

**INTERNATIONAL SPECIALIST FOR SOLE MACHINES
SPECIALIZZATI IN MACCHINARI PER SUOLIFICI**



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ORIGINAL**

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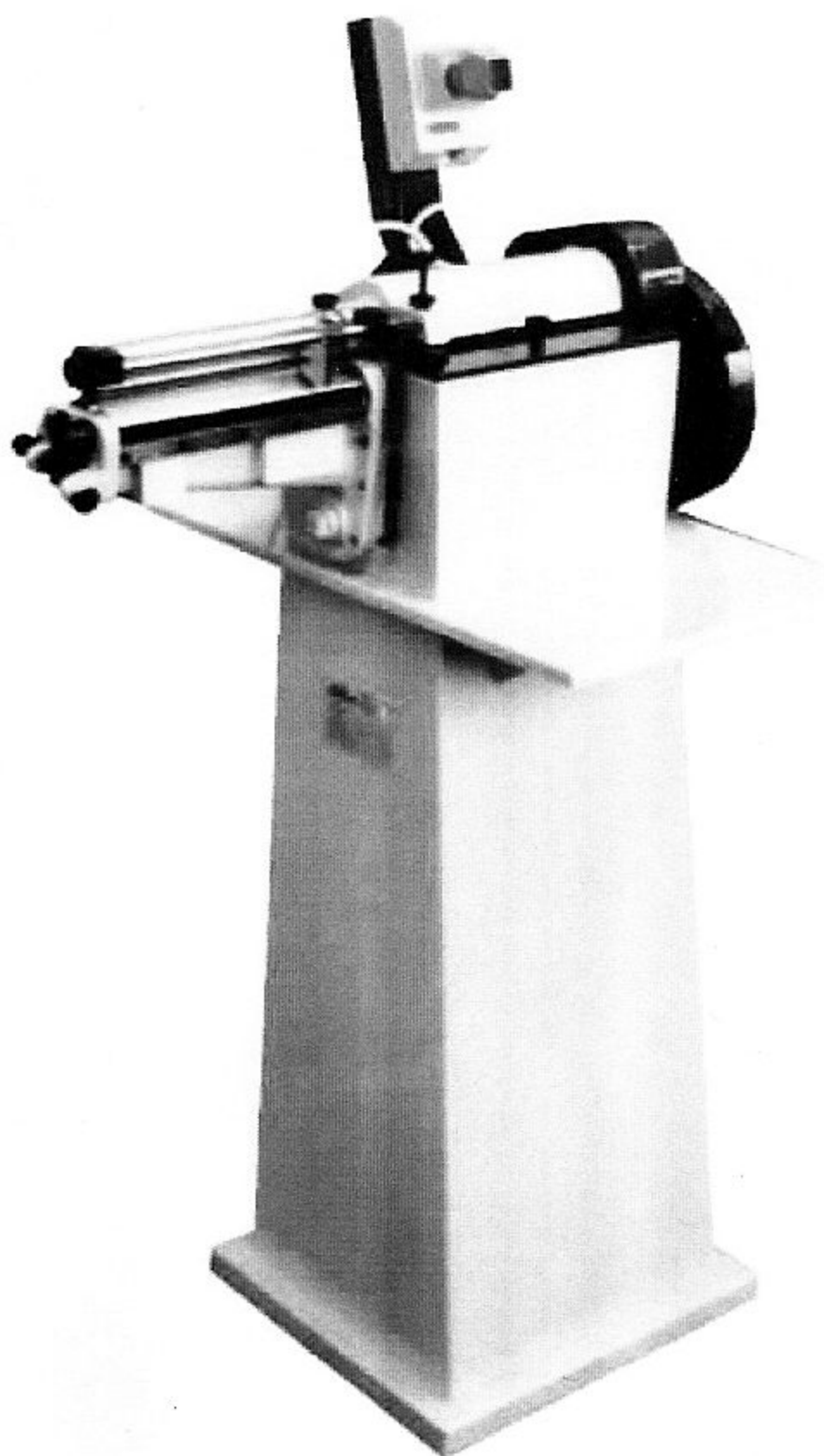
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INCOLLATRICE PER SOTTOPIEDI, CON RULLO
IN ACCIAIO, TAVOLINO D'APPOGGIO, NUOVA
INSOLE CEMENTING MACHINE, WITH STEEL
ROLL, SUPPORTING TABLE, NEW

Directions for use MAV3230

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Directions for use cementing machine MAV 3230

MODEL : MAV 3230
SERIAL NUMBER :
FABRICATION YEAR :

OFFICINA
MECCANICA

mario
angeleri sas

COSTRUZIONI MACCHINE PER CALZATURIFICI

Via Ruffini 15/3-27029 VIGEVANO(PV) -ITALIA-

DIRECTIONS FOR USE OF THE MAV 3230 CEMENTING MACHINE

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MODEL : MAV 3230
SERIAL NUMBER :
FABRICATION YEAR :

