad does not rise due to non functioning of micro commanding solenoid or non functioning of the solenoid, or diaphragm or proximity micro on the reducer unit or variable feed.</li> <li>- wrong setting of timing for rise of pad</li> <li>- possibility of faulty abrasives</li> <li>- wrong setting of the thickness</li> <li>- wrong setting of the thickness</li> </ul>	<ul style="list-style-type: none"> <li>- the machine stops.</li> <li>- excessive sanding at</li> <li>- faulty sanding at infeed</li> <li>- excessive sanding at</li> <li>- faulty sanding at outfeed</li> <li>- excessive sanding on the sides.</li> <li>- faulty sanding on the sides.</li> </ul>

LIST OF FAULTS

FAULTS	CAUSES	REMEDIES
Excessive sanding	<ul style="list-style-type: none"> <li>- excessive inflation pressure of the pad</li> <li>- wrong thickness setting</li> </ul>	<ul style="list-style-type: none"> <li>- reduce inflation pressure of the pad</li> <li>- lower the table</li> </ul>
Faulty sanding	<ul style="list-style-type: none"> <li>- possibility that the pad controlling system did not function</li> <li>- possible wear of the graphite cloth</li> </ul>	<ul style="list-style-type: none"> <li>- make the system function and if necessary replace the defective parts.</li> <li>- replace the graphite cloth</li> </ul>
Area (streak) of the panel not sanded.	<ul style="list-style-type: none"> <li>- possibility that the pad controlling system did not function.</li> <li>- possible wear of the graphite cloth</li> <li>- possibility of dirt (dust and chips) being accumulated between belt and pad.</li> </ul>	<ul style="list-style-type: none"> <li>- make the system function and if necessary replace the defective parts.</li> <li>- replace the graphite cloth</li> <li>- accurately clean the graphite cloth</li> </ul>
Area of the panel sanded too much at the infeed and outfeed.	<ul style="list-style-type: none"> <li>- possibility of dirt (dust and chips) being accumulated between belt and pad.</li> <li>- possible uneven wearing of the graphite cloth</li> <li>- possible deformation of the felt</li> </ul>	<ul style="list-style-type: none"> <li>- accurately clean the graphite cloth</li> <li>- replace the graphite cloth</li> <li>- rectify the felt of the pad.</li> </ul>
Breakage of abrasives.	<ul style="list-style-type: none"> <li>- faulty or humid abrasives</li> <li>- wrong timing of the pad</li> <li>- excessive removal</li> </ul>	<ul style="list-style-type: none"> <li>- use good abrasives</li> <li>- correct the timing of the pad.</li> <li>- reduce the amount of removal</li> </ul>

REMEDIES	CAUSES	FAULTS
<ul style="list-style-type: none"> <li>- Set the pad parallel to the table. If on the other hand the table is not level, discover the cause of this abnormality, eliminate it and proceed with a new setting of the table.</li> <li>- replace the graphite cloth</li> <li>- accurately clean the graphite cloth and the pad.</li> <li>- rectify the felt of the pad</li> <li>- the table and the contact roller are not parallel to each other.</li> <li>- excessive removal</li> <li>- lower the table.</li> </ul>	<ul style="list-style-type: none"> <li>- the pad is not parallel to the table</li> <li>- possible wearage of the graphite cloth</li> <li>- possibility of dirt (dust and chips) between belt and pad</li> <li>- possible deformation of the felt</li> <li>- the table and the contact roller are not parallel to each other.</li> <li>- excessive removal</li> </ul>	<ul style="list-style-type: none"> <li>The machine sands more to the right or to the left.</li> <li>Ondulated sanding longitudinally.</li> <li>The machine calibrates more to one side than the other</li> <li>White calibrating, the belt slides on the roller.</li> </ul>

NOTICE CONCERNING ORDERS FOR SPARE PARTS  
-----

When the time comes to order spare parts, it is necessary to give the following information:

- 1) The number of the picture for the spare part.
- 2) The name of the group (see spare parts list which belongs to the picture).
- 3) The number where the item is marked in the picture.
- 4) The name of the spare part as shown in the spare parts list.

THE FOLLOWING INFORMATION FOR THE MACHINE MUST BE DONE  
-----

- 1) The model of the machine.
- 2) Working width.
- 3) Size of the abrasive belts.
- 4) Indicate if the machine is equipped with at least an air suction table.
- 5) Number and invoice date of the machine.

EXAMPLE:

PICTURE n° 1.200

GROUP: Lubricating filter

ITEM n° 1

NAME: Rubber connector

Model of the machine. K A / 10

Working width mm. 1100

Size of the abrasive.

belts mm. 1900

Machine equipped with an air suction table

Invoice N. 1920 dated 1983.

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THE FOLLOWING CODES DISTINGUISH THE FREQUENT REPLACEMENTS OF PARTS WHICH ARE MADE UP BY MACHINES BASED ON THE WEAR-AGE AND A POSSIBILITY OF BREAKAGE

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- CODE 1. - Parts which wear out rapidly  
(graphite cloths - laminated belts - etc.).
- CODE 2. - Parts which wear out  
(belts - mats - felts - rubber covered rollers - brushes - finishing brush rollers - equipment for brake pads - scrapers).
- CODE 3. - Parts which are replaced  
(bearings - ball bearings liable to sliding friction - ball bearing - spirals - membranes - brake discs).
- CODE 4. - Parts which are replaced less  
items which are less needed (pulleys - rollers).
- CODE 5. - Parts which are impossible to replace  
(structures).

FIG. 1

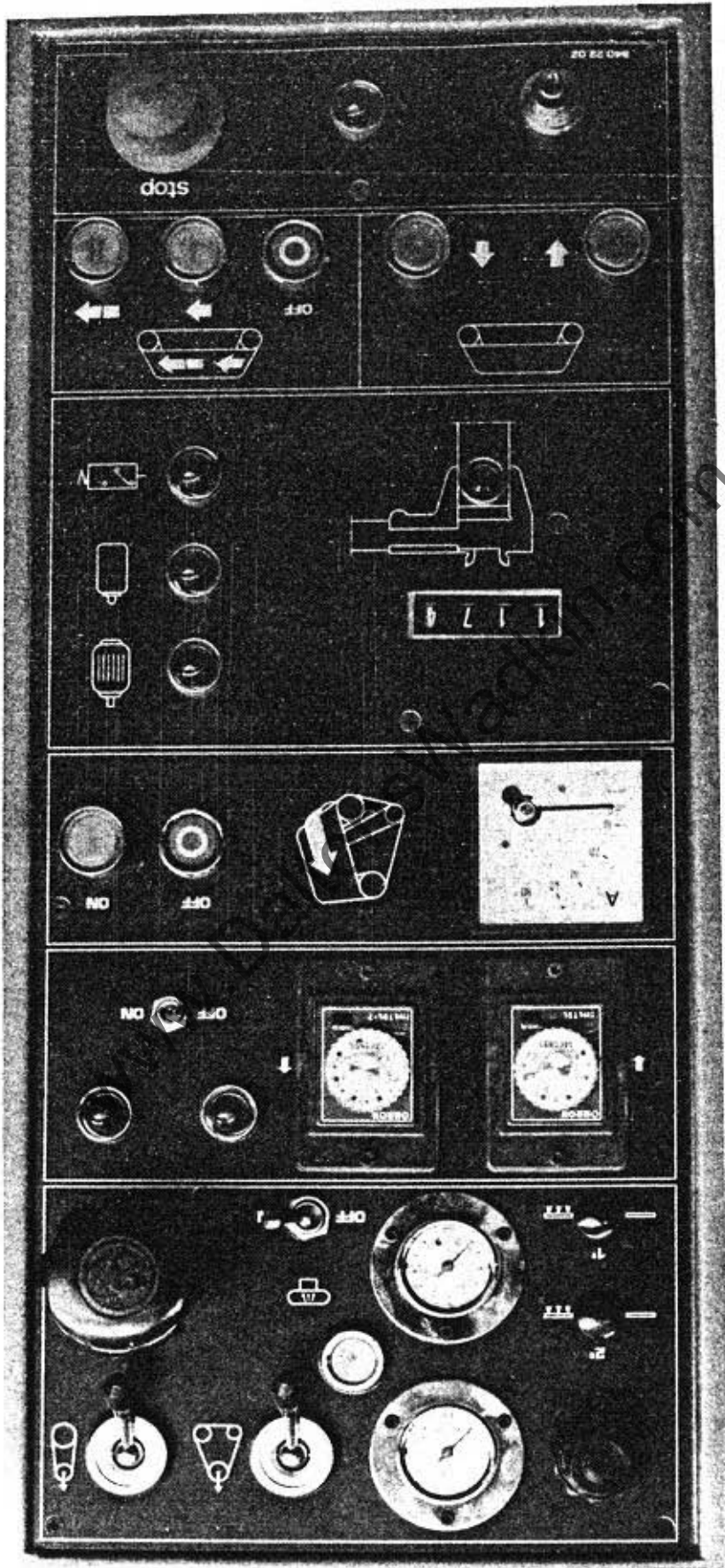
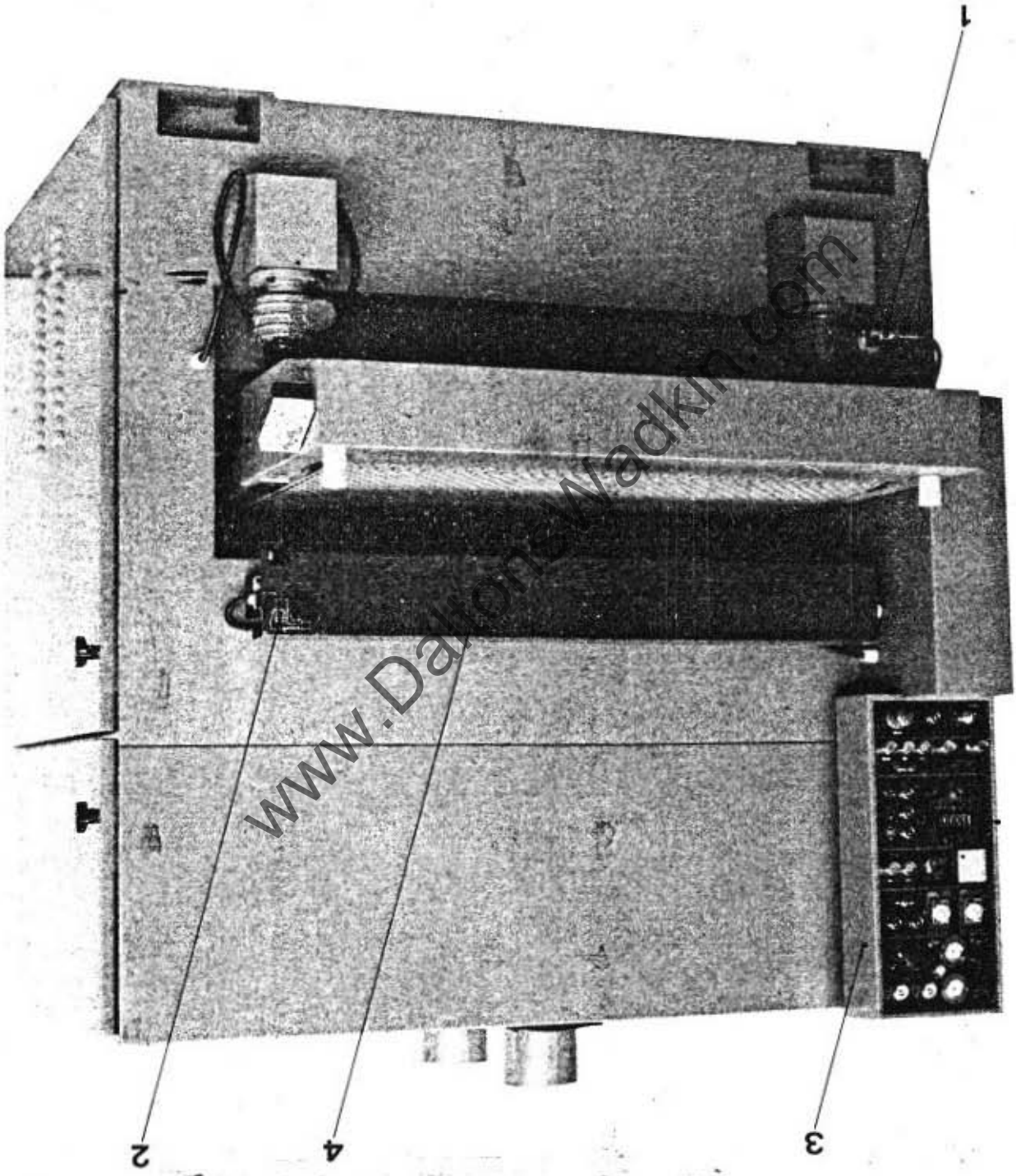


