

USER'S MANUAL

Translation of the original instructions

Hot press

“XL”

Oil boiler with fabricated steel platens

XL/8
XL/8-S
XL/8-J



XL/6
XL/6-S
XL/6-J



ITALPRESSE

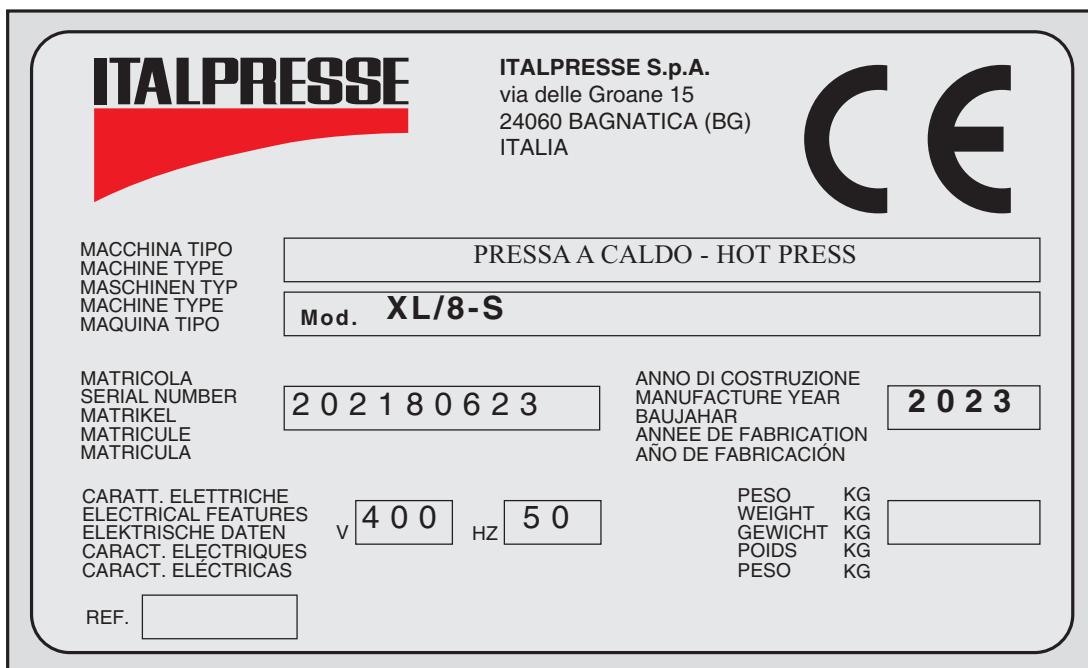
Dati di identificazione della macchina

Machine identification numbers

Données signalétiques de la machine

Kenndaten der Maschine

Datos de identificación de la maquina



Peso e dimensioni Weight and dimension Poids et Dimensions Gewicht und Abmessungen Peso y dimensiones
Peso / Weight / Poids / Gewicht / PesoKg. 5150
Lunghezza / Length / Longueur / Laenge / Larguramm. 4200
Larghezza / Width / Largeur / Breite / Anchuramm. 1800
Altezza / Height / Hauteur / Hoehe / Alturamm. 2200
pos. 25398
m. 804

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

La Direzione di ITALPRESSE S.p.A. considera tra i propri obiettivi aziendali il raggiungimento della Sicurezza intrinseca delle Macchine prodotte nel proprio Stabilimento di Bagnatica (BG). La Direttiva 2006/42/CE e successive modifiche indicano le procedure che devono essere messe in atto per garantire i requisiti essenziali ai fini della Sicurezza e della tutela della salute degli operatori e delle persone esposte.

L'applicazione dei criteri illustrati nella Direttiva, la verifica della loro efficacia ed il loro aggiornamento sono garantiti dalla Direzione Generale, e per lei dal Responsabile della Sicurezza, che a tal fine si avvale dei Servizi Tecnici che operano in collaborazione coi reparti di Produzione. Ai Servizi suddetti è attribuita l'autorità di identificare i problemi correlati con la Direttiva, di individuare la loro soluzione attraverso l'introduzione di azioni correttive e di verificarne l'applicazione.

Con l'approvazione della presente Dichiarazione la Direzione di ITALPRESSE S.p.A., e per lei il Responsabile della Sicurezza, si assume l'impegno di rendere operative le metodologie e di garantirne l'applicazione.

La Direzione

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

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

Company Management

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

La Direction d'ITALPRESSE S.p.A. place parmi les objectifs majeurs de l'entreprise la réalisation de la sécurité intrinsèque des machines produites dans son usine de Bagnatica (Bergame).

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

La Direction

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

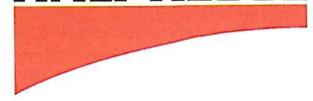
Die Direktion der ITALPRESSE S.p.A. sieht es als eins der Ziele des Unternehmens an, für die im eigenen Werk Bagnatica (BG) gebauten Maschinen eine vollkommene Sicherheit zu erreichen. Die EG-Richtlinie 2006/42/EG und nachfolgende Änderungen nennt die Verfahrensweisen, die als Grundvoraussetzungen zur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

Die Direktion

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

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

La Dirección



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

Oggetto della dichiarazione/Object of declaration/Sujet de la déclaration/Objekt der Erklärung/Objeto de la declaración

PRESSA A CALDO - HOT PRESS

Macchina modello/Model/Modèle/ Maschinenbezeichnung/Modelo	Matricola/Serial Number/Matricule/ Seriennummer/Matricula	Anno di fabbricazione/Manufacturing year/ Année de fabrication/Baujahr/Año de fabricación
XL/8-S	202180623	2023

DICHIARAZIONE CE di CONFORMITÀ

Si dichiara che la macchina oggetto della dichiarazione è conforme a quanto prescritto dalle direttive europee 2006/42/CE (Direttiva Macchine), 2014/30/UE (Direttiva Compatibilità Elettromagnetica), 2014/35/UE (Direttiva Bassa Tensione) e che Italpresse S.p.A. stessa ne costituisce il fascicolo tecnico.

EC DECLARATION OF CONFORMITY

We declare that the machinery object of the declaration suits the regulations of the European directives 2006/42/EC (Machinery Directive), 2014/30/EU (Electromagnetic Compatibility Directive), 2014/35/EU (Low Voltage Directive) and the relevant technical file is composed by Italpresse S.p.A.

DÉCLARATION CE DE CONFORMITÉ

On déclare que la machine objet de la déclaration est conforme à ce qui est prescrit par les directives européennes 2006/42/CE (Directive Machines), 2014/30/UE (Directive Compatibilité Électromagnétique), 2014/35/UE (Directive Basse Tension) et que Italpresse S.p.A. en constitue le dossier technique.

EG-KONFORMITÄTSERKLÄRUNG

Hiermit erklären wir, daß die von dieser Erklärung erfasste Maschine der Anforderungen gemäß der EU-Richtlinien 2006/42/EG (Maschinenrichtlinie), 2014/30/EU (Richtlinie zur elektromagnetische Verträglichkeit), 2014/35/EU (Niederspannungsrichtlinie) und Italpresse S.p.A. selbst, die bezügliche technische Dokumentation erzeugt.

DECLARACIÓN CE DE CONFORMIDAD

Se declara que la máquina objeto de la declaración es de conformidad según lo prescripto por las directivas europeas 2006/42/CE (Directiva Máquinas), 2014/30/UE (Directiva Compatibilidad Electromagnética), 2014/35/UE (Directiva de Baja Tensión) y que la misma Italpresse S.p.A. constituye el expediente técnico.

Bagnatica, 15/06/2023

L'Amministratore Delegato Chief Executive Officer - Der
 Geschäftsführer - Administrateur délégué - El administrador delegado
 Paolo Sala

Precautions and safety instructions:

- Before starting up, operating, performing any maintenance or carrying out any other operation on the machine, read the user's manual carefully. This manual should always be kept close at hand.
- In no circumstances use the machine other than in the ways described in this manual. The manufacturer accepts no responsibility for damage to any persons or property deriving from failure to observe the safety regulations.
- The operator should be in possession of all the necessary prerequisites for the use of a complex machine.
- Use all the necessary precautions (overalls, protective gloves, etc) to avoid burns from the hot working surfaces of the machine (the temperature can reach 110°C approx).
- Always wear the robust work boots as prescribed by local accident prevention regulations.
- Do not allow any unauthorised personnel to repair or perform any maintenance or other operations of any kind on the machine.
- The transport, installation and assembly operations should be carried out only by personnel with the necessary technical competence and experience in all the sectors involved.
- All operations on the electrical system should be carried out only by specialist electricians.
- The working area surrounding the machine should always be kept clean and unobstructed, for the sake of immediate, easy access to the electrical commands.
- The symbols below, used in the manual, warn the operator of the presence of risk factors in carrying out specific operations on the machine.



NEVER PUT LIMBS OR PARTS OF THE BODY BETWEEN THE PRESS PLATENS WHILE THEY ARE MOVING OR IF THE PLATENS SEEM TO BE OUT OF THEIR PROPER NORMAL POSITION!

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



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



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

SAFETY LABELS: the following safety labels are positioned on the machine and must not be removed by no means.



PERICOLO (generale)
DANGER (general)
PELIGRO
DANGER
GEFAHR



PUNTI DI AGGANCIO
RIGGING POINTS
PUNTOS DE ENGANCHE
POINTS D'ACCROCHAGE
ANHAKPUNKTE



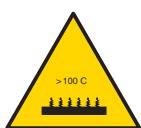
USARE I GUANTI
USE GLOVES
USAR GUANTES
PORTER DES GANTS
HANDSCHUHE TRAGEN



TENSIONE
HIGH VOLTAGE
TENSIÓN
TENSION
SPANNUNG



SCHIACCIAMENTO
RISK OF CRUSHING
APLASTAMIENTO
ECRASEMENT
QUETSCHUNG



ATTENZIONE PIANI A TEMPERATURA > 100°C
ATTENTION! LEVELS AT TEMPERATURE > 100°C
ATENCIÓN PLATOS CON TEMPERATURA > DE 100° C
ATTENTION: TABLES A TEMPERATURE > 100°C
ACHTUNG: TEMPERATUR DER PRESSENEBENEN > 100°C



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0. General information

This user's manual was drawn up by the manufacturer and is an integral part of the machine accessories.

The information contained herein should be read by qualified personnel only.



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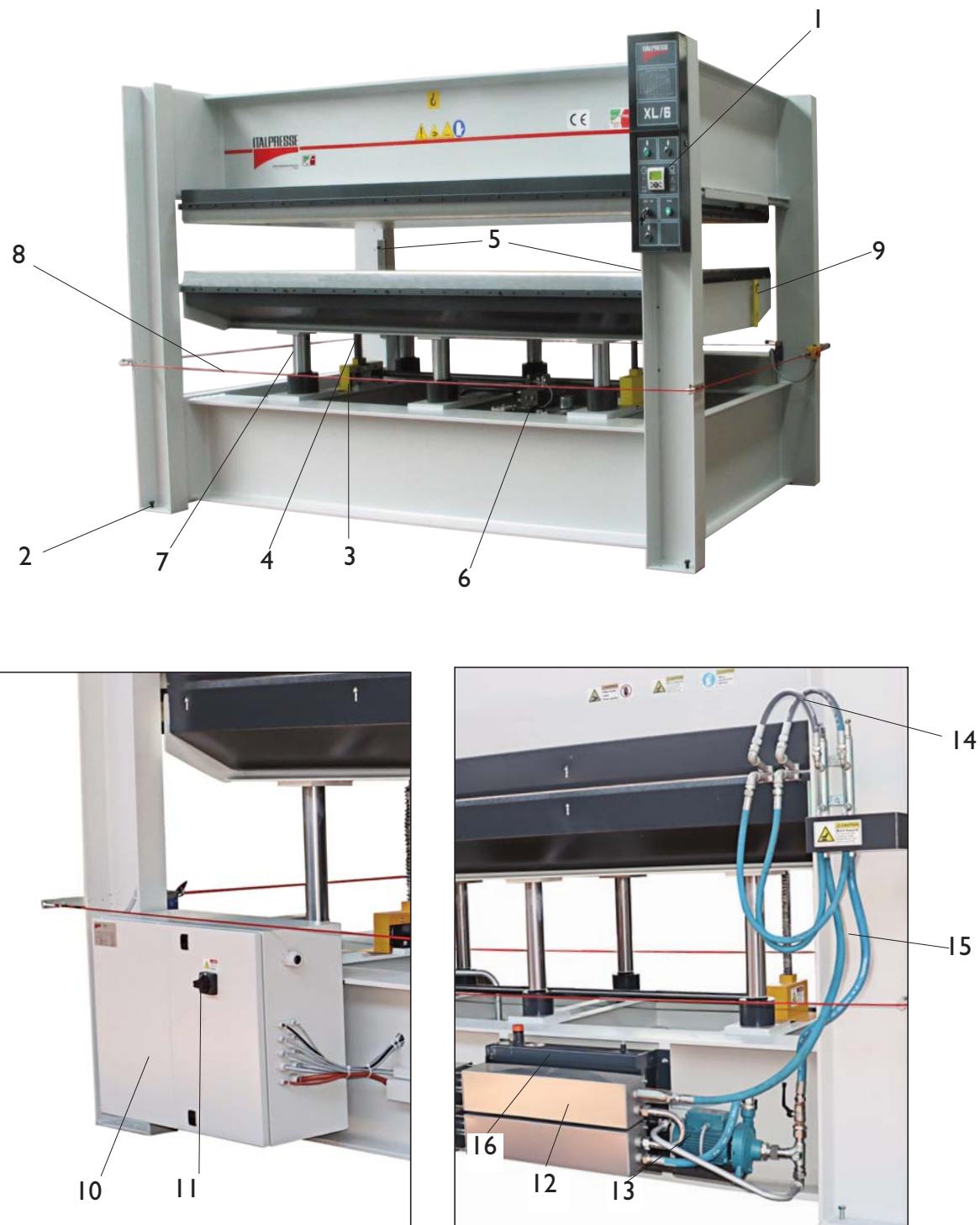
0.1 Products that can be obtained

The machine is designed to laminate particle boards, MDF or doors.

The overlay material may be:

- Veneer
- Plastic laminates (HPL)

0.2 General diagram of the machine



1 - Control board

2 - Press level line adjustment screws

3 - Rack support

4 - Rack

5 - Mobile platen guides

6 - Central hydraulic unit

7 - Cylinder

8 - Safety rope

9 - Latches for platen locking

10 - Electrical supply box

11 - Main switch "IG"

12 - Thermal oil boiler

13 - Thermal oil circulation pump

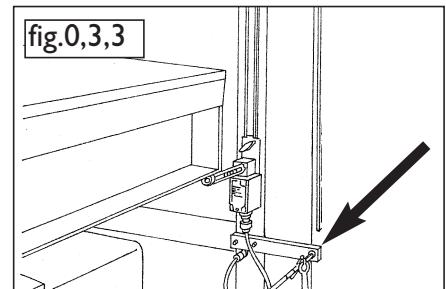
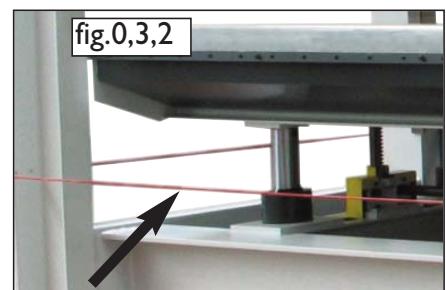
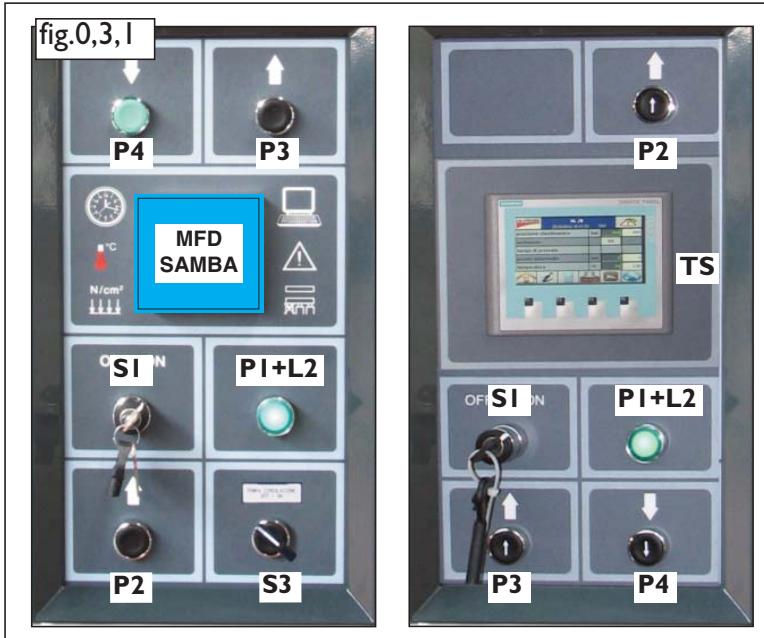
14 - Upper platen thermal oil hoses

15 - Lower platen thermal oil hoses

16 - Thermal oil expansion tank

0.3 safety devices

- **Two-hands press closure command:** this guarantees the operator safety during the closing movement of the mobile platen of the press (fig.0.3.1 P2-P3).



- **Safety rope** this protects personnel exposed to the press closing movement.

If this rope is pushed or pulled during the press closing, the mobile platen will stop and then it will descend for about two centimeters; if the rope is pushed or pulled during the press opening, the mobile platen will stop.

If the rope is too relaxed or too tight, the press stops (EMERGENCY / STOP).

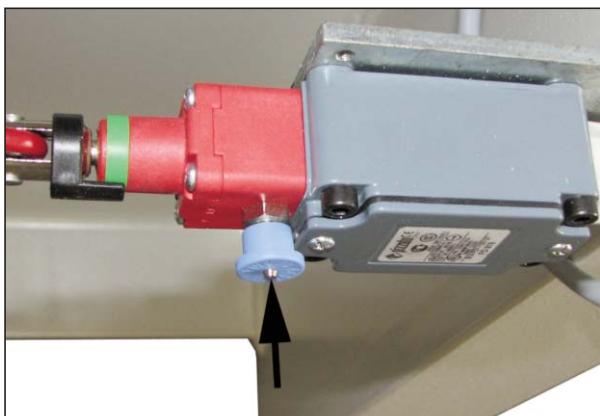
In this case the tension of the rope must be adjusted by proper device (fig. 0.3.3).

Reset:

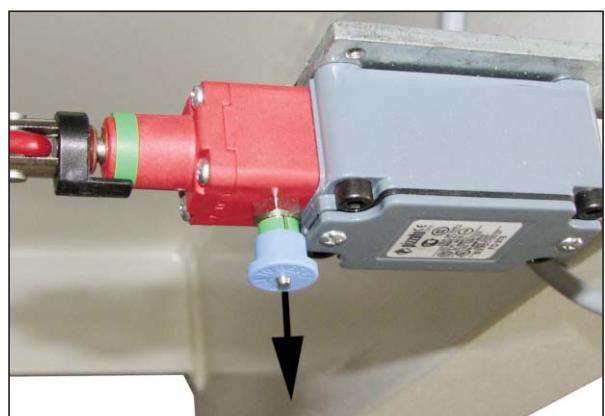
- remove the cause of the emergency situation.
- Rerarm the limit switch "RESET"
- Press the reset button "PI+L2"

At this point, the reset has been made and the machine can start to work again.

URGENCY



RESET



- Safety brackets

These brackets/letches are used to block the platen in a closed position. When performing maintenance, cleaning, inspection or any other operation that requires access to the parts of the press under the mobile platen, always close the platen completely and put these brackets in the “locked position”.

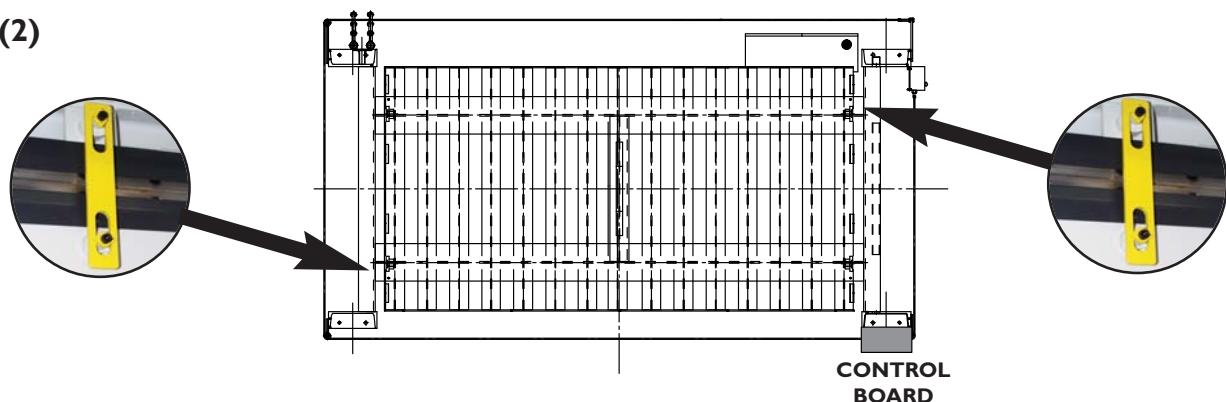
LOCKED POSITION



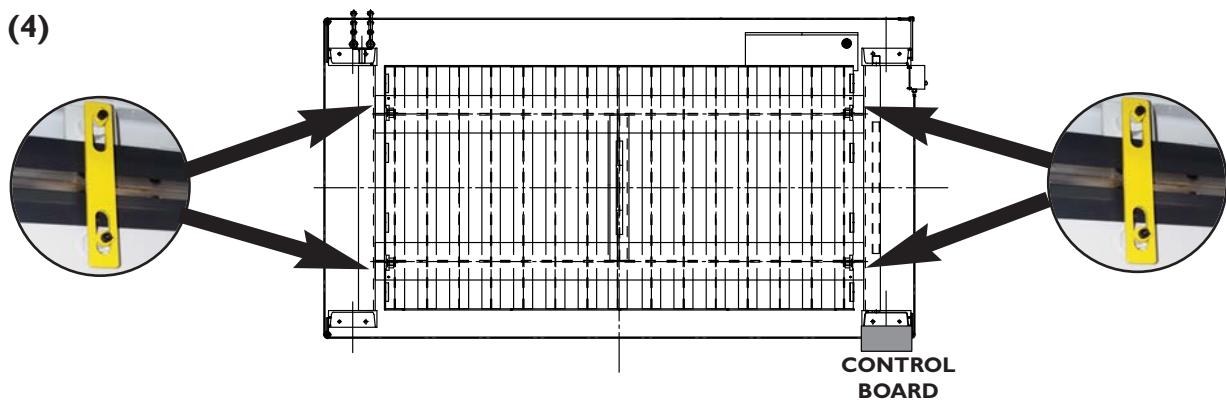
UNLOCKED POSITION



(2)



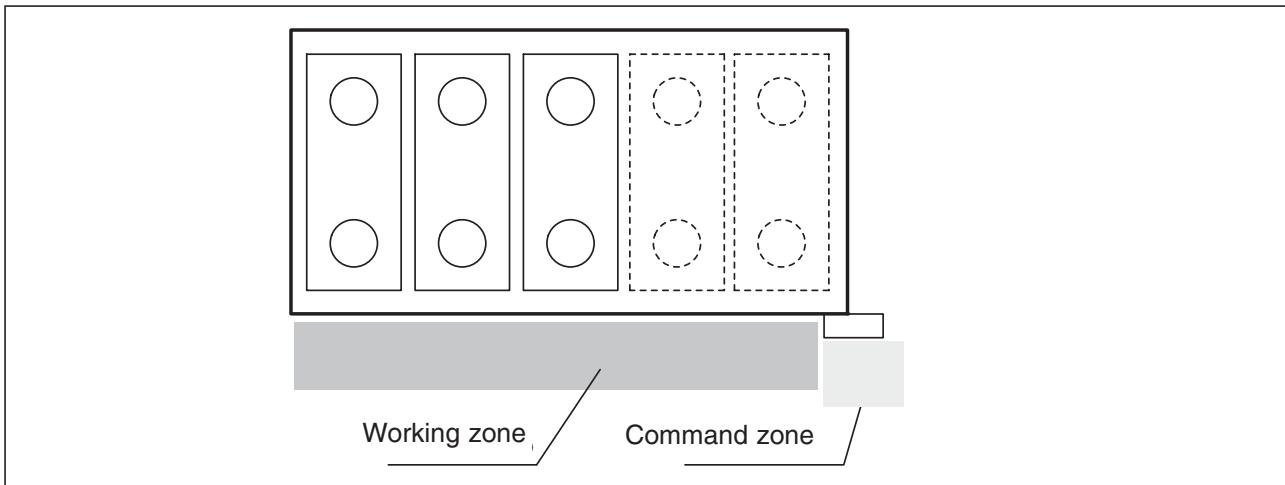
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0.4 Operator's working zone



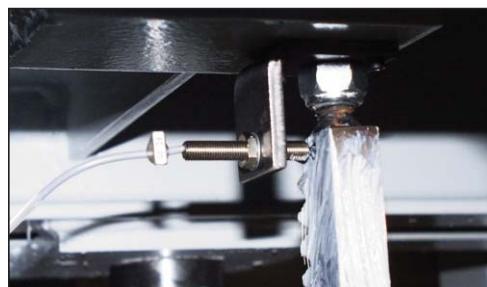
IMPORTANT: this machine is designed to be used by a single operator.



0.5 Flatness control devices (Optional)

THIS DEVICE GUARANTEES THE CONSTANT FLATNESS BETWEEN THE MOBILE PLATEN AND THE FIXED ONE.

IN CASE OF AN ANOMALY THIS DEVICE WILL STOP THE MACHINE.



0.6 Lockout procedure

This is a suggested procedure to lock-out the machine before performing any maintenance, cleaning, inspection or other operation which are not regular working operations on the press.

- a) announce lockout to other personnel.
- b) turn power OFF at the main panel
- c) lockout the power in OFF position
- d) put the key in your pocket
- e) clear the machine of all other personnel
- f) test lockout by hitting the RUN button
- g) block, chain or release stored energy sources
- h) clear the machine of the personnel before restarting the machine
- i) take the key from your pocket
- j) unlock the lockout device
- k) turn power ON at the main panel
- l) announce that the machine is ON to the other personnel.

I. Packaging/transport

There are normally three methods of shipping the machine to the user:

- in packing wooden cases
- in overseas containers
- by truck

Transport in wooden cases:

Packaging features:

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

Lifting:



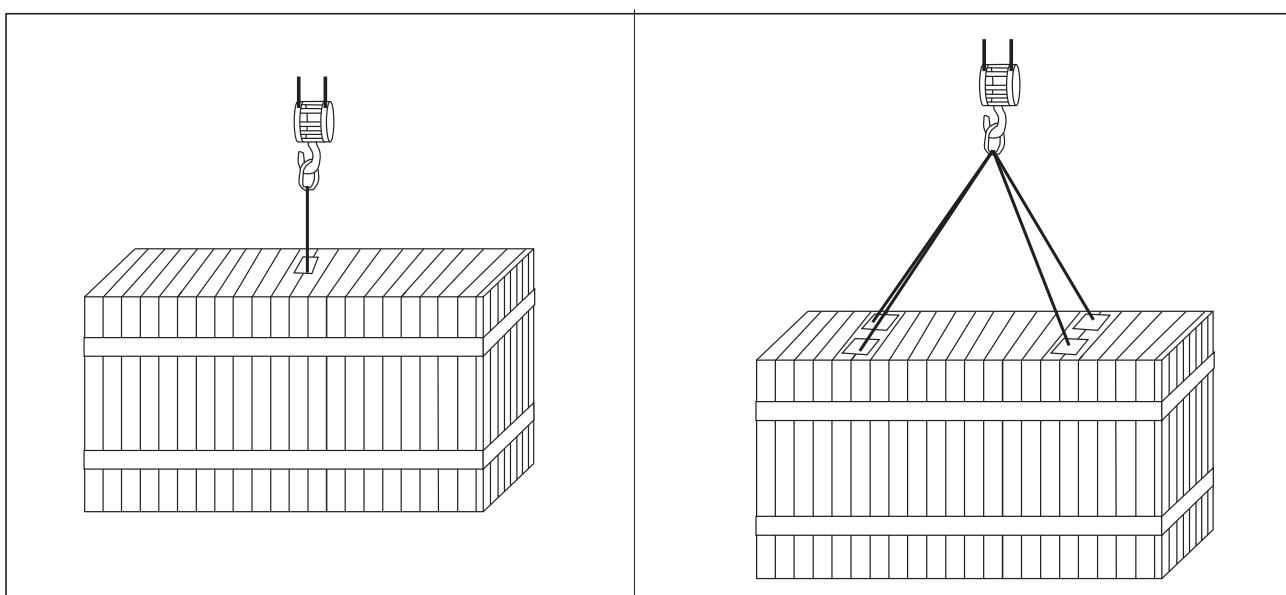
Before lifting the machine with the packaging, please check carefully its weight as set out in table I of chapter 2!

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



DO NOT STEP ON TOP OF THE CASE!

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



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



!DO NOT USE STRAPS OR FORK LIFTS TO MOVE THE CASE.

Opening the case:

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

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

Container or road transport:

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



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

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

2 Rigging/lifting methods

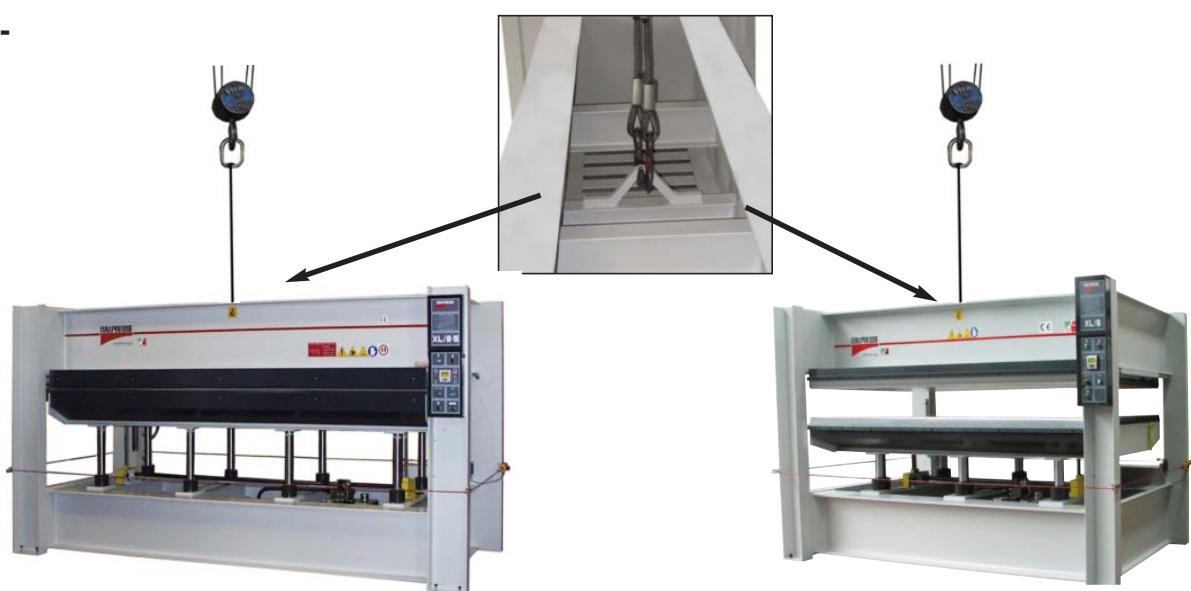


The lifting and rigging of the machine should be carried out by personnel trained and specialised in this type of operation.

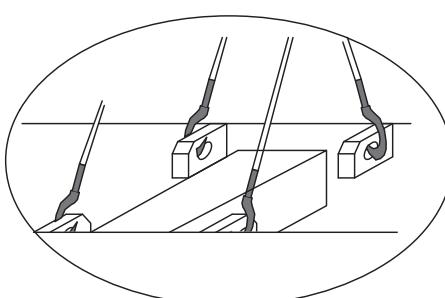
The operations can be carried out only by overhead crane or crane, proceeding as described below and with reference to picture below

- use steel chains or ropes with hooks, of the same length and of a suitable capacity;
- hook the steel chains or ropes to an overhead crane or crane, proceeding as described below and with reference to picture below
- position the hooks at the lifting points of the machine situated on the upper part;
- raise slowly and move with the maximum caution, avoiding even minimum swing, and position the machine in its operating zone.

-1-



-2-



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

3. Installation

3.1 Installation requirements

3.1.1 Ambient requirements

- Air room temperature: the machine has been designed to work properly between +15°C (59 °F) and +40°C (104 °F) air temperature.

OBS: average temperature referred to 24 hours has not to be more than + 35°C (95 °F).

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

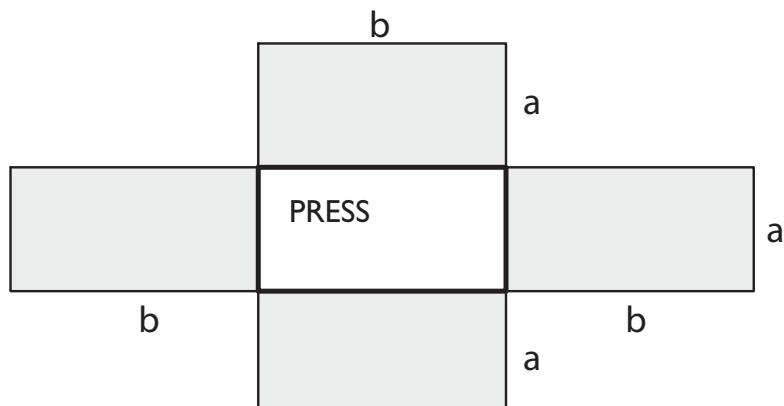
- Altitude: the machine is designed to operate at up to 1000 m above sea level.