MARIO ANGELERI S.A.S. MACHINE FACTORY

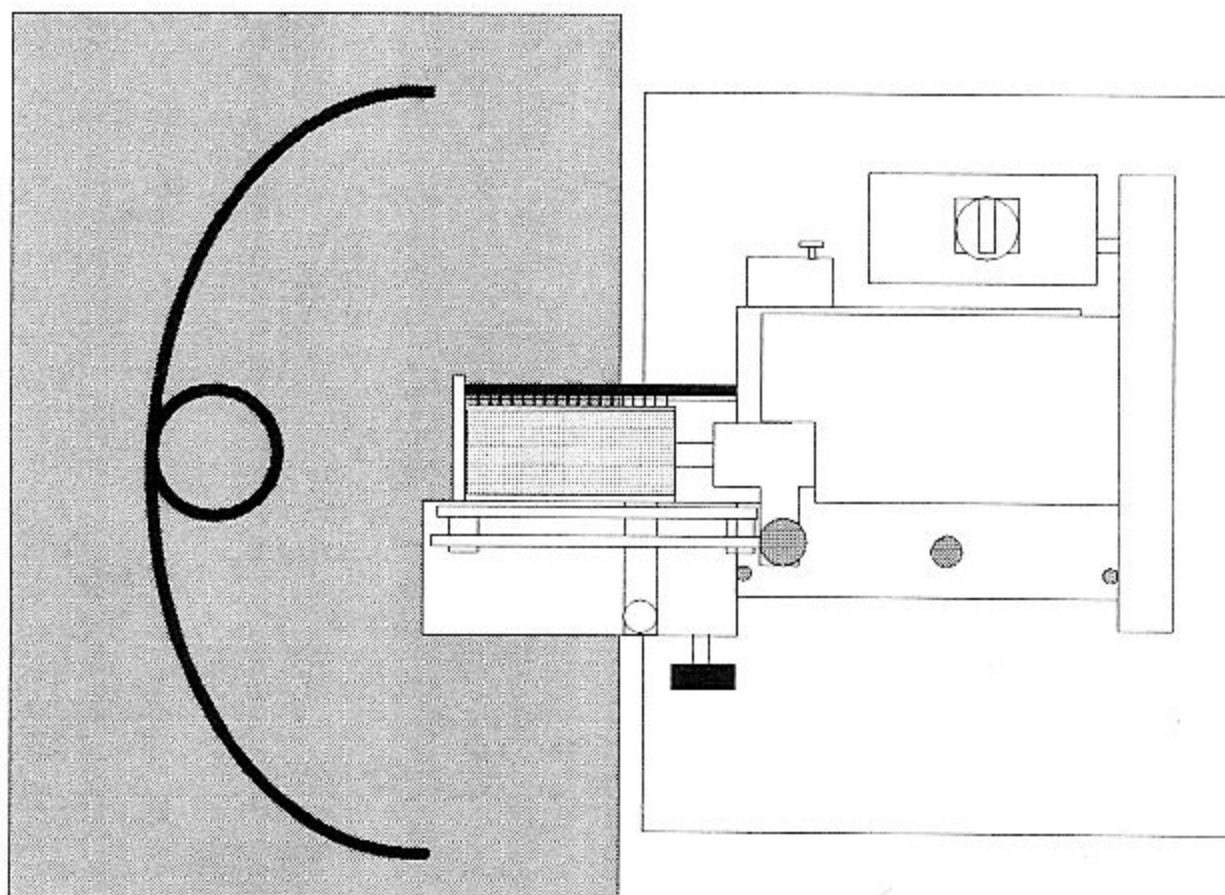
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-C.C.I.A.A. Pavia 169646
-Codice fiscale e partita I.V.A.01163890187
-Identification number: IT 01163890187
-Numero meccanografico: PV 004677
-Reg.Soc.5220-Fasc.3227-Tribunale di Vigevano

1. MACHINE DESCRIPTION

The MAV 3230 cementing machine, built by the Mario Angeleri s.a.s. machine factory, is a cementing machine for solvent adhesives.

This machine is usually used in footwear, leathersgoods and paper-working factories. The cementing operation consists in introducing the material to be cemented between the two rollers of the cementing machine and in taking back the cemented material when it comes out the machine.

The useful cementing width is of 230 mm; so this machine is usually used to cement parts of footwears, handbags, wallets and products of the footwear and leathersgoods industry. The cementing machine has a working position for the user, as indicated in picture 1.



1.1 Safety protections

Electrical dangers

The machine is protected from overloads and short circuits by means of a magneto-thermal circuit breaker. There is also a low-voltage coil, that, in case of a temporary current cutoff, permits to the machine to restart only by pushing the bottom 1 of the general switch.

Mechanical squashing or abrasion dangers.

All the parts, transmitting the motion (gears and chains) are protected.

The gears, transmitting motion to the upper arm, are protected by fixed carters; besides a microswitch stops the machine in case that the arm is lifted up excessively. (This microswitch is absent in case the machine is provided of a pedal).