FIG. 2





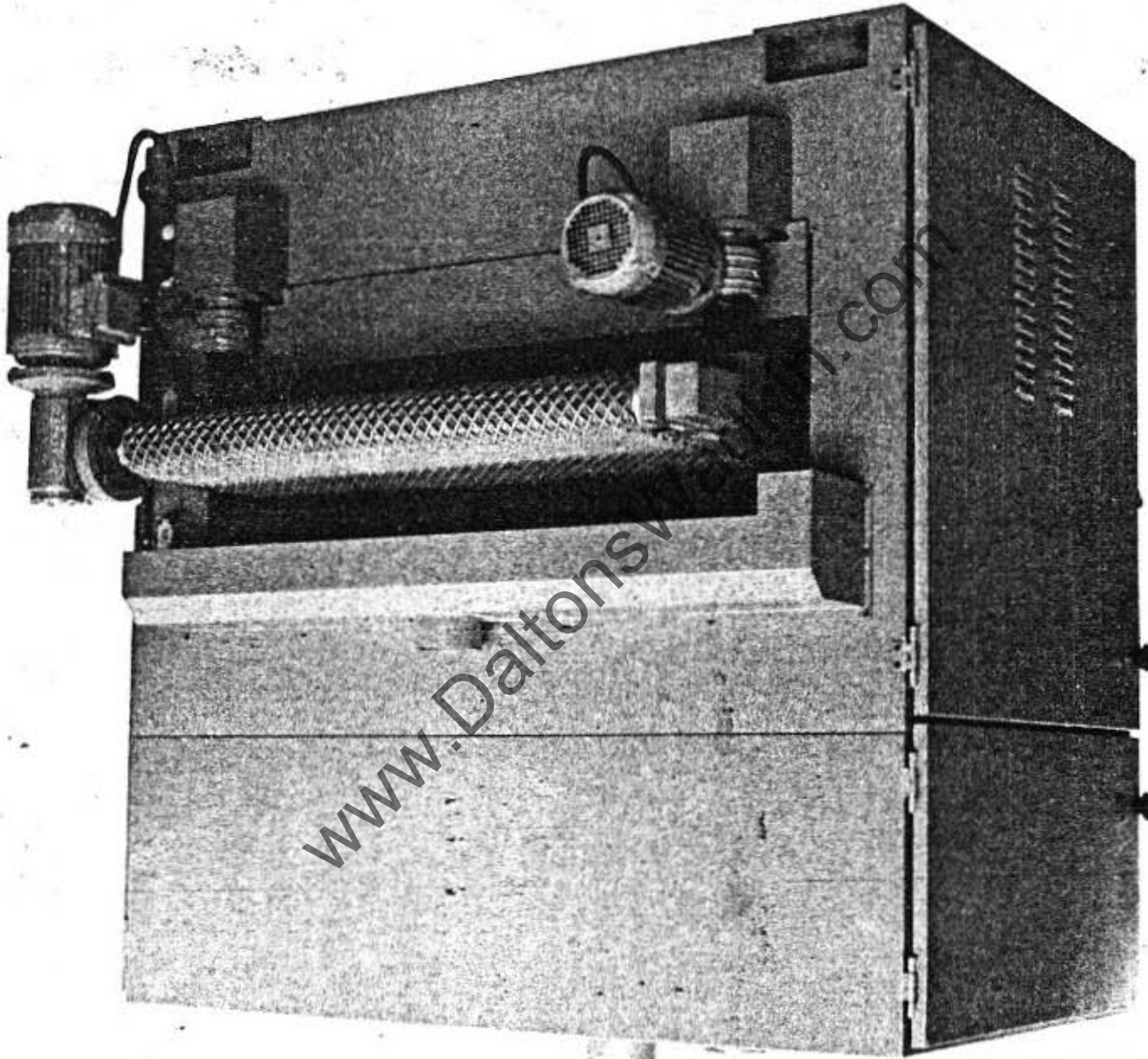


FIG. 4

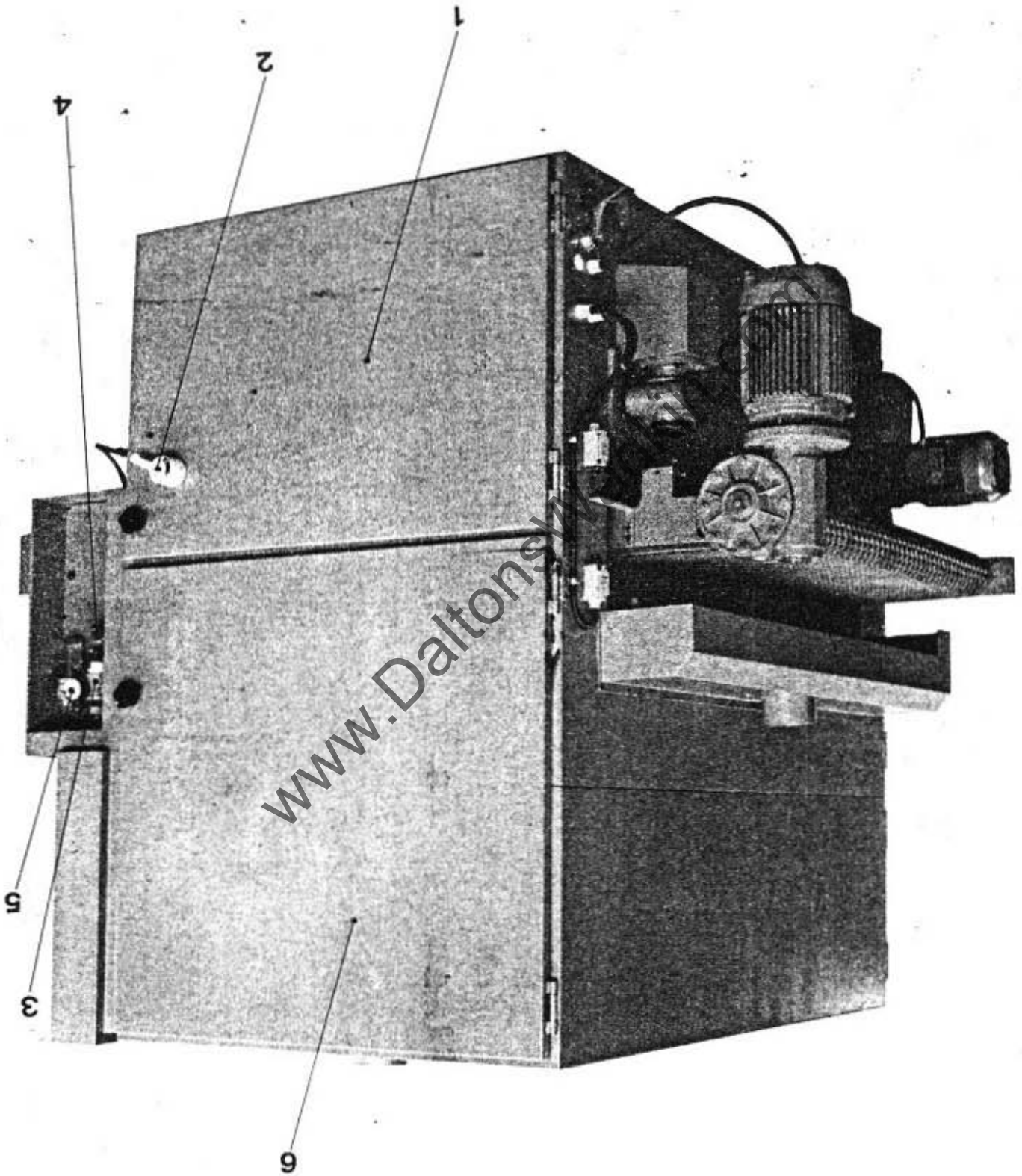


FIG. 5

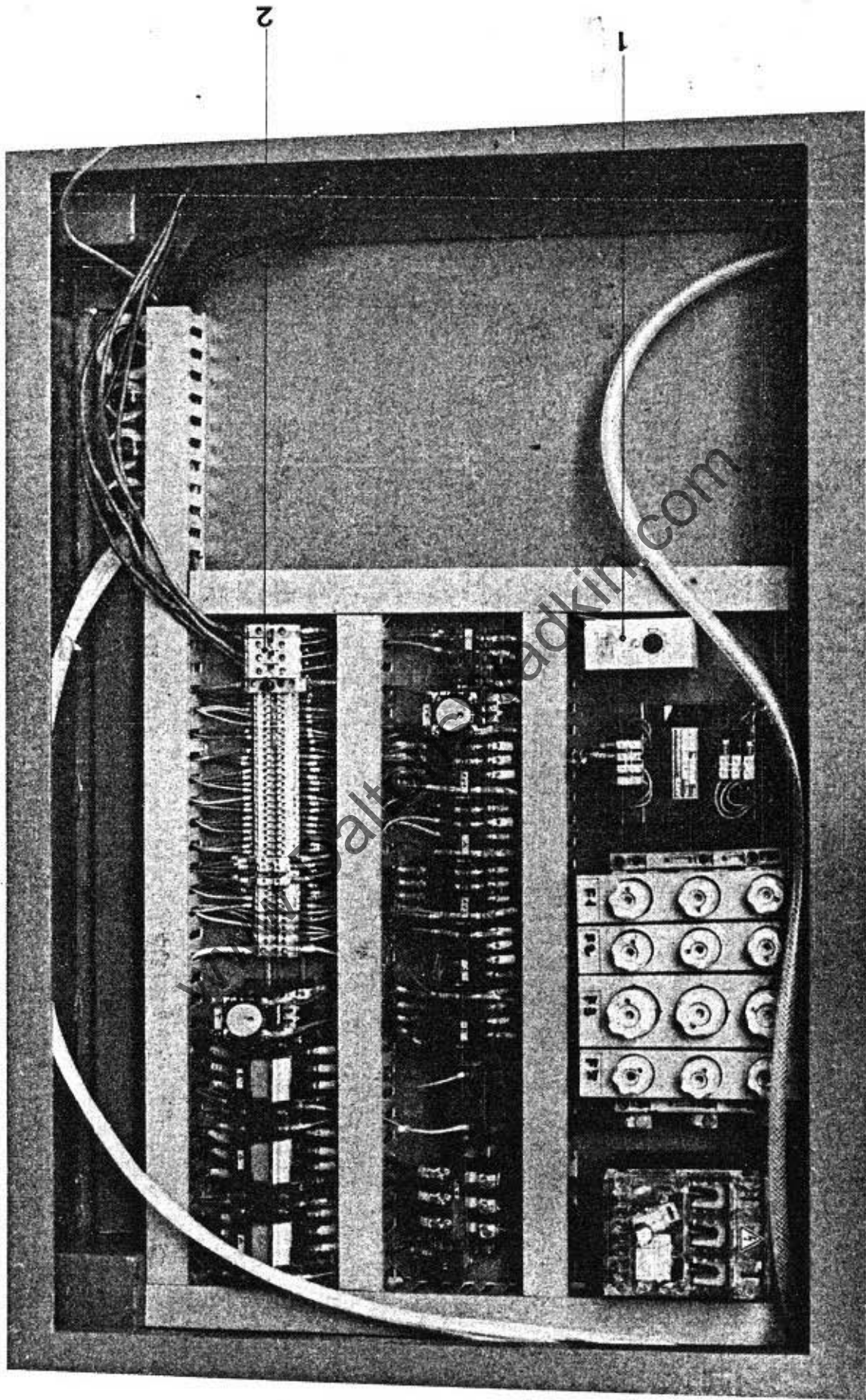


FIG. 6

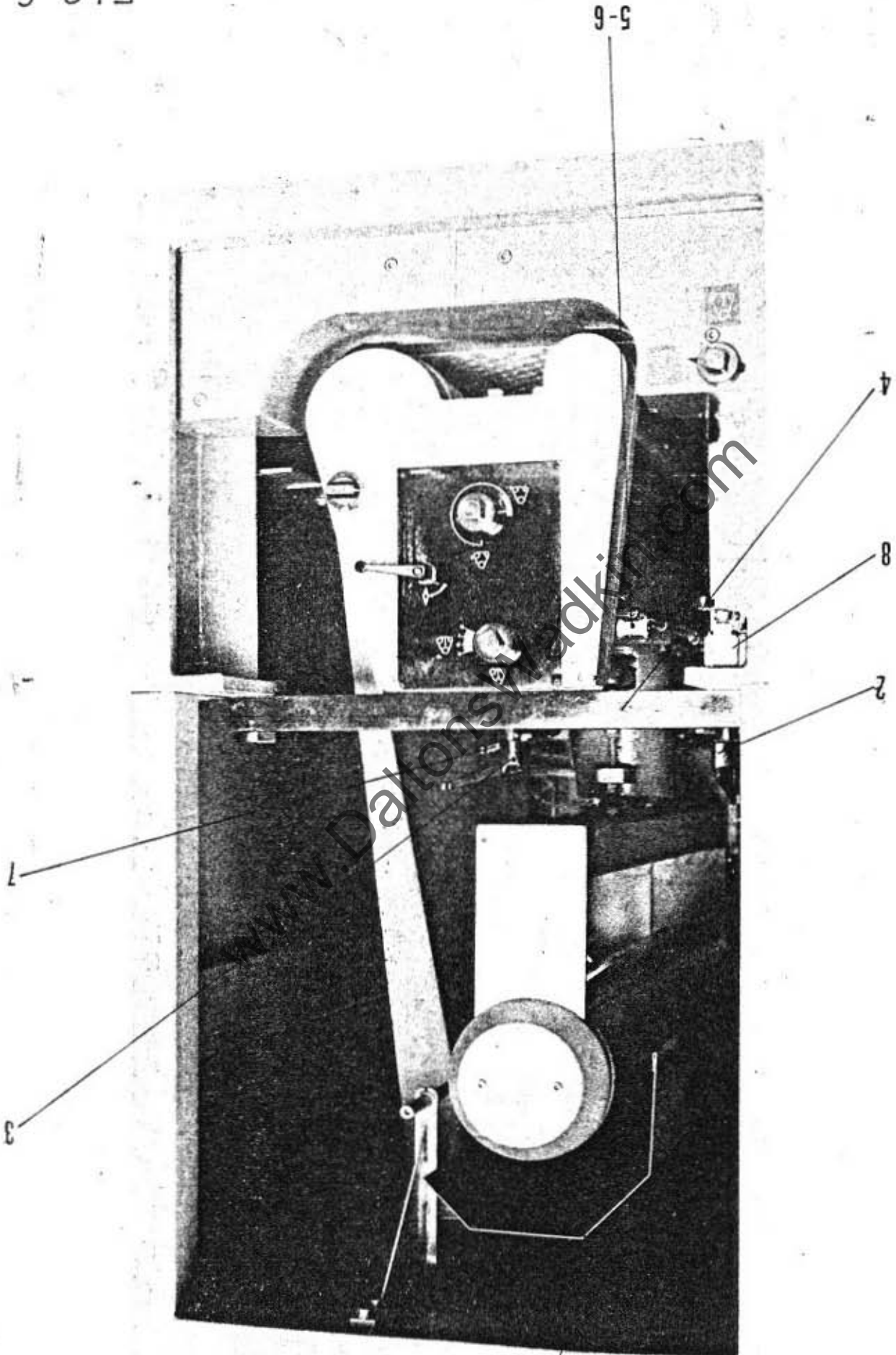


FIG. 7