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

3.1.2 Minimum space for use and maintenance

The overall dimensions of the machine are shown in table I of chapter 2. The minimum space around the machine for its operation, by considering the possibility of using all four sides to insert the materials in the press opening, is shown in picture 3.1.2.

The maintenance operations don't require any additional space beside the one needed for the normal use of the machine.



3.1.3 Flooring requirements

The floor should be of the industrial type with a minimum resistance of 7 Kg/cm₂ (100 psi). The floor should be carefully levelled.

3.1.4 Electric power supply

The electric system characteristic are the following:

SEE ELECTRICAL DIAGRAM

WARNING:

The voltage peaks in the electric network can never be more than +/- 10% of the voltage indicated on the plate.

Check the electric network voltage with the proper device; whenever the change is more than +/- 10% of the voltage indicated on the plate, please contact our Technical Assistance Department.



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

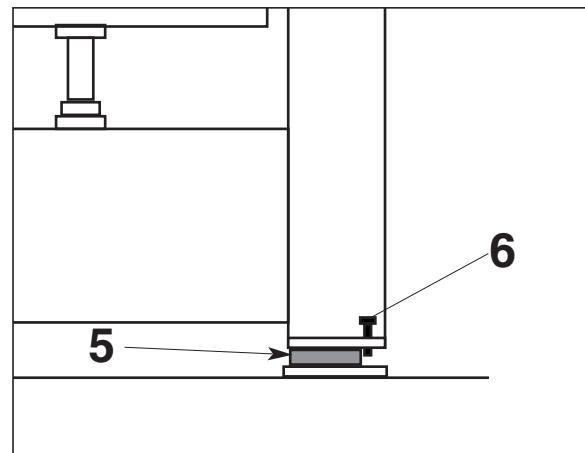
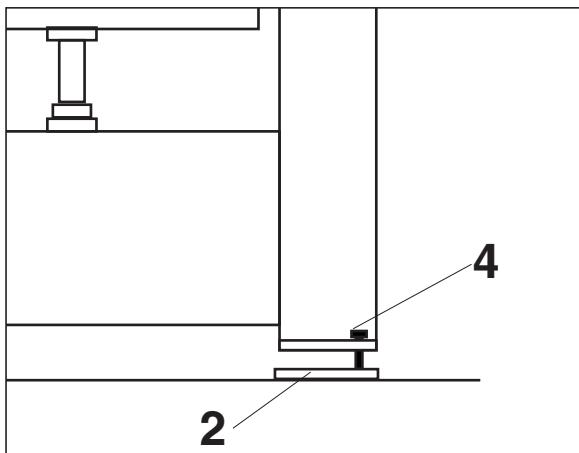
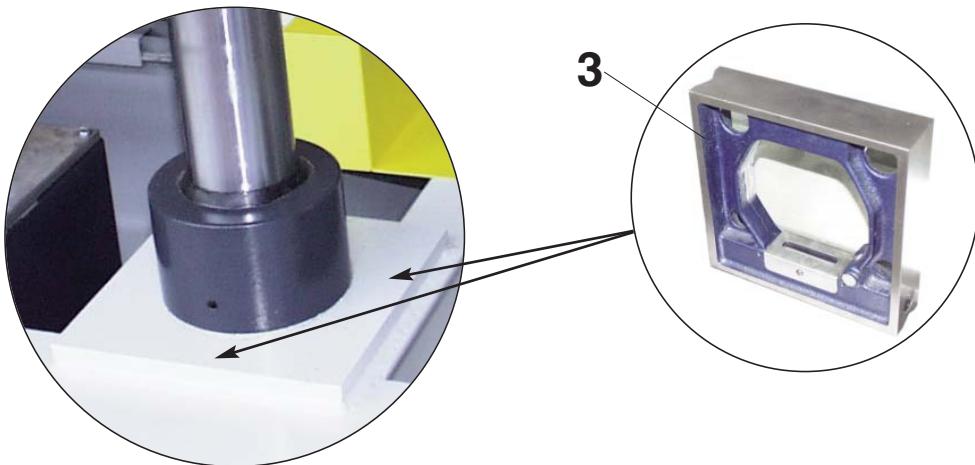
3.2 Installation and connections

This paragraph describes the following operations:

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

3.2.1 Levelling of the press

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





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-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

3.2.2 Electrical connection



Make sure that the power supply voltage is the same as indicated in the plate placed inside the electrical panel (see chapter 3.1.4.). To connect the electrical panel, use a flameproof cable with three phase conductors and the ground cable (usually yellow and green cable).

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



MAKE SURE THAT THE CABLE IS NOT UNDER POWER

- Set the main switch IG to position “0” and open the two locks of the electrical panel door by using the keys “2”;
- insert the cable in the electrical cabinet through the cable press “1”.

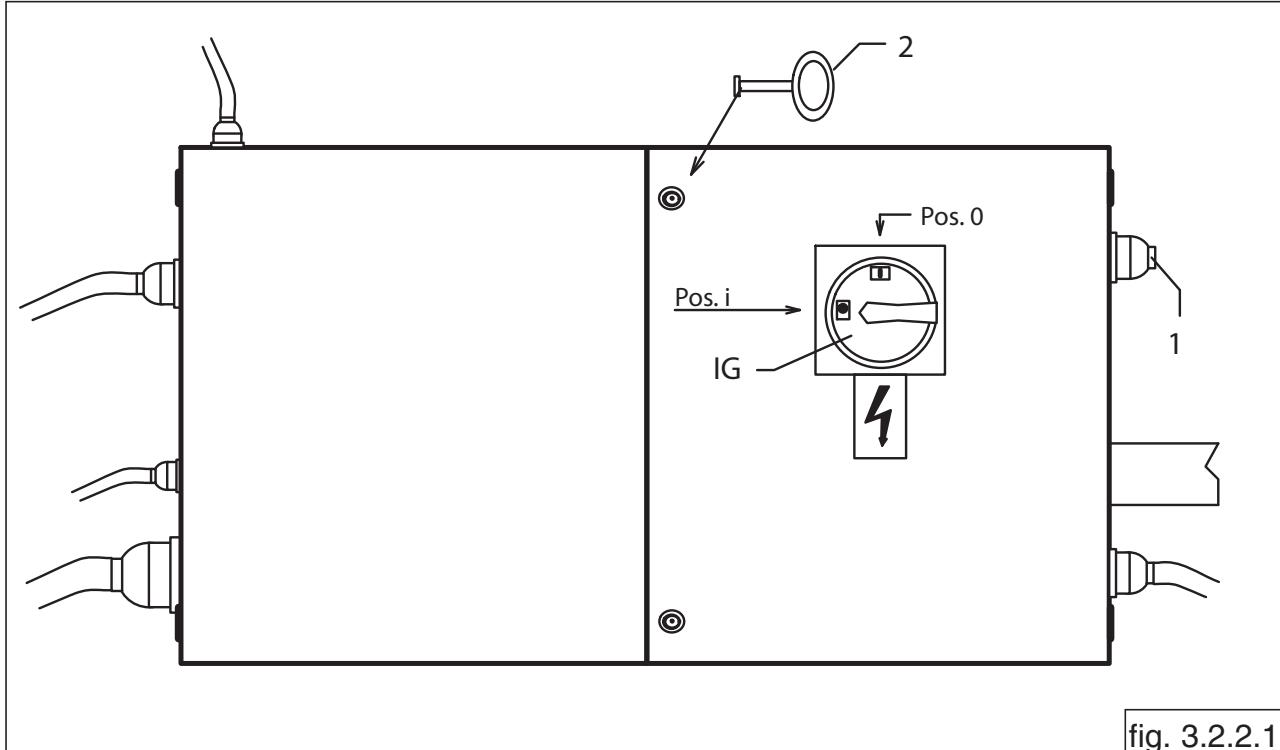
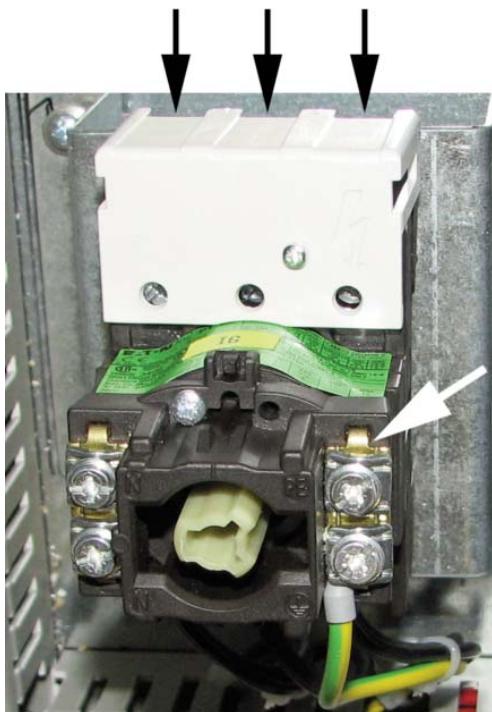


fig. 3.2.2.1



MAKE SURE THAT THE CABLE IS NOT UNDER POWER

fig. 3.2.2.1



- c) take the cable (not connected to the power supply!) and connect the three phase conductors with the terminal board of the main switch on the upper part (3.2.2.2). Fix the three conductors by tightening the worm screws. When carrying out this operation, make sure that the bare part of the wire is completely inserted in the clamp, to prevent contact with the outside.
- d) connect the conductor with green and yellow casing to the main ground terminal board of the machine (marked with "PE") situated inside the cabinet;
- e) block the cable by tightening the cable press;
- f) close the door of the electrical cabinet by means of the two locks and switch the main switch "IG" to the "I" position.



THE KEY OF THE ELECTRICAL CABINET MUST BE REMOVED FROM THE ELECTRICAL CABINET AND GIVEN TO THE MAINTENANCE MANAGER.



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-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

3.2.3 Heating system connection



The fluid to be used for the heating circuit must be exclusively DIATHERMIC OIL.

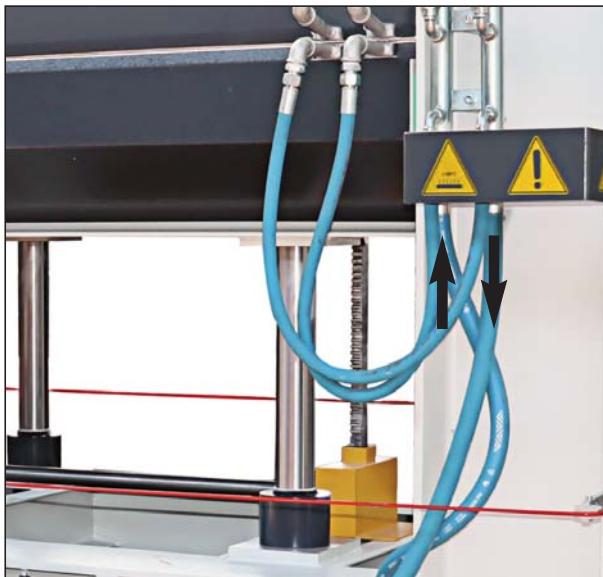
If the press is not equipped with oil electric boiler, connect the in and out pipes of the diathermic oil following the direction shown by the arrows in the picture



ATTENTION :

The temperature of the diathermic oil of the heating system must not exceed 120°C!

FABRICATED STEEL PLATENS



CAUTION: In the case of machines with table tops larger than 1300mm, follow the connection instructions in section 3.2.4



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3.2.4 Heating system connection >1300mm



The fluid to be used for the heating circuit must be exclusively DIATHERMIC OIL.

If the press is not equipped with oil electric boiler, connect the in and out pipes of the diathermic oil following the direction shown by the arrows in the picture



ATTENTION :

The temperature of the diathermic oil of the heating system must not exceed 120°C!

FABRICATED STEEL PLATENS >1300mm





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

4. Start-up

During transport, the machine travels with the lower platen raised in contact with the upper one.



BEFORE OPENING THE PLATENS, CHECK THAT THE SAFETY BRACKETS ARE NOT IN LOCKED POSITION, TO AVOID DAMAGE TO THE MACHINE.

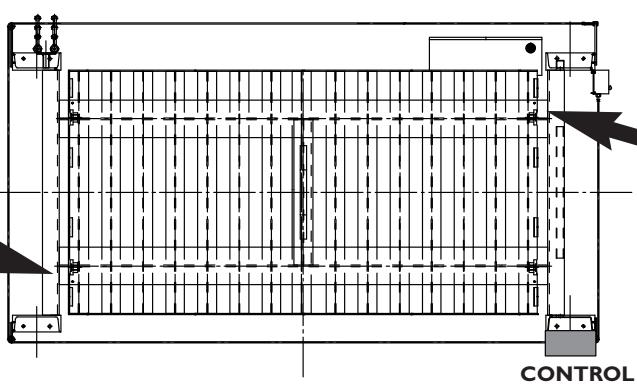
LOCKED POSITION



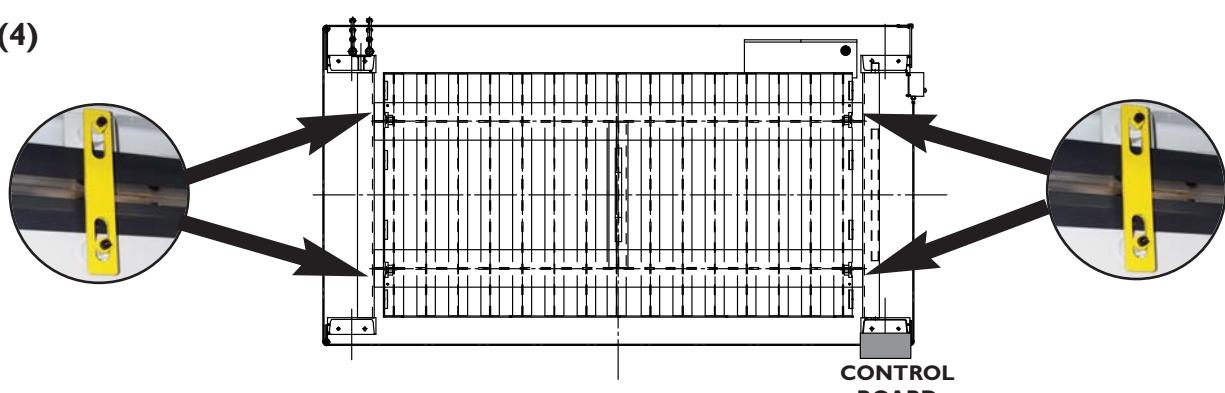
UNLOCKED POSITION



(2)



(4)



Before starting the machine, carry out the preliminary checks described in paragraphs 4.1, 4.2 and 4.3 below.



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-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

4.1 Checking the oil level of the central hydraulic unit



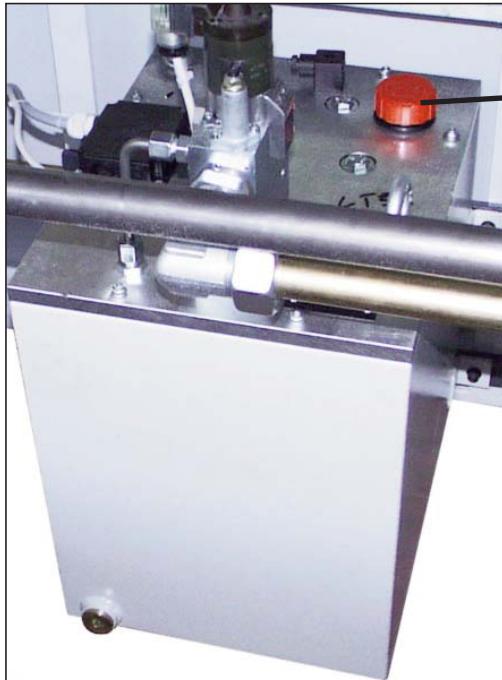
WARNING:

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

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



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



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

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

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



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-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

4.2 Checking the heating oil level

The minimum level of the heating oil has to be as indicated in picture “A”.

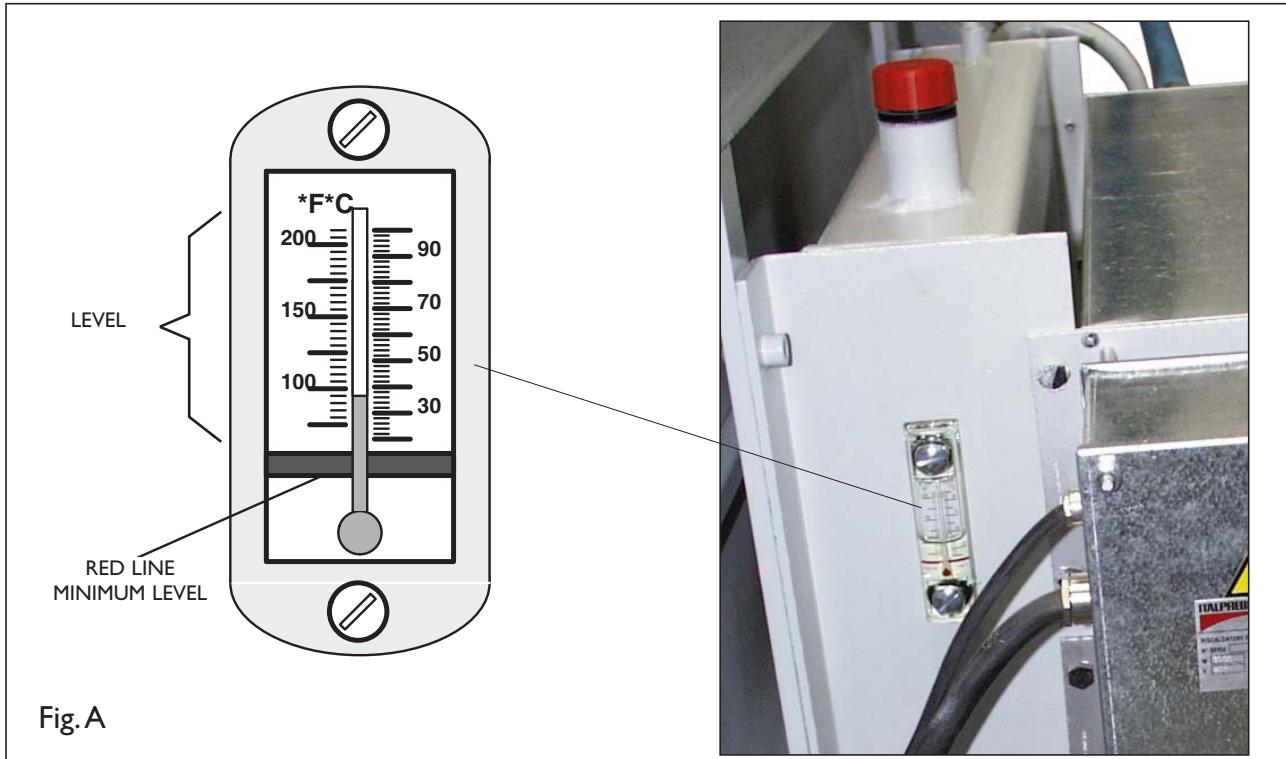


Fig.A



The remaining volume of the tank is necessary not to let the oil get out of the tank during its expansion due to the heating.



The check should be made when the press is cold.



IN NO CIRCUMSTANCES SWITCH ON THE HEATING BEFORE FILLING THE UNIT

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



IMPORTANT

The level of the oil must be periodically checked (when the press is cold). In case the level increases a lot, it means that some air is in the circuit.

In this case a degassing operation is necessary, and it is important to make sure that the breather valves are closed, in order to avoid that the oil may get out of the tank!! (4.4)



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

4.3 Checking the correct operation of the central hydraulic unit

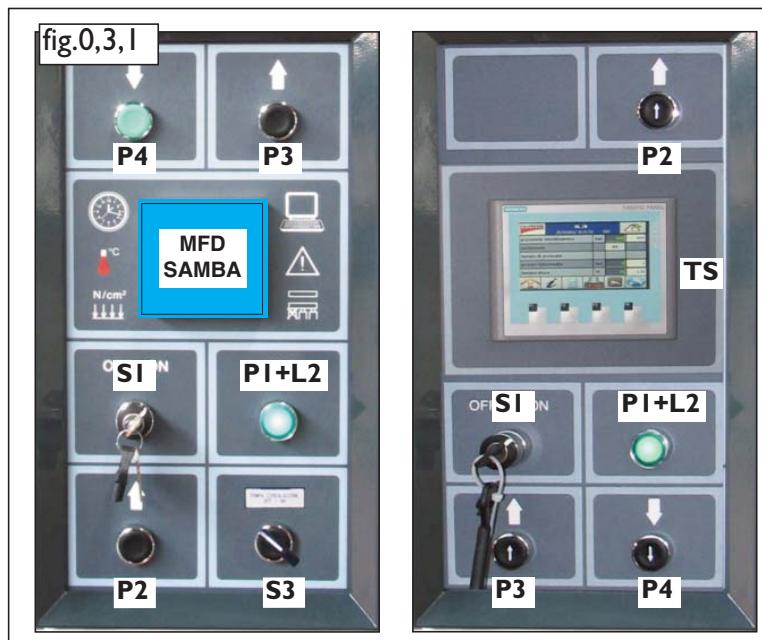
After checking the oil level in the central hydraulic unit, check that the unit itself operates correctly, proceed as follows: by turning in the right direction.

WARNING: FROM THIS MOMENT ON THE OPERATOR MAY GET IN TOUCH WITH THE MACHINE MOVING PARTS.

- Set the main power switch "S1" to the "ON" position
- Press the lit "RESET" button "P1+L2".
- Open the press by keeping pushed the "press opening" button "P4"
- Push simultaneously the press closure buttons "P2-P3".

If the press does not close then invert two of the three wires of the power line in the electric cabinet as in the chapt. 3.2.2.

After the change repeat the operations above described.



4.4 Platen heating-up (oil boiler)

The press platens are heated by circulating thermal oil heated in an electric boiler. The platens can reach a temperature in the region of 120°C, and it is therefore necessary to use specific protective gloves. However, accidental contact does not cause burns.

Warnings concerning the heating unit



Never fill the heating system with solutions containing even minimal quantities of water. By vapourising at 100°C, the water causes leaks of hot thermal oil from the expansion tank. Even when it's necessary to clean the platen's channel, never use water-based solutions.

- ! Do not adjust the calibration of the safety thermostats. This operation must be done only by specialised technicians.
- ! Never turn on the circulation pump and electrical resistances without the heating oil.



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

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-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

WARNINGS

- If the oil circulation pump, at the start up, is particularly silent, it means that it is unprimed.



- ATTENTION: THE PUMP WORKING WITH LITTLE LUBRIFICATION CAN DAMAGE THE SEALS.

- Therefore it is necessary to drain all the air from the pump as shown in 4.4.1.

- If the pump gives off scrubbing, it means that there's air in the system; therefore it is necessary to drain all the air from the pump as shown in 4.4.1.

- If the machine hasn't been used for a long period, at the start up, it is IMPORTANT to check manually that the circulation pump can freely turn. Viceversa, if there's any friction, it is necessary to insist on the manual rotation until the pump can freely turn.

- This operation is very important in order to preserve the seals.

- Moreover, if the machine hasn't been used for a long period, it is possible that at the re-start, there's some moisture in the heating system. In order to eliminate this moisture, follow this procedure:

-The heating oil must reach 95°C and circulate for approx half an hour; then it must reach 105° increasing step by step of 1°C each time by circulating for half an hour each step. This operation is essential to eliminate eventual spots of moisture inside the system.

- During the steps of this operation the air must be drained as described in 4.4.1.

Machine stop

- Before switching off the machine it is IMPORTANT to allow the pump to circulate the heating oil in the system for 15-20' with the heating elements OFF (selector switch. in pos. "I");
- This operation is very important in order to avoid any thermal shocks at the heating system.

4.4.1 Air drain from the heating circuit



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-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

The following operations must be performed with the machine cold!

Air drain from the pump

- 1 – Switch off the machine and loose the screw “V” until some oil comes out, then tight the screw again.



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

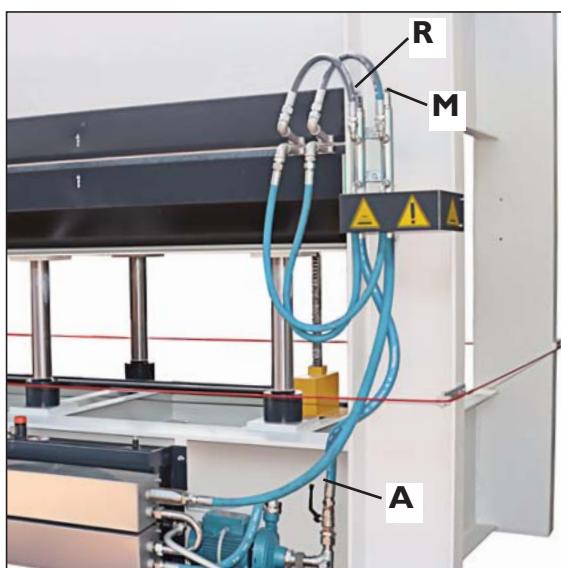
Air drain from the system

1. Start up the circulating pump without switching on the electric resistances ;
2. Close the ball valve “A”
3. Open the breathing valve “R”
4. When a little quantity of oil comes through valve “R”, close it
5. Open the ball valve “A”



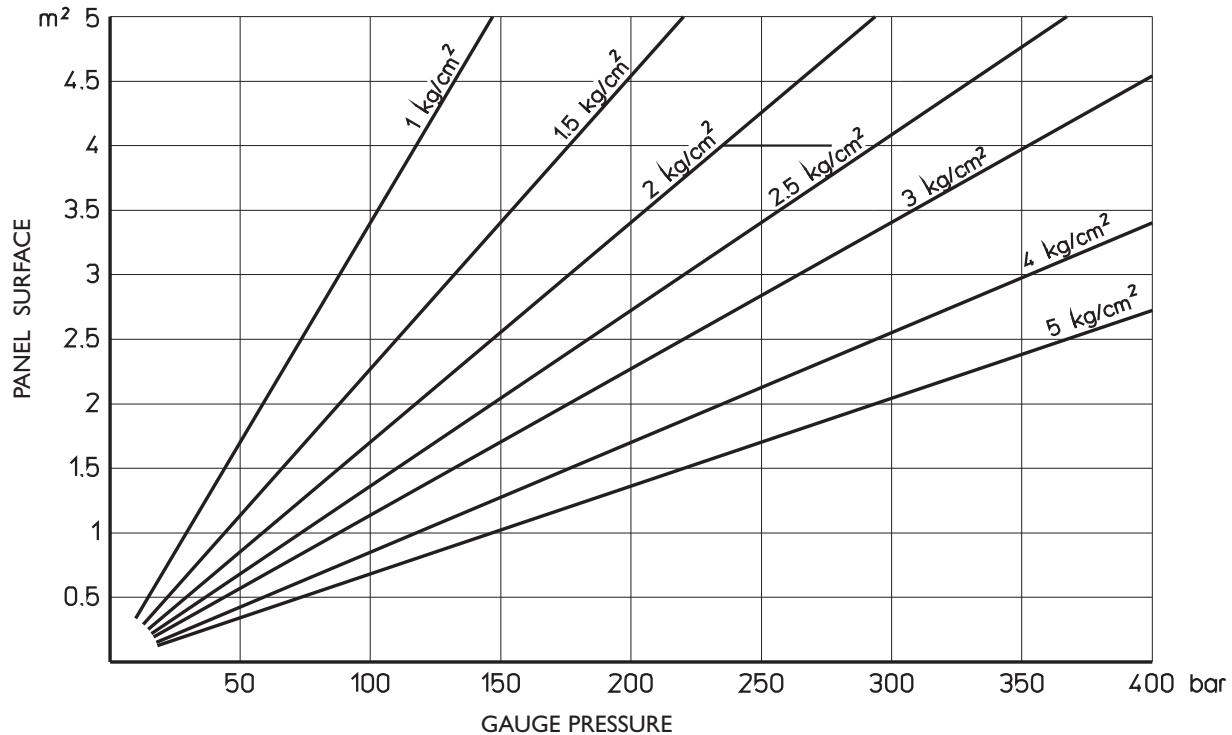
**ATTENTION: THE BREATHING VALVES “M” AND “R” MUST ALWAYS BE CLOSED;
PAY ATTENTION TO THE OIL LOSS FROM THE TANK!!**

FABRICATED STEEL PLATENS

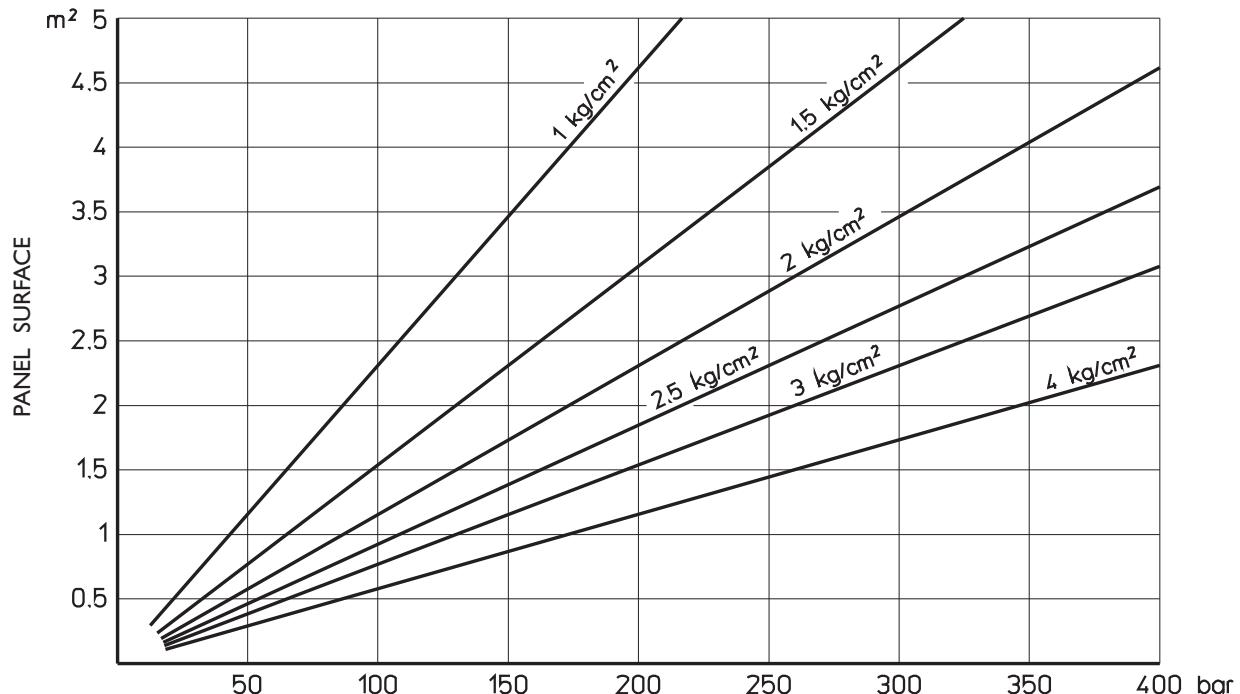


4.5 Working diagram

XL/6

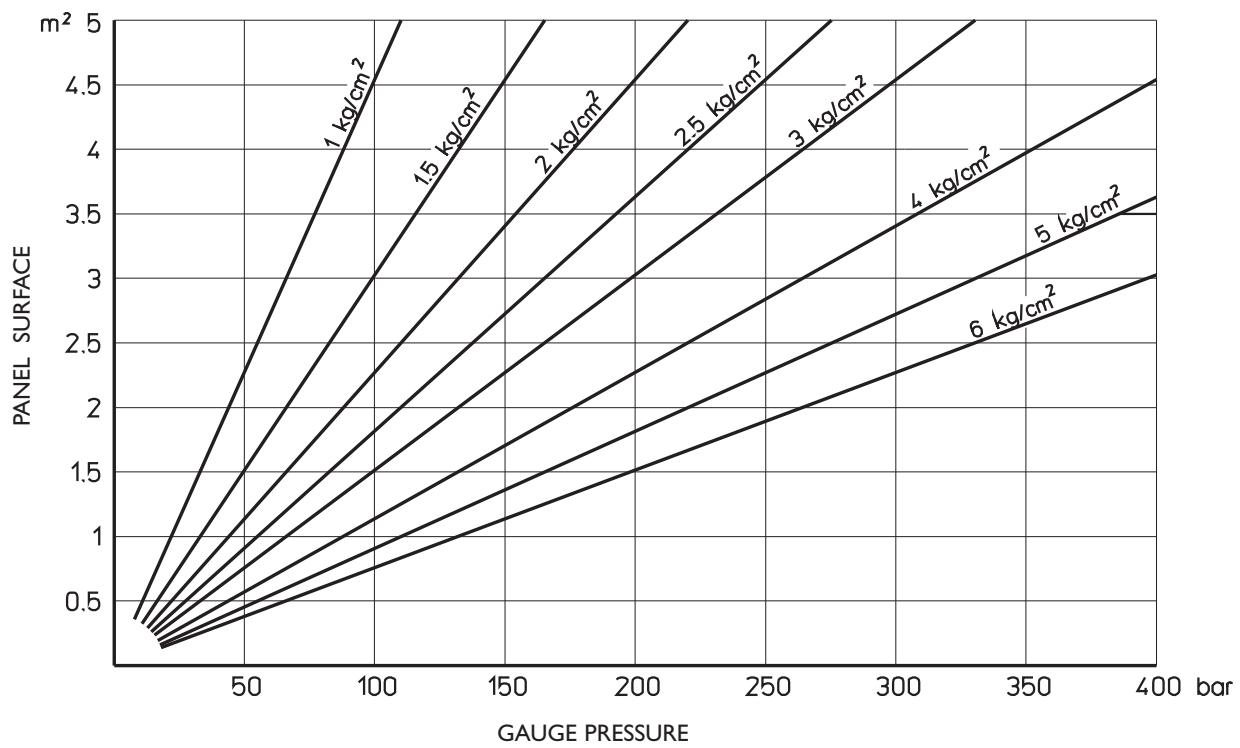


XL/6-S - XL/6-J

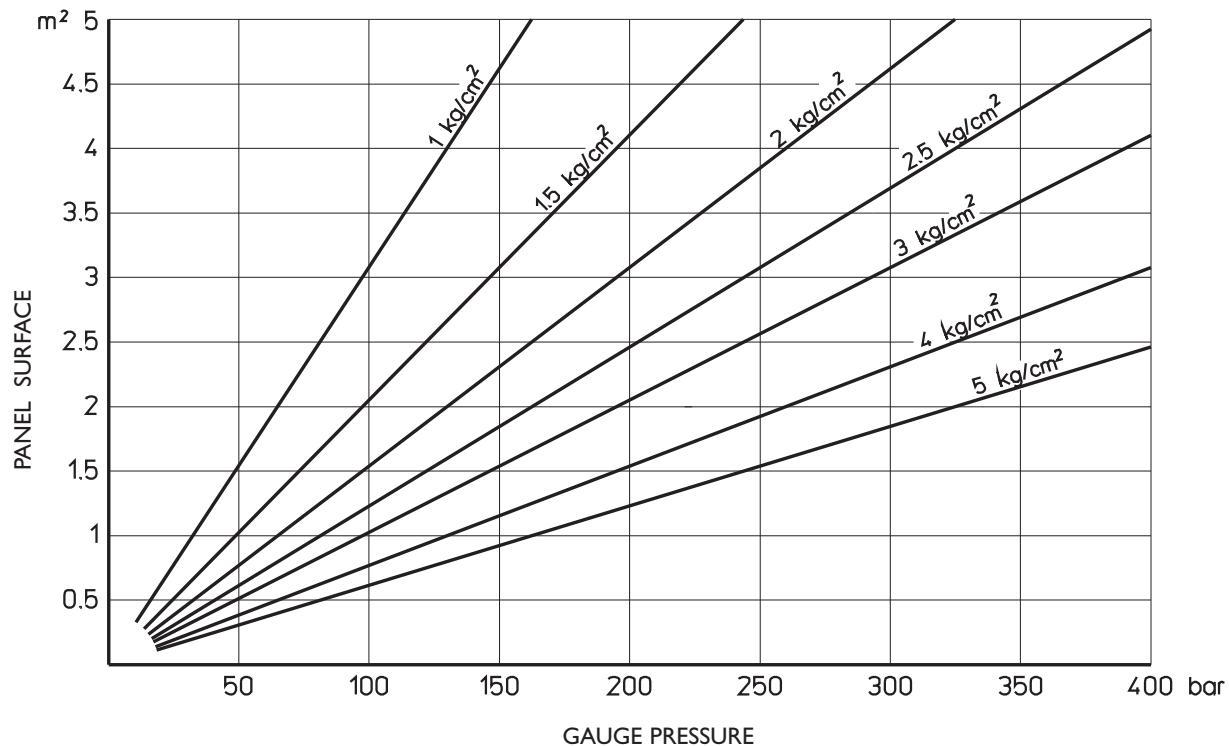


Working diagram

XL/8



XL/8-S - XL/8-J





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

4.6 General rules for loading the panels in the press

Since the press platens reach high temperatures the operator, when loading and placing panels into the press, must use appropriate personal heat-protective equipment and be extremely cautious.