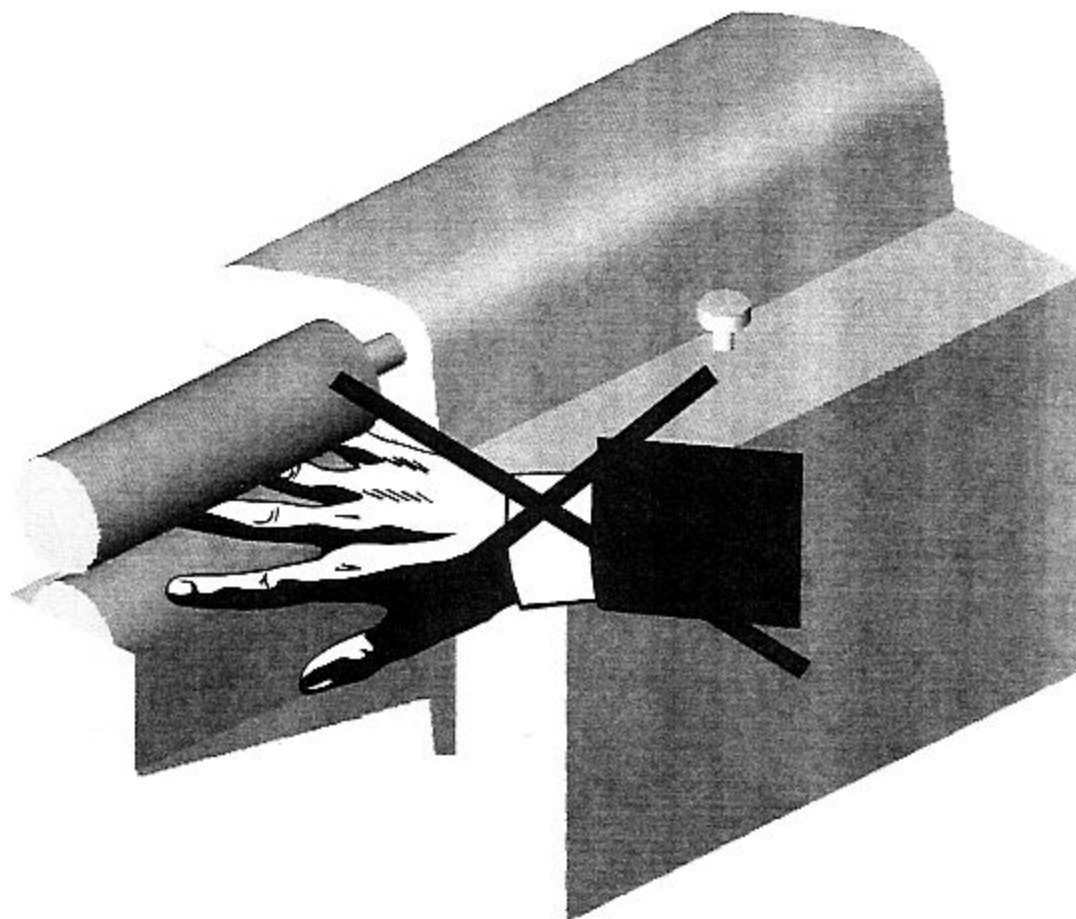
The arm of the upper transport roller can be lifted up, because it is holden only by a spring until the end of stroke position so to avoid dangerous situations, in case the operator touches the two rollers unintentionally.

The iron spreading roller has a slight knurl permitting the transport of the adhesive to be transfered to the material; the access to the roller is protected by a plexiglass fixed barrier A (picture 2)

Be careful during the introduction of the material so to avoid the touch, also casual, to the rollers (picture2).

In case of user's error, the material is inserted in a wrong way, don't try to correct the direction, but grasp it when it comes out the machine and repeat the operation beeing more careful.

The constructor recommends the use of gloves or of any other grasping tools (pliers, etc.), so to protect the operator's hands from possible burnings.



PICT 2.

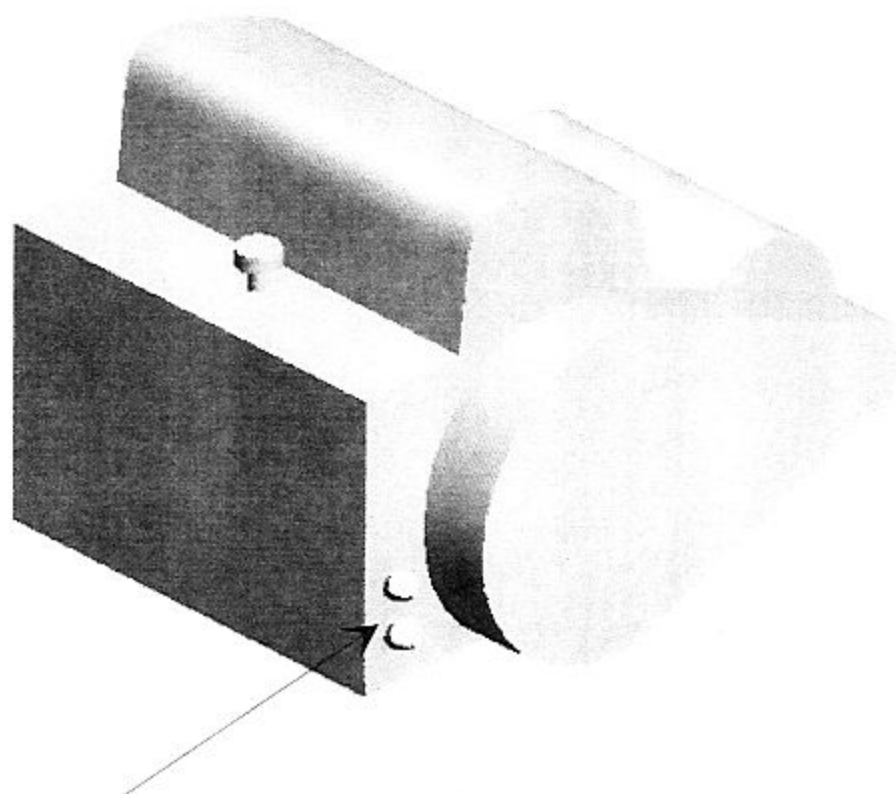
Dangers caused by the presence of fumes and vapours.