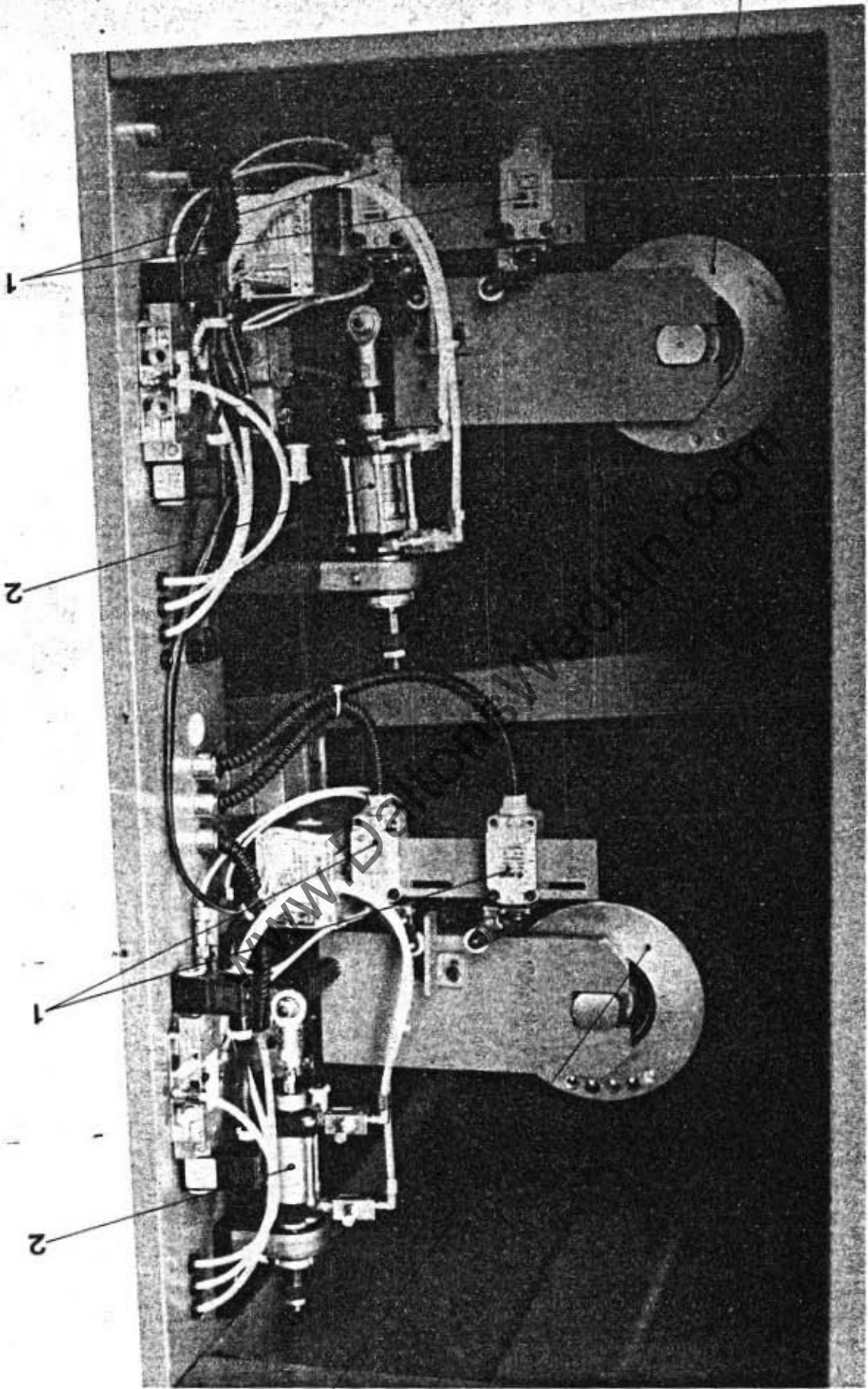


FIG. 8

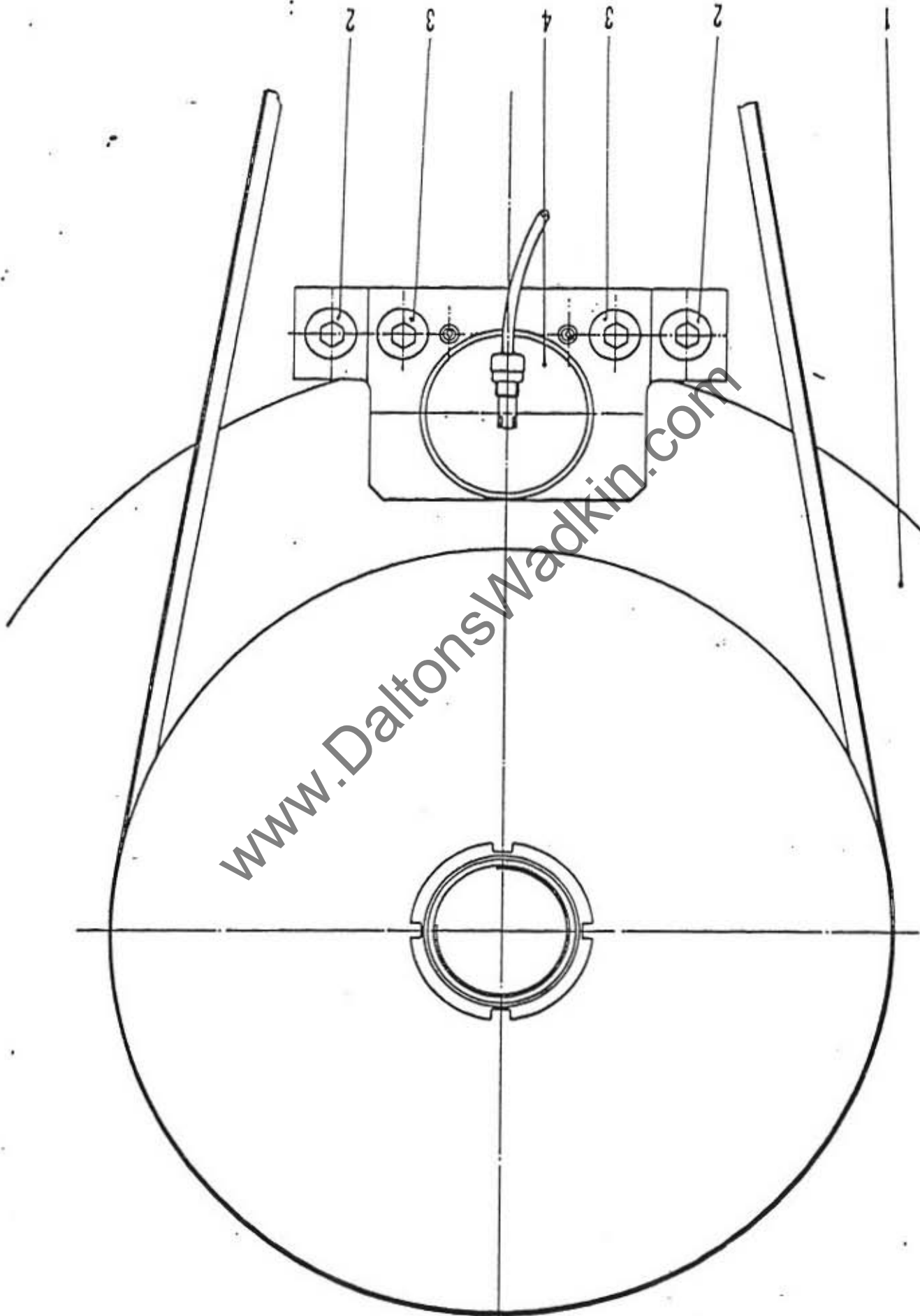
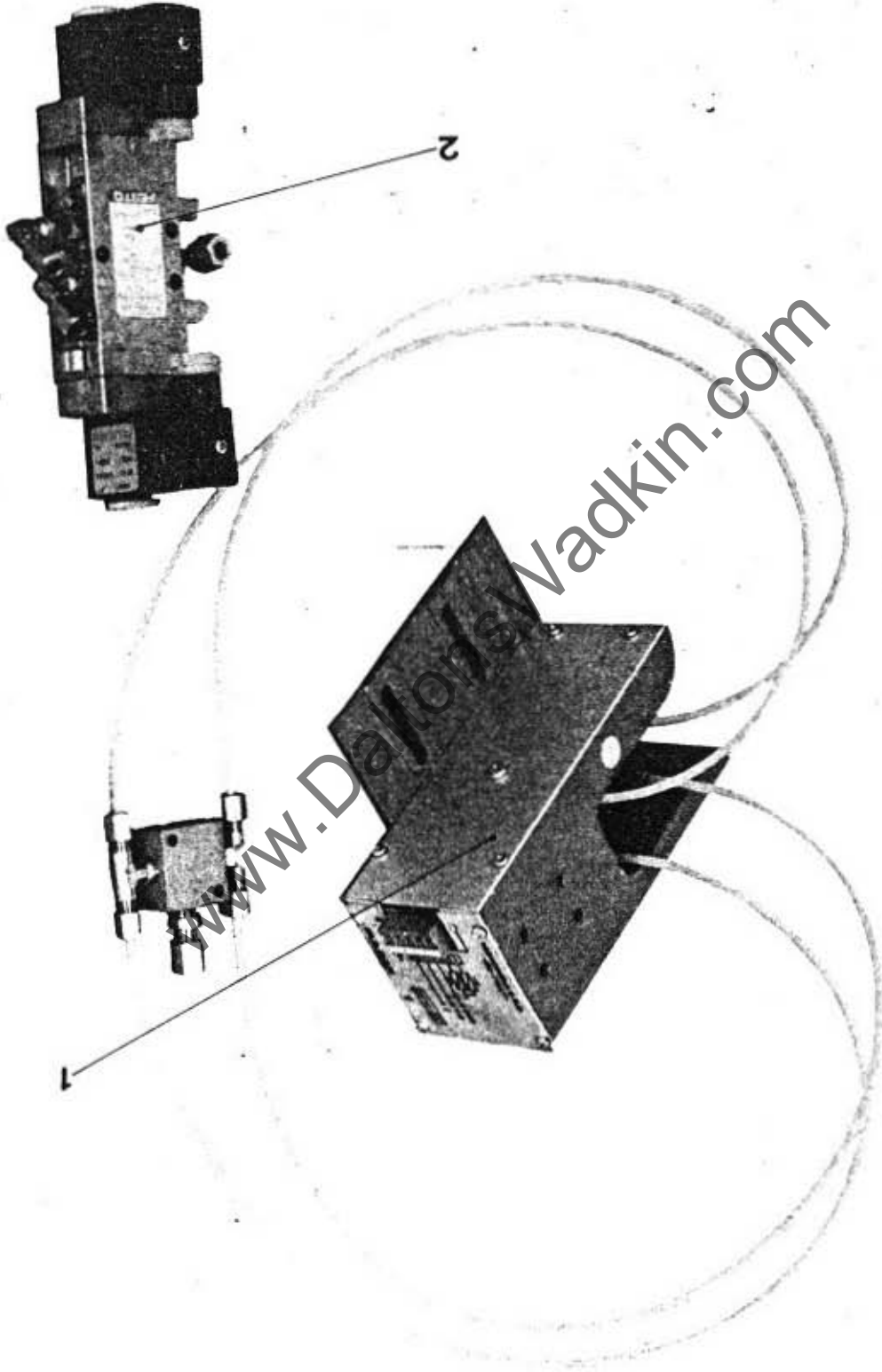


FIG. 9



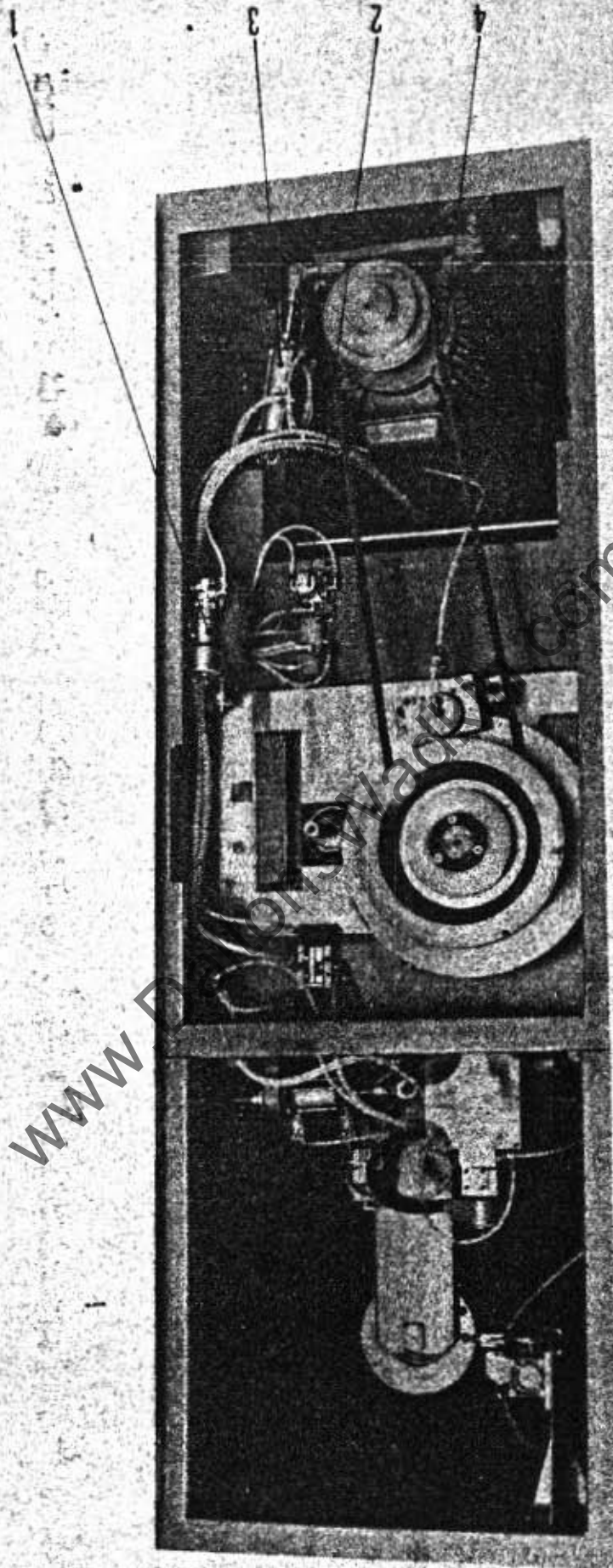
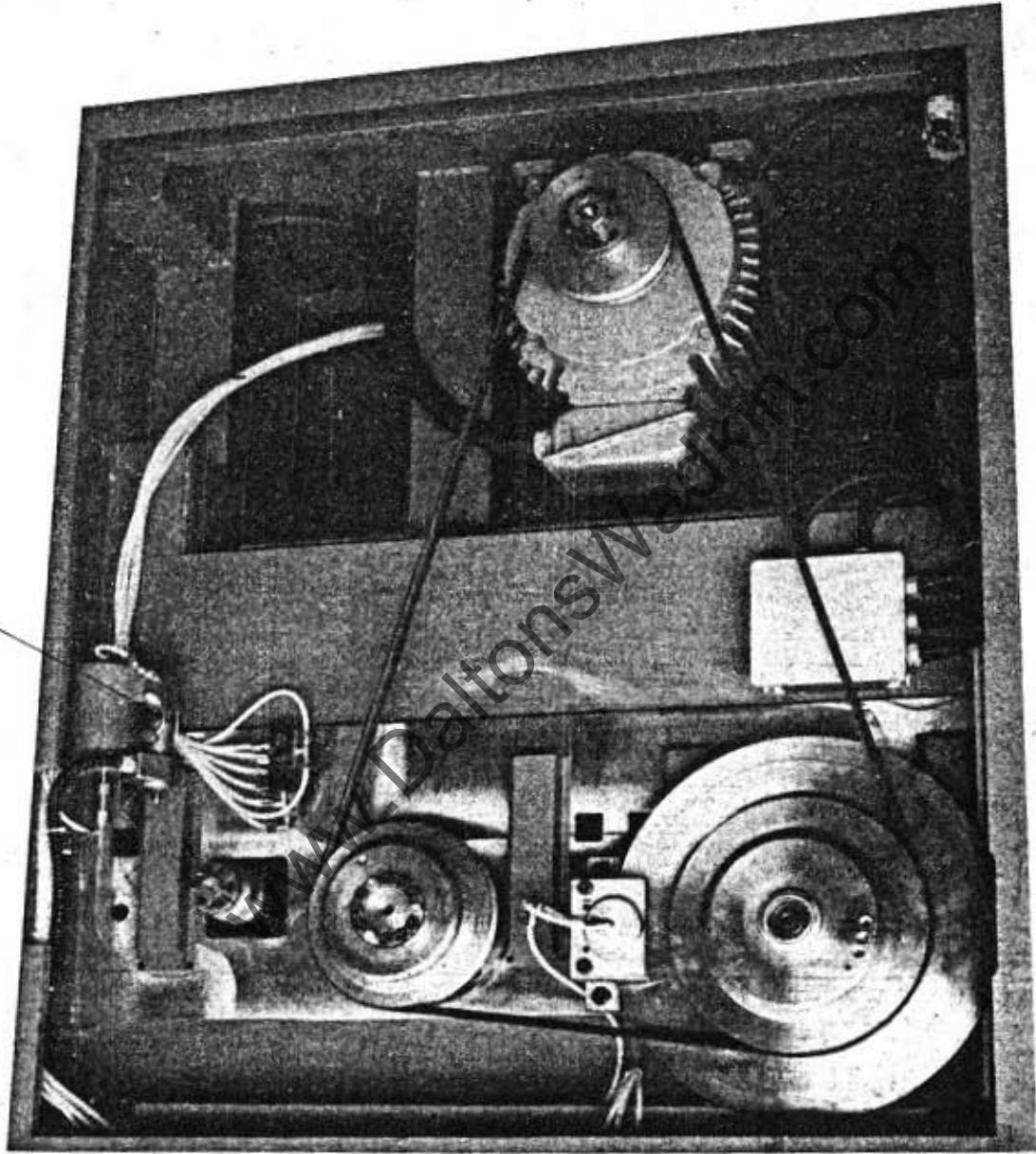




FIG. 10 bis.