The operator must arrange the panels to be pressed so that all the press push cylinders have an effect on the panels: it is necessary to avoid that single cylinders don't have an effect on the panels and instead they push directly on the press platen.

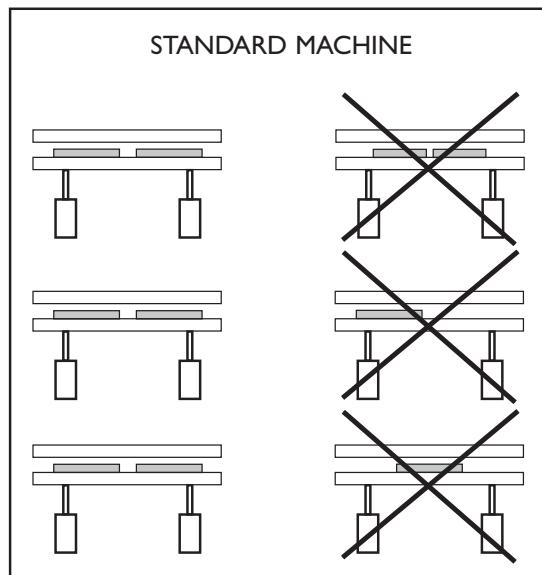
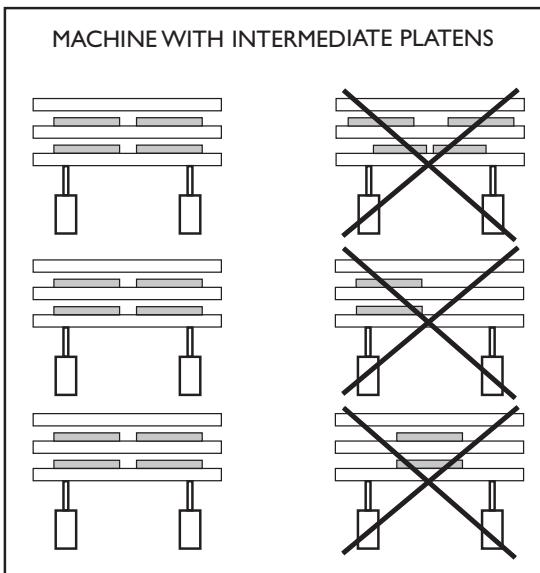


If the size of the panels, or the number of the panels to be pressed, is not such to cover the whole press platen, it is necessary to use wooden boards of the same thickness as the panels so that all cylinders that do not work on the panels will push onto the wooden boards.



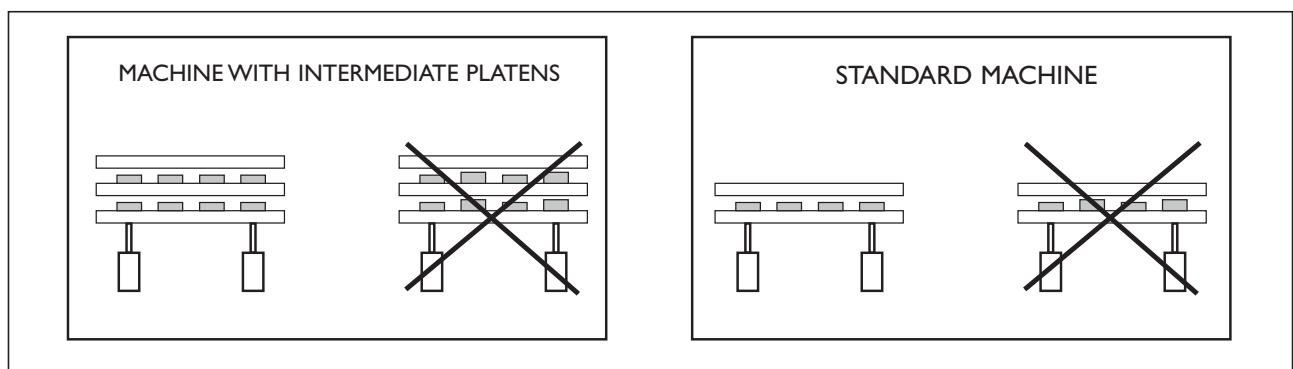
The thrust area of the cylinders must always be occupied by wooden panels and/or boards to avoid deformation of the platens.

The image below shows the correct positioning and arrangement of the panels on the table, or on the tables in the case of a machine with intermediate platens.

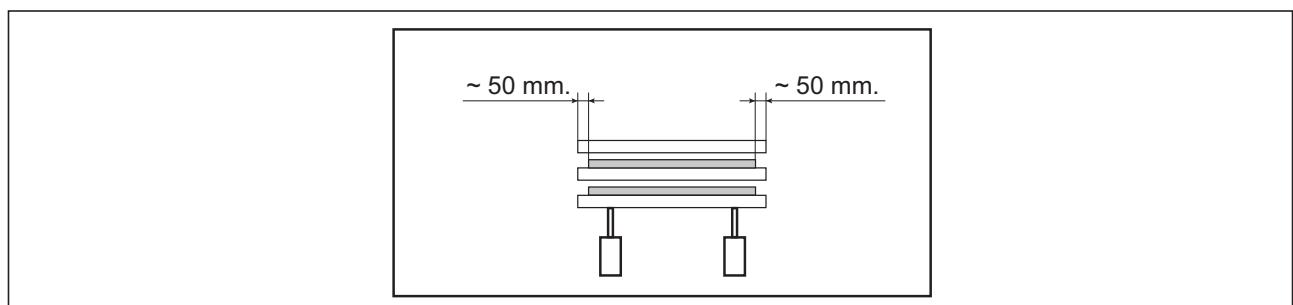




The thickness of the panels to be pressed must be uniform over the entire surface of the platen: panels and/or wood boards with different thicknesses must not be pressed at the same time.



To ensure good processing quality, load the panels leaving a gap of at least 50 mm between the outer edge of the platens and the edge of the panels.



GENERAL SAFETY INSTRUCTIONS FOR MACHINE WITH INTERMEDIATE FABRICATED STEEL PLATENS

The “fabricated steel platens” of the machine, onto which the panels to be pressed need to be placed, are manufactured with several layers consisting of:

- a tubular metal coil for the circulation of the heating fluid
- a thin steel plate placed on both sides of the coil
- a thin aluminum plate placed above the steel plate on the surface(s) in contact with the material to be pressed.

The machine must be operated and controlled by one single operator.

Before operating the machine and during its use, the operator must:

- check that no person is in the proximity of the machine
- check the correct position of the platens and panels of material to be pressed and/or wooden boards
- load and unload the panels only when the pressing platens are stationary at their support points
- avoid introducing hands or other body parts between the moving parts of the machine
- avoid working on the panels before the machine has finished its working phase and the platens have returned to their stationary position
- during loading and unloading operations make sure not to hit the machine with material handling equipment

When the pressing phase controlled by the operator is over, the platens come down following the activation of the related operation, as described in the "start/run/stop" section, until they arrive at their stop position, as shown in the image below.

FABRICATED STEEL PLATENS



Optional: shutoff of the side pair of cylinders by electric command

If the machine is fitted with an electrical command for the shutting down of one or two pairs of cylinders, only the surface corresponding to the active thrust cylinders should be covered by material to be pressed.

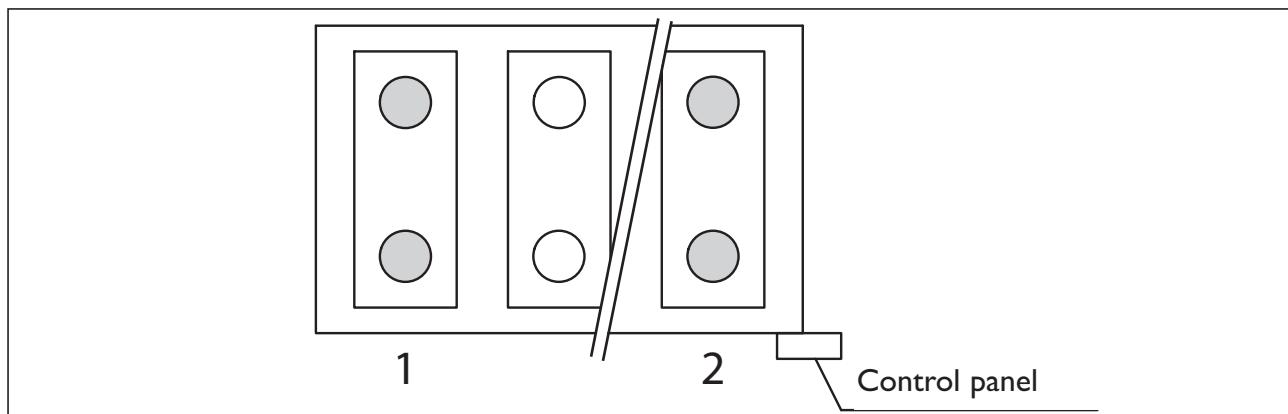
We recommend in any case to follow the instructions listed in this chapter.

The machine may have one or two cylinder shutoff devices.



Insert or deactivate the side cylinder pair shutoff only when the press is open.

The figure below shows the cylinder pairs of the machine that can be shut off where two shutoff devices are fitted. If there is only one shutoff device, the cylinder pair involved is that indicated with 1 (for side press the covered board).





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

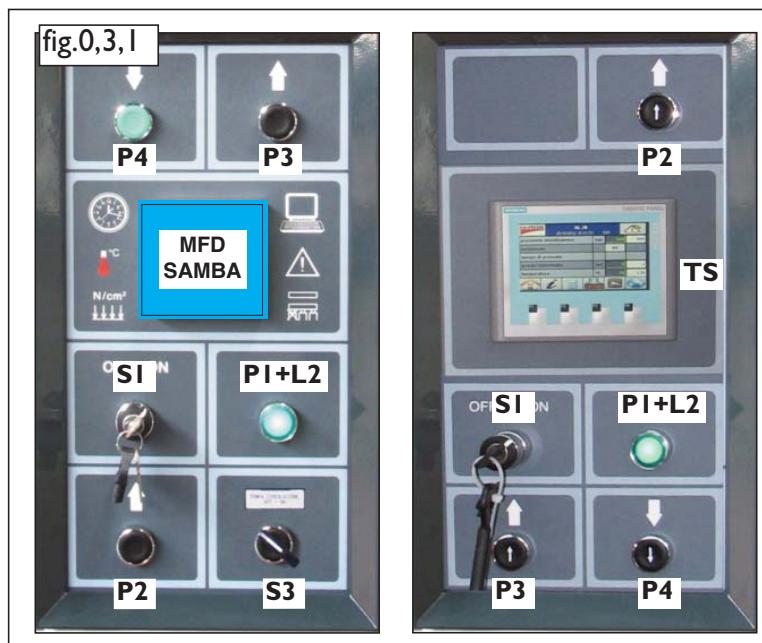
5. Start-up/operation/stop

Since the press platens reach high temperatures the operator, when loading and placing panels into the press, must use appropriate personal heat-protective equipment and be extremely cautious.

Description of operation

1. Turn the General Switch "S1" to the "ON" position.
2. Press the lit "RESET" button "P1+L2".
3. Open the press by pushing the button "P4" .
4. Set the pressing time
5. Set the pressure
6. Enter the desired cylinder pair exclusions if any
7. Set the work temperature
8. Load the material in the press daylight, following carefully the instructions described in the paragraph (general procedures for loading the panels in the press).
9. Push the closure buttons simultaneously "P2-P3".
10. To open the press, press and hold the "P4" button.
11. Wait for all machine platens to open checking that they are correctly positioned on their support points
12. Unload the processed material

Control panel



- SI KEY SELECTOR - POWER ON-OFF
PI+L2 GREEN LIGHT PUSHBUTTON / GENERAL AUXILIARIES RUN
P2 PUSH BUTTON FOR PRESS CLOSING (TO BE PUSHED SIMULTANEOUSLY WITH "P3")
P3 PUSH BUTTON FOR PRESS CLOSING
MFD/SAMBA - TS DIGITAL CONTROL SYSTEM
P4 GREEN PUSH BUTTON FOR PRESS OPENING
S3 SELECTOR FOR THE HEATING POWER 50/100% (OPTIONAL)



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-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

6. Malfunctions/faults/breakdowns

6.1 Oil leaks through cylinder gaskets

If any oil leaks due to the cylinder's gasket is detected, this is a sign of wear and tear on the gaskets. To change the gaskets, proceed as instructed below. The type of gasket to use is described in paragraph 14.3, "Cylinder drawings and parts".

To replace the sealing gasket (position 4) of one of the thrust cylinders, proceed as follows:

a - Lift the mobile platen in contact with the upper one.

b - Block the mobile platen in this position by means of the mechanical safety brackets (LOCKED POSITION).

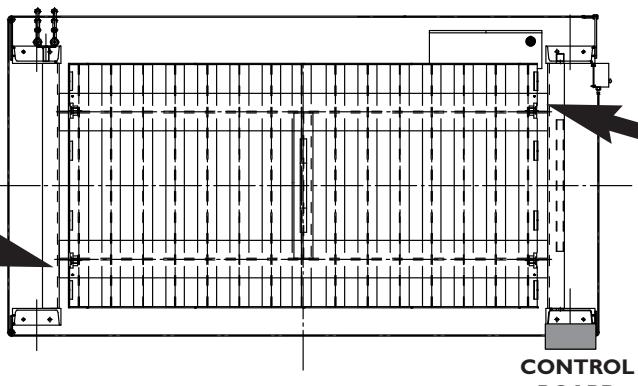
LOCKED POSITION



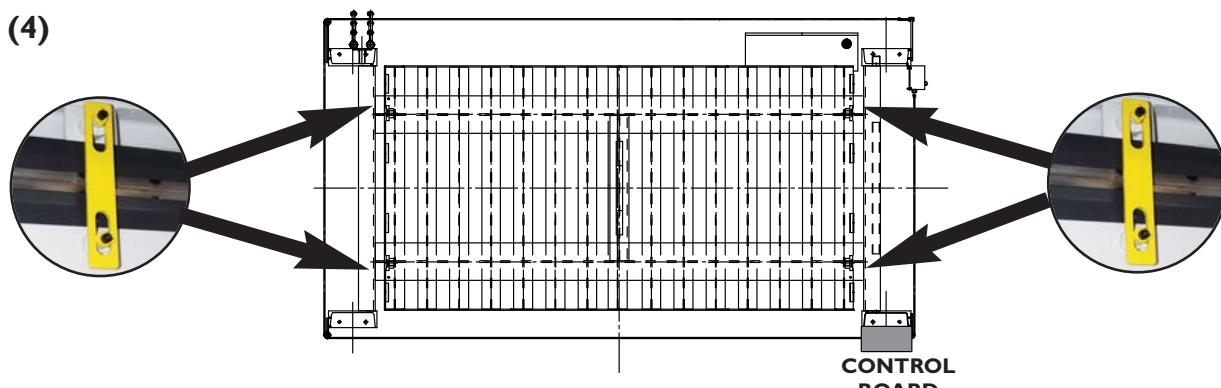
UNLOCKED POSITION



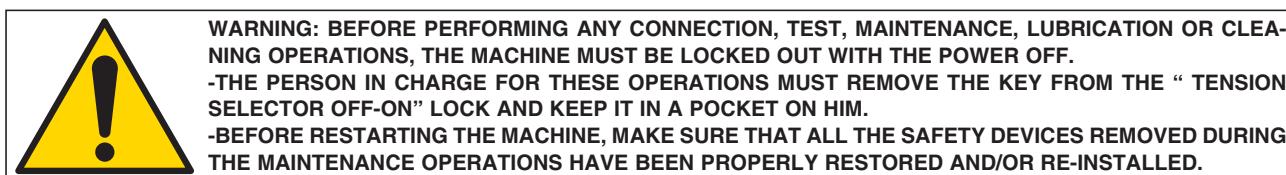
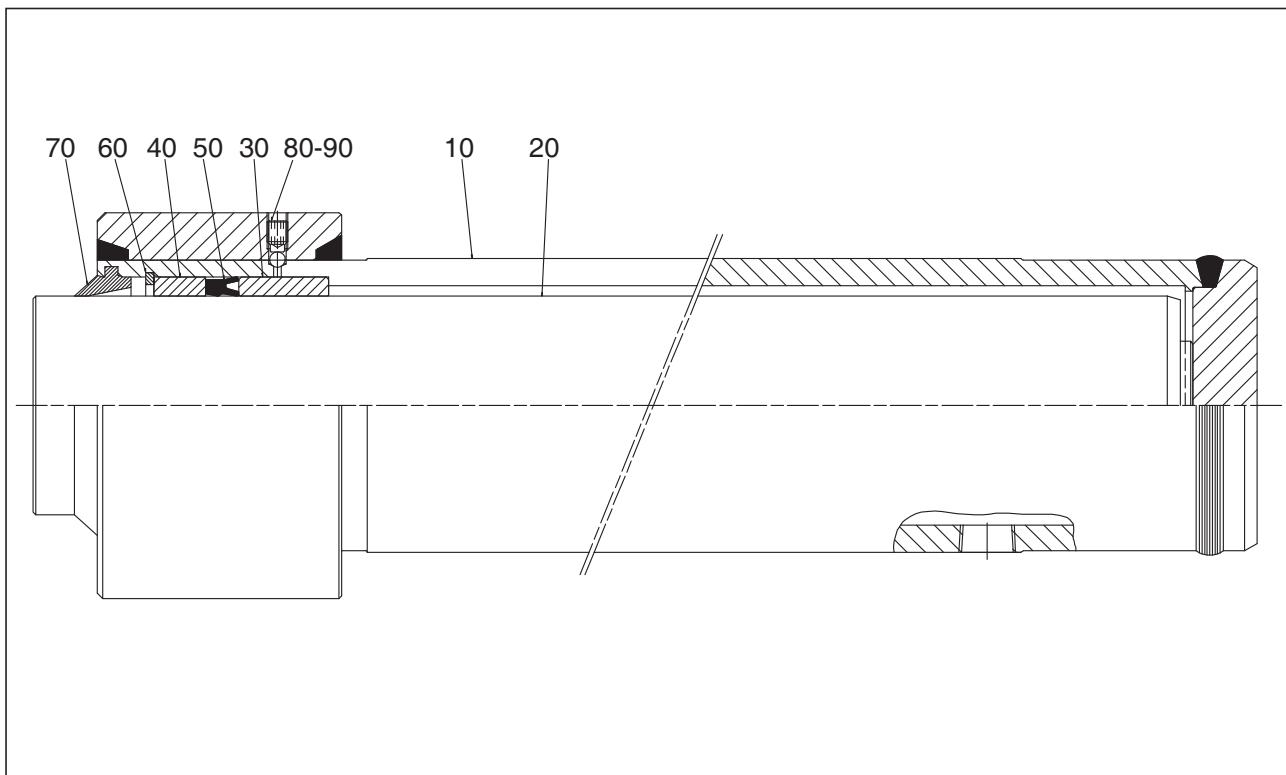
(2)



(4)



- c - Push the opening button and lower manually the shafts of all the cylinders (to avoid damage to the chrome plating).
- d - Remove the oil supply pipe from the cylinder.
- e - Remove the cylinder from its housing.
- f - Completely remove the shaft (eg. by applying compressed air to the oil connection).
- g - Remove the scraper ring pos.70, the stop ring pos.60 and the casing pos.40, and replace gasket pos.50
- h - Repeat all the operations in reverse order.
- i - Press the "close" buttons until all the shafts have completed their travel.
- j - Remove the safety brackets.



REMOVE BOTH THE PLATEN SAFETY BRACKETS IN ORDER NOT TO DAMAGE THE PRESS (UNLOCKED POSITION).



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

6.2 Oil leaks through the pump and the valves

Check if there is any oil leak in correspondence with the pump or solenoid valves once every six months.

If so, contact our technicians, who will supply relevant information, specifying the position of the solenoid valves in the "Hydraulic diagram".

6.3 Ageing of the hydraulic oil

The ageing of the hydraulic oil causes losses of its chemical-physical properties and obstructs the operation of the equipment. Refill or replace with hydraulic oil as described in 11.1, at the interval set out in 7.

6.4 Magnetothermic blockage

In the event of short circuits and overcurrents on the motor, the magnetothermal device in the electrical panel goes into BLOCK mode.

To rearm the device, open the electrical panel and push the black button until it reaches "OPERATING" position.

If the "BLOCK" mode continues, check the motor connections or contact our Service Department.

BLOCK



OPERATING





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-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

7. Cleaning

7.1 Central hydraulic unit:

A hydraulic line which is duly and constantly taken care of assures a long lasting time without any disadvantages.

Among the main break-down causes it is possible to point out the jamming of the devices due to the hydraulic oil getting old (with a consequent loss of the chemical and physical properties).

OPERATIONFREQUENCY

.....NORMAL OPERATION .FREQUENT OPERATION

Oil replacement and inner cleaningevery 2000every 500 working hours

Outer cleaningevery four months

Oil refillwhen level at minimum

Oil filter cleaning (if mounted)every three months

Air filter cleaning (if mounted)every three months

Replacement of filter cartridges (if mounted) .every two years

Pump and valves leaking checkevery two years

Accumulator preloading check (if mounted) ...every two years



WARNING: BEFORE PERFORMING ANY CONNECTION, TEST, MAINTENANCE, LUBRICATION OR CLEANING OPERATIONS, THE MACHINE MUST BE LOCKED OUT WITH THE POWER OFF.
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-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

7.2 Cleaning the heater system

We recommend to perform this operation when changing the heating oil. This operation is necessary as any oxidisation or cracking of the heating oil could partially obstruct its flow, with consequent uneven heating of the press platens.

To clean the unit, proceed as follows:

1. drain the heating system completely;
2. fill the expansion tank with cleansing oil in quantities sufficient to fill the boiler and pipes.
3. set the thermometer at 60°C.
4. switch on the boiler and let circulate the hot cleansing oil in one platen at a time for two hours.
5. Drain the heating system.



In order to carry on the emptying/filling operations follow the instructions inserted in 8.2 and 4.4.

HEATING OIL

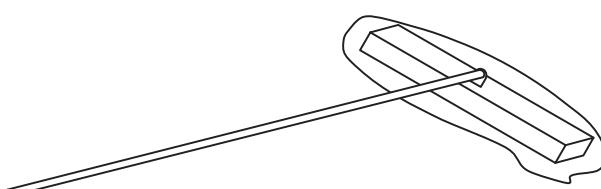
In order to keep the efficiency of any heating system, it is important for the heating oil have the appropriate chemical and physical properties.

It may happen that these properties may change, and this depends on how the oil is used. The following checks are highly recommended when using the heating oil in the system:

OPERATION	FREQUENCY
Level control	Every 500 working hours
Visual control (of the absence of any carbonious residues)	Every 1000 working hours
Total replacement	Every 5000 working hours

7.3 Cleaning the press platens

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



NEVER GET INTO THE PRESS PLATENS; USE SPECIFIC TOOLS.



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

8. Maintenance / inspection / checks



! THE MACHINE IS FITTED WITH MANUAL SAFETY BRACKETS THAT LOCK THE MOBILE PLATEN IN THE LOCKED POSITION.
ALWAYS INSERT THE SAFETY BRACKETS DURING THE MAINTENANCE OPERATIONS.

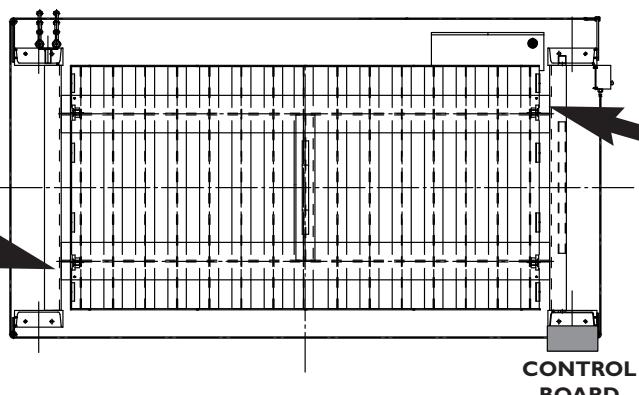
LOCKED POSITION



UNLOCKED POSITION

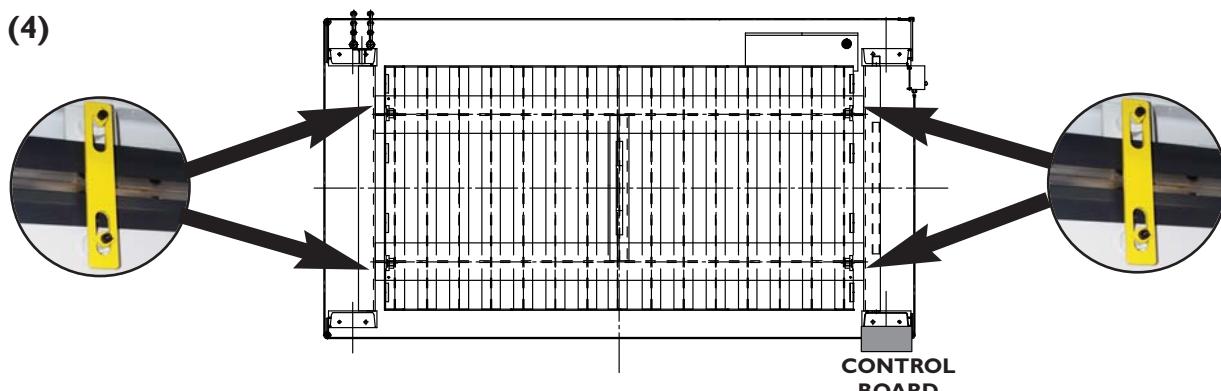


(2)



CONTROL
BOARD

(4)



CONTROL
BOARD



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

PRESS WITH INTERMEDIATE PLATENS



Please check periodically that the intermediate platens guide is in good conditions and well lubricated.

FABRICATED STEEL PLATENS



IT IS ABSOLUTELY FORBIDDEN TO HANDLE THE GUIDES AND THE LOCKS.



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-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

8.1 Changing the oil in the central hydraulic unit

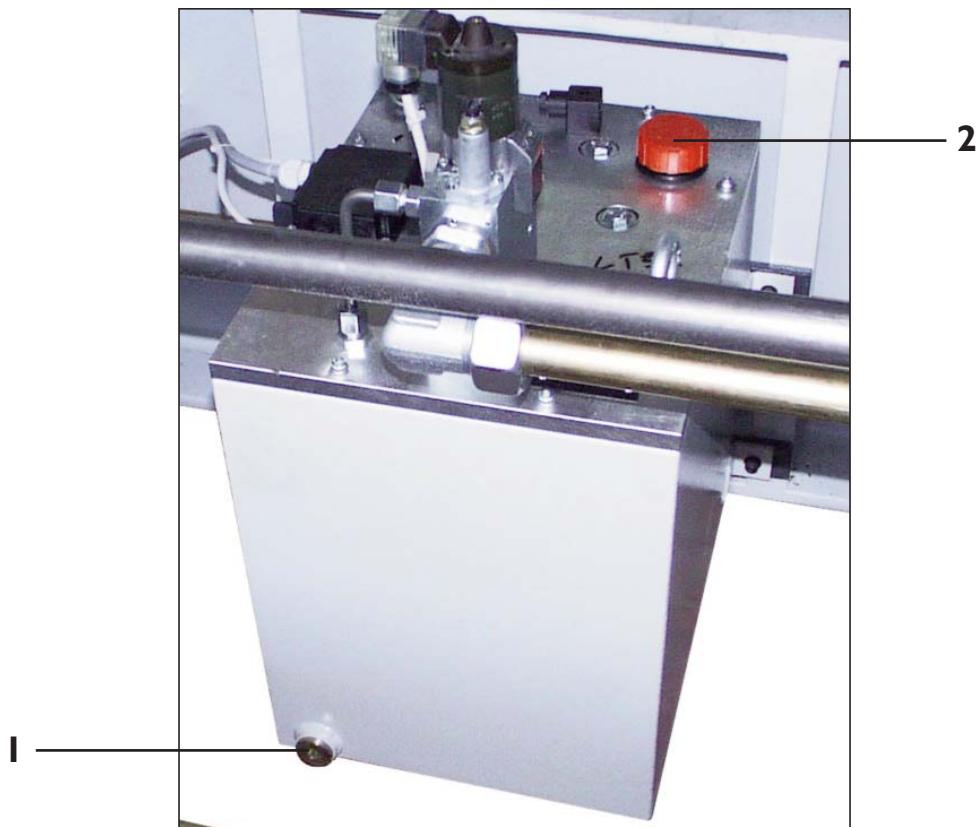


DISPOSE OF THE OIL REMOVED FROM THE MACHINE CORRECTLY!

A correct and constantly maintained hydraulic unit guarantees long life without operating problems.

Follow the following procedure:

1. close the press, without anything between the platens, by the closing pushbuttons;
2. lock the mobile platen by the special safety brackets;
3. drain the used oil, through the indicated plug "1", and collect it for disposal;
4. the new oil is filled through the plug with the measuring stick "2", placed on the top of the hydraulic unit;
5. The level should be as described in 4.1. Use the oil indicated in paragraph 11.1.





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-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE " TENSION SELECTOR OFF-ON" LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

8.2 Heating oil change

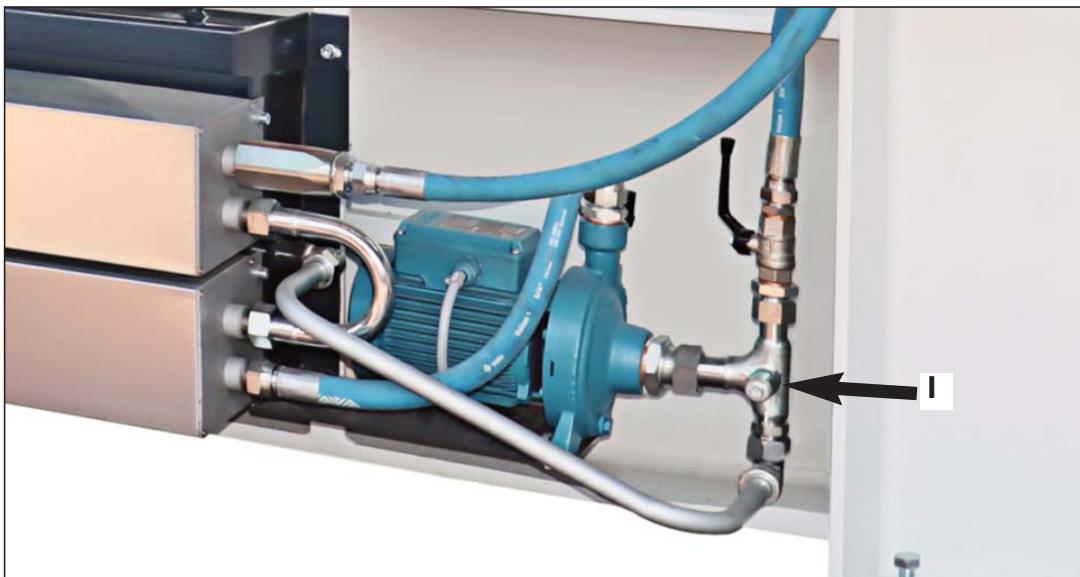
When the machine is cold, follow the following steps:

Draining:

1. Provide a tank for the exhaust oil to be disposed.
2. Unscrew and remove plug "I" of the piping system, most part of the oil will be drained out.
3. Unplug flexible pipes from the press and empty them from the oil.
4. Re-plug the flexible pipes again and screw on the plug "I".