In the posterior left side of the machine there are two 8 MA holes, to them, if necessary, the suction system can be fixed by means of the special hanger (picture 2 bis).

The constructor has prearranged the only holes for the hanger, to that it's possible to fix the suction device, without knowing a priori which kind of solvent adhesive the user intends to use.

The user has to inquire by the adhesive producers about the toxicity level of the used adhesive and about the necessity of a suction system. The suction system has to be connected to a centralized suction system. The volume of sucked air must be proportional to the kind of the adhesive, utilized by the user and to its toxicity.

If the factory, where the cementing machine is placed, is not equipped with a centralized suction system, the constructor can supply the machine with an aspirator, situated near the spreading roller and whose dimensions permit to it to be effective with the adhesives, usually utilized in the footwear industry. If the user wants to equip the machine with a suction system, buying it by the constructor, he has to specify in the purchase order the kind of adhesive he uses and the suction capacity he needs. In case of lack of specific information, the constructor will supply the suction system with the standard suction capacity (see pag. 8).



PICT 2-BIS

-WARNINGS:

1. Only technical-instructed staff or qualified operators in good health are allowed to use the machine.
2. Machines with three phase motor, after their connection with the feeding line, could operate with a reverse rotation; in this case the user has to check, if the rotation direction of the motor fan corresponds to that indicated by the arrow, situated near the motor.
3. The machine has been built to be used in footwear, leathersgoods and paper-working factories; therefore its use is forbidden in work environments with explosion dangers or exposed to bad weather (frost, rain).
4. By this machine can be used only the adhesives, whose use is provided for by the adhesive producers for the above -mentioned sectors (footwear, leathersgoods, paper-industry). The adhesives, producing explosive vapours, are not allowed.
5. The user has to be dressed adequately; don't wear large clothes or jewels and use specific hair-net in case of long hair.

2. TECHNICAL PECULIARITIES OF THE MAV 3230 CEMENTING MACHINE

MAV	3230
Width	600 mm
Length	600 mm
Height	1200 mm
Headstock Weight	28 Kg
Weight on stand	46 Kg
Useful cementing width	230 mm

Three-phase motor 380/50 Hz

-power of the electric asynchronous three phase motor.

-feeding voltage 380 Volt

-tip speed of the rollers 13 m/minute

Direct current motor with variable speed:

MAV	3230
Power of the electric three phase motor	0.33 Hp
Power of the electric single phase motor	0.25 Hp

-feeding voltage 380 Volt or 220 Volt , as required by the client (the client can require any other voltage)

-minimum tip speed of the rollers 1,5 rev/minute

-maximum tip speed of the rollers 16.5 rev/minute

Motor for the suction hood (optional)

kw	Rev/min	Air quantity	Speed	Insulation	Protection grade	Volt
0,10	2800	230 mc/h	14 m/sec	class F	IP 44	380

3. PROPER AND IMPROPER USE OF THE MACHINE

The cementing machine MAV 3230 has been built and planed to be used in the footwear, leathergoods and paper-working industry to cement materials by means of solvent adhesives.

This machine is usually used in the footwear sector to cement parts of footwears and in leathergoods. It can also cement any other material or edges with a maximum width of 230 m/m.

This machine can cement a lot of materials: leather, fabrics, paper, etc.. The constructor has planed this machine to be used only in the above-mentioned sectors and therefore to cement materials, usually used in the production of footwears, leathergoods and materials employed in the paper-working industry.

The cementing of particularly fragile materials, like glass (it could break during the cementing operation) is considered by the constructor as an improper use of the machine. Improper is also the cementing of plastic materials, that, by the (presence)of (solvente del colante), could loose their original composition or produce with the adhesive particularly harmful chemical compositions.

Besides the constructor considers as improper use of the machine the cementing of material of small dimensions and thickness, so that the introduction and the taking back of the material through the spreading rollers could be difficult for the user.

4. HANDLING AND TRANSPORT OF THE MACHINE

The MAV 3230 cementing machine, sold supplied complete with stand, can be leant on a pallet or sent packed into a wood box. The handling of the machine can be made by means of a shunter, but only after having fastened the machine to the pallet.