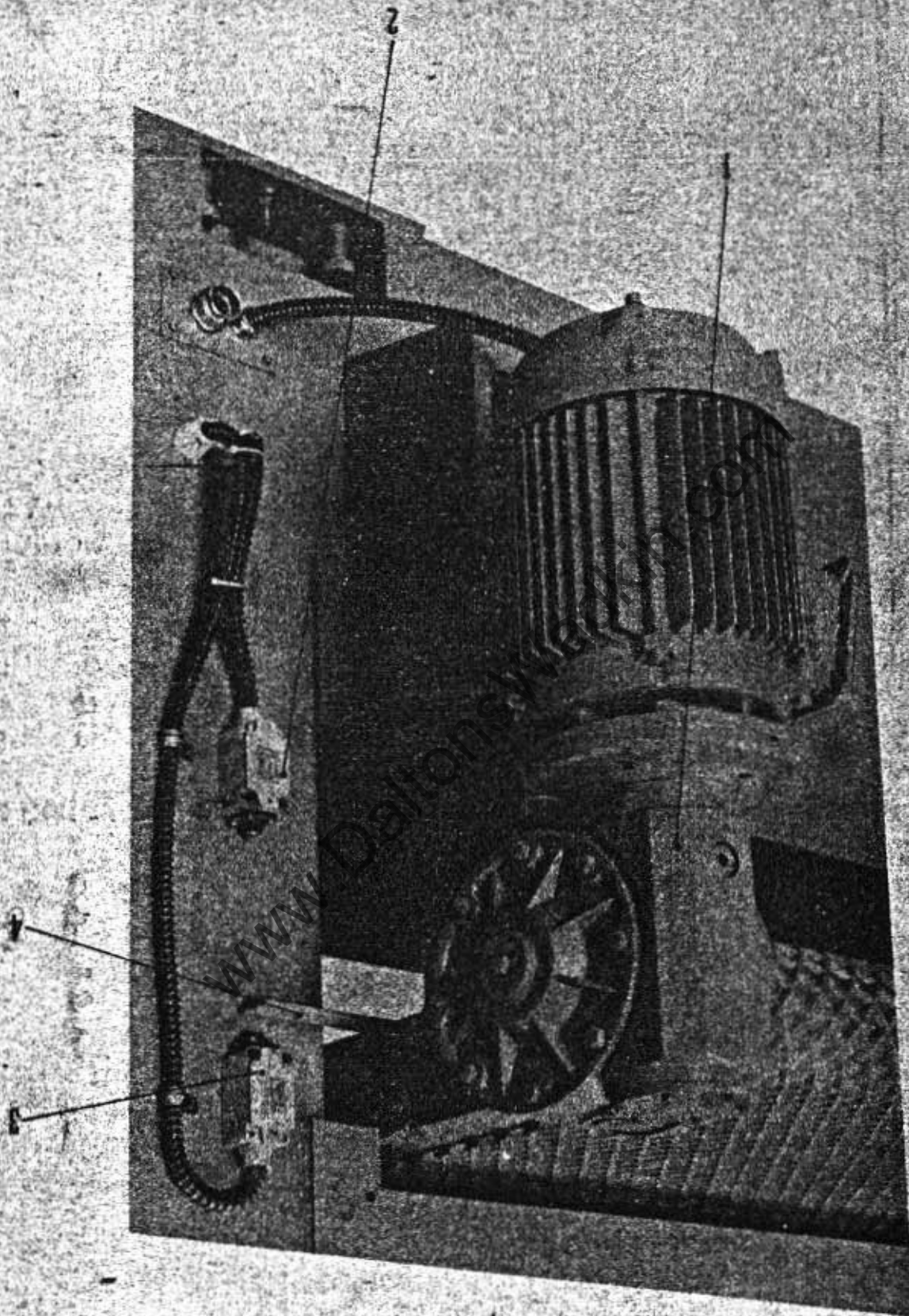


FIG.12

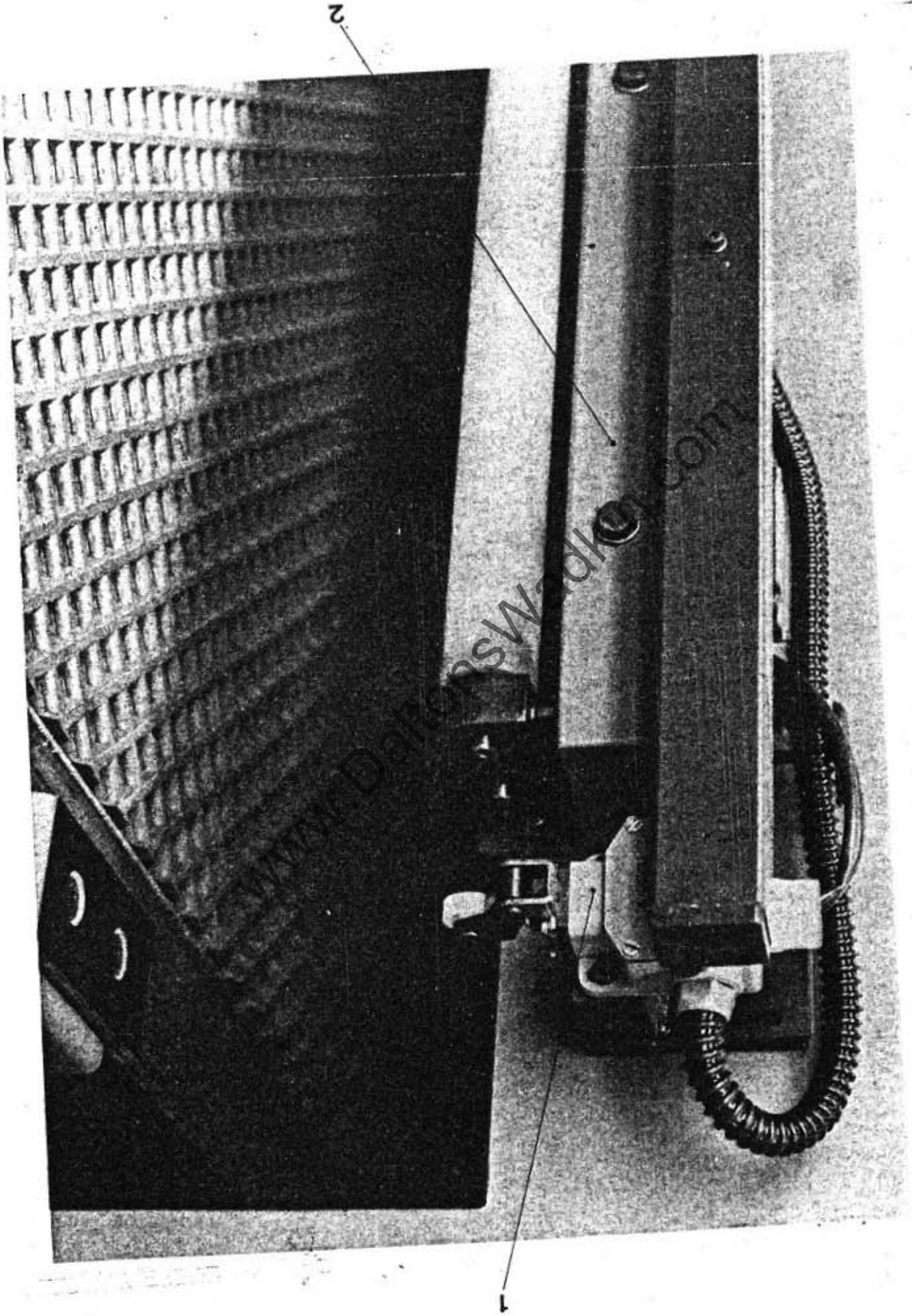


FIG. 12 bis.

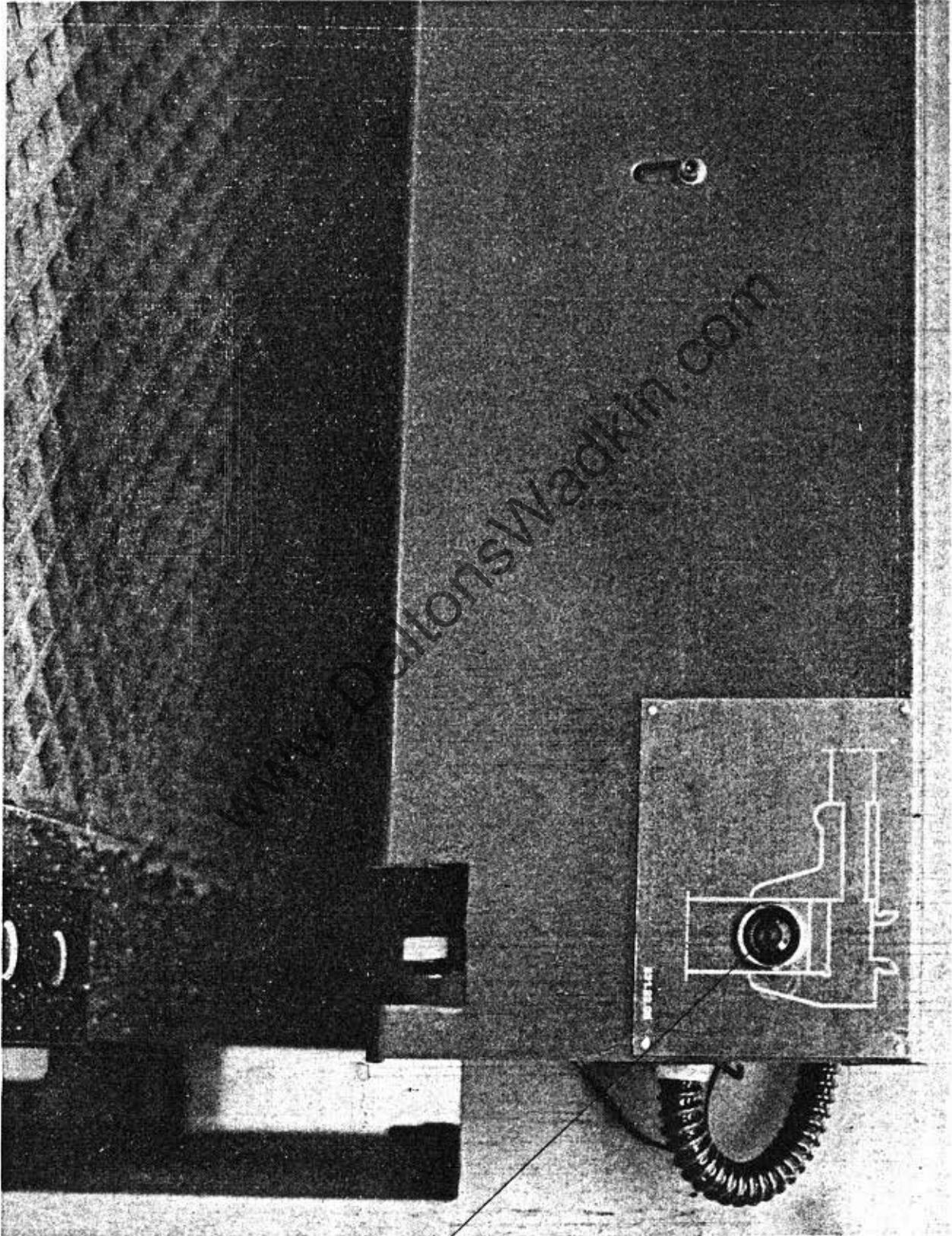
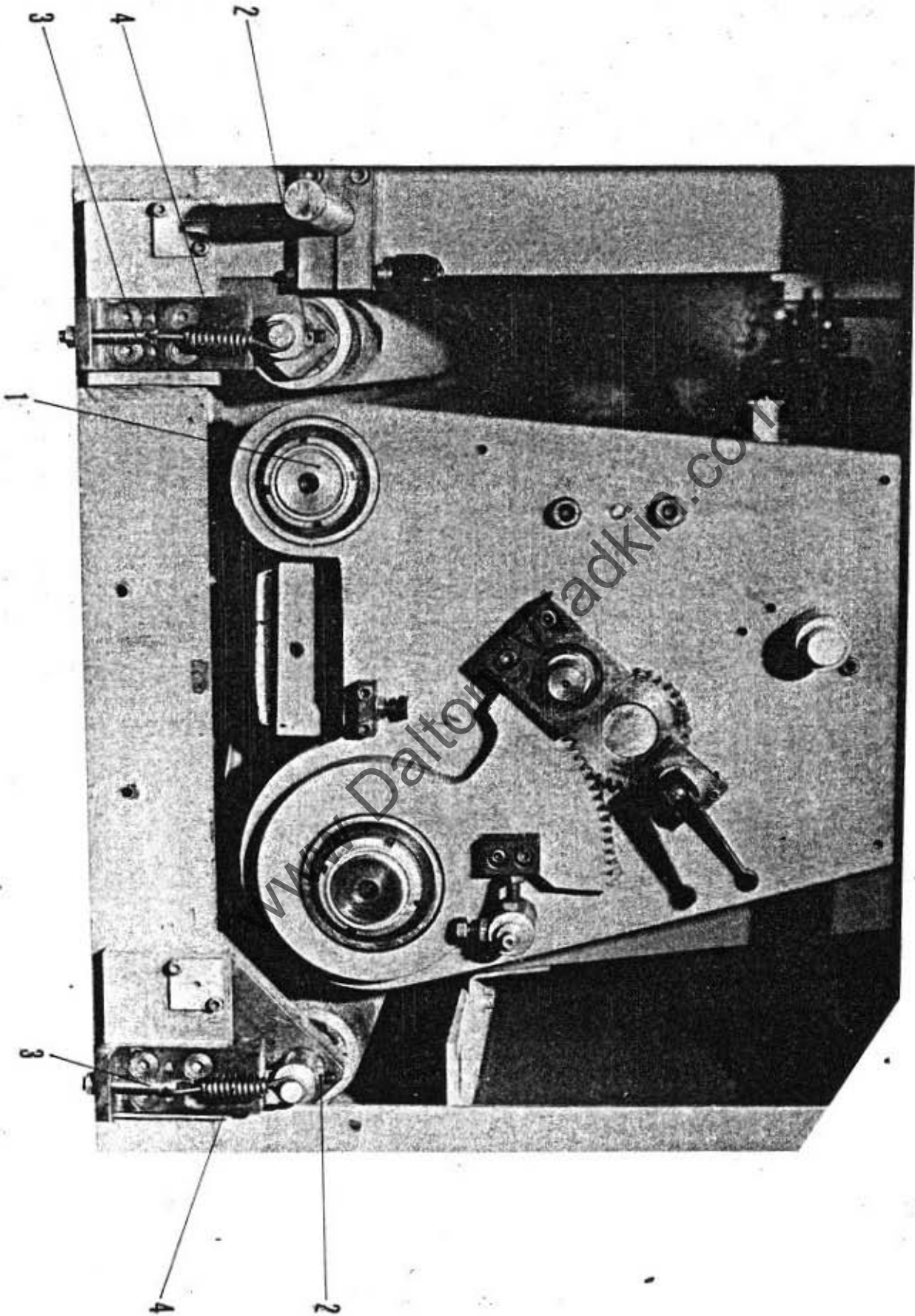