We suggest to do the cleaning of the heating system by following the instructions in paragraph 7 (Heating system cleaning)

We also suggest to check the boiler heating elements, as indicated in paragraph (Boiler efficiency check).



Filling:

Machine off

1. Fill the new oil through the oil tank
2. Bleed the pump through screw "V" till the oil comes out, then tighten the screw again

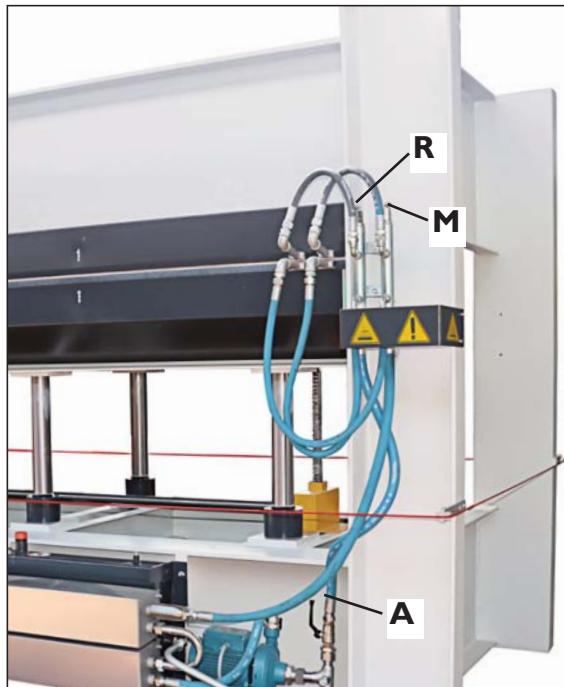




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-THE PERSON IN CHARGE FOR THESE OPERATIONS MUST REMOVE THE KEY FROM THE “ TENSION SELECTOR OFF-ON” LOCK AND KEEP IT IN A POCKET ON HIM.
-BEFORE RESTARTING THE MACHINE, MAKE SURE THAT ALL THE SAFETY DEVICES REMOVED DURING THE MAINTENANCE OPERATIONS HAVE BEEN PROPERLY RESTORED AND/OR RE-INSTALLED.

3. Close valve “A”
4. Open the two breathing valves “M” and “R”

FABRICATED STEEL PLATENS



5. Start the circulating pump with electric resistances off
6. When the oil comes out from valve “M” close it
7. Check the oil level indicator. During this phase, the oil level must decrease as the oil is filling the platens, then reset the level adding additional oil.
8. When oil comes out from valve “R”, close the valve “R” and open valve “A”



**WARNING: BREATHING VALVES “M” AND “R” MUST ALWAYS BE CLOSED CORRECTLY;
RISK OF OIL LOSS FROM THE TANK !!!**



FOLLOW THE INSTRUCTIONS DESCRIBED AT 4.4



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

8.3 Greasing the transmission parts

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

DESCRIPTION MAINTENANCE PROGRAM

- Racks **EVERY 100 WORKING HOURS**

DATA											

- Guides **EVERY 200 WORKING HOURS**

DATA											

- Chains **EVERY 250 WORKING HOURS**

DATA											

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

DATA											

- Bearing supports **EVERY 2000 WORKING HOURS**

DATA											

- Mechanism pivots **EVERY 1000 WORKING HOURS**

DATA											

FOR THE LUBRICATING SPECS, PLEASE CHECK THE (SUPPLIES) PROGRAM.



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

8.4 Boiler efficiency check

! IMPORTANT: this operation should be carried out only by an expert electrician.

The operation is aimed at checking the balance of the electric power supply phases of the boiler using an electrical measurement device (amperometer).

If the three phases are not balanced, this means that at least one of the boiler electrical resistances is not operating. The part involved is identified using the amperometer referred to above.

9. Caratteristiche tecniche

- technical data
- technische daten
- données techniques
- características técnicas

	Dimensioni piani Platen dimensions Plattenabmessungen Mesures plateaux Dimensiones platos mm (inch)	Pressione totale Total pressure Gesamtdruck Pression totale Presión total Ton.	Apertura (standard) Opening (standard) Öffnung (standard) Ouverture (standard) Apertura (standard) mm			Cilindri Cylinders Zylinder Cylindres Cilindros N.	Dimensioni di ingombro* Machine dimensions* Aussenmasse* Mesure encombrement* Medidas externas* mm
			PA	PM	PE		
XL/4 - S	2500 x 1300 / 98"x51"	50	400	370	350	4	3100 x 1800 x 2100
XL/4	2500 x 1300 / 98"x51"	70	400	370	350	4	3100 x 1800 x 2100
XL/6 - S	2500 x 1300 / 98"x51"	90	400	370	350	6	3100 x 1800 x 2100
XL/6	2500 x 1300 / 98"x51"	120	400	370	350	6	3100 x 1800 x 2100
XL/6 - K	3000 x 1300 / 118"x51"	50	400	370	350	6	3550 x 1750 x 1900
XL/6 - J	3000 x 1300 / 118"x51"	70	400	370	350	6	3550 x 1750 x 1900
XL/6 - S	3000 x 1300 / 118"x51"	90	400	370	350	6	3700 x 1800 x 2100
XL/6	3000 x 1300 / 118"x51"	120	400	370	350	6	3700 x 1800 x 2100
XL/8 - J	3500 x 1300 / 138"x51"	90	400	370	350	8	4300 x 1800 x 2100
XL/8 - S	3500 x 1300 / 138"x51"	120	400	370	350	8	4300 x 1800 x 2100
XL/8	3500 x 1300 / 138"x51"	160	400	370	350	8	4300 x 1800 x 2300
XL/8	3200 x 1600 / 126"x63"	160	400	400	350	8	4000 x 2100 x 2300
XL/8	4200 x 1400 / 165"x55"	160	400	400	350	8	5000 x 1900 x 2300
XL/10	3800 x 1600 / 150"x63"	190	400	400	350	10	4400 x 2100 x 2300
XL/10	4200 x 1600 / 165"x63"	190	400	400	350	10	5000 x 2100 x 2300

9.1 Phonometric measurements

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

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

10. Assistenza tecnica

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

Technical assistance

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

Assistance technique

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

Kundendienst

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

Asistencia técnica

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

Indirizzo - Address - Adresse - Adresse - Dirección:

ITALPRESSE S.p.A.

via Delle Groane 15 BAGNATICA 24060 (BG)

Tel.: +39 035 666341

Fax: +39 035 6663400/401

E-MAIL: sales@italpresse.com

WEB: www.italpresse.com

For information on packaging categories visit:

www.italpresse.com/packaging

II. Rifornimenti e materiali utilizzati - Supplies and materials used - Ravitaillements et matériaux utilisés - Verwendete Betriebs-und Werkstoffe - Abastecimientos y materiales usados

II.I Tipi di olio consigliati - Recommended oils- Types d'huiles conseillées - Empfohlene Öl - Tipos de aceite aconsejados

OLIO IDRAULICO - HYDRAULIC OIL - HUILE HYDRAULIQUE HYDRAULIK ÖL - ACEITE HIDRAULICO

API - CIS 68

BP - ENERGOL HLP 68

CASTROL - HYSPIN AWS 68

ELF - ELFONA 68

0ESSO NUTO 68

IP - HYDRUS OIL 68

SHELL - TELLUS OIL 68

TOTAL - AZOLLA ZS 68

FINA - HYDRAN 68

Quantità olio - Oil quantity - Quantité de huile - Ölmenge - Cantidad de aceite

~ lt.

MPN44-HZ 1,6/21 SB45 KW 2,1	SK 7207 HZ 7-3	100330460040
MPN44-HZ 2,4/37 SB45 KW 2,1	SK 7207 HZ 9-3	100330462050
MPN48-HZ 2,4/59 SB75 KW 3	SK 7207 HZ 10-3	100330464050
MPN48-HZ 2,4/75 SB75 KW 3	SK 7207 HZ 8-3	100330466075



OLIO DIATERMICO - DIATHERMIC OIL - HUILE DIATHERMIQUE - THERMOÖL - ACEITE TERMICO

AGIP ALARIA 3

API MF 32

BP TRANSCAL N

ESSO ESSOTHERM 500

FINA CALORANT IT 32

IP FORNOLA OIL 25

MOBIL MOBILTHERM 605

TOTAL SERIOLA 2100

SHELL HEAT TRANSFER OIL S2

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

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

TIPO	APPLICAZIONE	MARCA
TYPE	APPLICATION	BRAND
TYPE	APPLICATION	MARQUE
ART	VERWENDUNG	MARKE
TIPO	APLICACIÓN	MARCA
olio minerale	riduttori a ingranaggi	IP - MELLANA OIL 320/220
mineral oil	gear reducers	ESSO - SPARTAN EP 320/220
huile minerale	réducteurs à engrenages	AGIP - BLASIA 320/220
Mineralöl	Zahnradgetriebe zur Unterstellung	MOBIL - MOBILGEAR 632/630
aceite mineral	reductor de engranajes	SHELL - OMALA 3P 320/220 BP - ENERGOL GR-XP 320/220
olio minerale	riduttori a vite senza fine	IP - MELLANA OIL 460/320
mineral oil	tangent screw reducers	ESSO - SPARTAN EP 460/320
huile minerale	réducteurs à vis sans fin	AGIP - BLASIA 460/320
Mineralöl	Schneckengetriebe zur Unterstellung	MOBIL - MOBILGEAR 634/632
aceite mineral	reductores de tornillo sin fin	SHELL - OMALA EP 460/320 BP - ENERGOL GR-XP 460/320
grasso sintetico	ridutt. a ingran e a vite senza fine	IP - TELESIA COMPOUND B
synthetic grease	gear reducers and tangent screws	KLUEBER - STRUCTOVIS P LIQUID
graissé synthétique	réducteurs à engrenages et à vis sans fin	TOTAL - TOTALCARTER SY00
synthetisches Fett	Zahnrad- und Schneckengetriebe zur Unterstellung	
grasa sintética	reductores de engranajes y de tornillos sin fin	
olio sintetico	ridutt. a ingran. e a vite senza fine	IP - TELESIA OIL 150
synthetic oil	gear reducers and tangent screws	KLUEBER - SYNTHESOI D220EP
huile synthétique	réducteurs à engrenages et à vis sans fin	AGIP - BLASIA S
synthetisches Öl	Zahnrad- und Schneckengetriebe zur Unterstellung	
aceite sintetica	reductores de engranajes y de tornillos sin fin	

PER CREMAGLIERE, SUPPORTI
RACK AND SUPPORT GREASE
GRAISSE POUR CREMAILLERES, SUPPORTS
SCHMIERFETT FÜR ZAHNSTANGEN, LAGER
GRASA PARA CREMALLERAS, SOSTENES

PER CILINDRI ED INGRASSAGGIO GENERALE
CYLINDER AND GENERAL GREASE
GRAISSE POUR CYLINDRES ET GRAISSAGE GENERAL
SCHMIERFETT FÜR WALZEN UND ALLG. ABSCHMIEREN
GRASA PARA CILINDROS Y ENGRASAJE GENERAL

AGIP-GR-MU/2

AGIP - PV 20 (BIANCO)
(WHITE)
(BLANCHE)
(WEIß)
(BLANCO)

I I.3 Materiali di produzione - Production materials - Matériaux de production - Werkstoffe - Materiales de produccion

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

The glues should be prepared and used according to the supplier's instructions. ! BEFORE PREPARING OR USING THE GLUES, READ THE INSTRUCTIONS CAREFULLY.

ALWAYS ask the supplier for the toxicological specifications of the glues and the instructions for their correct use.

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

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

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

I2 Messa fuori servizio temporaneo

- **Temporary shutdown**
- **Mise hors service temporaire**
- **Vorübergehende Stillegung**
- **Parada por algún tiempo**

- If the machine is shut down temporarily, it is advisable to spray the following mechanical parts with an anti-oxidant: cylinders, mobile surface, guides.
- Set the machine to closed platens position.
- Disconnect the machine from the electric power line and compressed air supply.
- Leave the oil (central hydraulic unit and heating oil) in the machine and change it upon restart if the shutdown time is longer than 12 months.
- Upon restart, clean the mechanical parts coated with the protective spray using a dry cloth. Check the cylinder gaskets and change them if necessary.

Oil boiler:

! CHECK THAT THERE IS NO WATER IN THE LEVEL HEATING CIRCUIT: THIS WOULD CAUSE LEAKS OF BOILING OIL FROM THE EXPANSION TANK!

I3 Messa fuori servizio definitivo (smantellamento)

- Permanent shutdown (dismantling)
- Mise hors service définitive (démontage)
- Endgültige Stillegung (Abbau)
- Parada definitiva (desarmado)

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

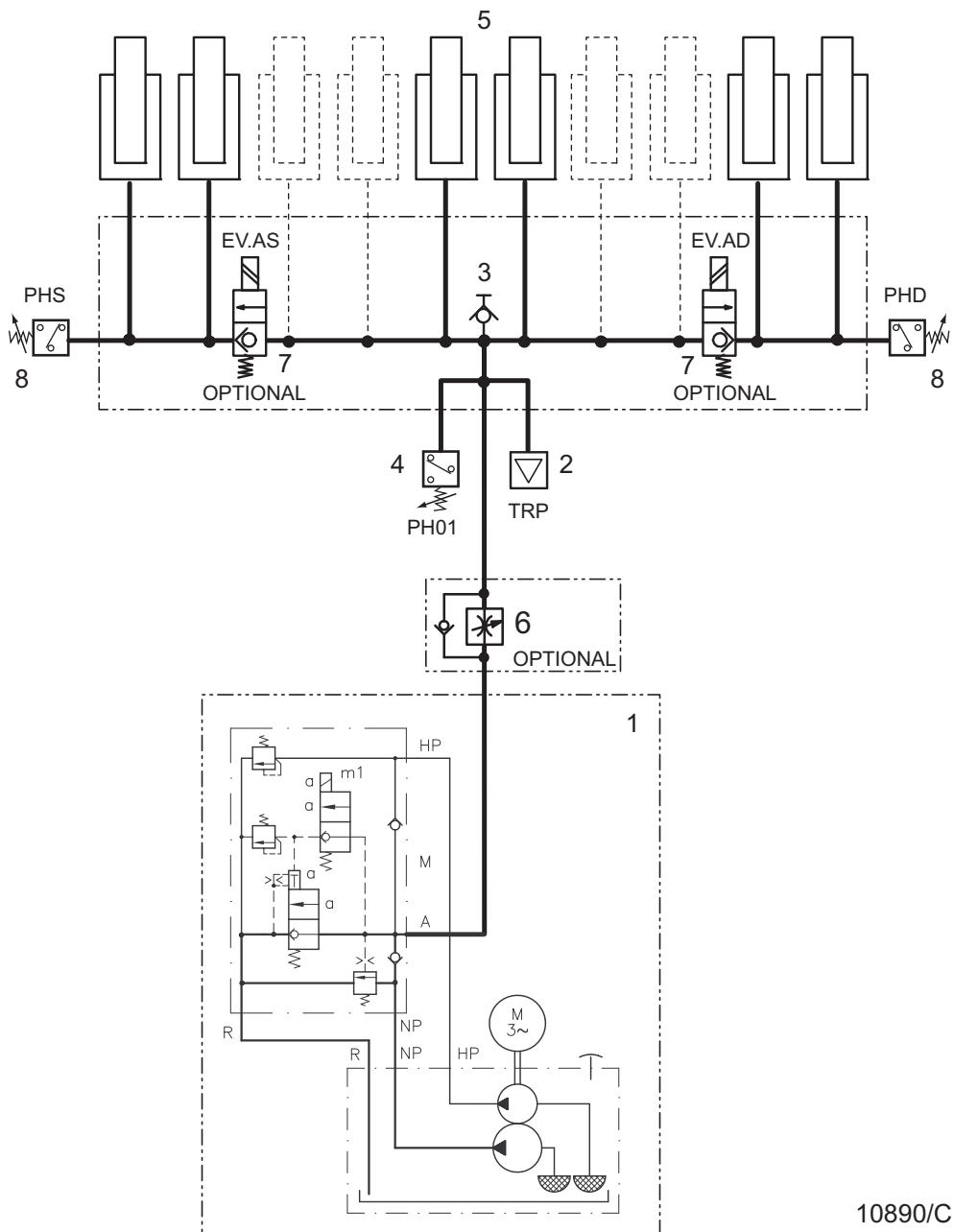
- First, remove the fluids used in the machine: oil from the central hydraulic unit, heating oil, air lubrication oil.

DISPOSE CORRECTLY THE OILS USED IN THE MACHINE.

- Collect the plastic and rubber materials, such as the cylinder gaskets, flexible tubes, cable covers, etc. These materials should be disposed of in accordance with the national laws in force.
- Remove the motors, electrical equipment, wiring, the equipment contained in the electrical panel, and recover the copper parts.
- The press body, levels and all the other steel parts can be disposed of as ferrous material.

I 4. Diagrams, main parts

I 4.1 Hydraulic diagram



Hydraulic diagram description

2 – Transducer ART. 3396.086.101 400bar 0-10 VDC 1/4"	1018530132
3 – Pressure check 620.01.204.21	1009360300
4 – Pressure switch DG 34	1014720135
6 – Valve SB 33C - 3/4" (optional)	1020093794
7 – Solenoid valve OD 15.05.21.37.00 (optional)nr.2	1005402550
8 – Pressure switch DG 35 (optional)nr.2	1014720130

XL/8

1 – Motor pump MPN48-HZ 2,4/75 SB75 KW 3	1003304660
5 – Cylinder D. 85 mm.nr.8	2500028107

XL/8-S

1 – Motor pump MPN44-HZ 2,4/37 SB45 KW 2,1	1003304620
5 – Cylinder D. 70 mm.nr. 8	2500026453

XL/8-J

1 – Motor pump MPN44-HZ 2,4/37 SB45 KW 2,1	1003304620
5 – Cylinder D. 70 mm.nr. 8	2500026453

XL/6

1 – Motor pump MPN48-HZ 2,4/59 SB75 KW 3	1003304640-01
5 – Cylinder D. 85 mm.nr.6	2500028107

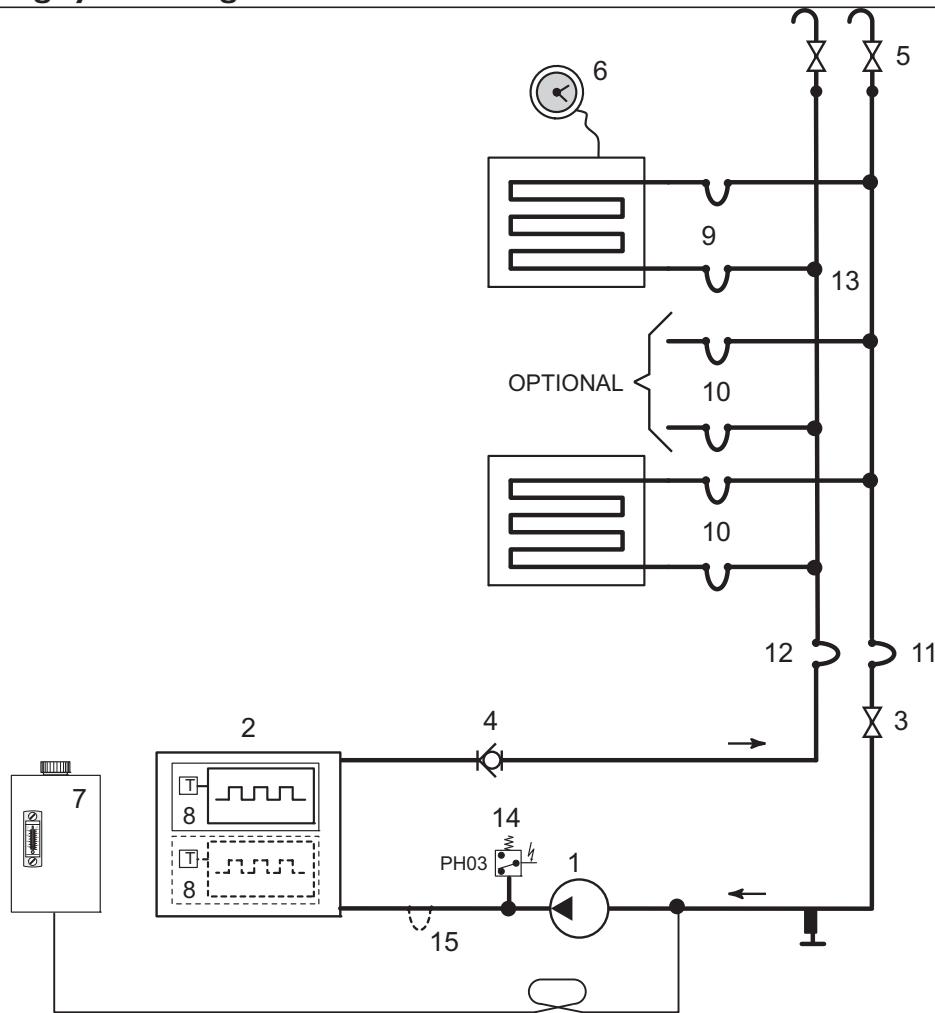
XL/6-S

1 – Motor pump MPN44-HZ 1,6/21 SB45 KW 2,1	1003304600
5 – Cylinder D. 70 mm.nr. 6	2500026453

XL/6-J

1 – Motor pump MPN44-HZ 1,6/21 SB45 KW 2,1	1003304600
5 – Cylinder D. 70 mm.nr. 6	2500026453

14.2 Heating system diagram



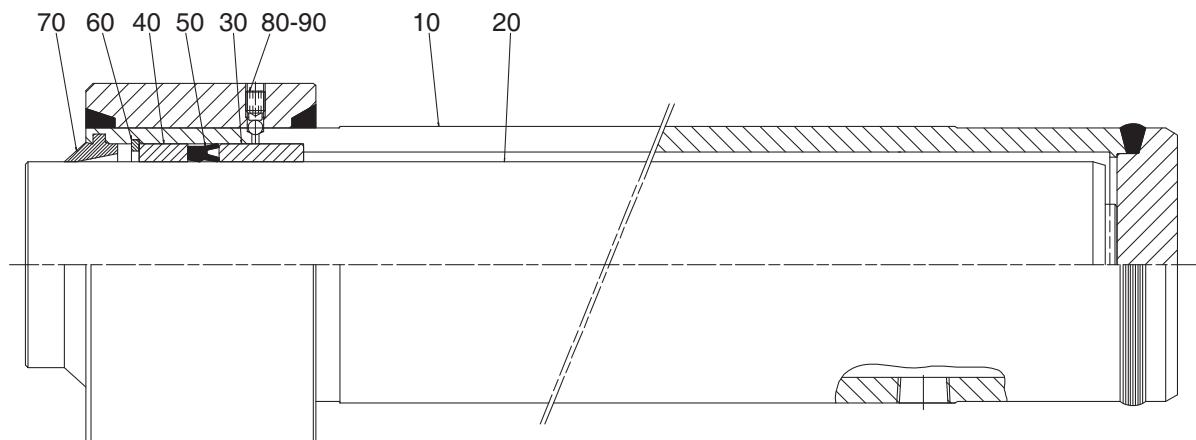
10368/R

1	ELECTROPUMP NM 25/12AE EYXYKRY KW 0,75 2P V.400-50	NRI	I005308650
2	HEATER:		
.....BOILER 13,5 KW: 13500 W V 400/50 HZ		NRI	I016254144
.....BOILER 18 KW: 9000 W V 400/50 HZ		NR2	I016254104
.....BOILER 18 KW: 18000 W V 400/50 HZ		NRI	I016254174
.....BOILER 27 KW: 13500 W V 400/50 HZ		NR2	I016254144
.....BOILER 36 KW: 18000 W V 400/50 HZ		NR2	I016254174
3	SPHEREVALVE ART. 2300 3/4"	NRI	I020091760
4	VALVE ADR-25 1" GAS	NRI	I020094250
5	BLOW-OFF VALVE ART. 3861 M/F 1/8"	2	I020090095
6	REMOTE THERMOMETER		
7	EXPANSION TANK	NRI	
8	THERMOSTAT A R.A. 0-300°C ART.70137840	NR2	I018400075
9	HOSE 0332 DN12 X450 325G 1/2"	NR2	I018733500
10	HOSE 0332 DN12 X1000 325G 1/2"	NR2	I018733510
11	HOSE 0332 DN19 X--- 325G+325G 3/4"	NRI	
12	HOSE 0332 DN19 X--- 325G+325G 3/4"	NRI	
13	MANIFOLD	NRI	
14	PRESSURE SWITCH 31-10-22A 1/4" TI,5S MEMBR.VITON	NRI	I014720270
15	HOSE 0332 DN19 X650 325G 1"	NRI	I061005146
15	HOSE 0332 DN19 X500 325G 1"	NRI	I018733605

I 4.3 Cylinders

Thrust cylinder XL/6-XL/8

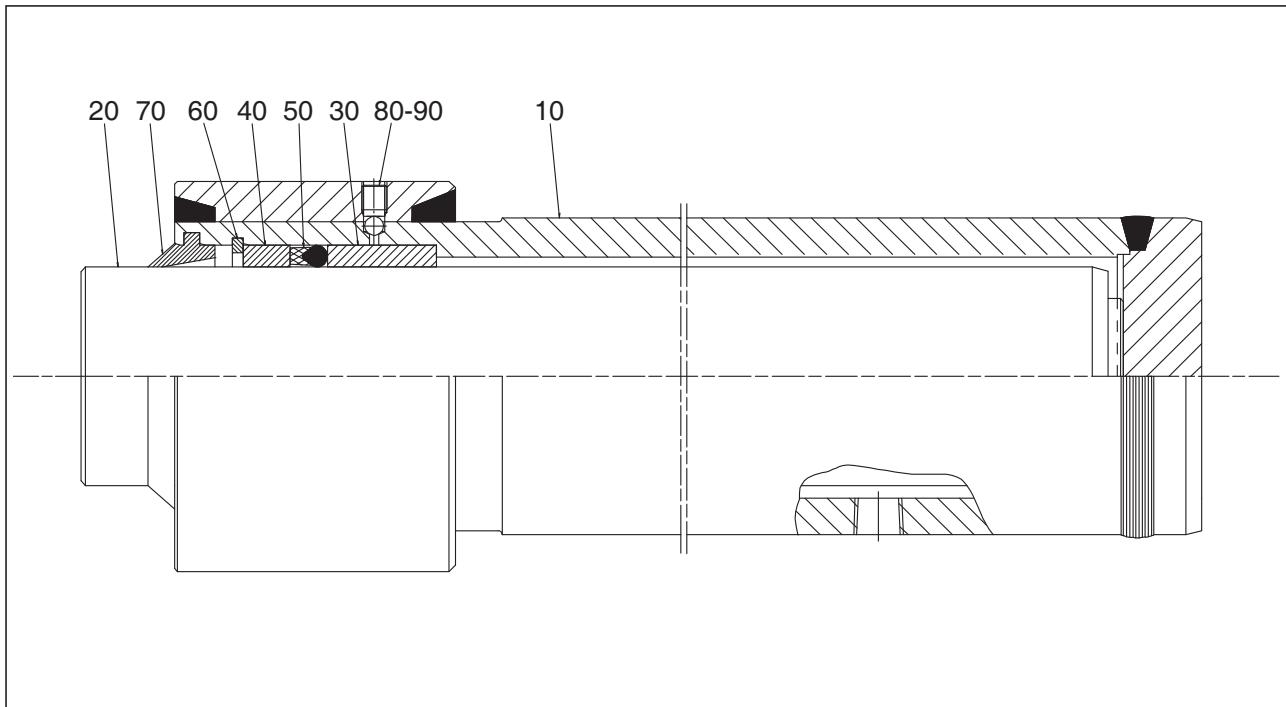
D. 85 - 2500028107



CODICE	POS	DESCRIPTION	N.PZ
2500000594	10	JACKET	1
2500000595	20	SHAFT	1
2500028106	30	BUSHING FOR CYLINDER LG.35	1
2500028105	40	BUSHING FOR CYLINDER LG.20	1
1007903785	50	GASKET EHRCO-HALLITE 605-4306800 85 X100X13	1
1017201320	60	STOP RING SEEGER PER INT. UNI 7437 D.100	1
1016150720	70	SCRAPER RING 85 TIPO RI	1
1007630280	80	DOWEL	1
1017440200	90	SPHERE	1

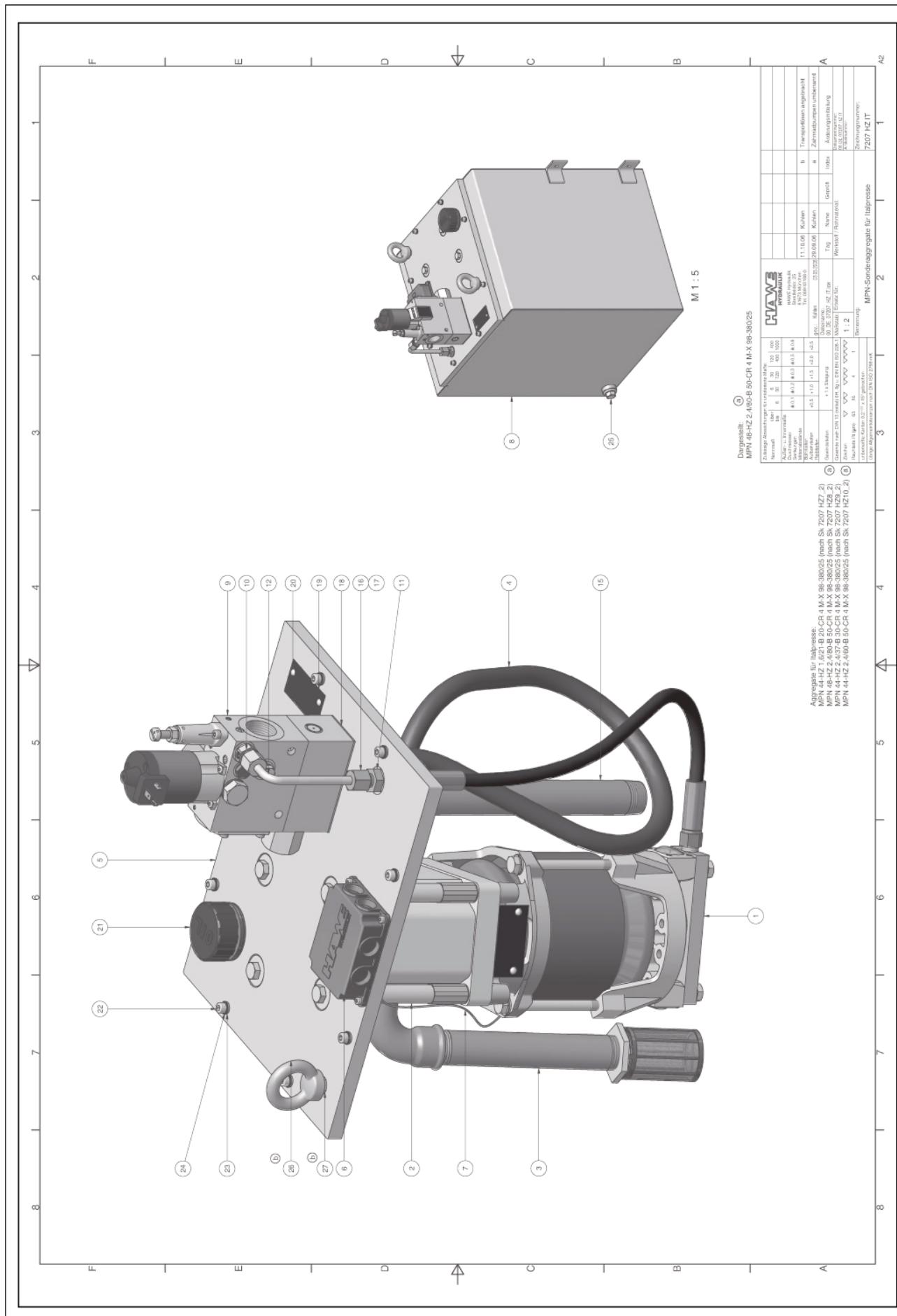
Thrust cylinder XL/6-S - XL/6-J - XL/8-S - XL/8-J

D. 70 - 2500026453



CODICE	POS	DESCRIPTION	N.PZ
2500000096	10	JACKET	1
2500000095	20	SHAFT	1
2500026449	30	BUSHING SP.35	1
2500026450	40	BUSHING SP.15	1
I007902520	50	GASKET FAGI R 4070 70X84X12	1
I017201280	60	STOP RING SEEGER PER INT. UNI 7437 D.85	1
I016150640	70	SCRAPER RING ITAL. 70/R1 D.69X86X22	1
I007630320	80	DOWEL	1
I017440200	90	SPHERE D6	1