For this reason, at the base of the stand, the machine has four holes, permitting to fix the cementing machine to the pallet by means of four M10 screws. Each of these screws has to be inserted in the holes at the base of the machine stand and to be fixed to the wood pallet, as indicated in picture 3.

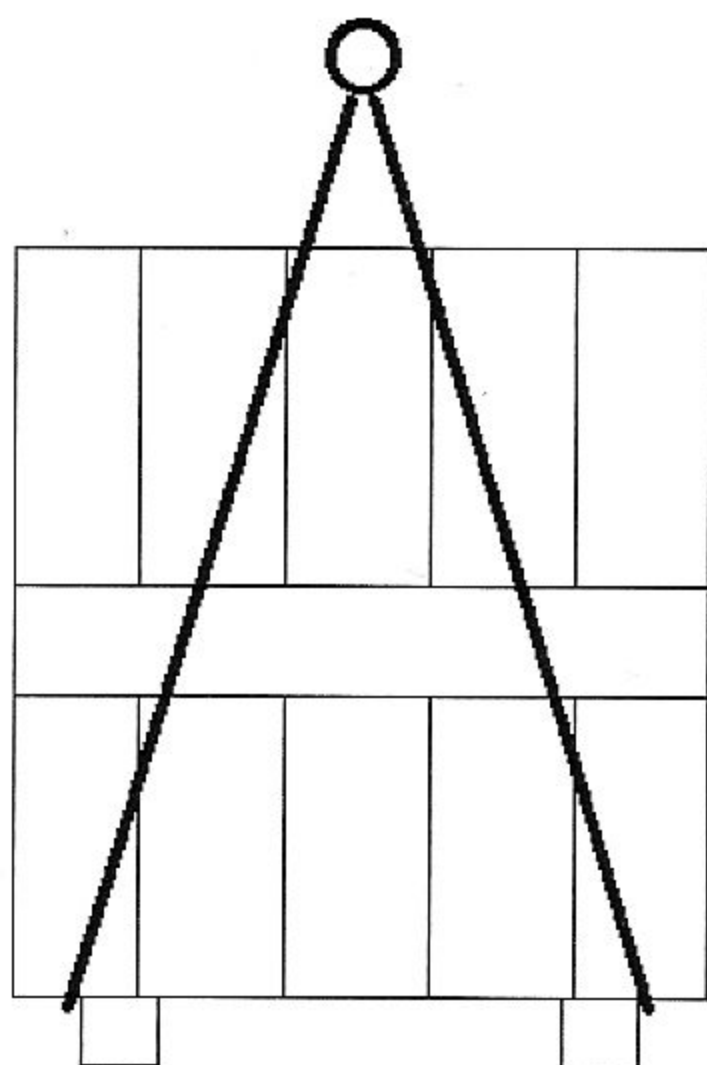
If the machine is packed in a box, it can be moved by means of ropes, as indicated in picture 2.

Sometimes, for short hauls, the machine is sent without packing and winded in cellophane. In this case the constructor recommends the presence of two persons at least to move the machine. After having been loaded it on the means of transport, the machine has to be laid down (situated) as indicated in picture 4-A.

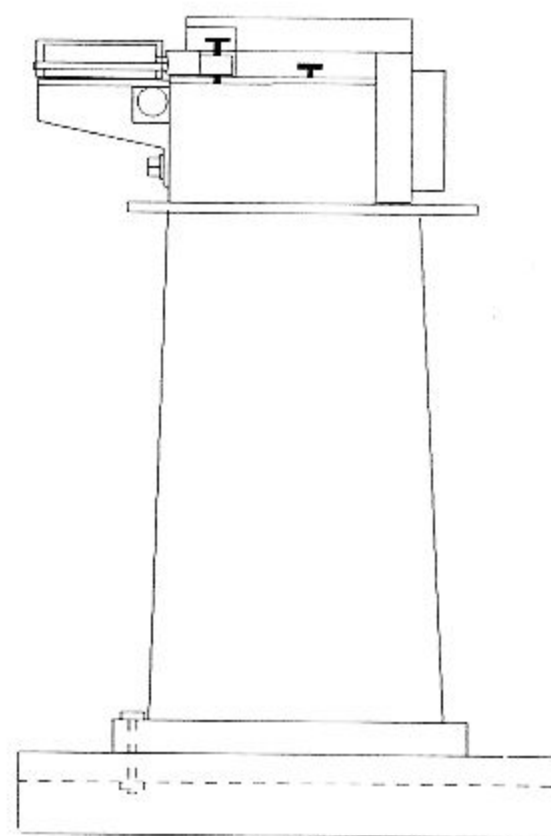
If the machine has to be moved for short positioning movements, the constructor recommends the presence of two persons at least.

The machine can be sold without the stand (picture 4), in this case the user has to fix the machine to a table by means of 4 MA8 screws.