FIG. 13



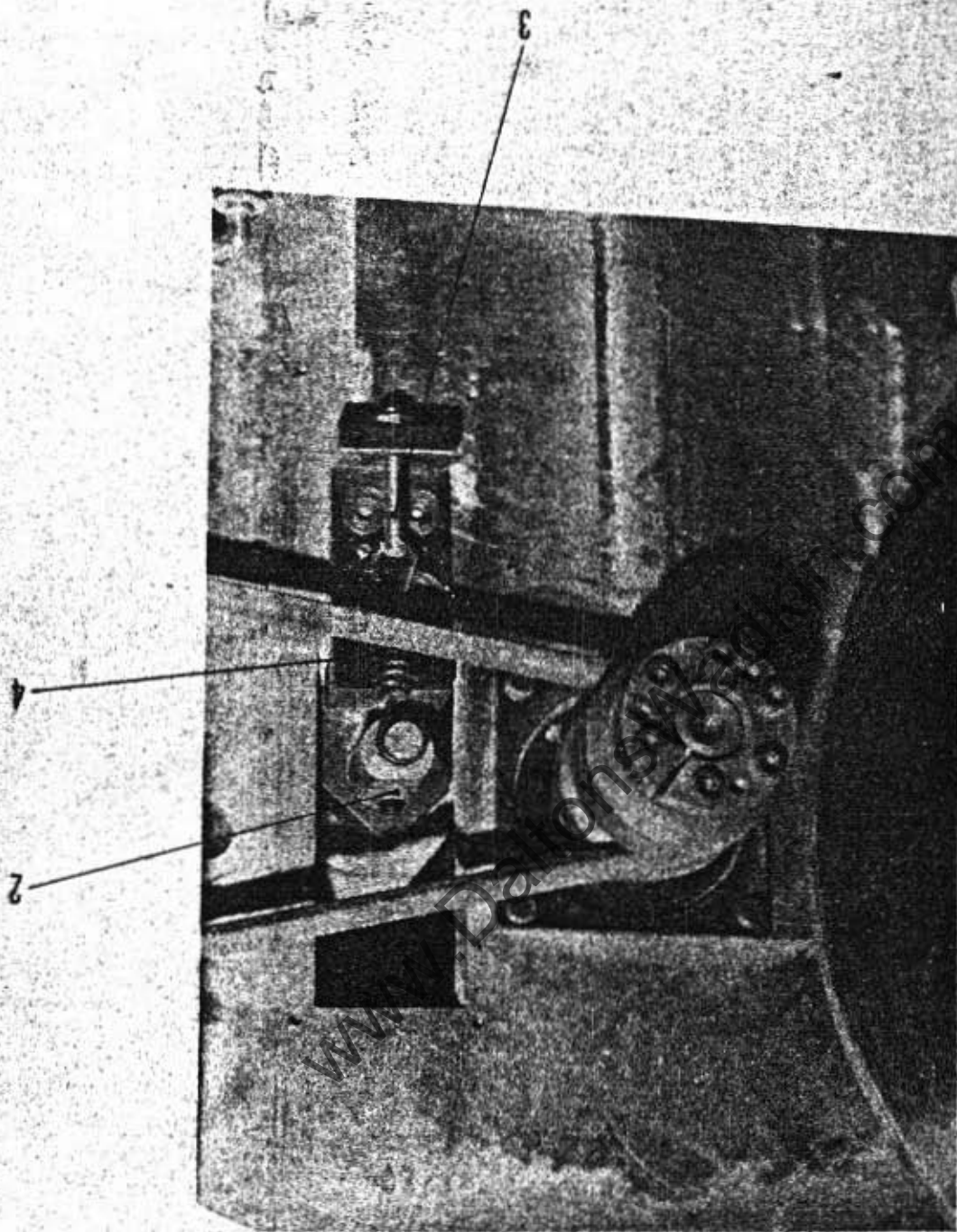


FIG. 15

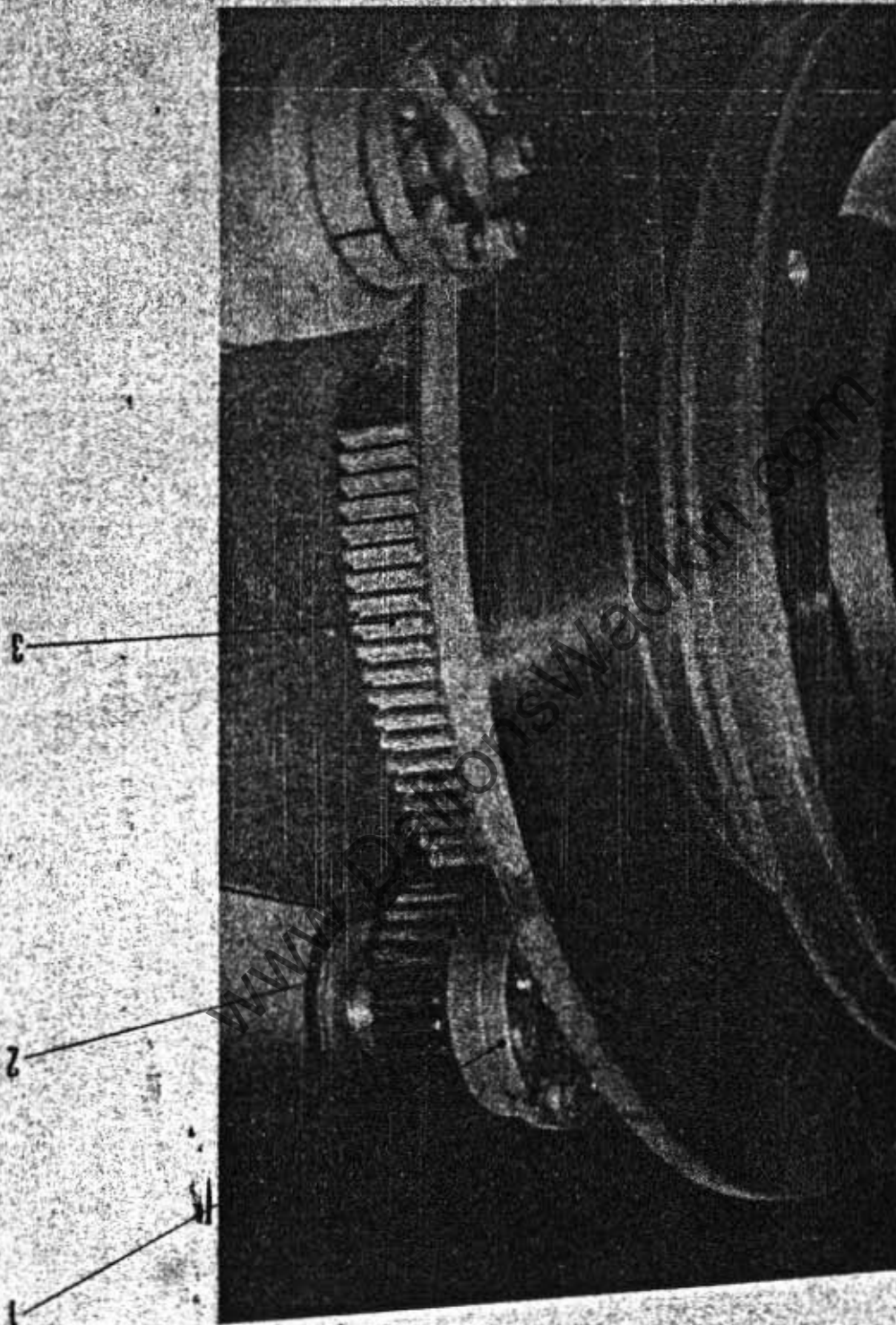
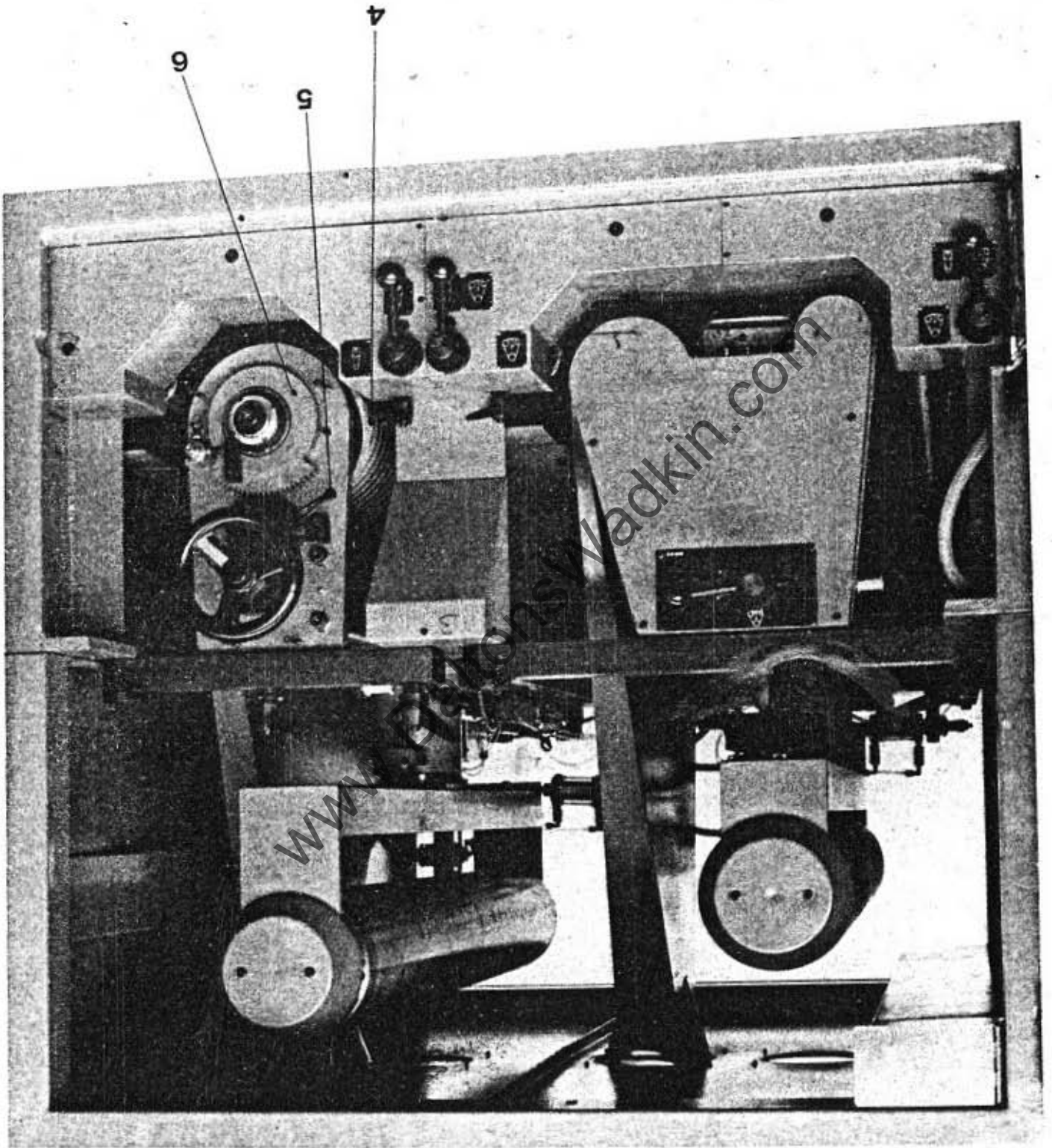
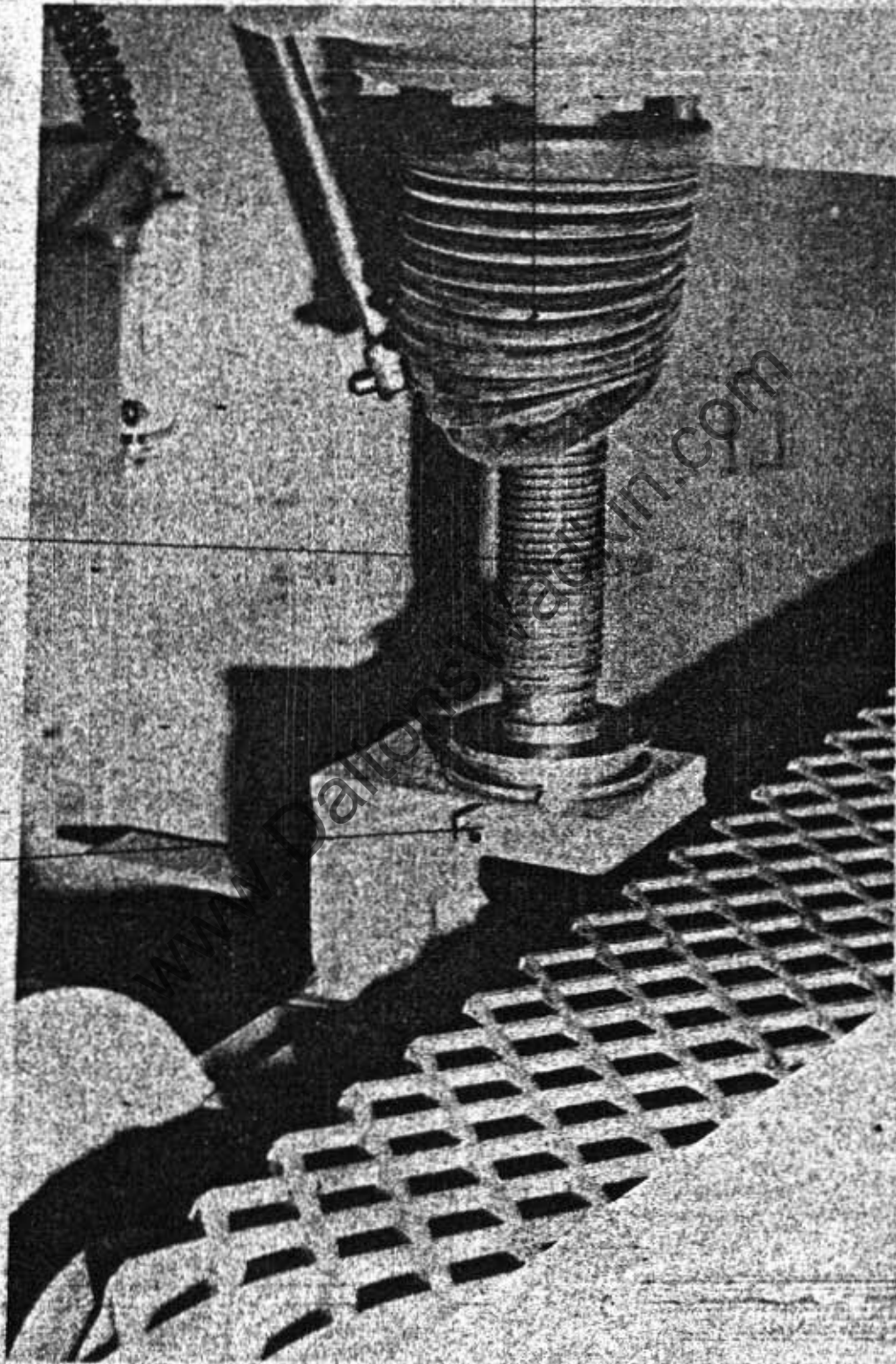