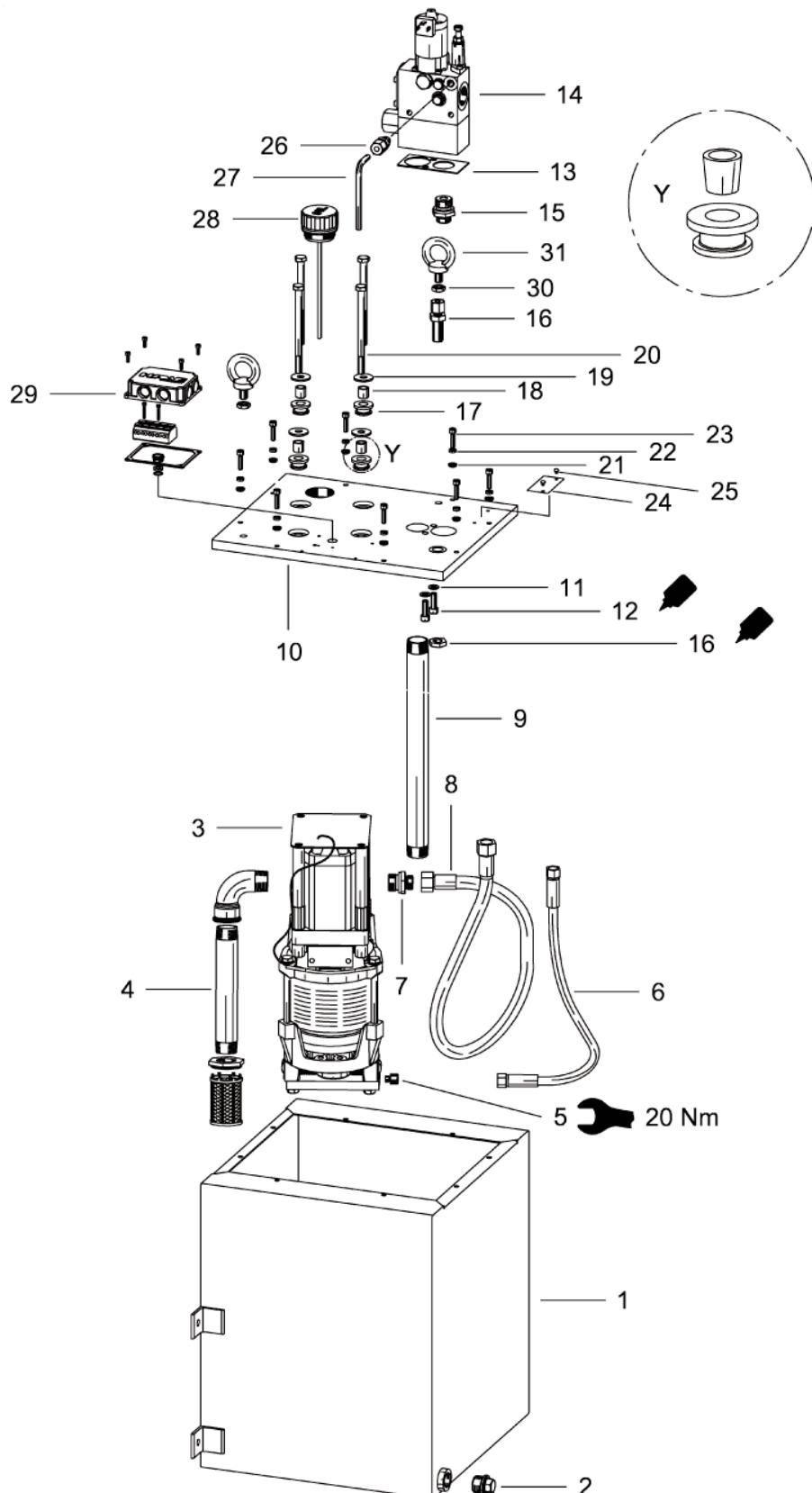
14.4 Motor pump group



						Stückliste 7207 HZ IT			Blatt 1/1	
						<u>MPN-Sonderaggregate für Italpresse</u>				
						<u>Druckeinstellungen am CR 4 M: 380/25</u>				
f	e	d	c	b	a	Benennung und Bemerkung			Zeichnungs-Nr.	Teil
			MPN 48-HZ 2,4/80 B 50-CR 4 M-X 98			MPN Grundpumpe komplett n. Stckl. *)			7207 710	1
			MPN 44-HZ 2,4/60 B 50-CR 4 M-X 98			MPN Befestigung C n. Stckl.			7207 725 c	2
			MPN 44-HZ 2,4/37 B 30-CR 4 M-X 98			MPN Befestigung D n. Stckl.			7207 725 d	
			MPN 44-HZ 1,6/21 B 20-CR 4 M-X 98			MPN Befestigung G n. Stckl.			7207 725 g	
					1	MPN Saugteile n. Stckl.			7207 730 h	3
					1	MPN Saugteile n. Stckl.			7207 730 l	(d)
		1				MPN Saugteile n. Stckl.			7207 730 i	(d)
					1	MPN Druckteile n. Stckl.			7207 740 ee	(c)
					1	MPN Druckteile n. Stckl.			7207 740 gg	(c)
		1				MPN Druckteile n. Stckl.			7207 740 kk	(d)
		1	1	1	1	Deckplatte D 20			7207 612 kpl	5
		1	1	1	1	MPN Klemmenkasten n. Stckl.			7207 752	6
		1	1	1	1	MPN Schutzleiter komplett n. Stckl.			7207 770	7
					1	Behälter B 20			7207 605 kpl	8
					1	Behälter B 30			7207 604 kpl	
		1	1			Behälter B 50			7207 606 kpl	
		1	1	1	1	Abschaltventil CR 4 M n. Stckl.			7150 000	9
		1	1	1	1	Ermeto GE 08-S R 1/4				10
		1	1	1	1	Ermeto SV 8-S				11
		1	1	1	1	Druckrohr			7207 983	12
		2	2	2	2	Zylinderschraube ISO 4762-M8x25-8.8-A2K				13
		2	2	2	2	Federring DIN 127-A8				14
		1	1	1	1	Doppelnippel DIN 2982 1 ZLx360				15
		2	2	2	2	Ermeto M 8-S				16
		2	2	2	2	Ermeto PSR 8-L/X				17
		1	1	1	1	Dichtung			7161 050	18
		1	1	1	1	Typenschild			7207 050...	19
		2	2	2	2	Kerbnagel ISO 8746 A 4x6				20
		1	1	1	1	Belüftungsfilter			7207 126	21
		8	8	8	8	Zylinderschraube ISO 4762-M6x25-8.8-A2K				22
		8	8	8	8	DUBO-Zahntellerring M6 Nr. 404				23
		8	8	8	8	DUBO-Schraubensicherung M6 Nr. 301				24
		1	1	1	1	Verschlusschraube mit Dichtring-G 3/4 A-NBR				25
		2	2	2	2	Ringschraube ISO 3266-M12-A2K				26
		2	2	2	2	Sechskantmutter DIN ISO 4035-M12-A2K				27
						*) Achtung:				
						Für Spalten c und d folgende Zahnrädpumpen verwenden:				
		1				Zahnradpumpe Z 80				
						ALP 3-S-80-CO-FG-MU (Marzocchi)				
		1				Zahnradpumpe Z 60				
						ALP 3-S-60-CO-FG-MU (Marzocchi)				
						Für Spalte d folgende Änderungen vornehmen:				
						In Stückliste 7207 740 kk Ermeto RI 1-ED x 1/2				
						hinzufügen!				
						In Stückliste 7207 730 i Fitting Nr 92 1 ZI (Pos 3) durch				
						Fitting Nr. 92 1 - 1 1/4 ersetzen!			03.05.06	
Ersatz für:	Änderung:	HAWE HYDRAULIK						HAWE Hydraulik		
		Streiffeldstr. 25, 81673 München						7208 HZ IT		



SK 7207 HZ. 2





SK 7207 HZ. 2

Part No.	Qty.	Item	Nomenclature	Drawing No.	Add. Information
3705 504700	1	1	TANK B 20 COMPL.	7207 605	with coding B 20
3705 504600	1	1	TANK B 30 COMPL.	7207 604	with coding B 30
3705 504500	1	1	TANK B 50 COMPL.	7207 606	with coding B 50
3013 410800	1	2	TAPPED PLUG COMPL.WITH ELAST.SEAL G 3/4 A		
6801 096601	1	3	MPN 44-HZ 1.6/21 COMPL.	7207 710 D	
6801 096602	1	3	MPN 44-HZ 2.4/37 COMPL.	7207 710 D	
6801 096603	1	3	MPN 44-HZ 2.4/60 COMPL.	7207 710 D	
6801 096604	1	3	MPN 44-HZ 2.4/80 COMPL.	7207 710 D	
6801 057810	1	4	SUCTION COMPONENTS MPN 4-HZ 45	7207 730 H	with Pump MPN44-HZ 1.6/21
6801 057813	1	4	SUCTION COMPONENTS MPN 4-HZ 37	7207 730 L	with Pump MPN44-HZ 2.4/37
6801 057811	1	4	SUCTION COMPONENTS MPN 4-HZ 59 + 75	7207 730 I	with Pumps MPN44-HZ 2., 4/60 and MPN44-HZ 2.4/80
3026 407500	1	5	TAPPED SECTION	7207 013	Max. torque 20 Nm
3018 600900	1	6	PRESSURE HOSE HD 600 MM		
6030 921600	1	7	GE 10-L/R 1/2-ED/O CO.ERMETO	GE10LR1/2EDOMD A3C	with Pump MPN44-HZ 1.6/21
6030 967900	1	7	GE 18-L/R 3/4-ED/O CO.ERMETO	GE18LR3/4EDOMD A3C	with Pump MPN44-HZ 2.4/37
6030 956800	1	7	GE 18-LR-ED/OMD CO.ERMETO	GE18LREDOMDA3 C	with Pumps MPN44-HZ 2.4/60 und MPN44-HZ 2.4/80
3018 600800	1	8	PRESSURE HOSE DN 8 600 MM		with Pump MPN44-HZ 1.6/21
3018 602000	1	8	PRESSURE HOSE DN 16 600 MM		with Pumps MPN44-HZ 2.4/37; MPN44-HZ 2.4/60 und MPN44-HZ 2.4/80
6045 091200	1	9	DOUBLE NIPPLE 1" X 360		
3407 441000	1	10	COVER PLATE D 20 KPL.	7207 612	
6083 020100	2	11	LOCK WASHER SHAPE A DIN 127 8		
6005 022300	2	12	SKT.-HEAD SCREW ISO 4762 8X40 8.8 A2K		
4765 416500	1	13	SEAL	7161 050	Secured with liquid threadlocker !
6800 309000	1	14	CR 4 M-WG 110	7150 000 E	
6030 923400	1	15	RJ 3/4-ED X 3/8 CO.ERMETO	RJ3/4EDX3/8A3C	with Pump MPN44-HZ 1.6/21
6030 967900	1	15	GE 18-L/R 3/4-ED/O CO.ERMETO	GE18LR3/4EDOMD A3C	with Pumps MPN44-HZ 2.4/37; MPN44-HZ 2.4/60 und MPN44-HZ 2.4/80
6031 642600	1	16	SV 8-S/OMD CO.ERMETO	SV08SOMDA3C	Nut of the fitting secured with liquid threadlocker !
6130 310200	1	16..1	DPR 8-L/S CUTTING EDGE RING CO.ERMETO		
6066 120100	1	16..2	M 8-S SLEEVE NUT A 3 C (YELLOW CO.ERM		
3004 448800	4	17	GROMMET	7207 010	

**SK 7207 HZ. 2**

Part No.	Qty.	Item	Nomenclature	Drawing No.	Add. Information
3004 452400	4	18	SLEEVE	7207 008	Observe mounting, see detail "Y"
6075 050100	4	19	WASHER DIN 9021 - 10.5		
6005 034700	4	20	HEX.HEAD SCREW ISO 4014-M10 x 170-8-A2K		with Pumps MPN44-HZ 1.6/21; MPN44-HZ 2.4/37 und MPN44-HZ 2.4/60
6000 323100	4	20	HEX.HEAD SCREW ISO 4014-M10 x 140-8-A2K		with Pump MPN44-HZ 2.4/80
6083 910100	8	21	LOCK WASHER CO.DUBO M 6 PART NO. 404		
6084 410100	8	22	SCREW LOCK CO.DUBO M 6 PART NO. 301 NYLON		
6005 017100	8	23	SKT.-HEAD SCREW ISO 4762 6X25 8.8 A2K		
4708 476800	1	24	TYPE PLATE, BLANK	7207 050	Blank !
6140 311200	2	25	GROOVED DRIVE STUD ISO 8746 4X6-ST -A2K		
6030 951600	1	26	GE 8-SR-ED/OMD CO.ERMETTO	GE08SRERDOMDA3C	
6130 310200	1	26.1	DPR 8-L/S CUTTING EDGE RING CO.ERMETTO		
6066 120100	1	26.2	M 8-S SLEEVE NUT A 3 C (YELLO CO.ERM		
3018 451000	1	27	PRESSURE PIPE	7207 983	
6285 550500	1	28	BREATHER WITH DIPSTICK	7207 126	
6801 055801	1	29	TERMINAL BOX MPN 4	7207 752 A	Complete
6065 730300	2	30	HEXAGON NUT SHAPE B DIN 439 12 04 A2K		
6016 120400	2	31	EYE BOLT ISO 3266-M12-A2K		

I 4.5 Electrical diagrams

FEATURES OF MACHINE

SERIAL NUMBER

DRIVE TENSION

LINE VOLTAGE

FREQUENCY

PHASES

MAXIMUM POWER

FULL LOAD CURRENT

INPUT CABLE SECTION

MODIFICATION

SHEET

DATE

ID C3463213TP

RIF 25341



24060 Bagnatica (Bergamo)
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MODEL

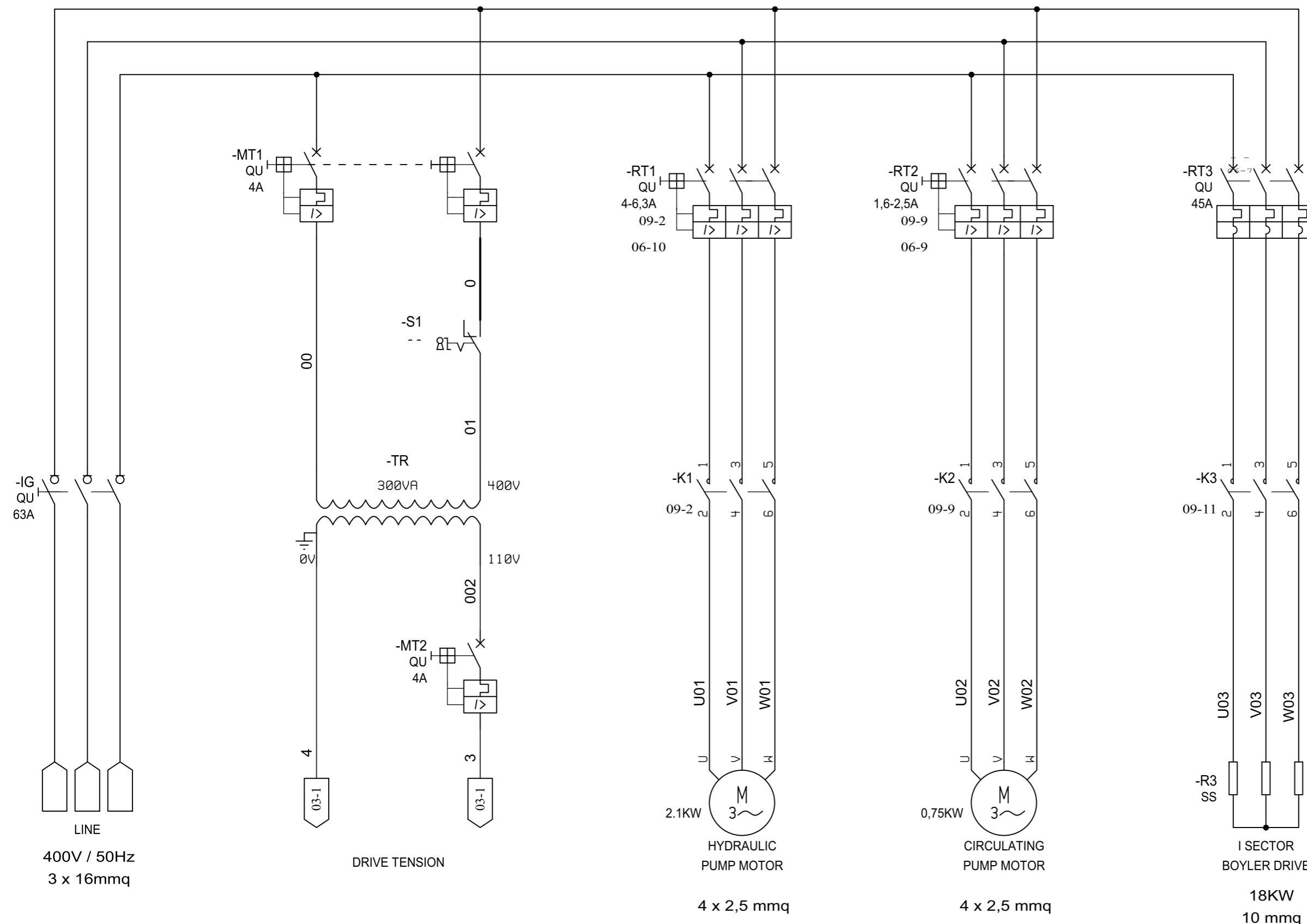
XL/8-S

P25398_P25399

PLANNER

DESIGNER FRANI

DRAW
4561EDATE
02/03/2023SHEET
01



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FABBRICA
MACCHINE PER LEGNO

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MODEL XL/8-S

P25398_P25399

DRAW
4561E

DATE
02/03/2023

PLANNER	
DESIGNER	FRANI
SHEET	02

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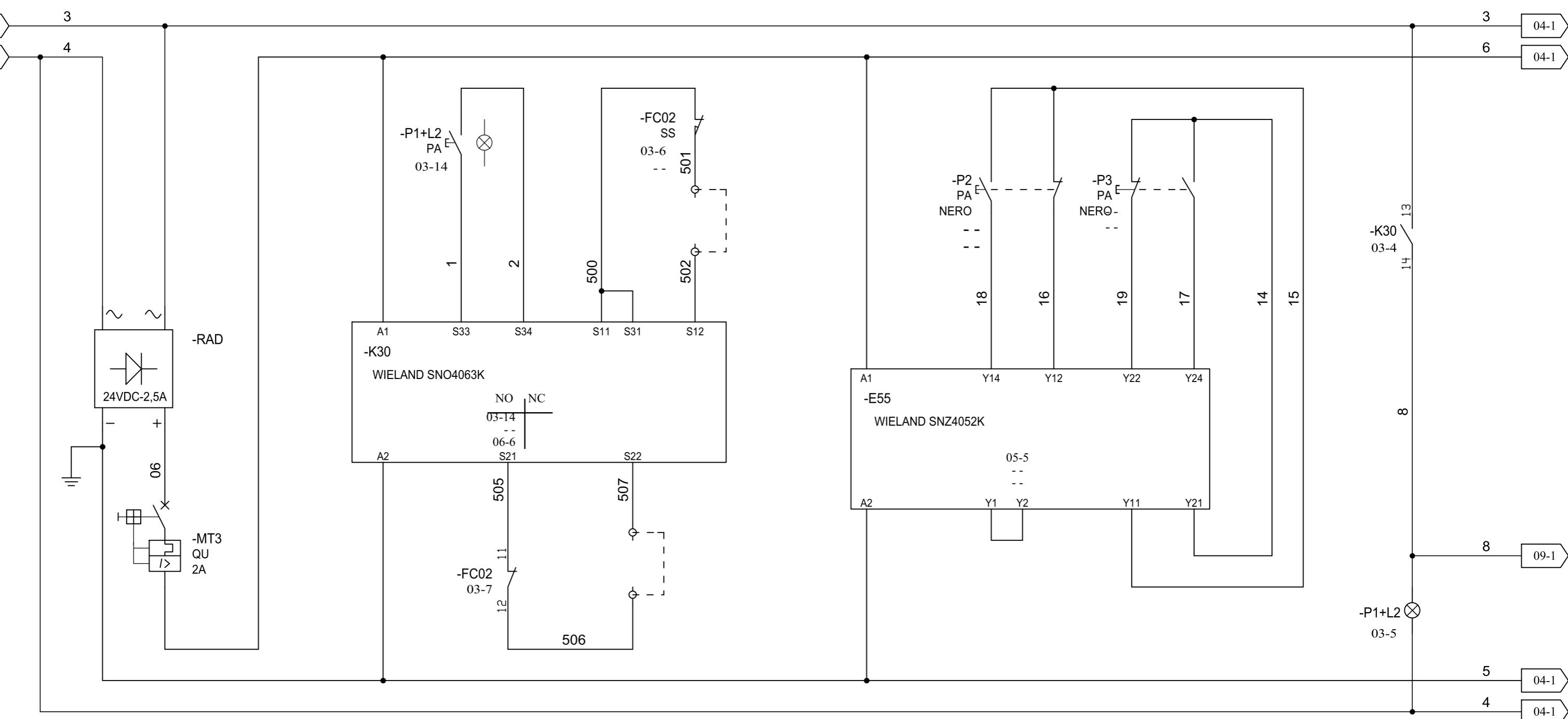
FEEDER

24VDC

EMERGENCIES
CONTROL DEVICE

PRESS CLOSING DUAL
PUSHBUTTON CONTROL DEVICE

FEEDING
ELECTROVALVES
+ CONTACTORS



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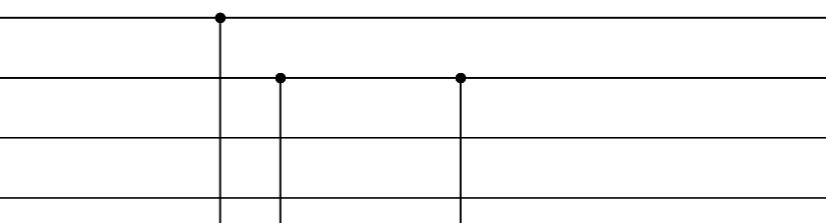
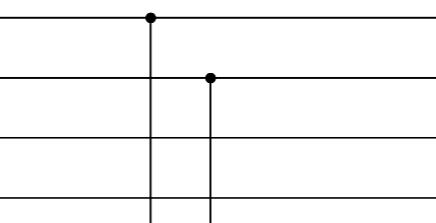
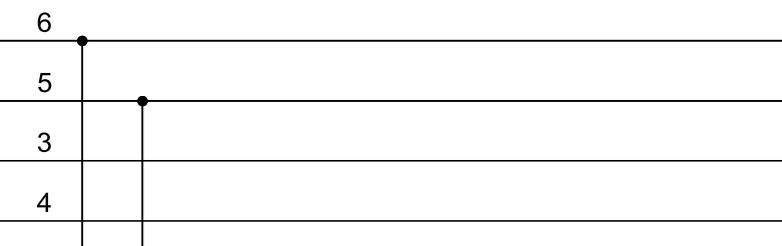
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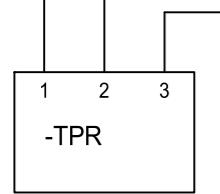
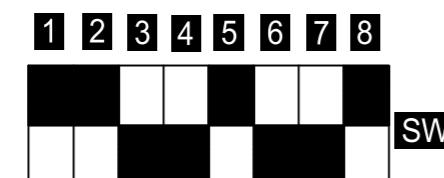
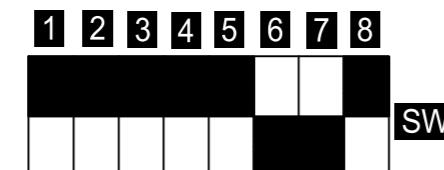
PRESSURE TANSUCCER

CONVERTER
TEMPERATURE CONTROL

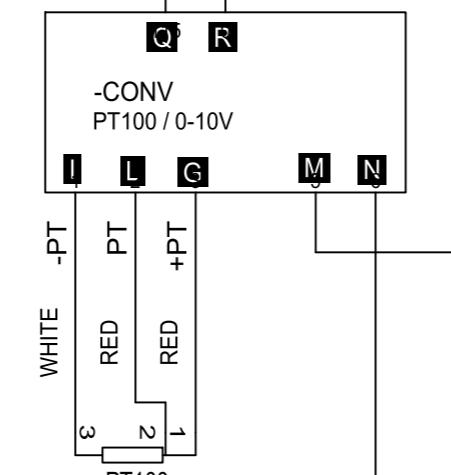
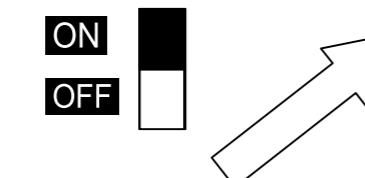
PLC POWER FEED



REGOLAZIONE DIP-SWITCH

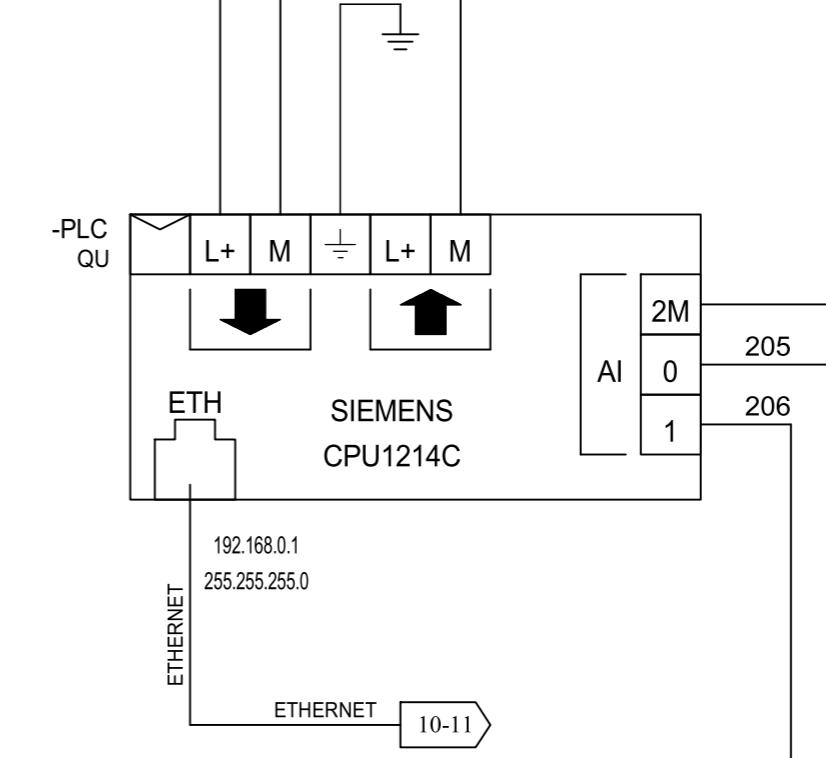


205



THERMORESISTANCE

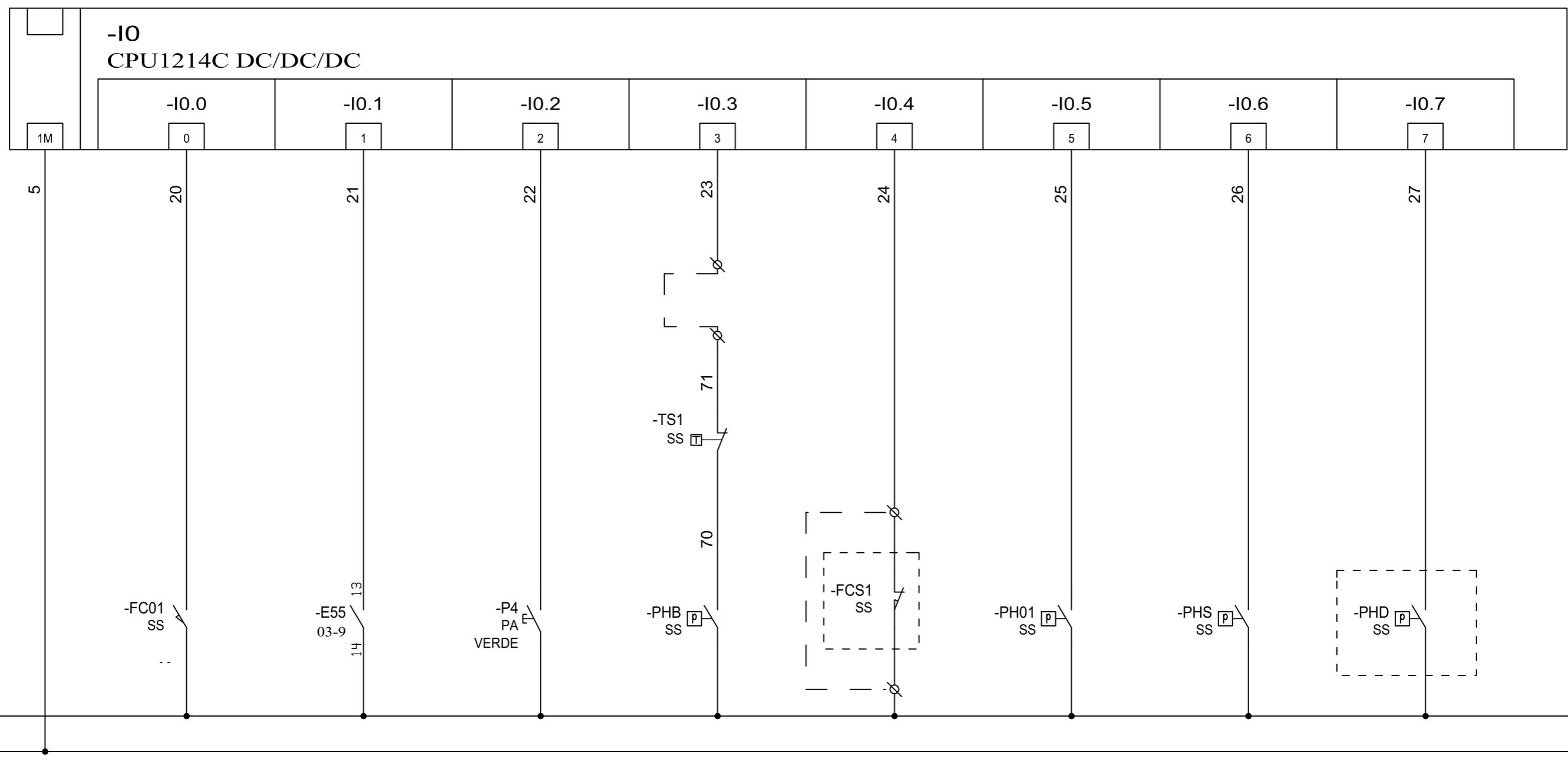
206



ATTENZIONE!!!!
ALIMENTAZIONE 24VDC

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

LIMIT SWITCH PRESS OPENING	CONSENT TO PRESS CLOSING	PRESS OPENING PUSHBUTTON	SAFETY THERMOSTAT +	OPTIONAL	PRESSURE SWITCH FOR PRESS MAX PRESSURE	LEFT EXCLUSION SAFETY PRESS. SWITCH	RIGHT EXCLUSION SAFETY PRESS. SWITCH OPTIONAL
			PRESSURE SWITCH TANK IN PRESSURE				