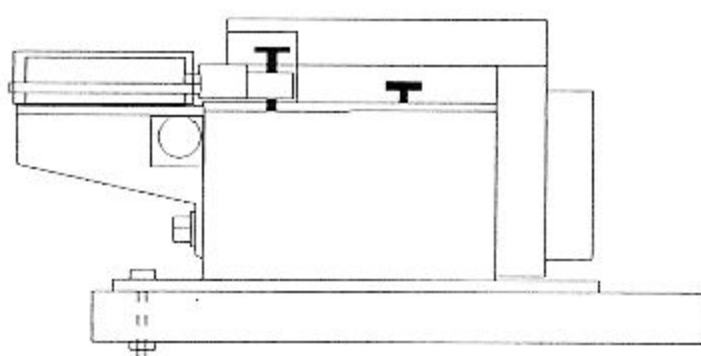
If the machine has been ordered with some others of our machines, considering its exiguos weight and its small dimensions, it will be packed in a chest or put on a pallet with the other machines and fixed to that by means of 2 10MA screws.



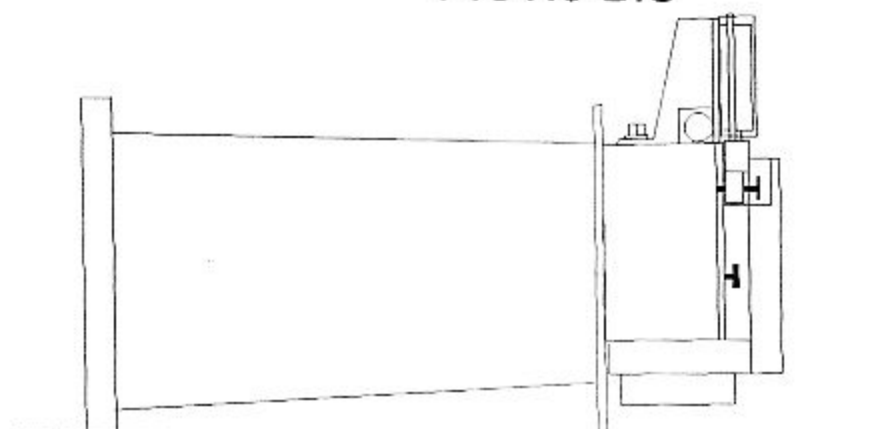
PICT.3



PICT.3-BIS



PICT.4



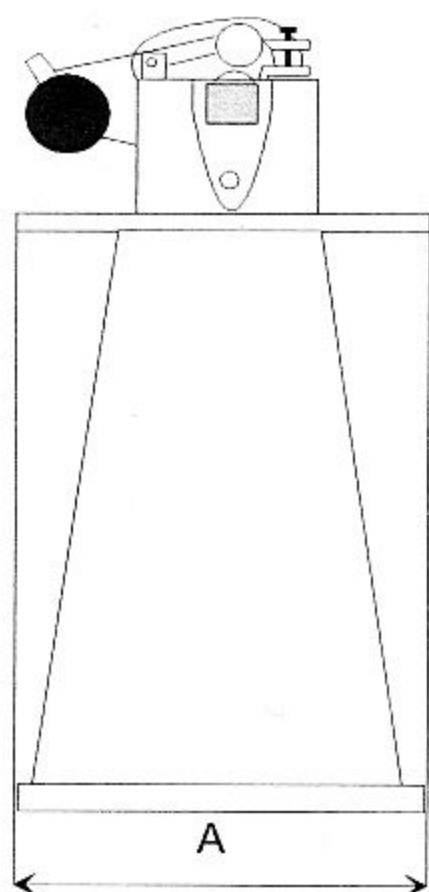
PICT.4-A

5. INSTALLATION OF THE MACHINE

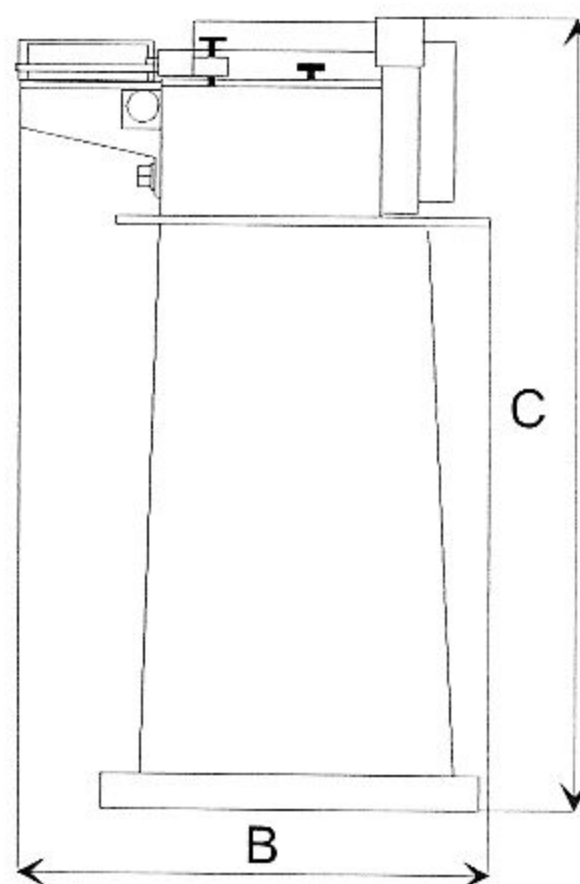
5.1 Overall dimensions of the machine

In pictures 5, 6, are indicated the maximum overall dimensions of the MAV 3230 cementing machine.