FIG. 15bis







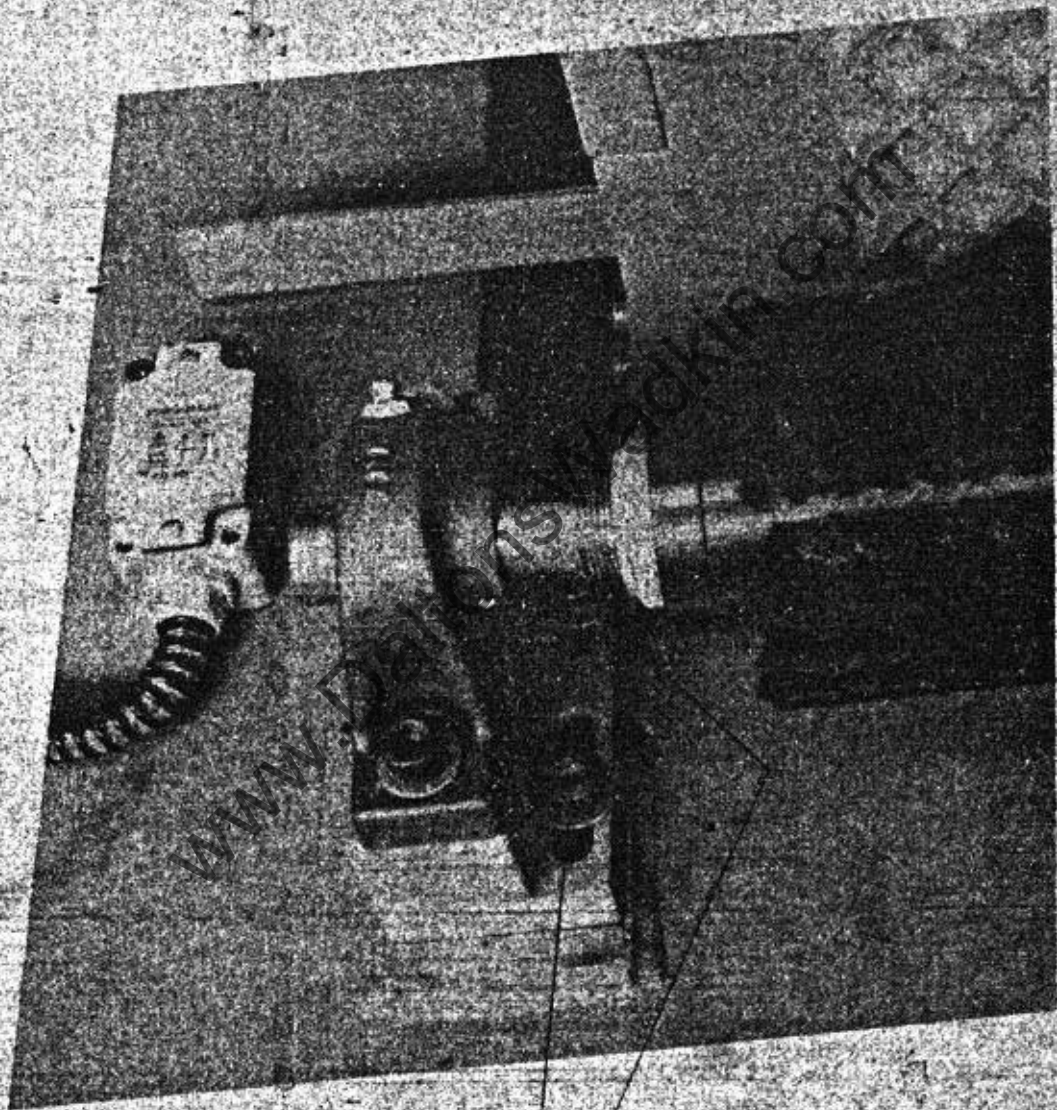


FIG 18

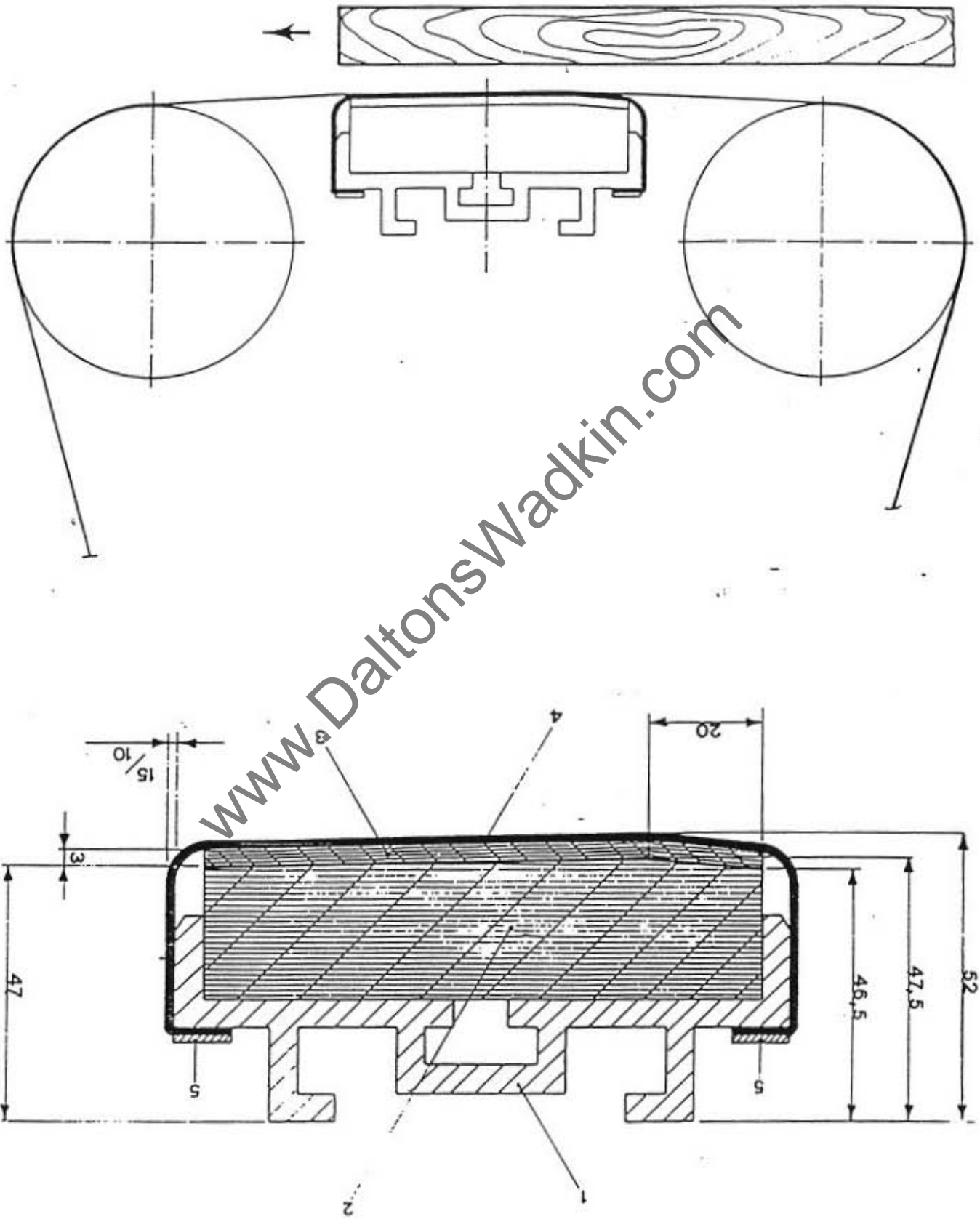
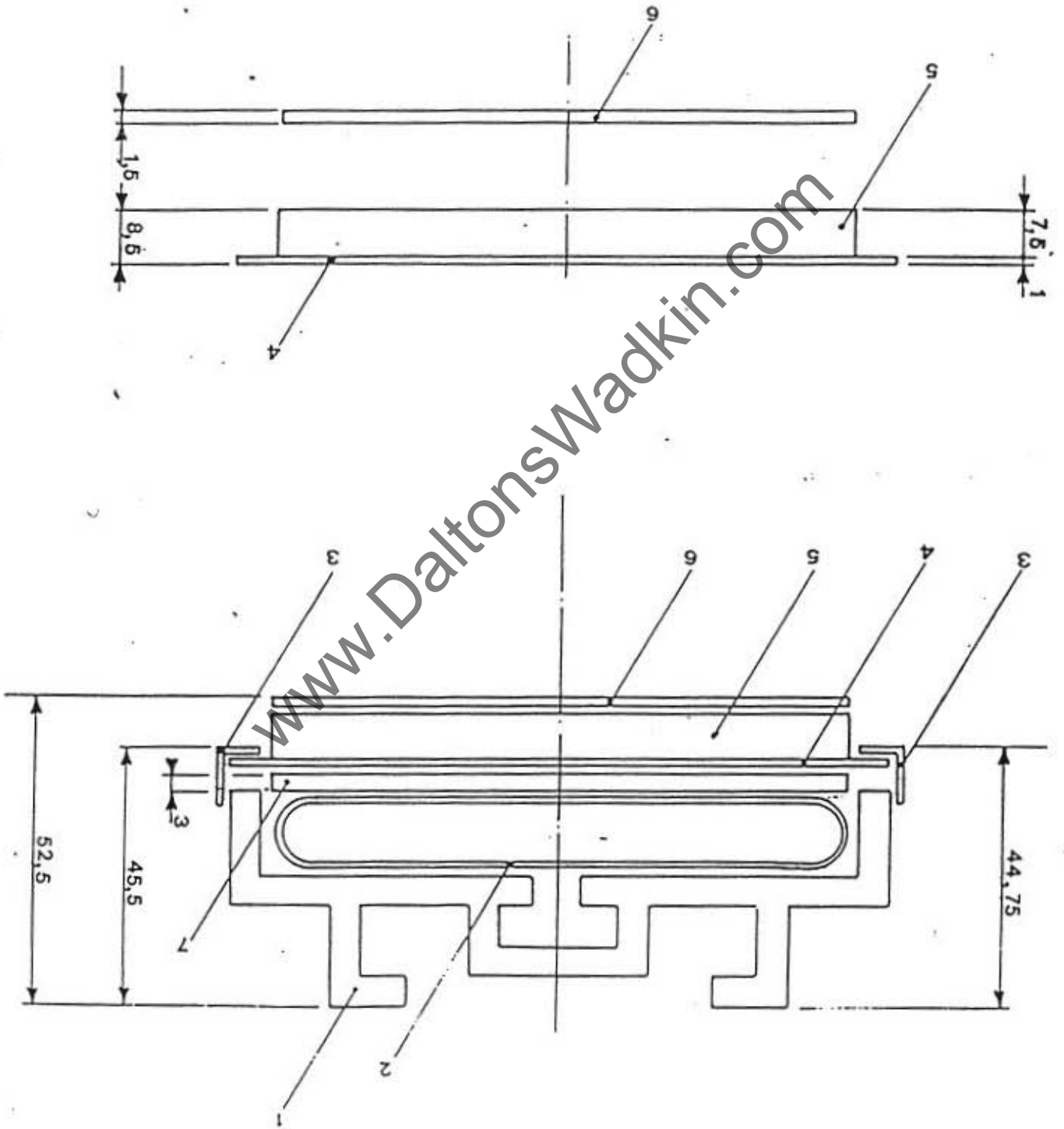
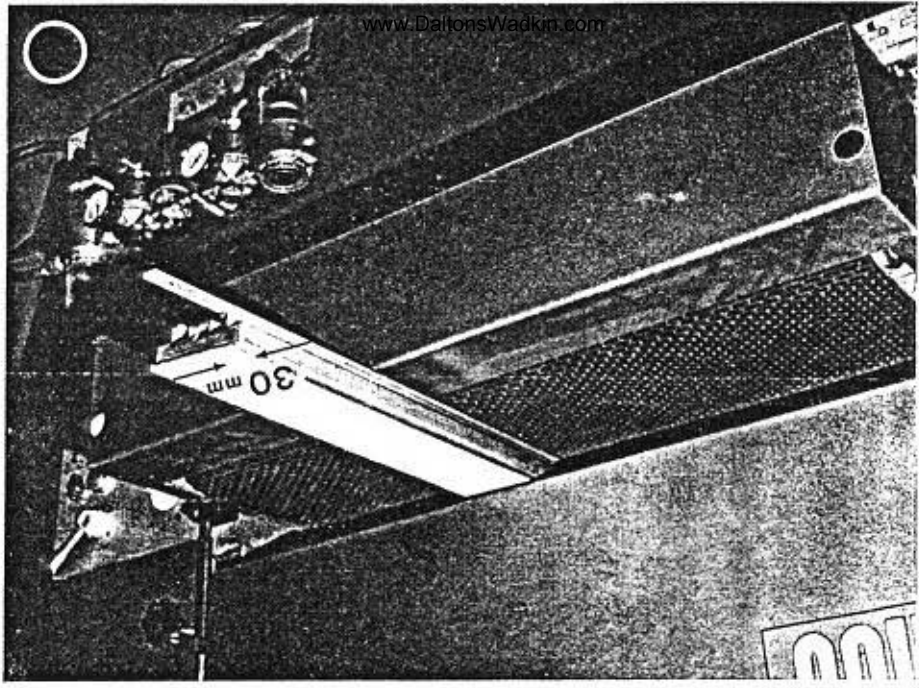


FIG. 19

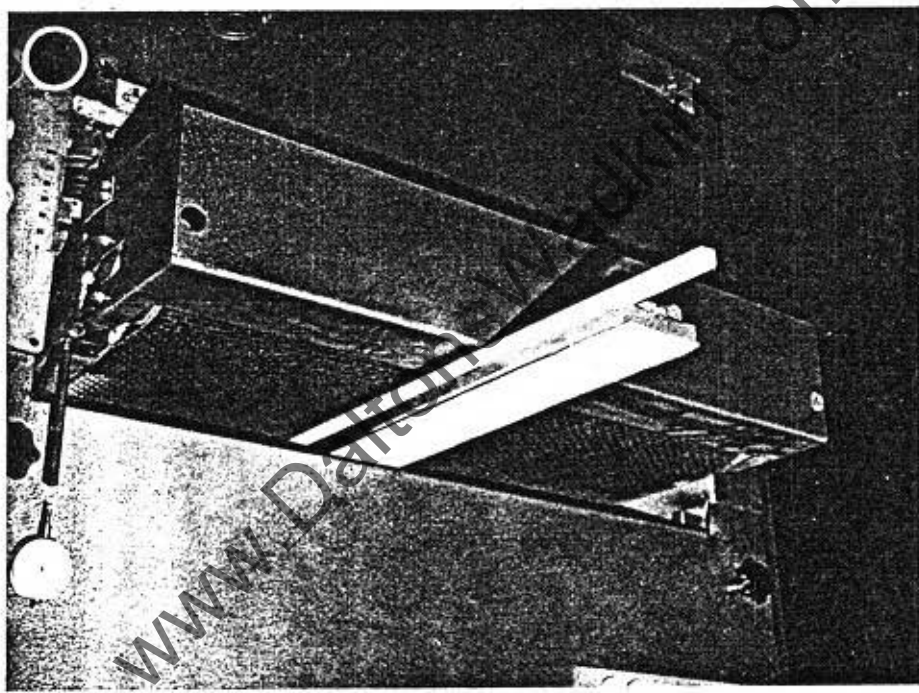


22

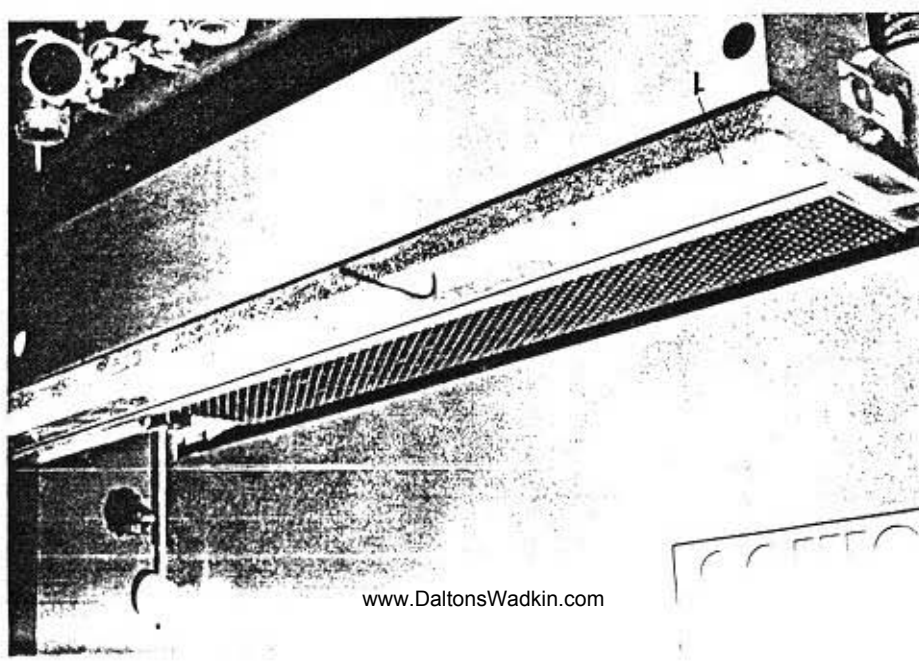


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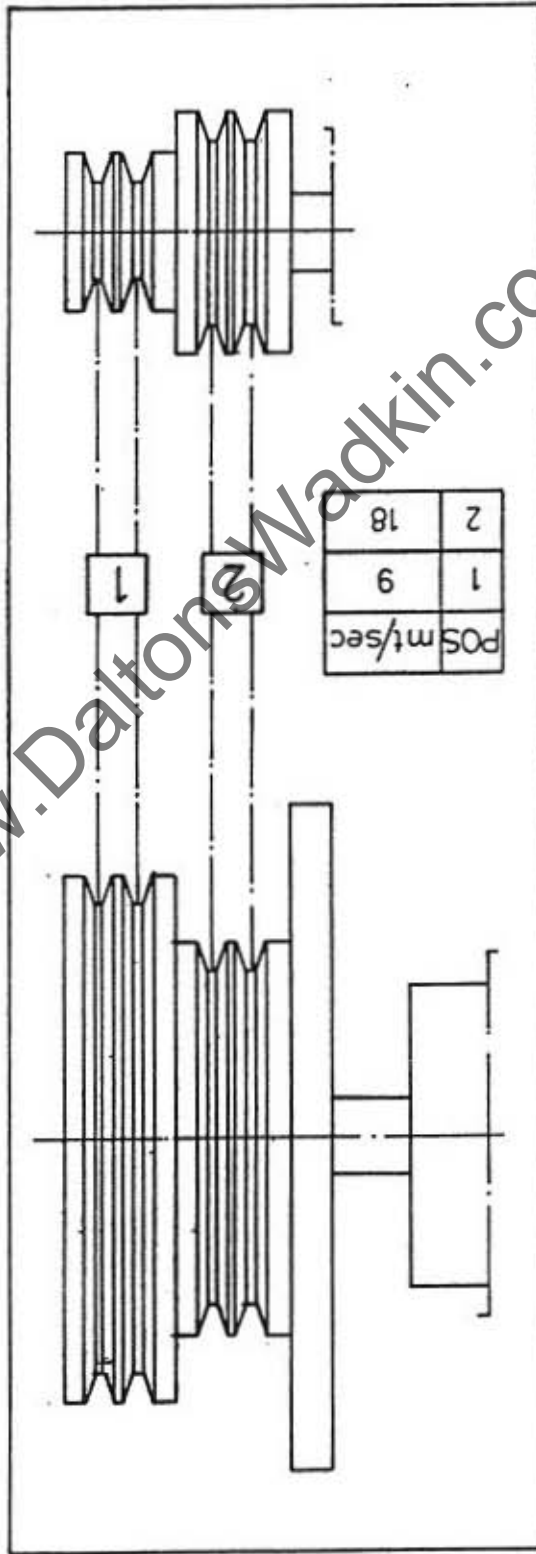