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MODEL XL/8-S

P25398_P25399

PLANNER

DESIGNER FRANI

DRAW
4561E

DATE
02/03/2023

SHEET
05

PROSSIMITY
CONTROL
PLATEN FLATNESS
SX

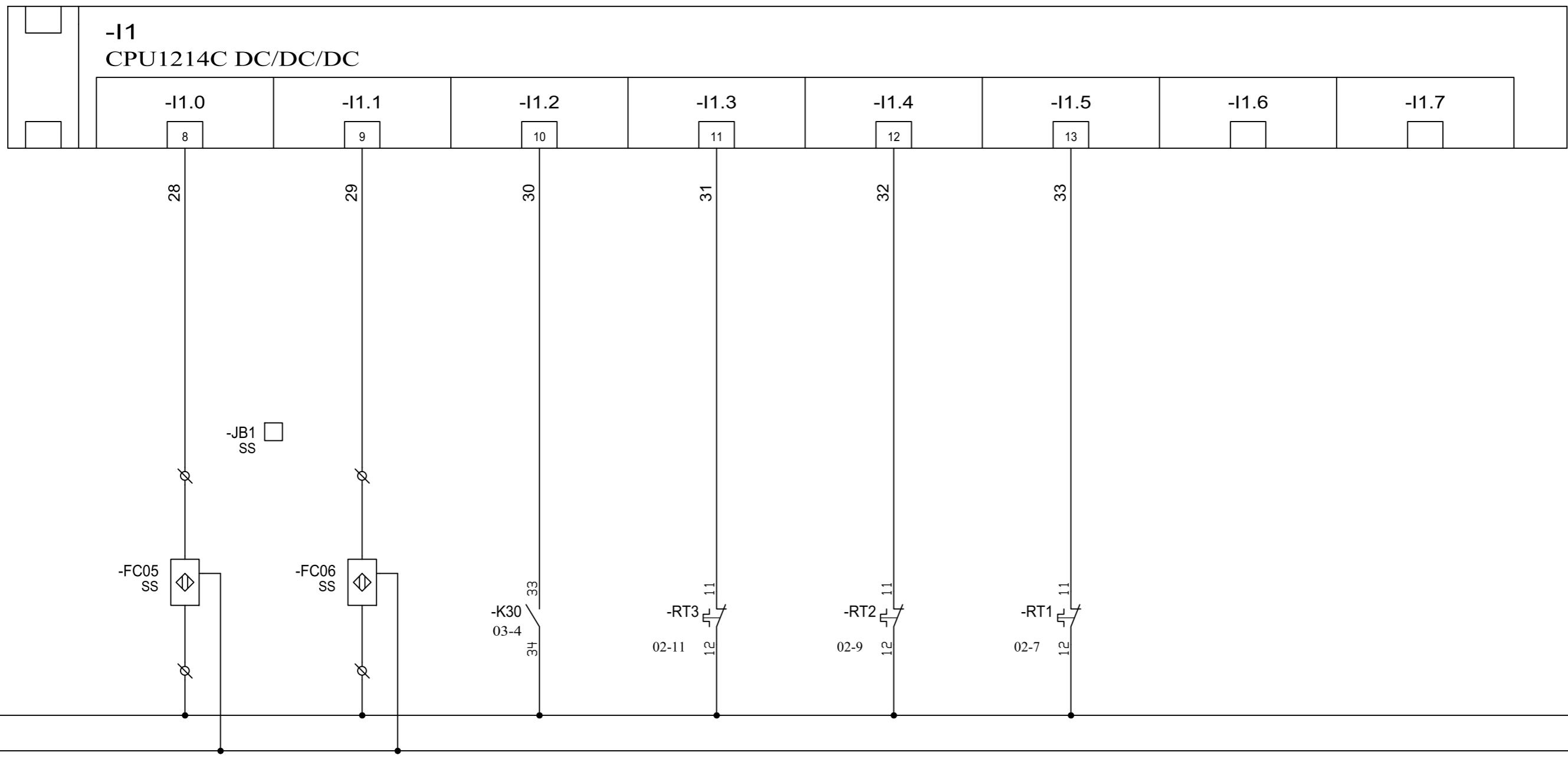
PROSSIMITY
CONTROL
PLATEN FLATNESS
DX

GENERAL
AUXILIARIES
CONSENT

THERMIC CLICK
HEATING UNIT

THERMIC CLICK
CIRCULATION PUMP

THERMIC CLICK
OLEODINAMIC PUMP



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SHEET
06

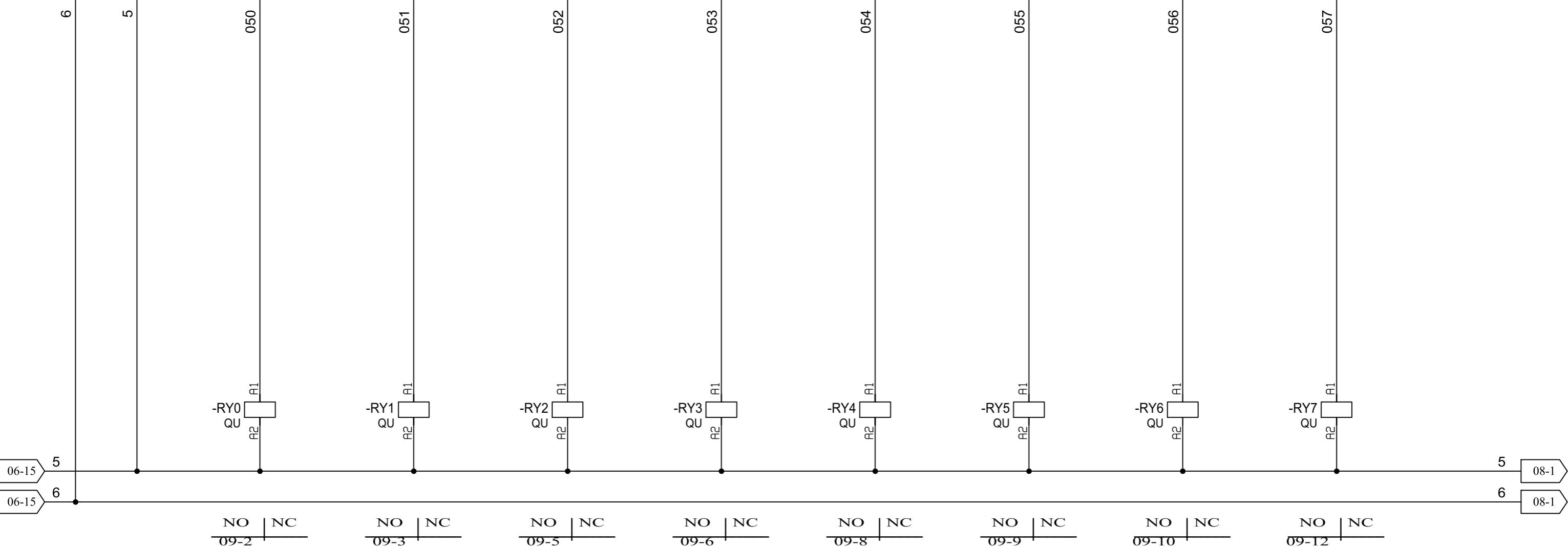
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CONTACTOR
PUMP HYDRAULIK PRESS OPENING
SOLENOID VALVE ELECTROVALVE
LEFT EXCLUSION ELECTROVALVE
RIGHT EXCLUSION SIREN LIQUID CIRCULATION
PUMP CONTACTOR I SECTOR
BOYLER DRIVE FREE

OPTIONAL OPTIONAL

-Q0
CPU1214C DC/DC/DC

	-Q0.0	-Q0.1	-Q0.2	-Q0.3	-Q0.4	-Q0.5	-Q0.6	-Q0.7
	0	1	2	3	4	5	6	7



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MODEL XL/8-S

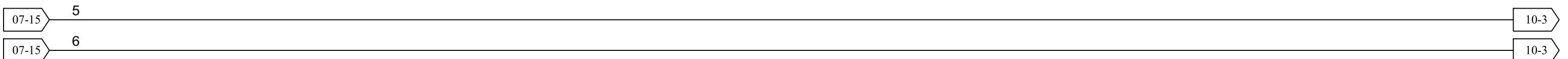
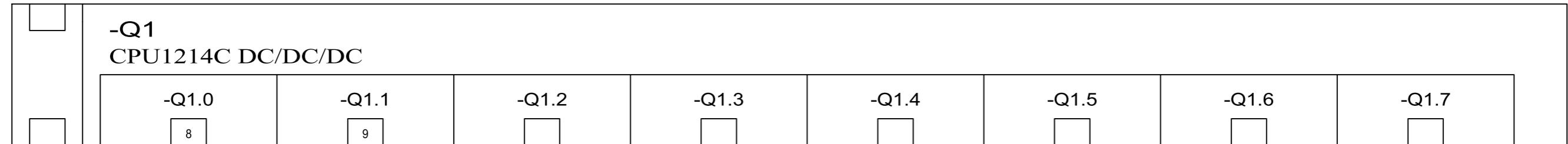
P25398_P25399

PLANNER
DESIGNER FRANI

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DATE
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SHEET
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MACCHINE PER LEGNO

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MODEL	XL/8-S	P25398_P25399	PLANNER
			DESIGNER FRANI
		DRAW 4561E	DATE 02/03/2023
			SHEET 08

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

CONTACTOR
PUMP HYDRAULIK

PRESS OPENING
SOLENOID VALVE

ELECTROVALVE
LEFT EXCLUSION

ELECTROVALVE
RIGHT EXCLUSION

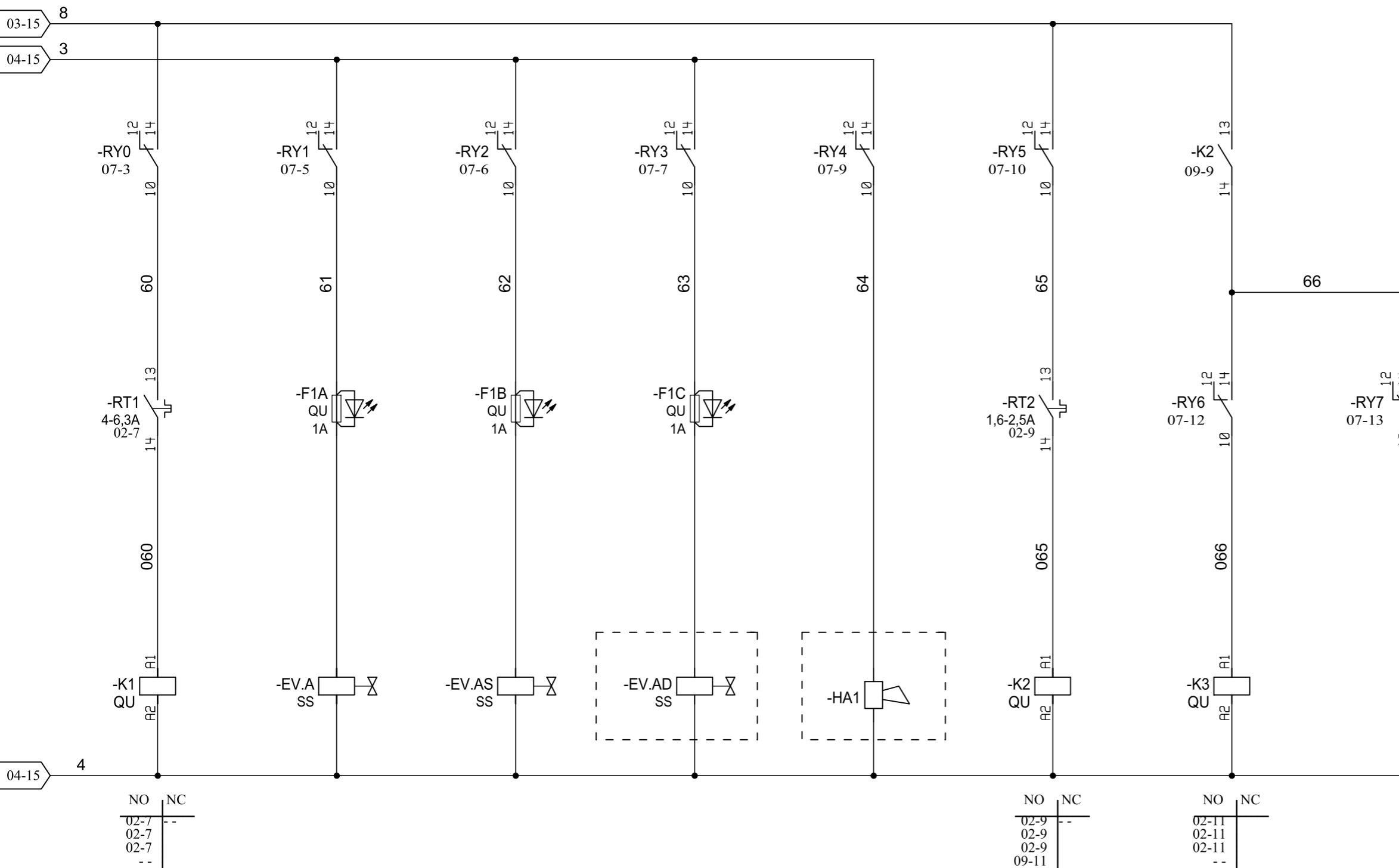
SIREN
OPTIONAL

LIQUID CIRCULATION
PUMP CONTACTOR

I SECTOR
BOYLER DRIVE

FREE

OPTIONAL



ITALPRESSE
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MACCHINE PER LEGNO

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MODEL

XL/8-S

P25398_P25399

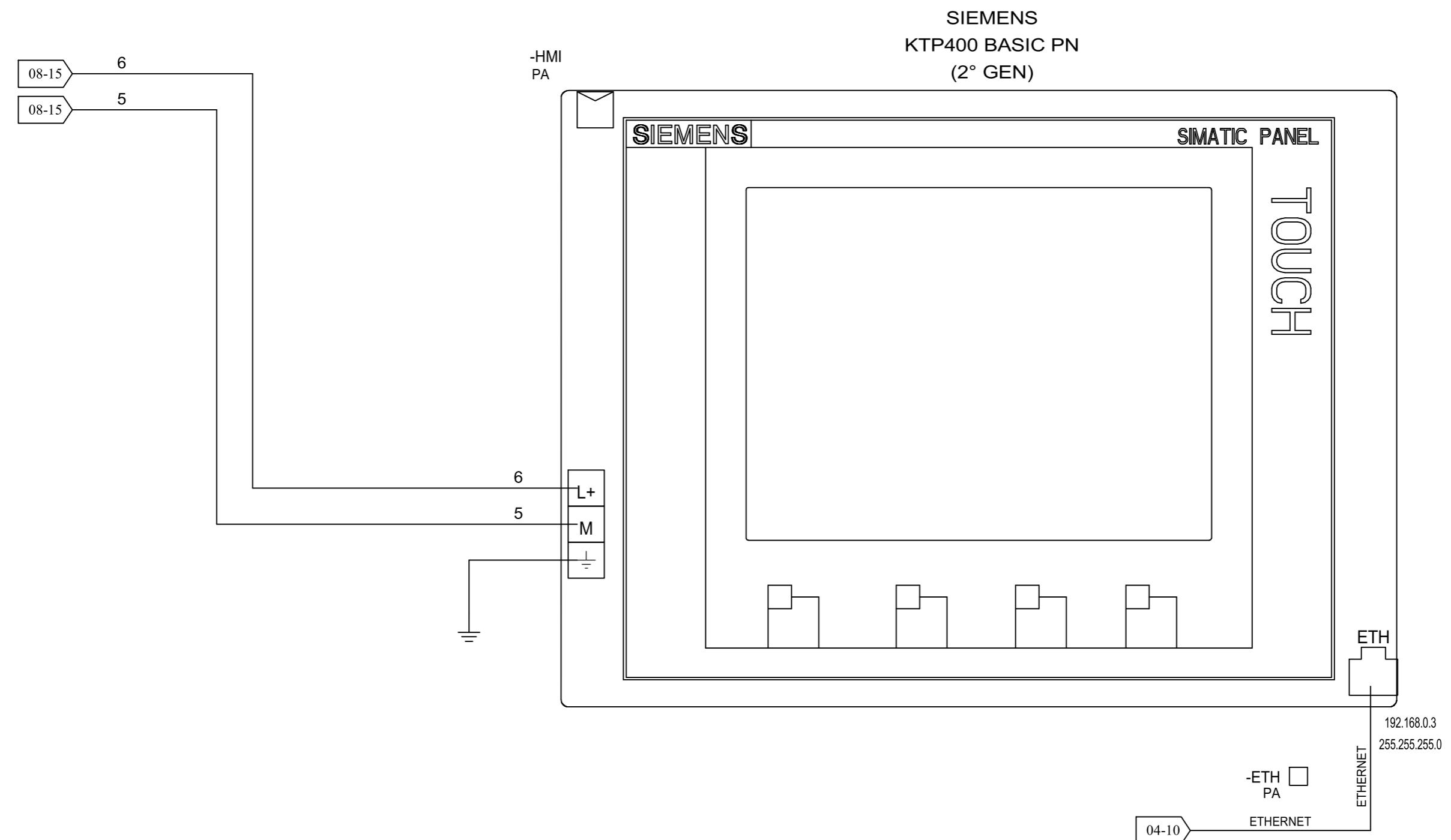
PLANNER

DESIGNER FRANI

DRAW
4561E

DATE
02/03/2023

SHEET
09



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MODEL

XL/8-S

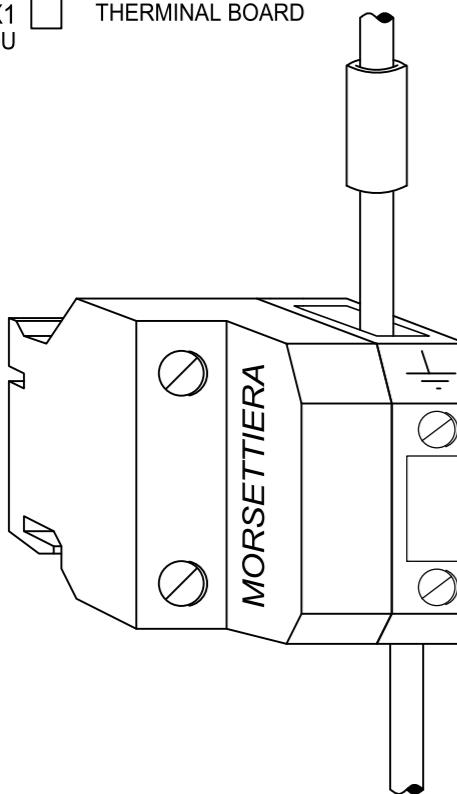
P25398_P25399

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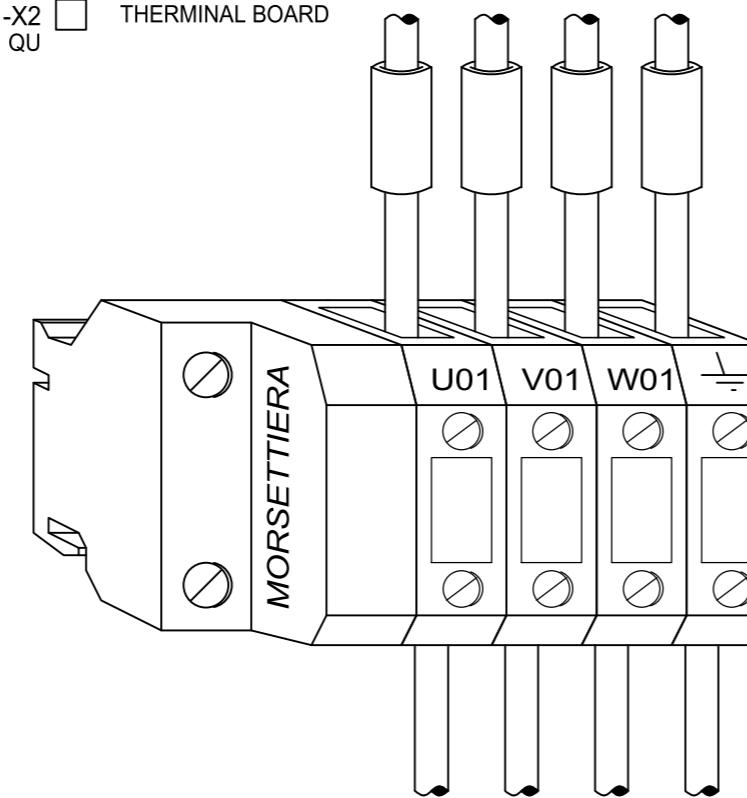
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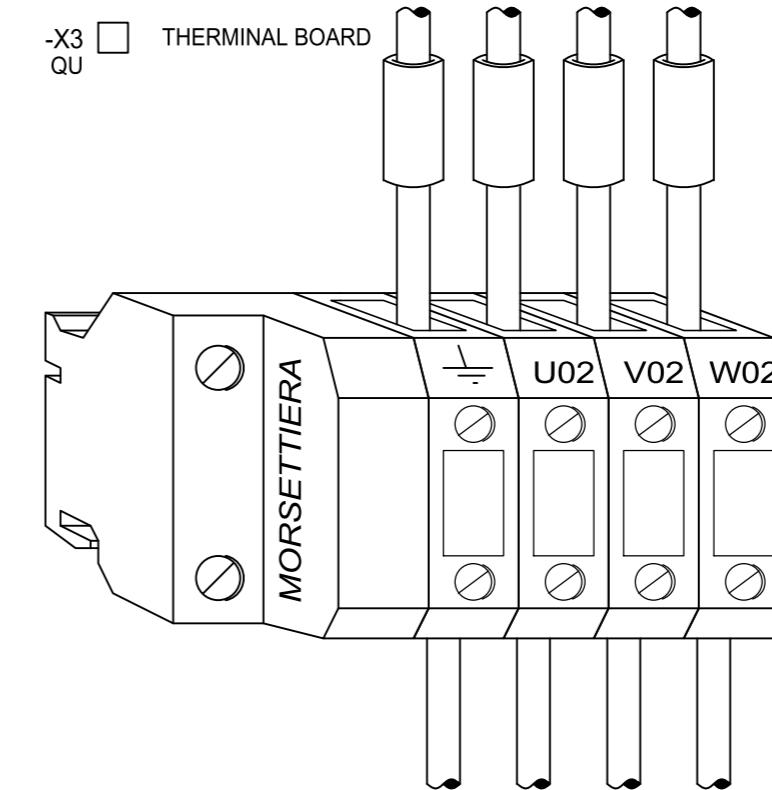
-X1 QU THERMINAL BOARD



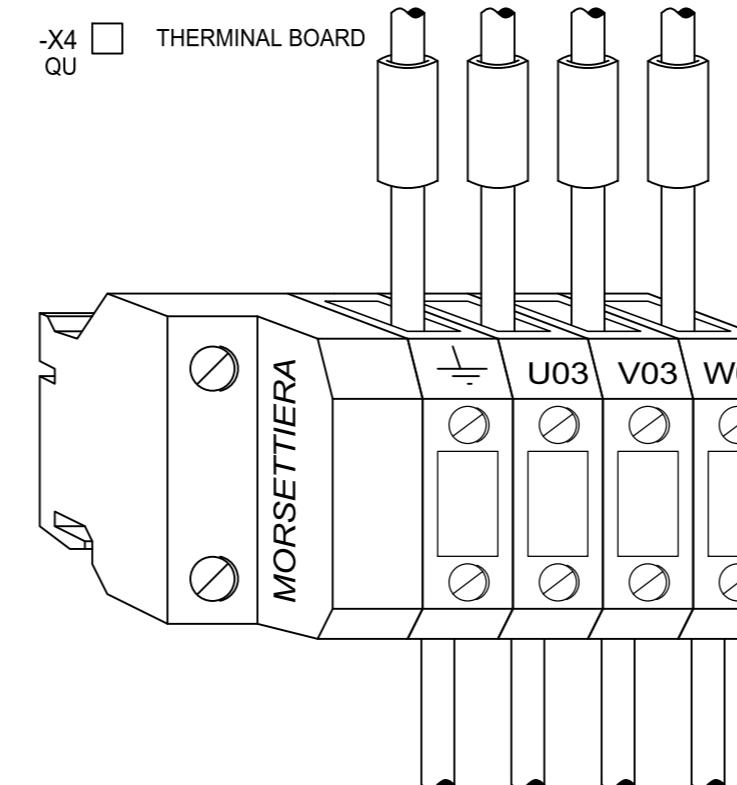
-X2 QU THERMINAL BOARD



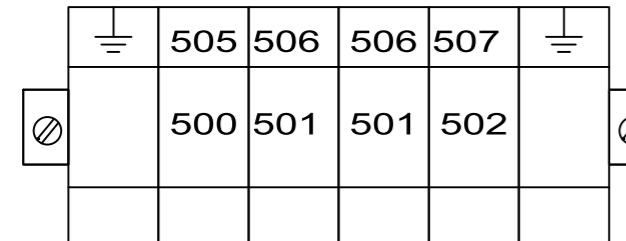
-X3 QU THERMINAL BOARD



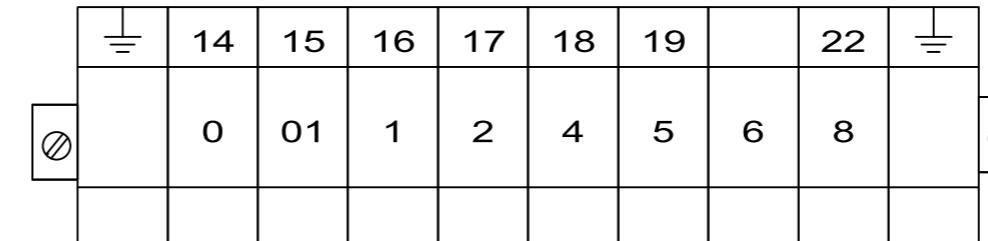
-X4 QU THERMINAL BOARD



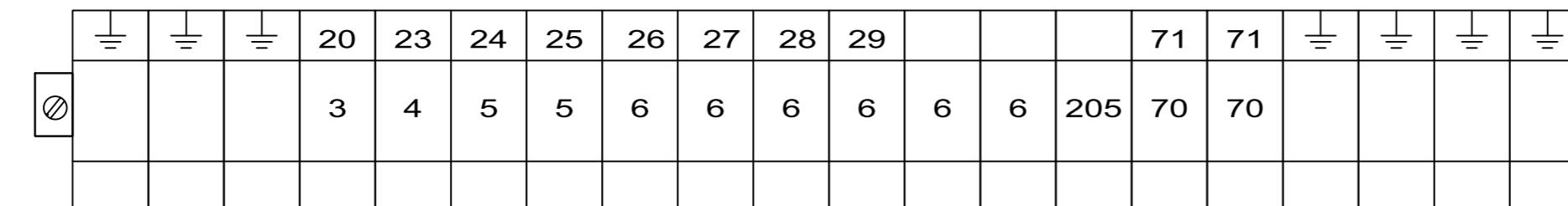
THERMINAL BOARD



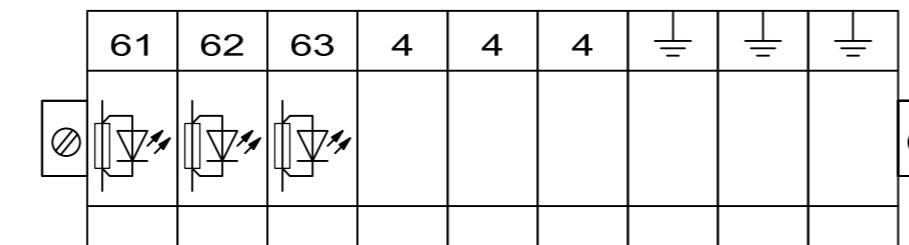
-X6 SAFETY
QU



-X7 CONTROL PANEL
QU



-X8 PRESS
QU



-X9 ELECTROVALVES
QU

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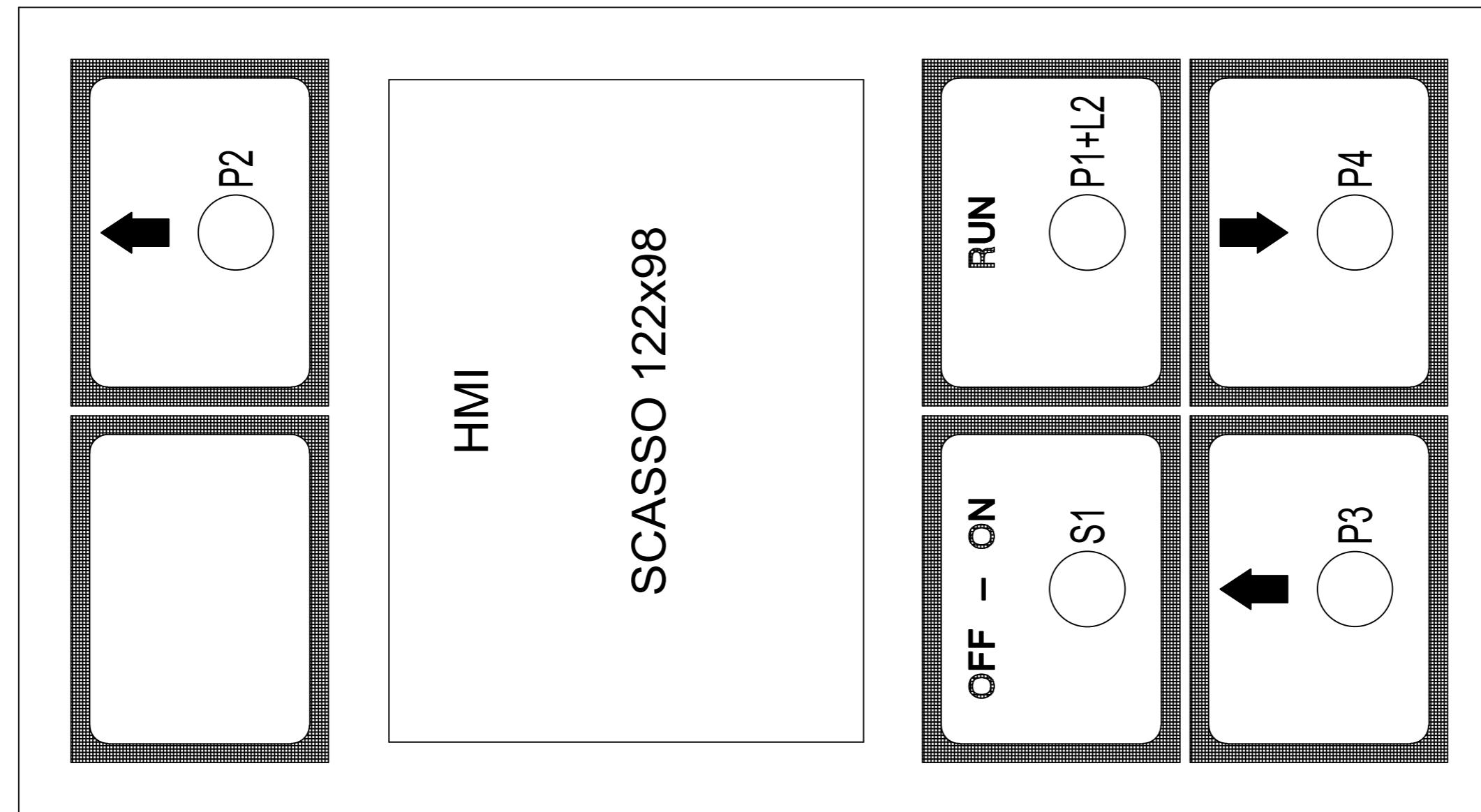
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CONTROL PANEL



-PA
 PA
 PA_TS
 PA

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CONTROL PANEL

S1	OFF-ON SELECTOR KEY
P1+L2	GREEN LIGHT PUSHBUTTON GENERAL AUXILIARIES RUN
P2	BLACK PUSH BUTTON FOR PRESS CLOSING
P3	BLACK PUSH BUTTON FOR PRESS CLOSING
P4	GREEN PUSH BUTTON FOR PRESS OPENING
HMI	CONTROL UNIT

PANEL LINE

18X1 mt6

1 --- 0
 2 --- 01
 3 --- 1
 4 --- 2
 5 --- 4
 6 --- 5
 7 --- 6
 8 --- 8
 9 ---
 10 --- 18
 11 --- 19
 12 --- 22
 13 ---
 14 --- 14
 15 --- 15
 16 --- 16
 17 --- 17



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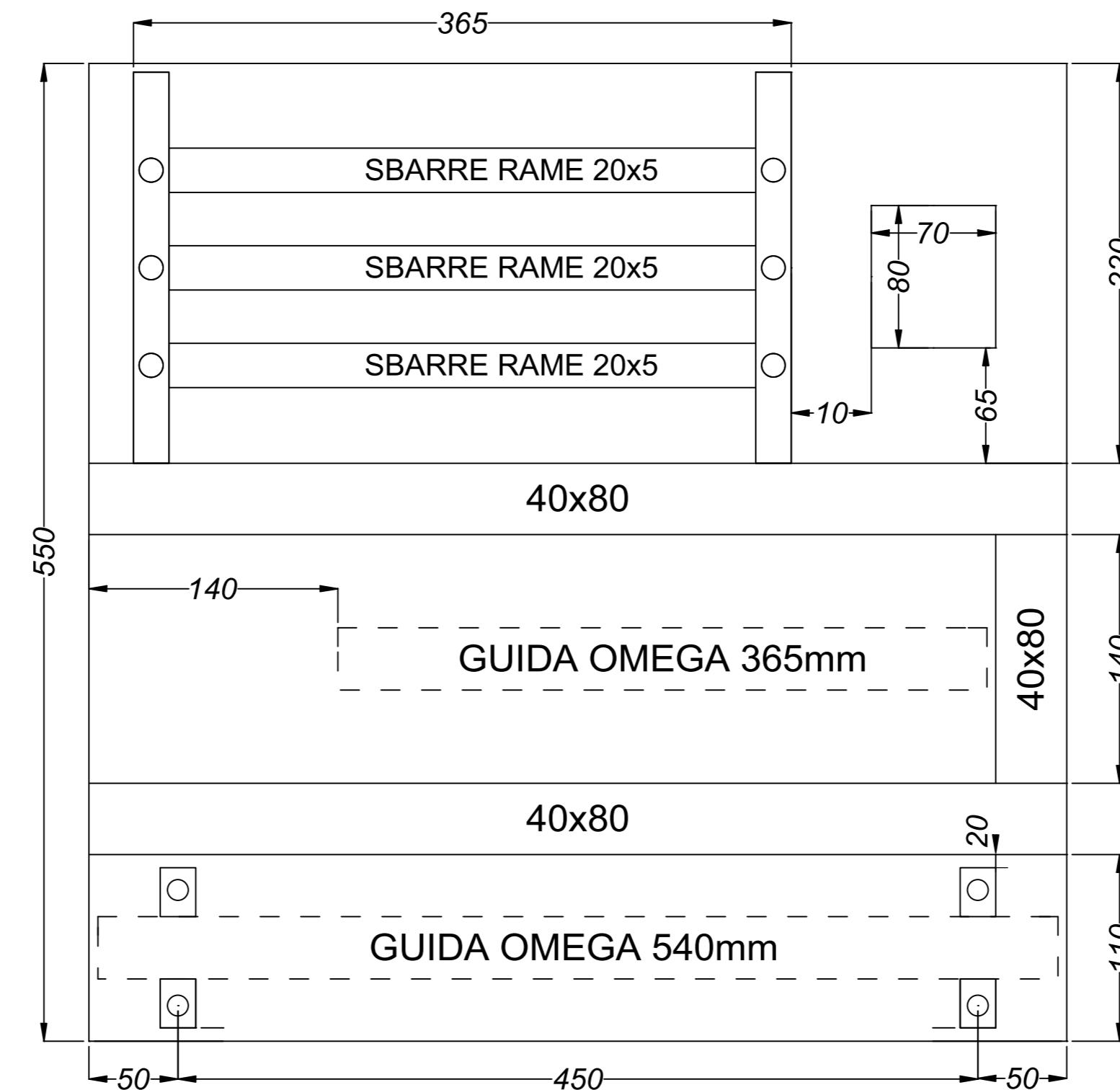
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ELECTRIC-BOARD