MAV	3230
A	600 mm
B	600 mm
C	1200 mm
WEIGHT	46 kg
HEADSTOCK WEIGHT	28 Kg



PICT.5



PICT.6

5.2 Installation plan of the MAV 3230 CEMENTING MACHINE

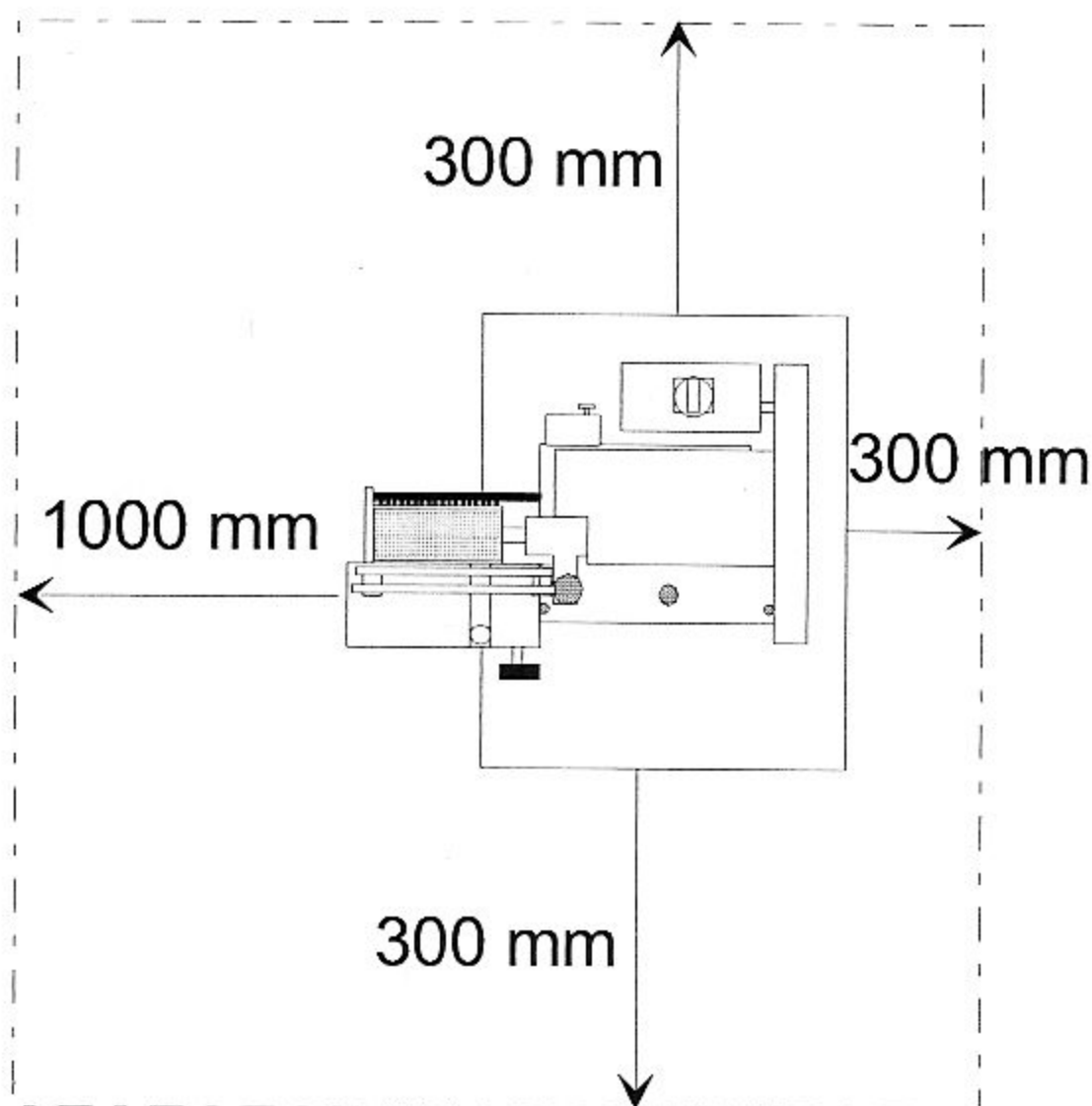
For a good working of the cementing machine, it is not necessary to fix it to the ground. The suction hood (if it is required) has to be connected to a centralized suction system.

The quantity of sucked air depends on the kind of the used adhesive.

If the user's factory isn't equipped with a centralized suction system, the constructor can supply a suction position system of different dimensions in conformity with the buyer's requirements. Binding for the dimensions of the suction system is the specification of the kind of adhesive and of the suction capacity, required by the user.

5.3. Free spaces

To get a correct use of the cementing machine and to upkeep it in safety conditions, the constructor recommends to install it, respecting the minimum free spaces, indicated in picture 7.