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FIG. 23



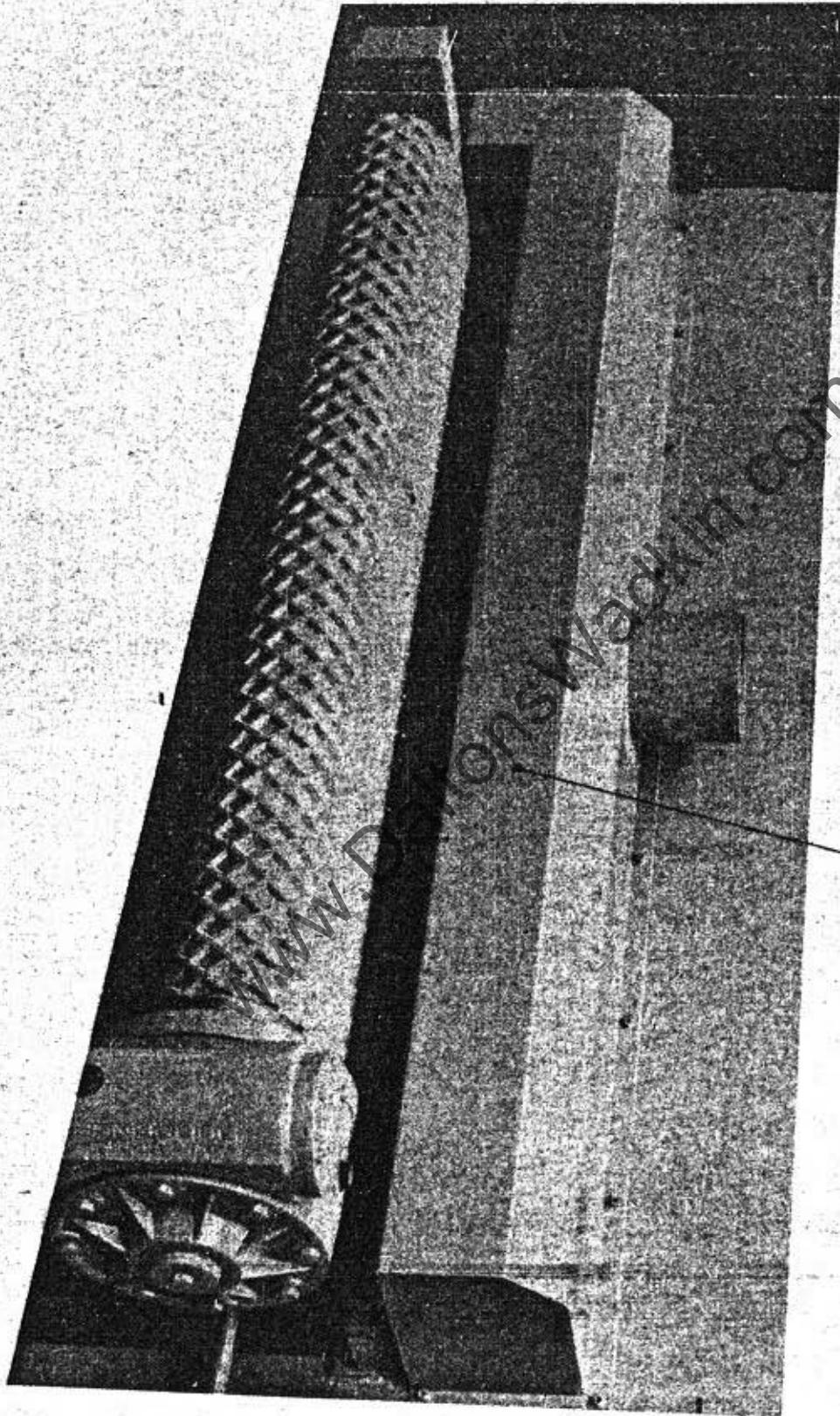
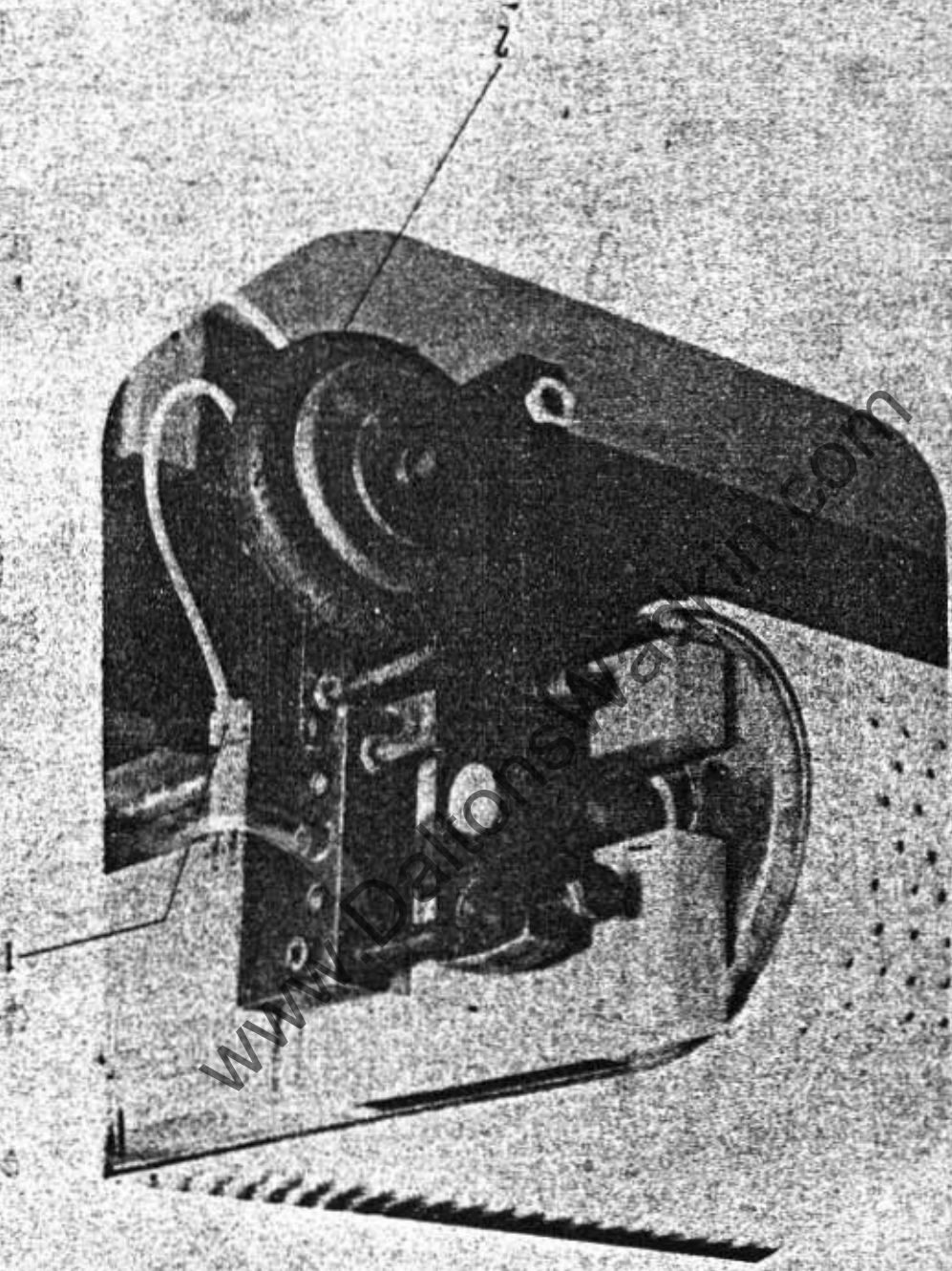
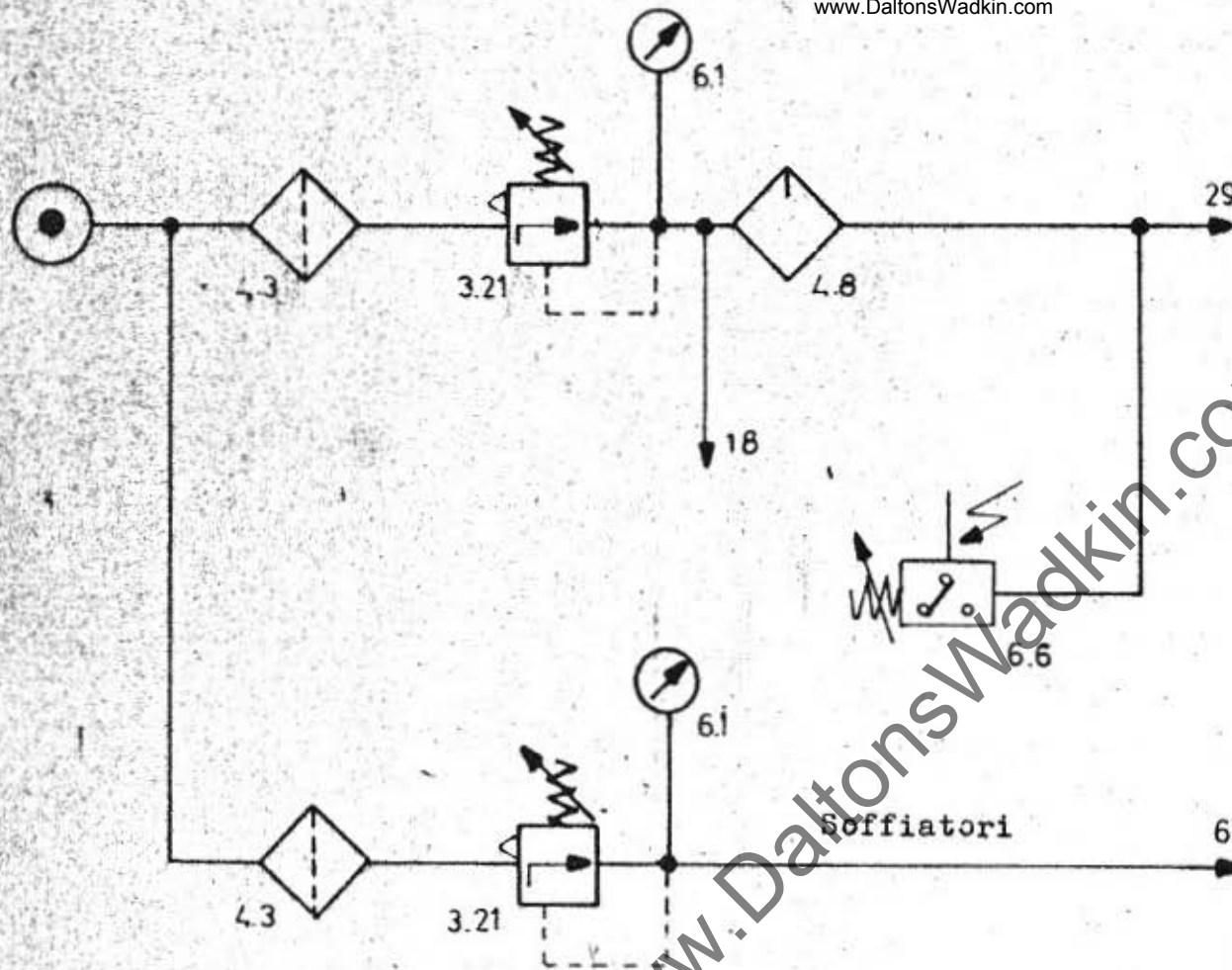


FIG. 25

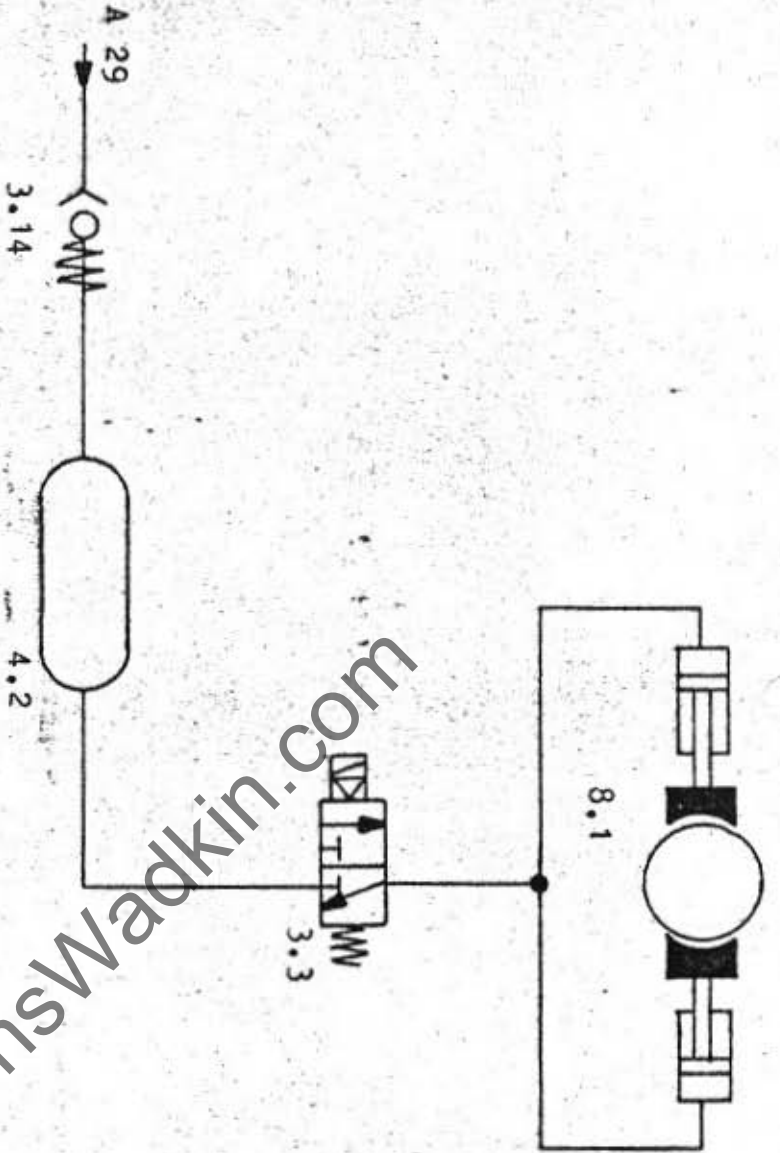






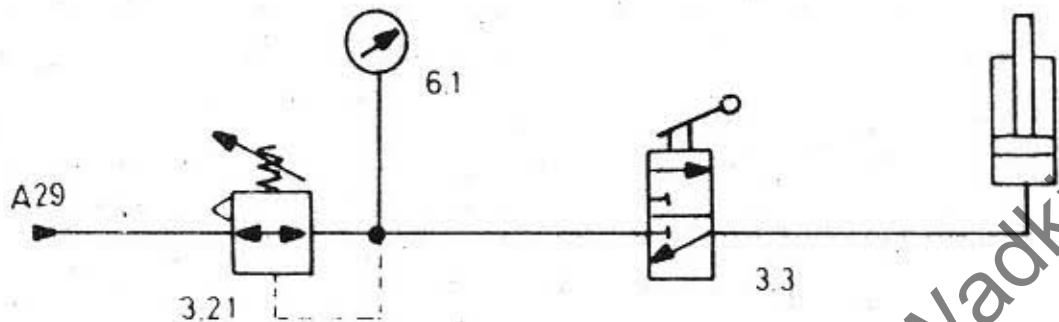
N. PART.	DENOMINAZIONE PART.	TIPO	COSTRUT.
4.3	FILTRO		
3.21	RIDUTTORE	B 11-M3	NORGREN
6.1	MANOMETRO	0 - 10 ATM	NORGREN
4.8	NEBULIZZATORE	L 11-200 MLR	NORGREN
6.6	PRESSOSTATO	B 25 D	FANTINI-COSMI