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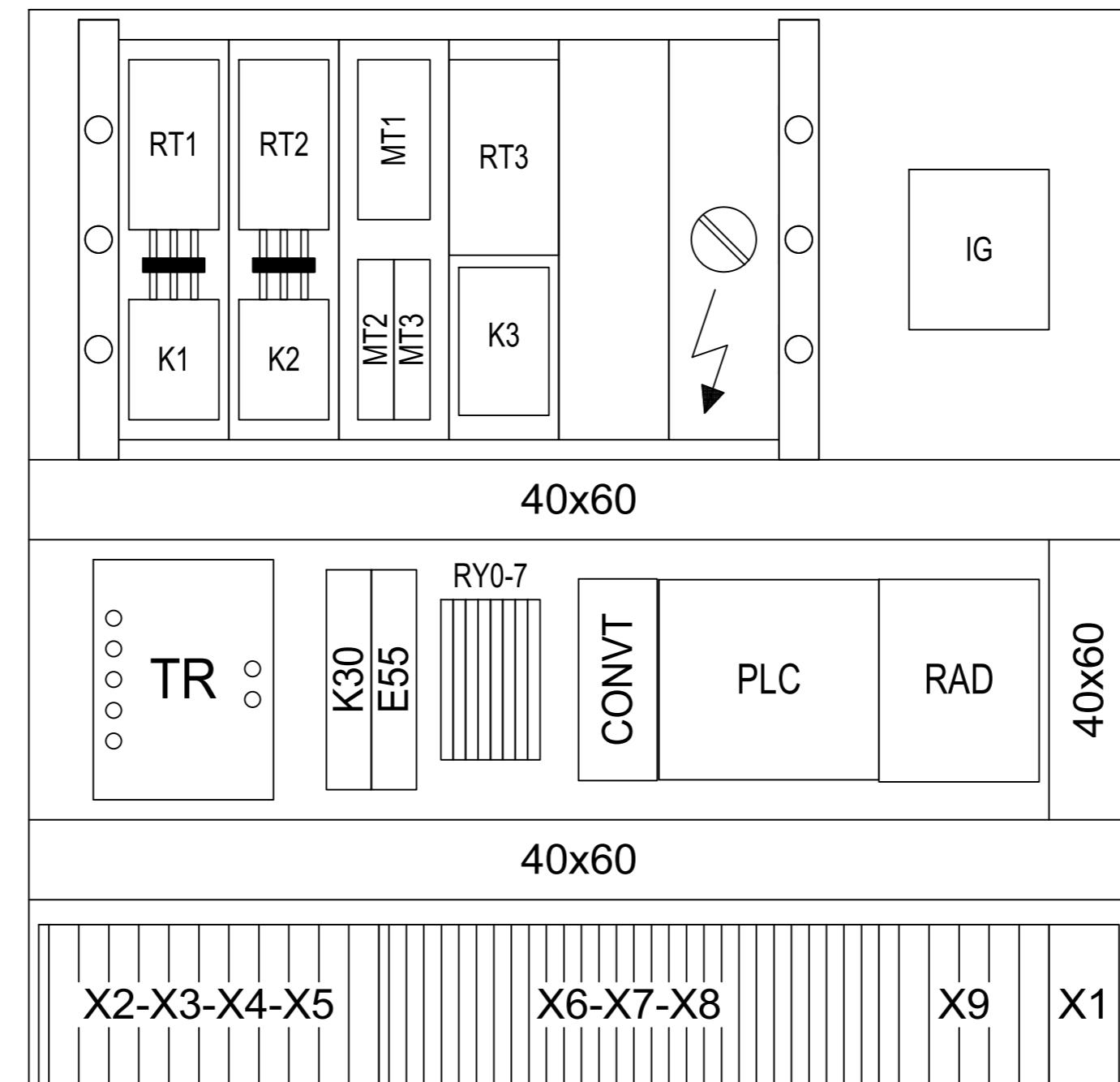
DESIGNER FRANI

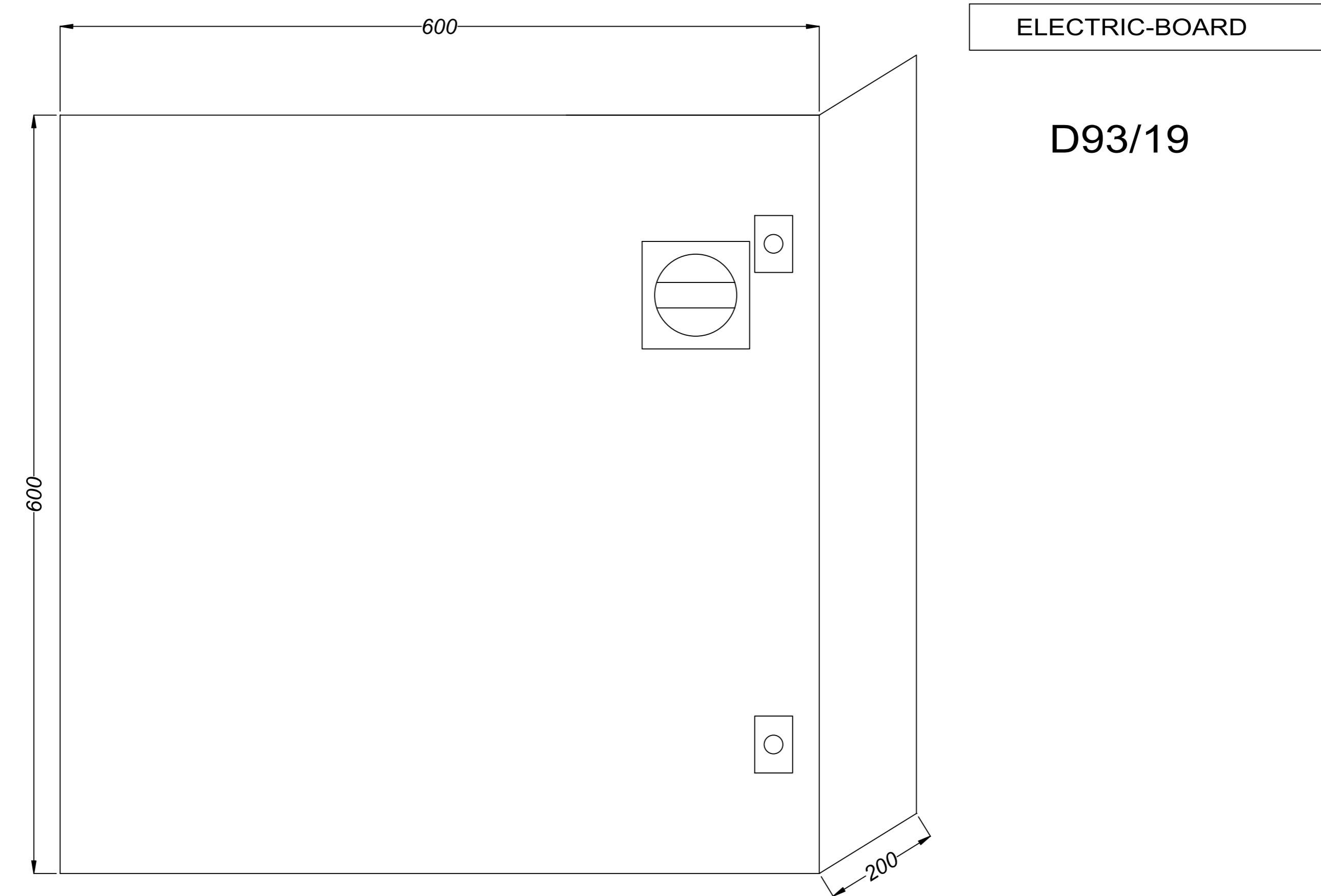
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ELECTRIC-BOARD





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Listato materiale

Pag.	Sigla	Codice	Descrizione 1	Descrizione 2	Descrizione 3	Ubicazione
002	-S1	1003470280	SELETTORE A CHIAVE XB4-BG21	(EX.XB2-BG21)	(EX.XB2-BG21)	PA
003	-P1+L2	1002060083	BASE DI FISSAGGIO ZB4-BZ009 PER	PULSANTERIA TELEMECANIQUE		PA
003	-P1+L2	1005100240	ELEMENTO DI CONTATTO ZBE 101 (NO)			PA
003	-P1+L2	1005100312	ELEMENTO LUMINOSO LED 110V VERDE	ZBV-G3 PER PULSANTERIA		PA
003	-P1+L2	1014842041	TESTA PULSANTE LUMIN. VERDE	ZB4-BW333 -TELEMECANIQUE-	(EX.ZB2-BW33)	PA
003	-P1+L2	2064180120	PULS.LUMIN.VERDE + 1 NO + LAMP.	130V TELEMECANIQUE		PA
003	-P2	1002060083	BASE DI FISSAGGIO ZB4-BZ009 PER	PULSANTERIA TELEMECANIQUE		PA
003	-P2	1005100240	ELEMENTO DI CONTATTO ZBE 101 (NO)			PA
003	-P2	1005100280	ELEMENTO DI CONTATTO ZBE 102 (NC)	(EX ZB2-BE102)	(EX ZB2-BE102)	PA
003	-P2	1014841520	PULSANTE NERO ZB4-BA2		(EX.ZB2-BA2)	PA
003	-P2	2064180114	PULSANTE NERO + CONT. NO + CONT. NC	TELEMECANIQUE		PA
003	-P3	1002060083	BASE DI FISSAGGIO ZB4-BZ009 PER	PULSANTERIA TELEMECANIQUE		PA
003	-P3	1005100240	ELEMENTO DI CONTATTO ZBE 101 (NO)			PA
003	-P3	1005100280	ELEMENTO DI CONTATTO ZBE 102 (NC)	(EX ZB2-BE102)	(EX ZB2-BE102)	PA
003	-P3	1014841520	PULSANTE NERO ZB4-BA2		(EX.ZB2-BA2)	PA
003	-P3	2064180114	PULSANTE NERO + CONT. NO + CONT. NC	TELEMECANIQUE		PA
004	-CONV	1001451302	APPAR.CONVERTITORE SONDA PT.100	EUROTEK 0-10V		PA
005	-P4	1002060083	BASE DI FISSAGGIO ZB4-BZ009 PER	PULSANTERIA TELEMECANIQUE		PA
005	-P4	1005100240	ELEMENTO DI CONTATTO ZBE 101 (NO)			PA
005	-P4	1014841600	PULSANTE VERDE ZB4-BA3 (EX.ZB2-BA3)	TELEMECANIQUE		PA
005	-P4	2064180102	PULSANTE VERDE + CONTATTO NO			PA
010	-ETH	1003260984	CAVO MT.5 PATCH CORD CCS RJ45-RJ45	CAT.5E FT QU2005034 SCH.		PA
010	-HMI	1011500428	PANN. OPERATORE 6AV2123-2DB03-0AX0	SIMATIC KTP400 TFT 4,3" 65K COLORI		PA
013	-PA	1014060637	CONSOLLE PER XL/6	(+ COD. 1014060636)		PA
013	-PA	1014060649	PANN. COM. XL PER TS SIEMENS KTP400	IN ALLUMINIO SP.3 240X440		PA
013	PA_TS	2060607350	PANNELLO XL BOILER TS400	SCHEMA 4562E - CABLOTECH		PA
002	-IG	1003670126	ACC. INTERRUTTORE COPRIMORSETTO	H-P3 COD. 021999 (+COD. 1009501515)		QU
002	-IG	1009501514	ACC. INTERR.TARGHETTA PER IG 63A	COD.065739 TIPO ZFS61/62-P3		QU
002	-IG	1009501515	INTERR.BLOCCO PORTA COD. 60230	P3-63/V/SVB/SW MANIGLIA COMANDO		QU
002	-IG	1014760501	PROLUNGA ALBERO ZAV-P3 KLOECKNER	ART. 29417		QU
002	-IG	1014760601	PROLUNGA BLOCCO ZVV-P3 KLOECKNER	ART. 24671		QU
002	-MT1	1009503340	INTERR.AUT.BIP. 4A UL-CSA	1492-SP2-C040 ART.30554	(EX.1492-CB2G040) ALL.BR.	QU
002	-MT2	1009503315	INTERR.AUT.UNIP. 4A UL-CSA	1492-SP1-C040 ART.30535	(EX.1492-CB1G040) ALL.BR.	QU
002	-RT1	1002111133	BLOCCO CONT.AUSIL.PER MAGNETOTERMI	140M-C-AFA11		QU
002	-RT1	1009500507	INTERR.MAGNETOT. 4-6,3A	140M-C2E-B63 ALLEN BRADLEY		QU
002	-RT2	1002111133	BLOCCO CONT.AUSIL.PER MAGNETOTERMI	140M-C-AFA11		QU
002	-RT2	1009500505	INTERR.MAGNETOT. 1,6-2,5A	140M-C2E-B25 ALLEN BRADLEY		QU
002	-RT3	1002111133	BLOCCO CONT.AUSIL.PER MAGNETOTERMI	140M-C-AFA11		QU
002	-RT3	1009507415	INTERR.MAGNETICO 140M-F8N C.45	ALL.BR. (+COD.1009507421)		QU
002	-TR	1018521551	TRAS.TMUL130-14264 VA300(P) 0/230/	400/415 (S1)0-110 DOPPIO ISOL.CL.B.	+SCH. - CMI -	QU
003	-E55	1011505305	MODULO COMANDO BIMANUALE	SNZ 4052K 24Vdc	MINOTTI 08/10/2021	QU
003	-K30	1011505300	MODULO SICUREZZA ARRESTO/EMERGENZASNO	4063K 24Vdc	WIELAND	QU
003	-MT3	1009503310	INTERR.AUT.UNIP. 2A UL-CSA	1492-SP1-C020 ART.29719	(EX.1492-CB1G020) ALL.BR.	QU
003	-RAD	1001170286	ALIMENTATORE MONOFASE MDR-60-24	180/260VAC/24VDC-2,5A		QU

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Listato materiale

Pag.	Sigla	Codice	Descrizione 1	Descrizione 2	Descrizione 3	Ubicazione
004	-PLC	1011500521	MOD.CPU S7-1200 6ES7214-1AG40-0XB0	CPU1214C (14DI+10DOT+2AI0-10V)FW4.0		QU
007	-RY0	1011500707	MODULO RELE INTERF. TRS-24VDC-1CO	WEIDMULLER ART.1122770000		QU
007	-RY1	1011500707	MODULO RELE INTERF. TRS-24VDC-1CO	WEIDMULLER ART.1122770000		QU
007	-RY2	1011500707	MODULO RELE INTERF. TRS-24VDC-1CO	WEIDMULLER ART.1122770000		QU
007	-RY3	1011500707	MODULO RELE INTERF. TRS-24VDC-1CO	WEIDMULLER ART.1122770000		QU
007	-RY4	1011500707	MODULO RELE INTERF. TRS-24VDC-1CO	WEIDMULLER ART.1122770000		QU
007	-RY5	1011500707	MODULO RELE INTERF. TRS-24VDC-1CO	WEIDMULLER ART.1122770000		QU
007	-RY6	1011500707	MODULO RELE INTERF. TRS-24VDC-1CO	WEIDMULLER ART.1122770000		QU
007	-RY7	1011500707	MODULO RELE INTERF. TRS-24VDC-1CO	WEIDMULLER ART.1122770000		QU
009	-F1A	1006982160	FUSIBILE VETRO WEBER 5X20-1A			QU
009	-F1B	1006982160	FUSIBILE VETRO WEBER 5X20-1A			QU
009	-F1C	1006982160	FUSIBILE VETRO WEBER 5X20-1A			QU
009	-K1	1003564000	CONTATT.100C09D10 110V	9A 110VAC50HZ 120VAC/60HZ 1NO A.B	(EX.100A09ND3) ALLEN BRADLEY	QU
009	-K1	1006561150	FILTRO X CONTATTORI 100-FSC-280	ALLEN BRADLEY	EX.199-FSMA1	QU
009	-K2	1003564000	CONTATT.100C09D10 110V	9A 110VAC50HZ 120VAC/60HZ 1NO A.B	(EX.100A09ND3) ALLEN BRADLEY	QU
009	-K2	1006561150	FILTRO X CONTATTORI 100-FSC-280	ALLEN BRADLEY	EX.199-FSMA1	QU
009	-K3	1003564025	CONTATT.100C37D00 110V	37A 110VAC50HZ 120VAC/60HZ A.B		QU
009	-K3	1006561150	FILTRO X CONTATTORI 100-FSC-280	ALLEN BRADLEY	EX.199-FSMA1	QU
011	-X1	1011631120	MORSETTO WPE 35 ART.N101050	GIALLO/VERDE	(EX. USLKG 35) - WEIDMULLER	QU
011	-X2	1011631000	MORSETTO WDU 4 ATEX	ART.1020100000	WEIDMULLER (EX. UK 5 N)	QU
011	-X2	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	WEIDMULLER	QU
011	-X3	1011631000	MORSETTO WDU 4 ATEX	ART.1020100000	WEIDMULLER (EX. UK 5 N)	QU
011	-X3	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	WEIDMULLER	QU
011	-X4	1011631010	MORSETTO WDU 10 ART.N102030	WEIDMULLER (EX.UK 10 N)		QU
011	-X4	1011631115	MORSETTO WPE 10 ART.N101030	GIALLO/VERDE-WEIDMULLER	(EX.USLKG.10 N)	QU
012	-X6	1011631050	MORSETTO WDK 2,5 PER WQV	ART.1021500000	ART.N102150	QU
012	-X6	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	WEIDMULLER	QU
012	-X6	1014270960	PIASTRA TERMINALE PER WDK 2,5	WAP-WDK ART.N105910 PER MORSETTO	MORS.(EX.DUKK3/5)WEIDMUL	QU
012	-X6	1014480080	PONTICELLO COLLEG. WQV 2,5/10	ART.1054460000	WDK 2,5)	QU
012	-X6	1017800040	STAFFA TERMINALE EW 35 (8,5)	ART. 0383560000	EW 35 WEIDMULLER	QU
012	-X7	1011631050	MORSETTO WDK 2,5 PER WQV	ART.1021500000	ART.N102150	QU
012	-X7	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	WEIDMULLER	QU
012	-X7	1014270960	PIASTRA TERMINALE PER WDK 2,5	WAP-WDK ART.N105910 PER MORSETTO	MORS.(EX.DUKK3/5)WEIDMUL	QU
012	-X7	1014480080	PONTICELLO COLLEG. WQV 2,5/10	ART.1054460000	WDK 2,5)	QU
012	-X7	1017800040	STAFFA TERMINALE EW 35 (8,5)	ART. 0383560000	EW 35 WEIDMULLER	QU
012	-X8	1011631050	MORSETTO WDK 2,5 PER WQV	ART.1021500000	ART.N102150	QU
012	-X8	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	WEIDMULLER	QU
012	-X8	1014270960	PIASTRA TERMINALE PER WDK 2,5	WAP-WDK ART.N105910 PER MORSETTO	MORS.(EX.DUKK3/5)WEIDMUL	QU
012	-X8	1014480080	PONTICELLO COLLEG. WQV 2,5/10	ART.1054460000	WDK 2,5)	QU
012	-X8	1017800040	STAFFA TERMINALE EW 35 (8,5)	ART. 0383560000	EW 35 WEIDMULLER	QU
012	-X9	1011630951	MORSETTO PORTAFUS.WSI 6LD CON LED	110/220V ART.101240 - WEIDMULLER	WEIDMULLER	QU
012	-X9	1011631000	MORSETTO WDU 4 ATEX	ART.1020100000	WEIDMULLER (EX. UK 5 N)	QU
012	-X9	1011631110	MORSETTO WPE 6 GIALLO/VERDE ATEX	ART.1010200000	WEIDMULLER	QU
012	-X9	1014480083	PONTICELLO COLL.WQV 4/10 WEIDMULLER	ART. 105206 (PER MORSETTO WDU 4)		QU

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Listato materiale

Pag.	Sigla	Codice	Descrizione 1	Descrizione 2	Descrizione 3	Ubicazione
012	-X9	1017800040	STAFFA TERMINALE EW 35 (8,5)	ART. 0383560000	EW 35 WEIDMULLER	QU
016	FILI	1003700022	CORDICELLA FLESS. MMQ.0,5 BLU	ART.PP-H05VK0-50BC		QU
016	FILI	1003700040	CORDICELLA FLESS. MMQ.1	GIALLO-VERDE		QU
016	FILI	1003700041	CORDICELLA FLESS. MMQ.1 ROSSA			QU
016	FILI	1003700042	CORDICELLA FLESS. MMQ.1 BLU			QU
016	FILI	1003700120	CORDICELLA FLESS. MMQ.2,5	GIALLO-VERDE		QU
016	FILI	1003700125	CORDICELLA FLESS. MMQ.2,5 NERO			QU
016	FILI	1003700280	CORDA FLES.UNIPOL.MMQ.10 NERO			QU
016	FILI	1003700280	CORDA FLES.UNIPOL.MMQ.10 NERO			QU
016	FILI	1003700320	CORDA FLES.UNIPOL.MMQ.16 NERO			QU
016	FILI	1003700351	CORDA FLES.UNIPOL.MMQ.16	GIALLO-VERDE		QU
016	QU	1003020400	CANALETTA APERTA 60X60 MOD.T1-EN	BO-01108 - IBOCO -		QU
016	QU	1003462079	COFANO TIPO D93/19 600X600X200	X QUADRO XL BOILER RAL7035 FORATO	CON 4 DADI X FISSAGGIO PIASTRA	QU
016	QU	1003462098	ACCESSORI COFANO PIASTRA INTERNA	D93/81 X COFANO 600x600 -ZANARDO-		QU
016	QU1	1001080043	ADATTATORE PER BARRE 32A ART.W32442	WOHNER - CON VITI W43002	(EX W32254)	QU
016	QU1	1001080051	ADATTATORE PER SBARRE 63A W32455			QU
016	QU1	1002030035	BARRA RAME 20X5 ART.01620	WOHNER - LUNGH. 2,4 MT.		QU
016	QU1	1003020120	CANALETTA APERTA 40X60 MOD.T1-EN	IBOCO		QU
016	QU1	1007980160	GUIDA DIN DR7 (OMEGA)	PREFORATA		QU
016	QU1	1014270990	PIASTRA PER MORS. LINEA ART.01240	WOHNER ALLACCIAIMENTO SEZ. 6-50MMQ		QU
016	QU1	1014610050	PORTASBARRE TRIPOLARE ART.01500	WOHNER		QU
016	QU1	1017800080	STAFFA TERMINALE BG/S			QU
016	QU18	1003020400	CANALETTA APERTA 60X60 MOD.T1-EN	BO-01108 - IBOCO -		QU
016	QU18	1003462079	COFANO TIPO D93/19 600X600X200	X QUADRO XL BOILER RAL7035 FORATO	CON 4 DADI X FISSAGGIO PIASTRA	QU
016	QU18	2067507307	QUADRO MONTATO XL BO 18KW 4561E	(COMPL. DI LAVOR.+MATER.) TS400		QU
002	-R3	1014690240	PRESSACAVO GRIGIO PG21 BM 4721 IN	POLIAMMIDE COMPLETO DI CONTRODADO		SS
003	-FC02	1006630172	FINECORSASICUR. FUNE FD978	PIZZATO		SS
004	-PT100	1018390008	TERMORESISTENZA PT100 D.5 LUNGH.300	CAVO LUNGH.7MT		SS
004	-TPR	1018530132	TRASDUTT. DI PRESSIONE USCITA 0-10V	0.400BAR, G1/4" SENZA CAVO	AGGIUNGERE SEMPRE IL CAVO X RICAMBI	SS
005	-FC01	1006630720	FINECORSAXCK-J10541 TELEMECANIQUE	LEVA LUNGA REGOLABILE CON ROTELLA		SS
005	-PH01	1003501535	CONNEX. ELETTR. GRIGIO SENZA LED	KA042000A9 ART.62548 CAVO 4 MT CNE		SS
005	-PHB	1003501537	CONNEX. X PRESSOSTATO COD. 3900200	EUROSWITCH PER MOD. 31 (+ COD.	PRESSOSTATO 1014720270)	SS
005	-PHD	1003501535	CONNEX. X ELETTR. GRIGIO SENZA LED	KA042000A9 ART.62548 CAVO 4 MT CNE		SS
005	-PHS	1003501535	CONNEX. X ELETTR. GRIGIO SENZA LED	KA042000A9 ART.62548 CAVO 4 MT CNE		SS
005	-TS1	1003580200	CONTRODADO GRIGIO PG 9 ART. BM4809	NYPG9		SS
005	-TS1	1014690200	PRESSACAVO GRIGIO PG9 BM 4709 IN	POLIAMMIDE COMPLETO DI CONTRODADO		SS
005	-TS1	1018400075	TERMOSTATO DI SICUREZZA ARA 0-300C	ART.TU.L-DT.T.150		SS
006	-FC05	1014770302	PROXIMITY M08 PNP CAVO3mt BALLUFF	BES M08MI-PSC15B-BV03 ART. 141936	(EX.1014770024)	SS
006	-FC06	1014770302	PROXIMITY M08 PNP CAVO3mt BALLUFF	BES M08MI-PSC15B-BV03 ART. 141936	(EX.1014770024)	SS
006	-JB1	1003180360	CASSETTA WESTEC S1 101X101X58	COD. 8000.6261.0		SS
009	-EV.A	1003501521	CONNEX. X ELETTR.LED+VAR+RADR 110V	KA132R55T9 ART.62549 CAVO 4 MT CNE		SS
009	-EV.AD	1003501521	CONNEX. X ELETTR.LED+VAR+RADR 110V	KA132R55T9 ART.62549 CAVO 4 MT CNE		SS
009	-EV.AS	1003501521	CONNEX. X ELETTR.LED+VAR+RADR 110V	KA132R55T9 ART.62549 CAVO 4 MT CNE		SS
016	CAVOSS	1003281016	CAVO MMQ. 3X0.50 SCHERMATO	ELITRONIC CY MARCHIATO A NORME CON	FILI COLORATI	SS

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MODEL

XL/8-S

P25398_P25399

PLANNER

DESIGNER FRANI

DRAW
4561EDATE
02/03/2023SHEET
20

Listato materiale

Pag.	Sigla	Codice	Descrizione 1	Descrizione 2	Descrizione 3	Ubicazione
016	CAVOSS	1003281021	CAVO PVC GRI.UL-AWM-2587-90	C-3XAWG18(1)CSA-AWM-I/II 3G1	-VDE-NF-USE-FRN05VV5-F	SS
016	CAVOSS	1003281060	CAVO PVC GRI.UL-AWM-2587-90 C-	4XAWG14 CSA-AWM-I/II 4G2.5	VDE-NF-USE-FRN05VV5-F	SS
016	CAVOSS	1003282402	CAVO PVC GRI.UL-AWM-2587-90 C-	5XAWG18 CSA-AWM-I/II 5G1	VDE-NF-USE-FRN05VV5-F 5G 1	SS
016	K_BM	2035807309	KIT MONTAGGIO B.M. XL BASE	DISTINTA N.3 - MATERIALE CABLOTECH		SS
016	PRESS	1014690200	PRESSACAVO GRIGIO PG9 BM 4709 IN	POLIAMMIDE COMPLETO DI CONTRODADO		SS
016	PRESS	1014690210	PRESSACAVO GRIGIO PG11 BM 4711 IN	POLIAMMIDE COMPLETO DI CONTRODADO		SS
016	PRESS	1014690220	PRESSACAVO GRIGIO PG13,5 BM 4713	IN POLIAMMIDE COMPLETO DI CONTROD.		SS
016	PRESS	1014690240	PRESSACAVO GRIGIO PG21 BM 4721 IN	POLIAMMIDE COMPLETO DI CONTRODADO		SS



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MODEL	XL/8-S	P25398_P25399	PLANNER
			DESIGNER FRANI
		DRAW 4561E	DATE 02/03/2023
			SHEET 21

ITALPRESS



XL **TS400**

TOUCH-SCREEN HANDBOOK

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1) GENERAL NOTES

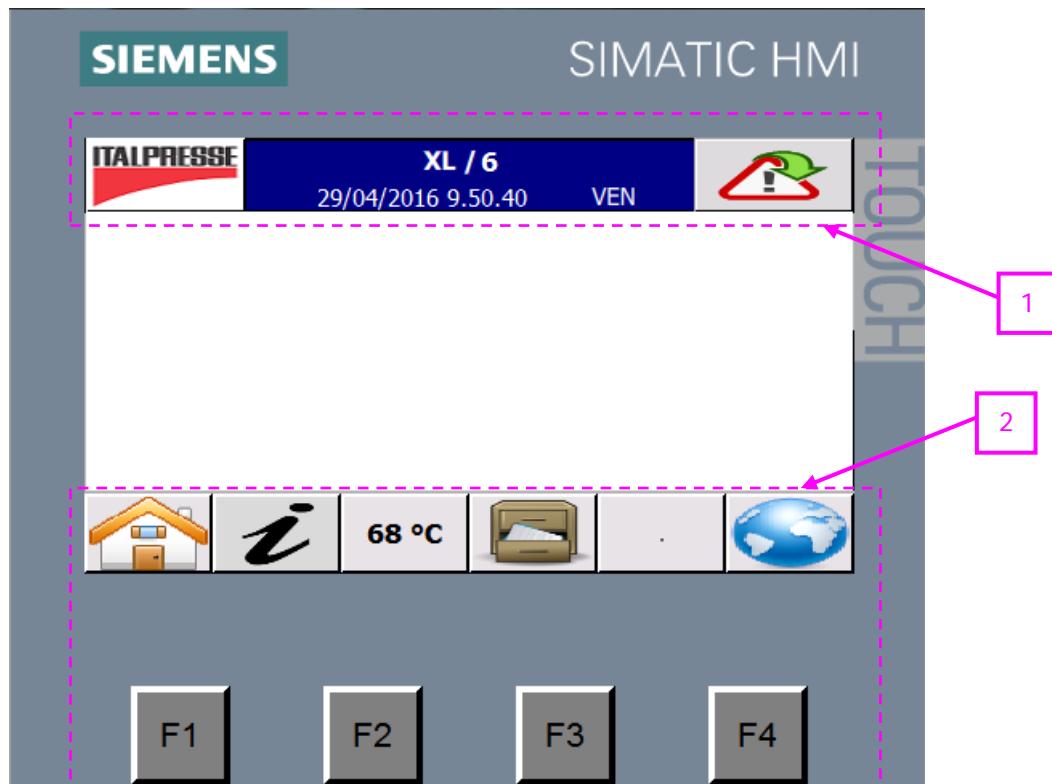


Figure 1

The various pages on the touch-screen panel present an upper and a lower section with common functions and indications.

- 1) The upper section displays the following information

Display	Function
	Corporate logo / key to display the machine parameter pages (see page 20)
XL / 6	Press model
29/04/2016 9.50.40	Current date and time
	Alarm symbol, displayed when an alarm is active. Press to access the ALARMS PAGE (see page 22)

2) The lower section has the page navigation keys

Touch key	Function
	Displays the home page (see page 5)
	Displays the press information page (see page 9)
	Platen actual temperature red-out and button to display heating page (see page11)
	Displays the recipes page (see page 17)
	Displays the international settings page (see page 19)

For each page there are four buttons whose functions are:

F1= button to display the home page (see page 5)

F2= button to display the press information page (see page 9)

F3= button to display heating page (see page11)

F4= button to display recipes page (see page 17)



Figura 2

2) HOME PAGE

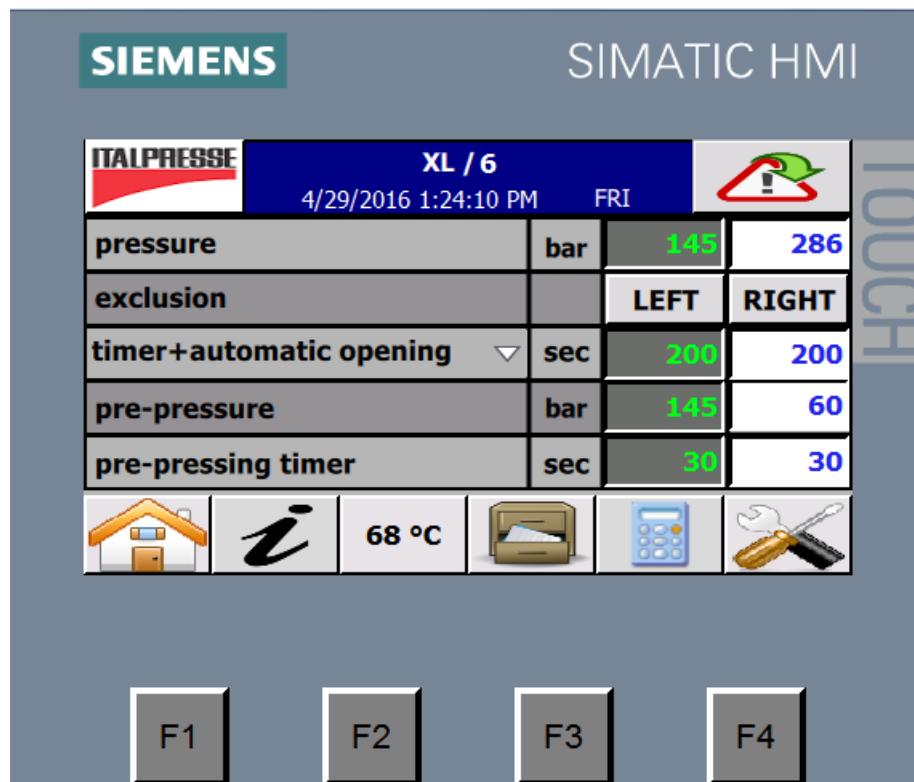


Figure 3

When you switch the machine on, the HOME PAGE is displayed on the touch-screen panel. Here the operator can enter all the machine operation parameters, which are shown in the following table.