LC K A	CIRCUITO DI FILTRAGGIO	FOGLIO
BASAMENTO		A



LC K A	AZIONAMENTO FRENO	FOGLIO
FRENO		B

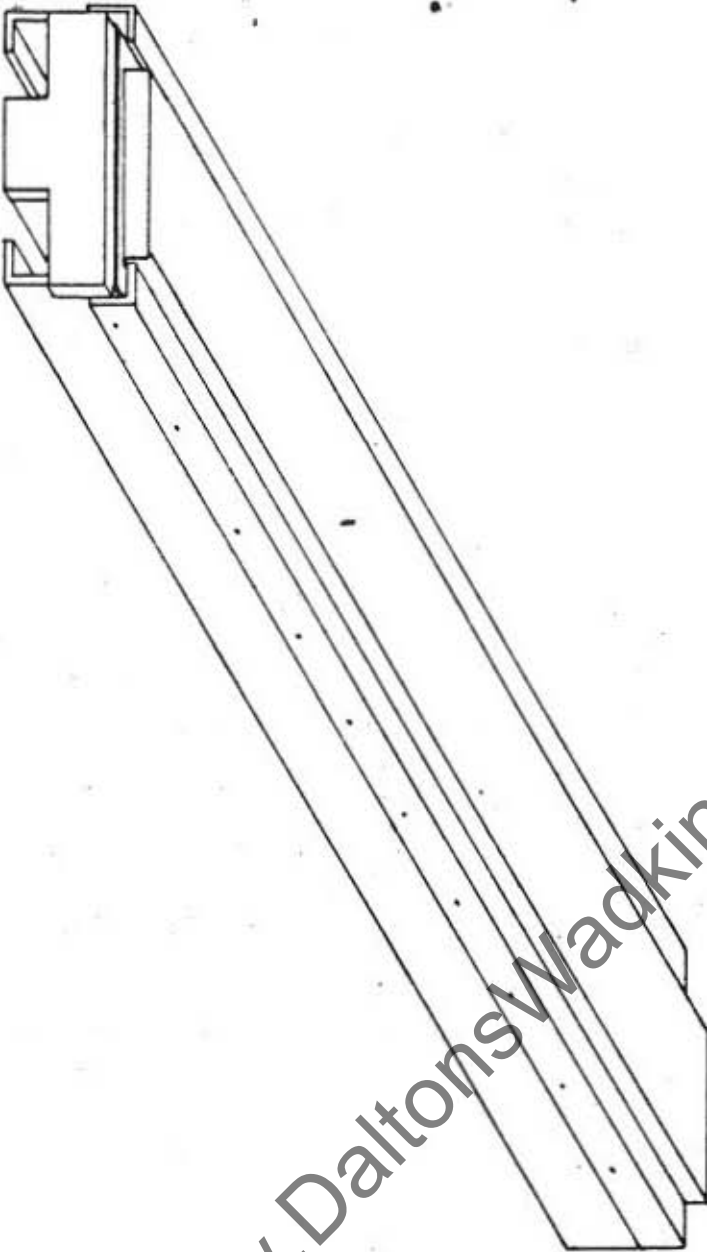
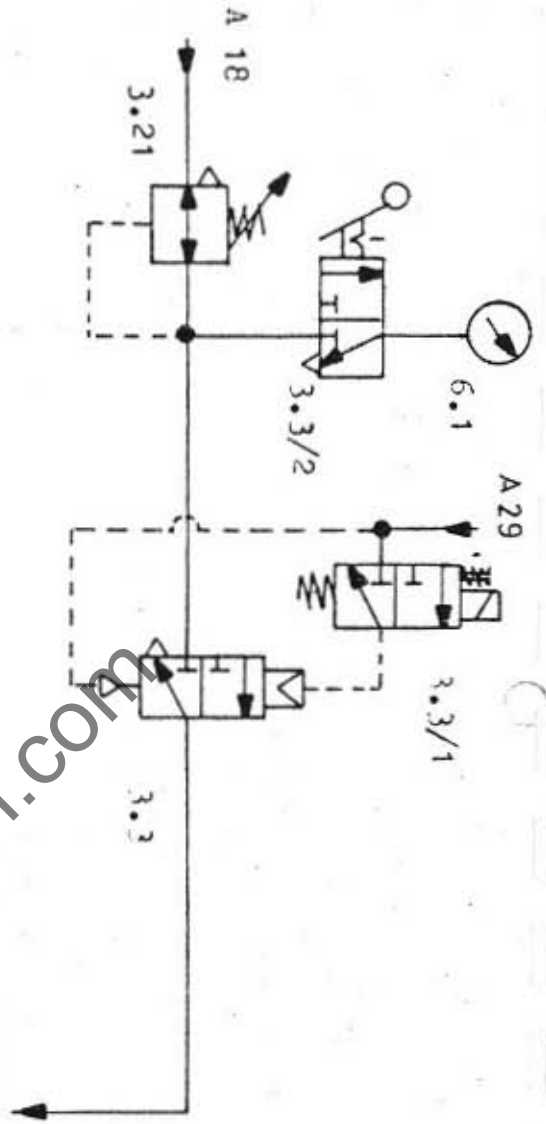
N. PART.	DENOMINAZIONE PART.	TIPO	COSTRUTTORE
3.14	VALVOIA UNIDIREZIONALE	UD / 4	BONESI
4.2	SERBATOIO		STEMAC
3.3	ELETTROVALVOIA	ES350/8/0 110-50	BONESI
8.1	FRENO		STEMAC



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N° PART.	DE NOMINAZIONE PART.	TIPO	COSTRUTT.
3.21	RIDUTTORE	RO 6 125 P.S.I.	NORGREN
6.1	MANOMETRO FLANGIATO	0-12 BAR	WICA
3.3	VALVOLA	105.32.627	PNEUMAX
2.1	CILINDRO		STEMAC

" LC KA "	TENSIONE NASTRO	FOGLIO
		C



LC KA

Confiaggio Tampone

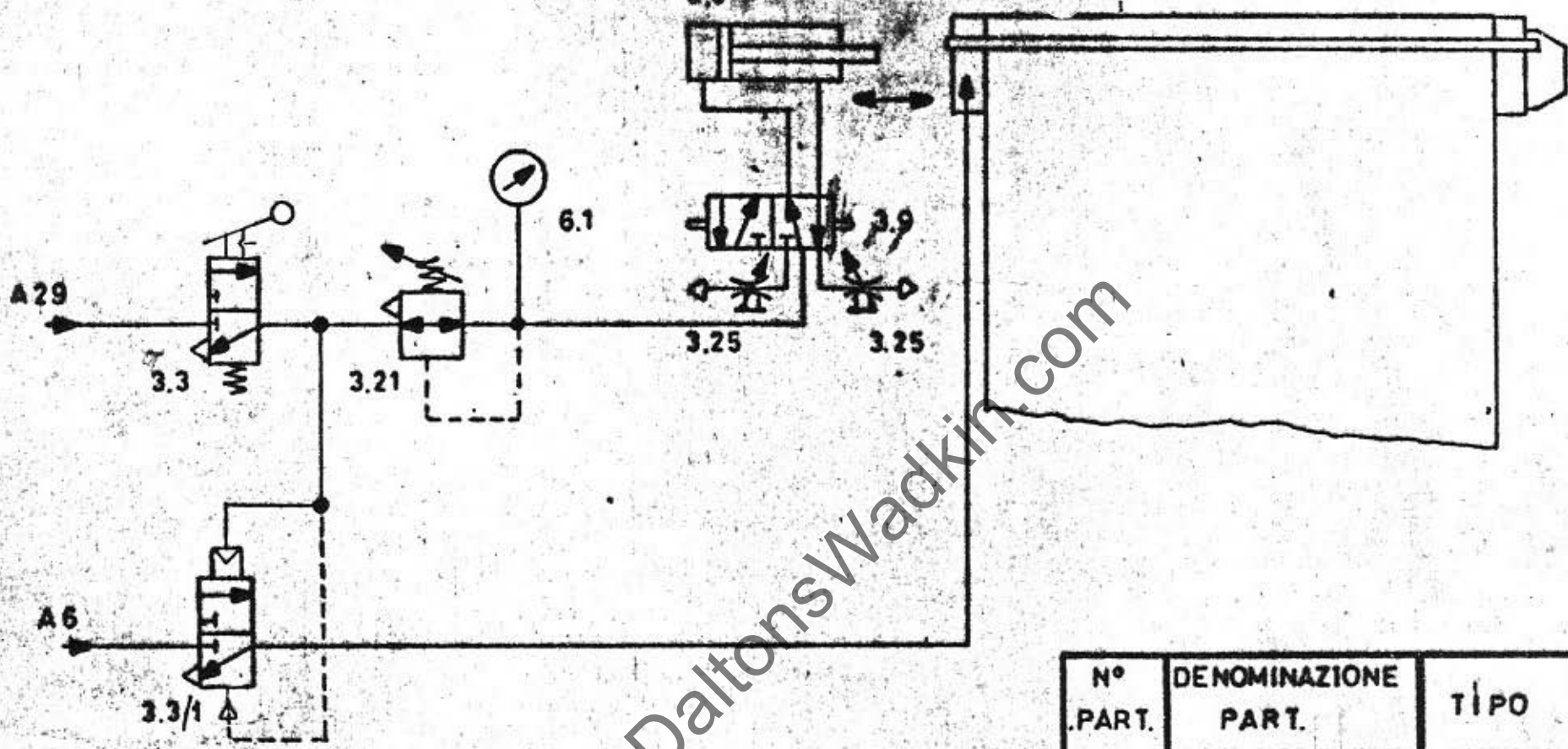
Foglio

TAMPONE TEMPORIZZATO

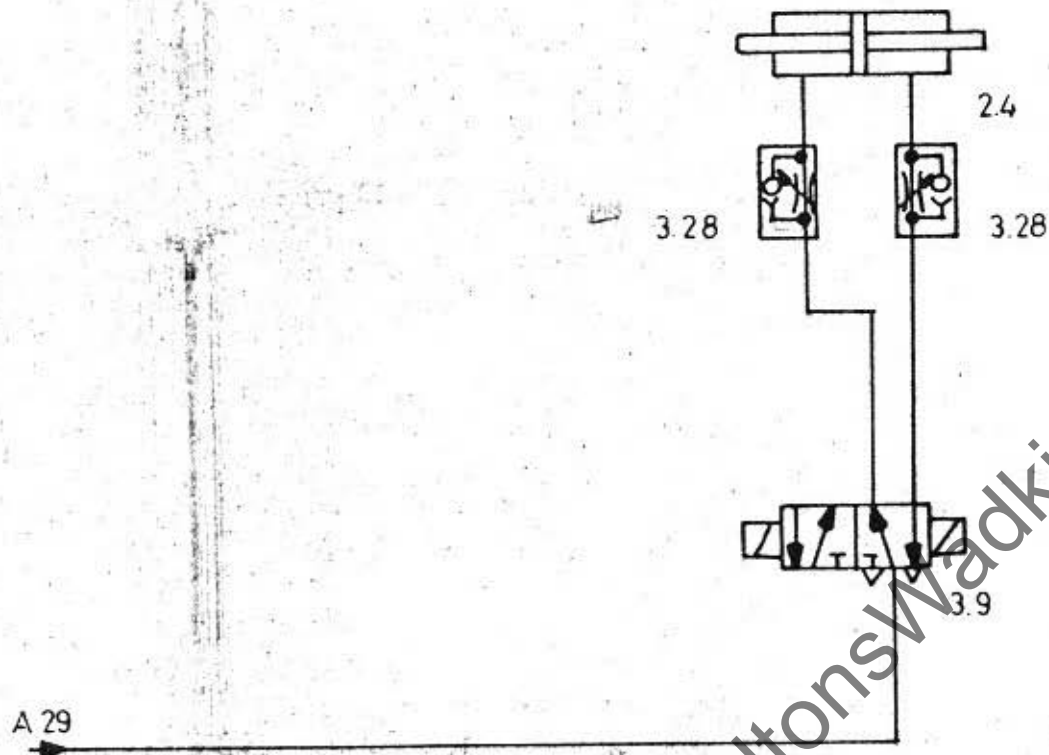
D

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N. PART.	DENOMINAZIONE PART.	TIPO	CONSERVITA'
3.21	RIDUTTORE	11400 2 BAR	NOBORGREN
3.3	VALVOLA DIFFERENZIALE	214.32.11 12	PN. U. A.
3.3/1	ELETTROVALVOLA	EC 38	PN. U. AX
3.3/2	MANOMETRO PIANGIATO	0 - 1 BAR	VICA
3.3/2	VALVOLA	105.32.62	PN. U. AX



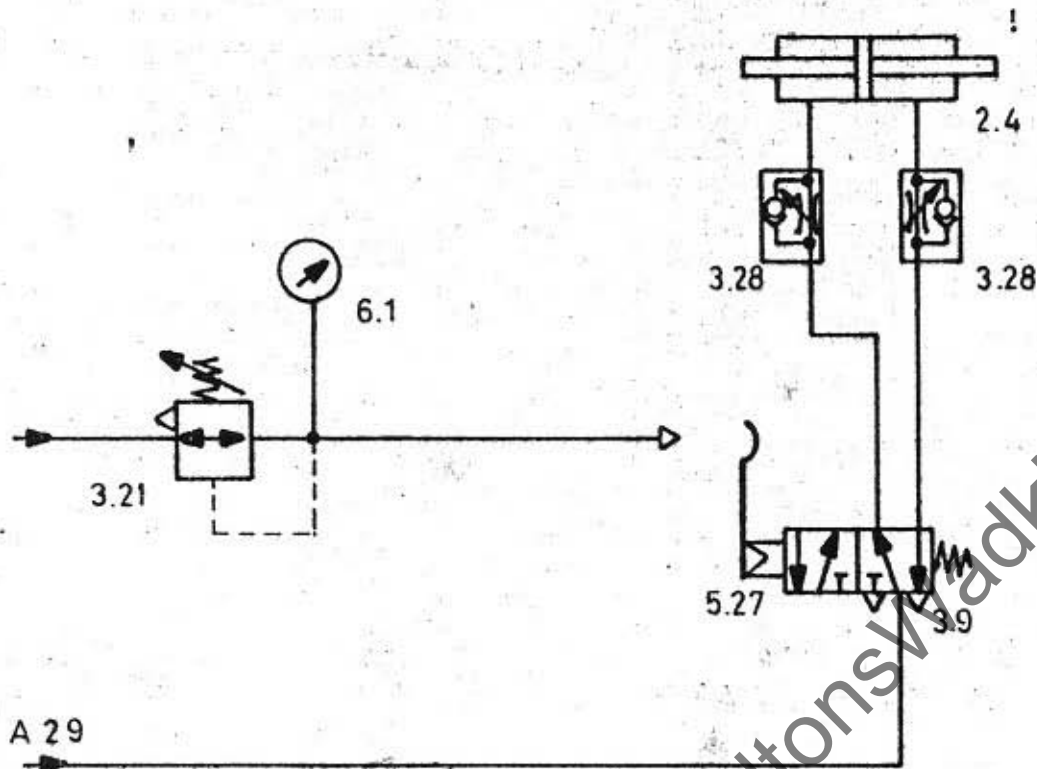
N° PART.	DENOMINAZIONE PART.	TIPO	CoSTRUTT.
3.3/1	VALVOLA	214/2.52.11.12	PNEUMAX
3.25	REGOLATORE DI SCARICO	R4/4S	BONESI
3.21	RIDUTTORE	R06 125 PSI.	NORGREN
3.9	VALVOLA	D402910	BONESI
2.3	CILINDRO SOFFIATORI	∅40-80	BONESI



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N° PART.	DENOMINAZIONE PART.	TIPO	COSTRUTT.
3.28	REGOLATORE DI FLUSSO	60118/1	PNEUMAX
3.9	VALVOLA OSCILLAZIONE	JMFH-5-1/8	BONESI
2.4	CILINDRO	CN AP 32/25	BONESI

" LC KA "	ELETTRONICA	FOGLIO
OSCILLAZIONE		F



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N° PART	DENOMINAZIONE PART	TIPO	COSTRUTT.
3.21	RIDUTTORE	RO 6 125 P.S.I.	NORGREN
3.28	REGOLATORE DI FLUSSO	60118/1	PNEUMAX
3.9	VALVOLA OSCILLAZIONE	RS-4-1/8	FESTO
6.1	MANOMETRO	0-10 BARS	WICA
2.4	CILINDRO	CN AP 32/25	BONESI

" LCKA "	PNEUMATICA	FOGLIO
OSCILLAZIONE		G