Display	Function
Hydraulic pressure	The hydraulic pressing pressure expressed in bar or psi.
Exclusion	<p>Keys to exclude the left or right row of cylinders from pressing. <u>Cylinders can only be excluded when the press is completely open.</u></p> <p>Touch LEFT to exclude the left row of cylinders. The key turns green LEFT when exclusion is active.</p> <p>Touch RIGHT to exclude the right row of cylinders. The key turns green RIGHT when exclusion is active.</p> <p>These keys are only present if the press has the side cylinder exclusion function.</p>

Timer	<p>Select the pressing time mode by pushing the "timer" button:</p> <ul style="list-style-type: none"> • timer off: the pressing time is not shown on the screen. The operator will have to open the press manually by pushing the opening pushbutton located on the operator's interface. • timer + manual opening: the pressing time will be shown. The operator can set the desired time (in seconds). At the end of the countdown, the time will start blinking and the alarm (optional) will start. The operator will have to open the press manually by pushing the opening pushbutton located on the operator's interface. • timer + automatic opening: the pressing time will be shown. The operator can set the desired time (in seconds). At the end of the countdown, the press will open automatically. (Optional depending on the regulations in force and the conditions of sale) The press can always be opened during closing and pressing by pressing the open button on the control panel.
pre-pressing	Press the 'pre-pressing' button to activate this option. Set the pre-pressing pressure value that will be reached before the final pressing phase.
Pre-pressing timer	Set the pre-pressing dwell time.

The current value of each parameter is displayed in green on a grey background. The setpoint is displayed in blue on a white background. Touch the setpoint value to display a numeric keypad (Figure 4) for entering the desired value.



Figura 4



The button displays the specific pressure calculation page (see page 8)



The button displays the optional features page (see page 7)

3) OPTIONAL FEATURES PAGE

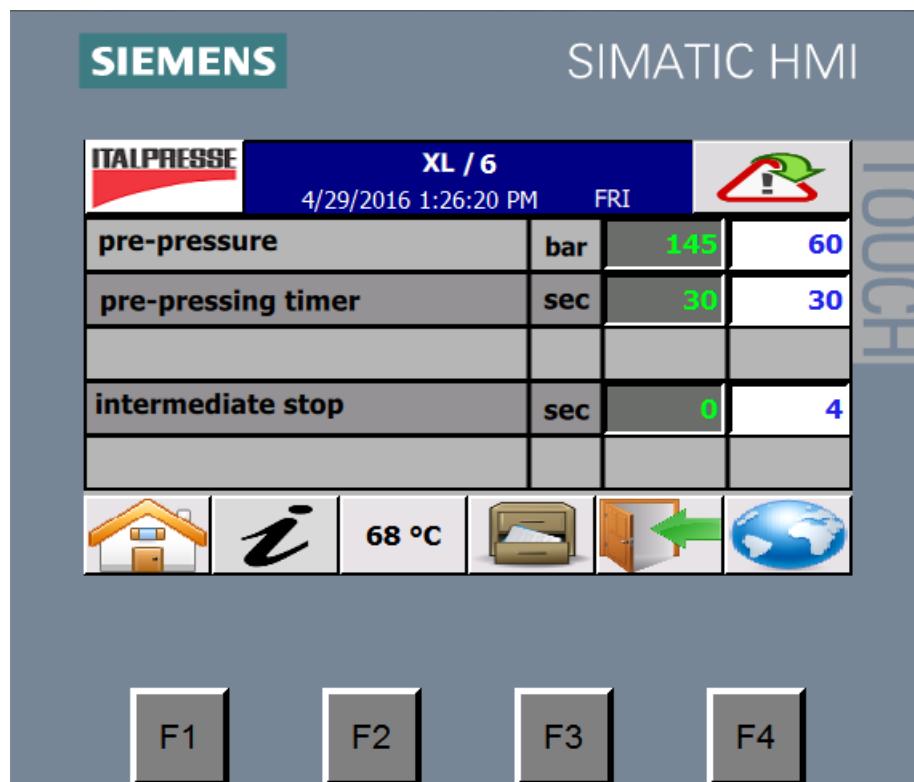


Figura 5

On this page the operator can select and set the following optional features:

Display	Function
pre-pressing	Press the 'pre-pressing' button to activate this option. Set the pre-pressing pressure value that will be reached before the final pressing phase (that is set on the main page)
pre-pressing timer	Set the pre-pressing dwell time.
Intermediate stop	Touch Intermediate stop to activate timed stop of the press and enter the opening time expressed in seconds. The press stops at the end of the opening time and a new pressing can be performed. To open the press completely, press the open button on the control panel.

4) CALCULATION PAGE

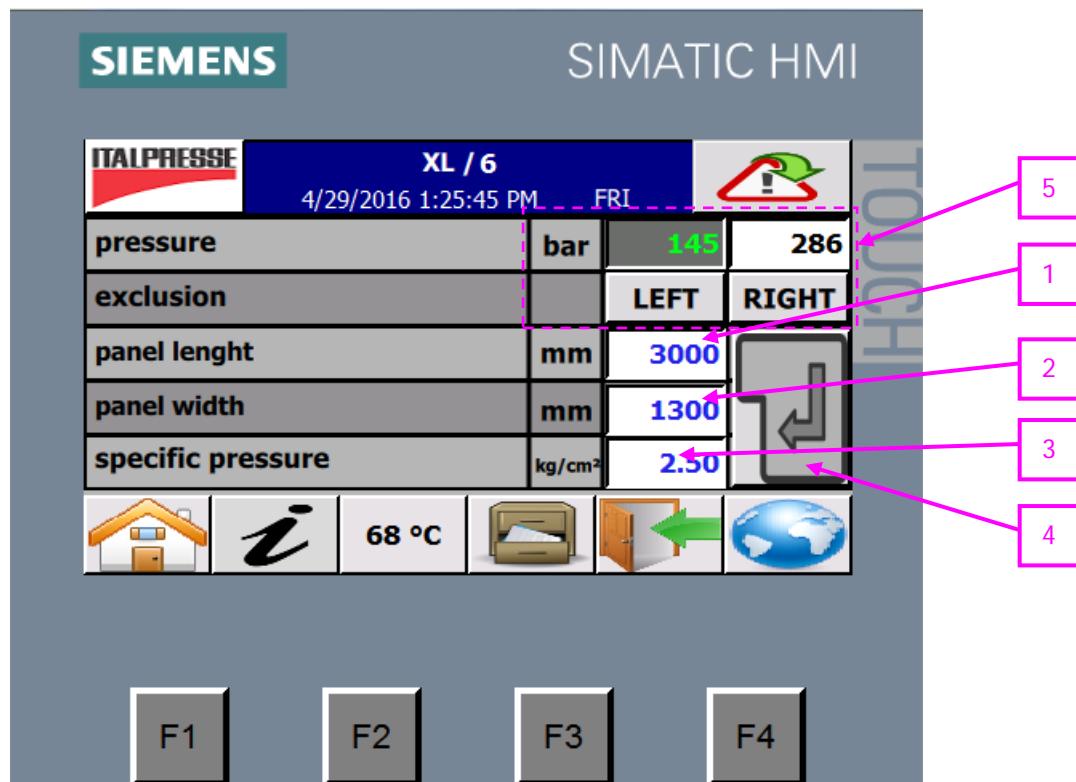


Figura 6

On the CALCULATION PAGE, you can enter the hydraulic pressure and exclude cylinder rows if you know the dimensions of the panel to be pressed and the specific pressure.

Proceed as follows:

- 1) Enter the length of the panel expressed in mm or inch.
- 2) Enter the width of the panel expressed in mm or inch.
- 3) Enter the specific pressure expressed in kg/cm² or psi.



- 4) Press .
- 5) The hydraulic pressure is updated and any exclusions are activated. The data on these pages are display-only. If you wish to modify a value, touch the HOME PAGE key.

Calculations are only possible when the press is completely open.

5) PRESS INFORMATION PAGE

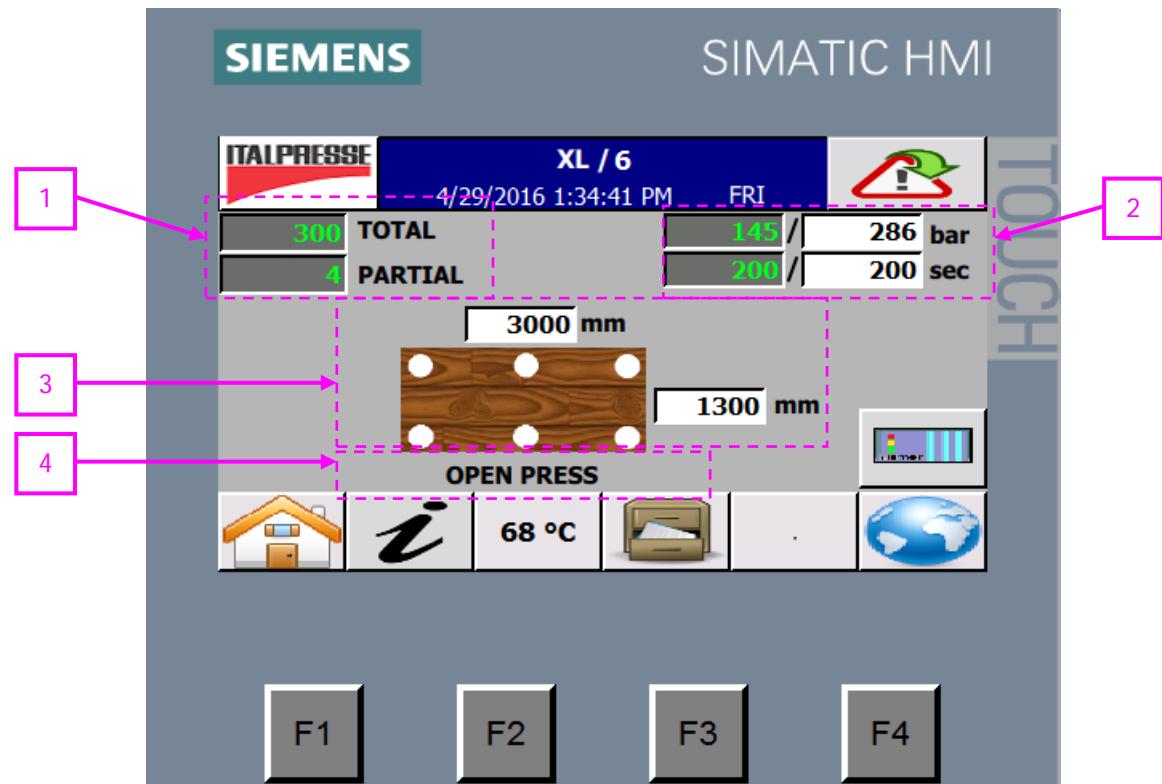


Figura 7

The PRESS INFORMATION PAGE displays all the press operation parameters.

It is divided into the following sections:

- 1) total and partial pressing stroke counter. The partial count can be modified and/or reset by touching the field and entering the desired value.
- 2) display of the hydraulic pressure and pressing time. The current value is displayed in green on a grey background, the setpoint value in black on a grey background.
- 3) display of exclusions and load positioning on the press platen. Table 1 on page 10 shows the various exclusion possibilities.
- 4) description of the pressing stage.



Touch to access the PLC input/output page. Refer to page 15.

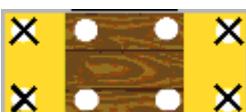
Display	Function
	No row of cylinders is excluded from pressing. The panel load must cover all the cylinders.
	The left-hand row is excluded from pressing. The panel load must cover the remaining cylinders. The symbol  means the cylinder is excluded from pressing. The symbol  means the excluded cylinder is in an emergency.
	The left- and right-hand rows are excluded from pressing. The panel load must cover the remaining cylinders. The symbol  means the cylinder is excluded from pressing. The symbol  means the excluded cylinder is in an emergency.

Table 1

6) HEATING PAGE

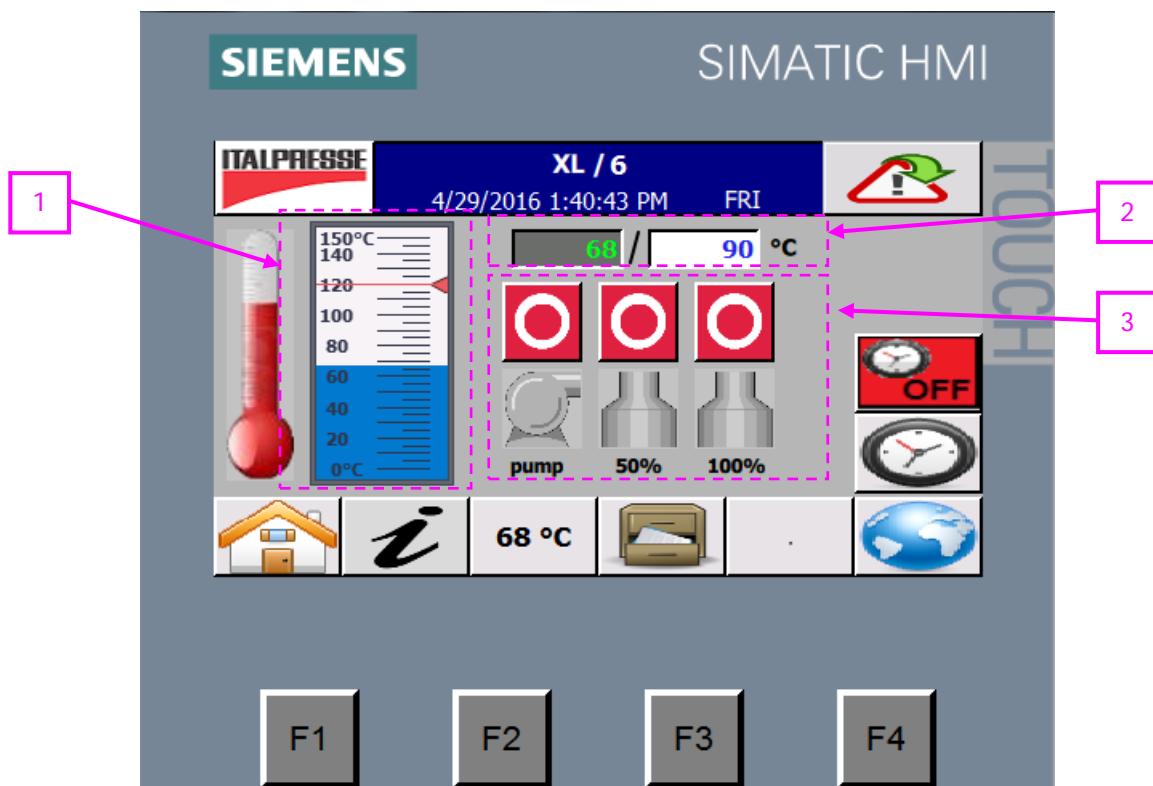


Figura 8

The HEATING PAGE is used to control and check heating of the press platens. The page is divided into the following sections:

- 1) a graph bar showing the temperature change.
- 2) actual temperature display in green on a grey background, and setpoint in blue on a white background. Touch this field to enter the desired value.
- 3) heating controls (see Table 2).

Display	Function
	Activation of heat circulating pump and heater.
	Deactivation of heat circulating pump and heater.
	Heat circulating pump on.
	Heat circulating pump off.
	Heater off.
	Heater on. If the symbol flashes, it means the heater is on stand-by because there is a heating alarm or the temperature setpoint has been reached or it is awaiting an enable signal from the daily/weekly timer.
	Access to daily/weekly timer setting. See DAILY/WEEKLY TIMER PAGES on page 12.
	Daily/weekly timer off. Heating is always enabled.
	Daily/weekly timer on. Heating is only enabled if the current time is within the intervals set on the daily/weekly timer.

Table 2

7) DAILY/WEEKLY TIMER PAGES

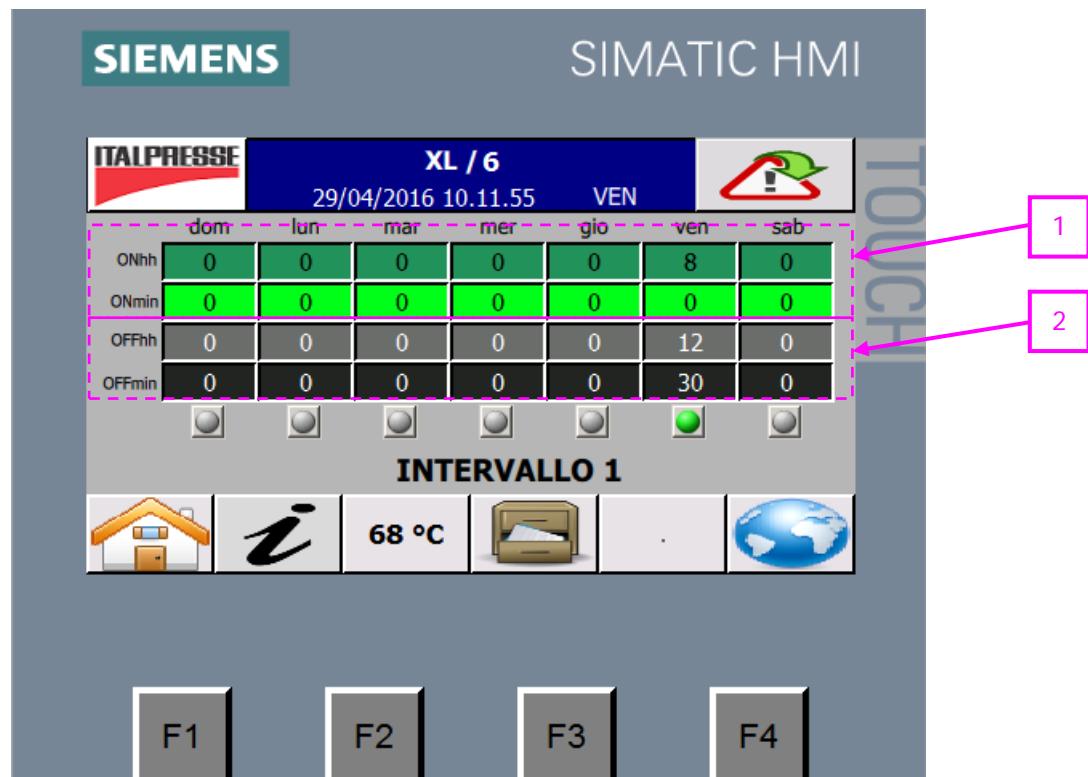


Figura 9

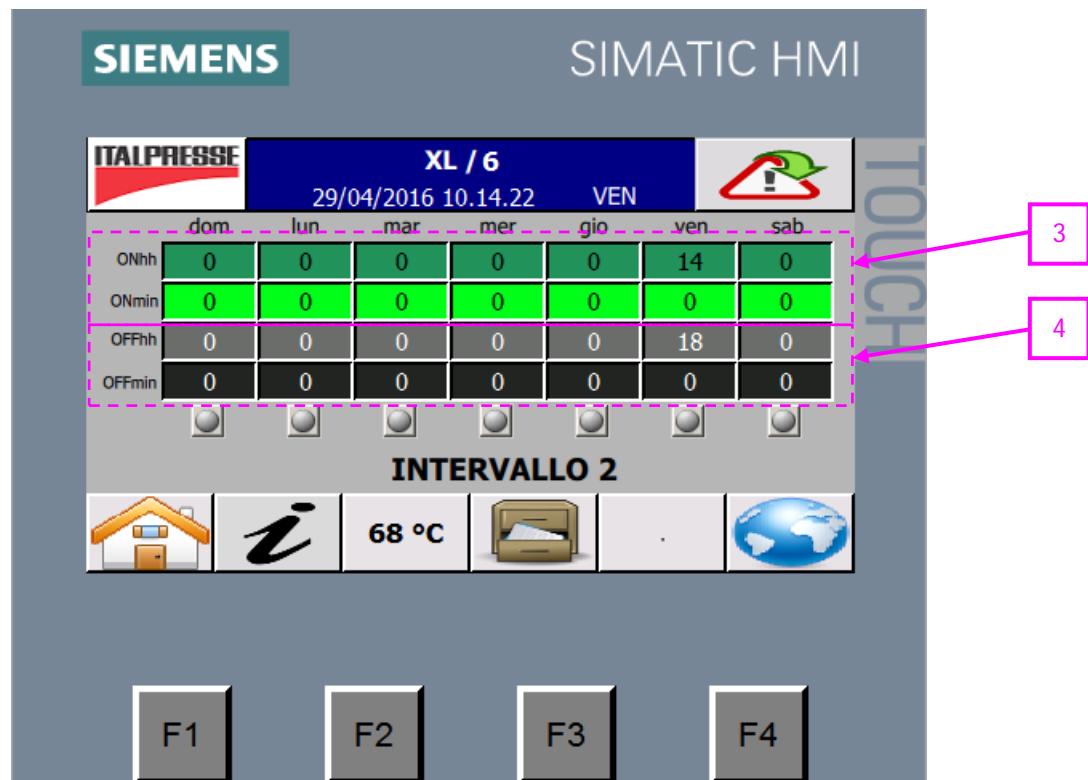


Figura 10

The DAILY/WEEKLY TIMER PAGE is used to set the heating on and off times. Two time intervals can be set to turn the heating on automatically twice on each day of the week.



Use and to select the time interval to set and/or display.

The following settings must be made:

- 1) heating-on hours and minutes, for time interval 1
- 2) heating-off hours and minutes, for time interval 1
- 3) heating-on hours and minutes, for time interval 2
- 4) heating-off hours and minutes, for time interval 2

Proceed as follows to switch the heating on and off automatically at the set times:

- 1) Check the current time and date on the display at the top of the page, and adjust if necessary (see INTERNATIONAL SETTINGS PAGE on page 19).
- 2) Enter the heating on and off hour and minutes for time interval 1.
- 3) Enter the heating on and off hour and minutes for time interval 2. If you want to switch the heating on and off once only, set the time interval 2 hour and minutes to zero.
- 4) On the HEATING PAGE, activate the daily/weekly timer and switch on the heat circulation pump and heater (see HEATING PAGE on page 11).

N.B. At the switch off time, the heater switches off, but the circulation pump remains on until the temperature of the press platen drops below the safety temperature.

8) PLC INPUT AND OUTPUT PAGES



Figura 11



Figura 12

The PLC INPUT AND OUTPUT PAGES are used to monitor the status of the PLC signals.

If the box next to a digital input is green, it means the PLC is receiving the signal.

If the box next to the digital output is green, it means the PLC is sending the signal.

A heart is displayed on the right-hand side. When it beats, it means the PLC is active.



Touch to display the previous page.



Touch to display the next input/output pages.



Touch to display the previous input/output pages.



Touch to display the page of alarms (see ALARMS PAGE on page 22).

9) RECIPES PAGE

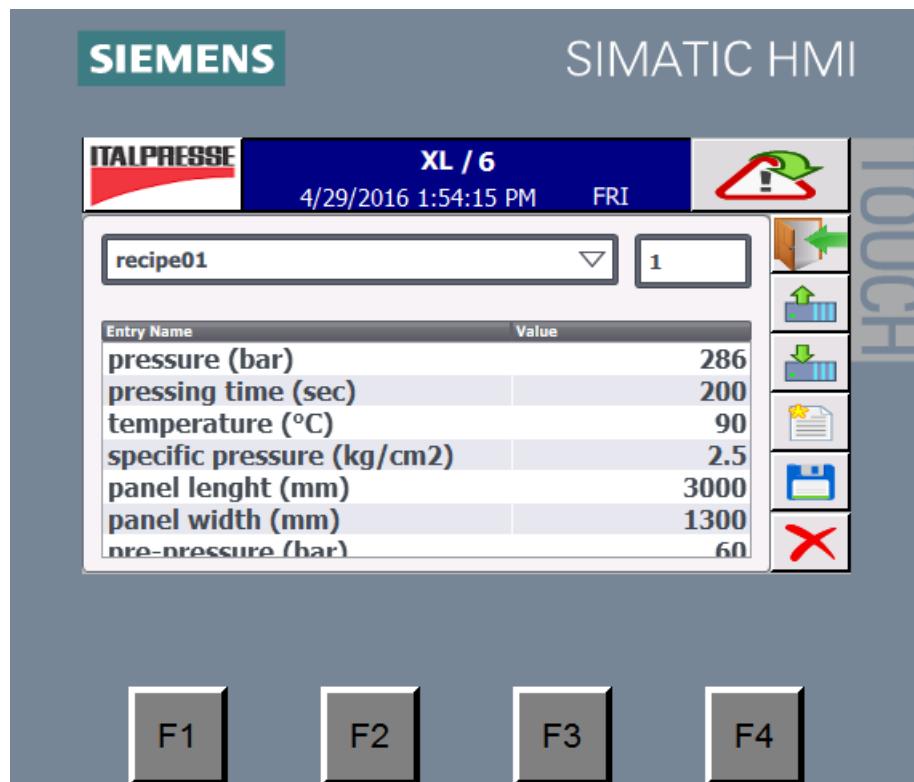


Figure 13

The RECIPES PAGE is used to create and store new pressing recipes and modify the existing ones.

Proceed as follows to create a new recipe.

- 1) Touch  to access the RECIPES PAGE.
- 2) Touch the button  to create a new recipe
- 3) Touch the field  and type the name of the new recipe
- 4) set all the pressing darts
- 5) touch the button  to save the new recipe

Proceed as follows to execute a stored recipe:

- 1) Touch  to access the RECIPES PAGE

- 2) touch the field  **recipe01** and select an existing recipe
- 3) Touch the name of the recipe to execute.
- 4) The pressing data are displayed.

- 5) Touch  to send the pressing data to the PLC.

N.B. A recipe can only be executed when the press is completely open.

Proceed as follows to store in a recipe the data entered manually in the work page:

- 1) Touch  to access the RECIPES PAGE.

- 2) touch the button  to create a new recipe

- 3) touch the field  **recipe01** and type the name of the new recipe

- 4) touch the button  to import the pressing data from the PLC

- 5) touch the button  to save the new recipe

N.B. Current pressing data can only be recorded in a recipe when the press is completely open.

Touch  to display the previous page.

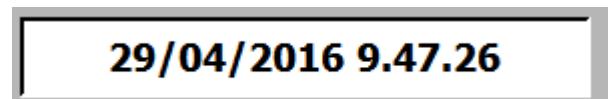
10) INTERNATIONAL SETTINGS PAGE



Figure 14

The INTERNATIONAL SETTINGS PAGE is used to select the language for the messages displayed on the operator panel. Touch the flag corresponding to the desired language.

Proceed as follows to enter the current date and time:



- 1) Touch the field.
- 2) Enter the current date and time and touch to confirm.
- 3) Touch to update the date and time at the top of the page.

11) PARAMETERS PAGES

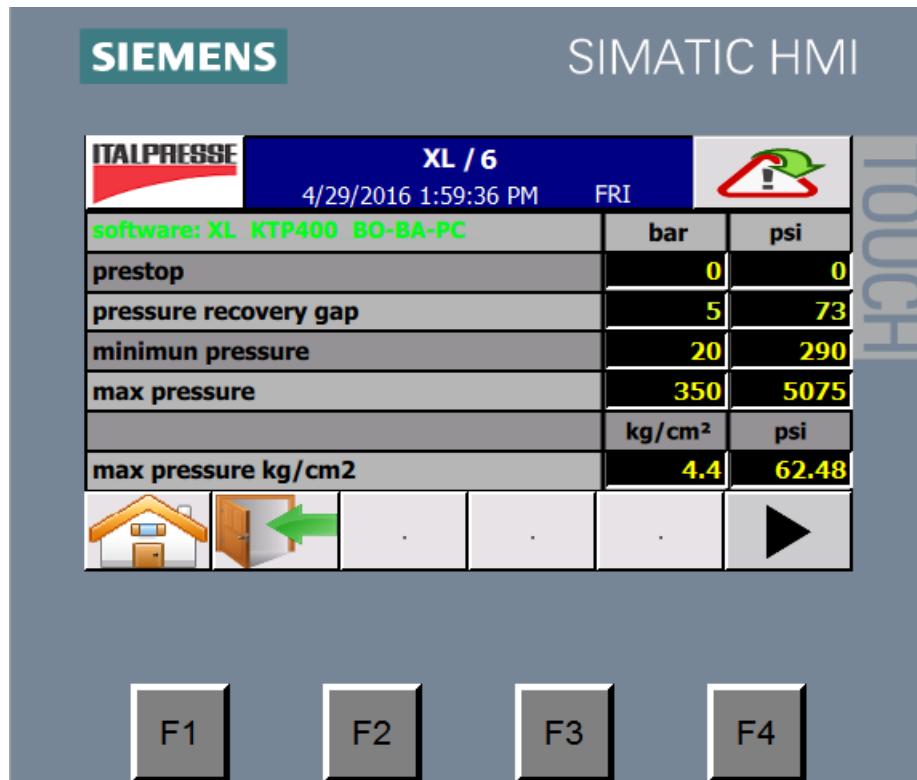


Figure 15

The PARAMETERS PAGES are used to modify the press operating parameters. Only authorised personnel can enter these pages, which requires the entry of a password.

Contact the manufacturer before changing any of these parameters.

Below is an indicative example of the press parameters

PARAMETER	UNIT OF MEAS.	SETTING
Pre-stop	bar	0
Pressure recovery delta	bar	5
Minimum pressure	bar	20
Maximum pressure	bar	380
Maximum specific pressure	kg/cm ²	4.4
Maximum length	mm	3500
Minimum length	mm	2200
Maximum width	mm	1300
Minimum width	mm	860
Left exclusion position	mm	2
Right exclusion position	mm	1
Total pistons	No.	8
Left pistons excluded	No.	6
Right pistons excluded	No.	6
Cylinder diameter	mm	70
Maximum temperature	°C	120
Temperature recovery delta	°C	2
Safety temperature	°C	40
Boyle 100% prestop temperature	°C	4
OILBOILER		
Exclusion time	sec	7
Depression time	sec	0
Emergency opening time	sec	2
LH exclusion		YES
RH exclusion		--
Planarity control		YES
Boyle 50%		NO
Maintained opening		YES
Unit of measurement		S.I.
Minimum pressure	ADC	0
Maximum pressure	ADC	27648
Minimum pressure	bar	0
Maximum pressure	bar	400
Minimum temperature	ADC	0
Maximum temperature	ADC	27648
Minimum temperature	°C	0
Maximum temperature	°C	200

12) ALARMS PAGE

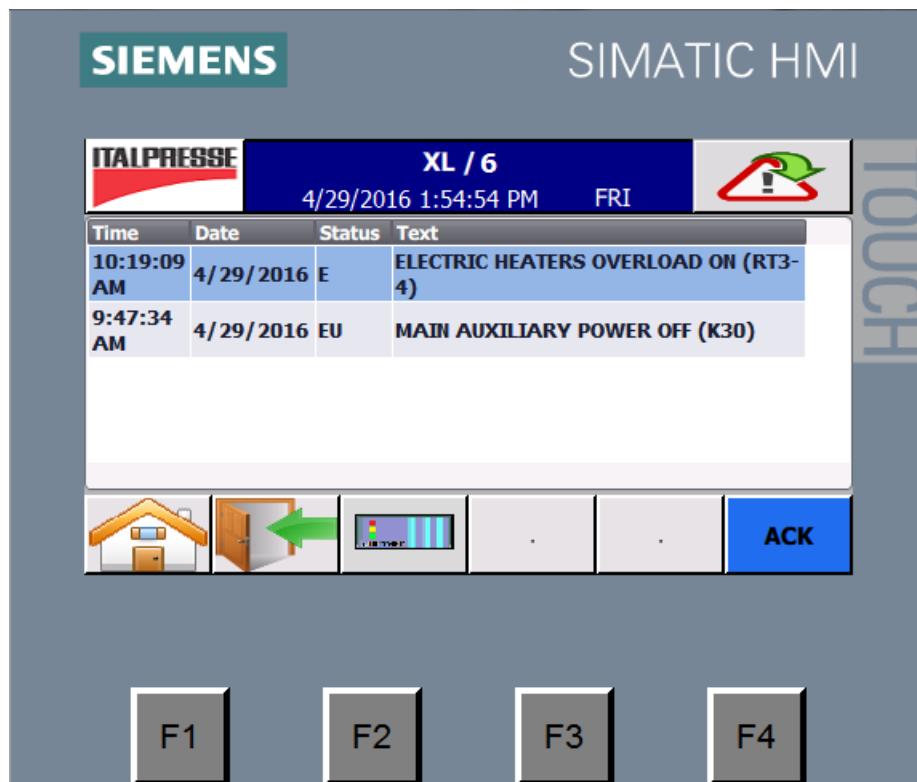


Figure 16

The ALARMS PAGE displays a description and the attributes of alarm events on two lines. The date and time of occurrence, the alarm status code and a description of the alarm are displayed.

The alarm status code is an alphanumeric label with the following meanings:

E = Event on = alarm condition has occurred

U = Event off = alarm condition has disappeared

R = alarm acknowledged by the operator

ACK

Touch to acknowledge the alarm.



When an alarm occurs, the symbol is displayed in the top right-hand corner and a description of the alarm appears in the list with the attribute E. When the alarm is acknowledged by the operator pressing

ACK

, the attribute changes to ER. When the alarm condition has disappeared, the symbol disappears and the alarm is removed from the list. If the alarm disappears beforehand, the symbol



disappears, but the description remains in the list with the attribute EU and is only removed when



the operator has acknowledged it by touching .



Touch to display the previous page.



Touch to access the PLC input/output page. Refer to page 15.