PICT.7

6. ASSEMBLY AND SET UP OF THE MACHINE FOR ITS STARTING

The machine is entirely assembled and tested by the constructor's factory.

6.1 Checks and preventive verifications

By the receiving of the machine the constructor advises to control it as follows.

6.1.2 Control of the possible damages caused to the machine.

To find possible damages, caused to the machine during its transport, check the integrity of the following parts:

- protection systems, plexiglass screens, carter
- Electrical components, switch set on the motor, feeding cable, plug

6.1.2. Machine cleaning

By means of common industrial detergents, clean carefully the machine, removing dust and other substances, accumulated during the transport.

6.2 Connection of the machine to the electric current.

6.2.1 Electric connection

The machine is sent already equipped with the feeding cable with plugs 16 A-64/380-415 V 50-60 Hz 3P+Earth IP44 in conformity with the CEE specifications.

Verify if the plug of the machine is compatible with the user's plant. Otherwise the user has to change it.

Connect then the feeding line with the proper plug to the current outlet of the main line, checking if the voltage and the frequency of the electric motors of the machine correspond to those of the free line of the user's plant.

The values of the voltage and of the electrical frequency for the feeding of the motors, are indicated on an apposite data plate, fixed to the motor.

Warnings

1)Protect the feeding main line of the user from overcurrents by means of circuit breakers (magnetothermal breakers)

6.2.2 Verification of the right rotation direction of the motor (only machines with three phase motor)

To verify the right rotation direction, operate as follows:

- Connect correctly the machine to the line voltage.
- Set the selector of the GENERAL SWITCH on 1
- Verify if the rotation direction corresponds to that indicated by the arrow situated near the spreading roller.
- Operate on the wires of the plug to reset the correct rotation direction.

7. STARTING AND USE OF THE MACHINE.

The machine has a working position for the user (picture 8)

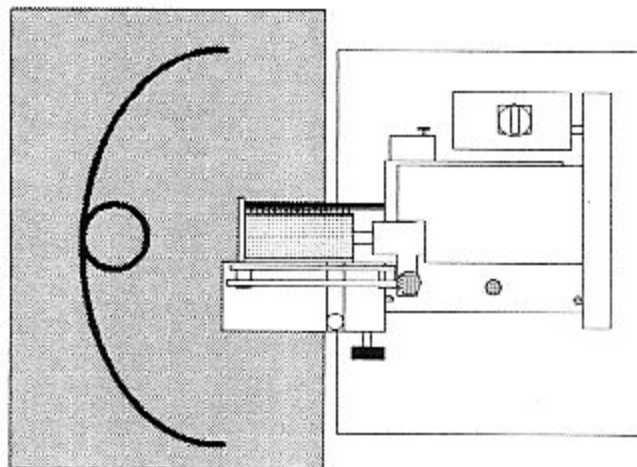


fig.8

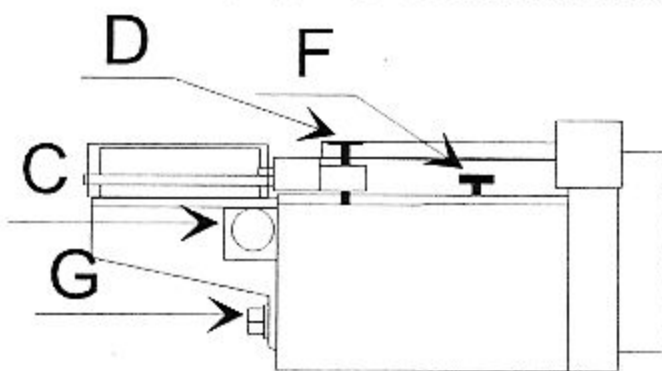
8. SETTING AT WORK AND USE OF THE MACHINE.

8.1. Working cycle

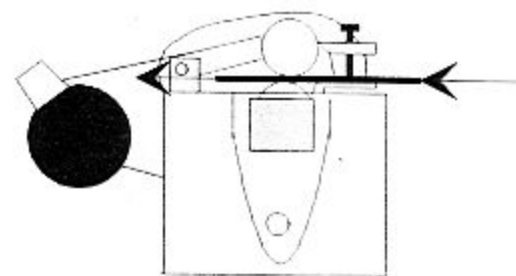
On motor of the machine there is the general switch with the two positions selector 0 and 1.

The correct working procedure is the following one:

1. By means of the selector A of the GENERAL SWITCH (1-IG) the user can get the electric feeding to the motor.
2. The two rollers will start rotating at the speed consented by the three-phase motor
3. Regulate the quantity of adhesive that the user wants to use to cement the material by means of the knobs C of picture 9.
4. Regulate the height of the upper transport roller in conformity with the thickness of the material to be cemented by means of the knobs D of picture 9.
5. Begin the cementing procedure verifying if the suction hood (if the machine is supplied with it) is working.
6. Introduce the material to be cemented between the two rollers, as shown in picture 10, being careful. If the machine is provided of the optional pedal P, the user has to push it in order to make the upper roller come down.
7. Take back the cemented material following and lifting it during the taking back phase.



PICT.9



PICT.10

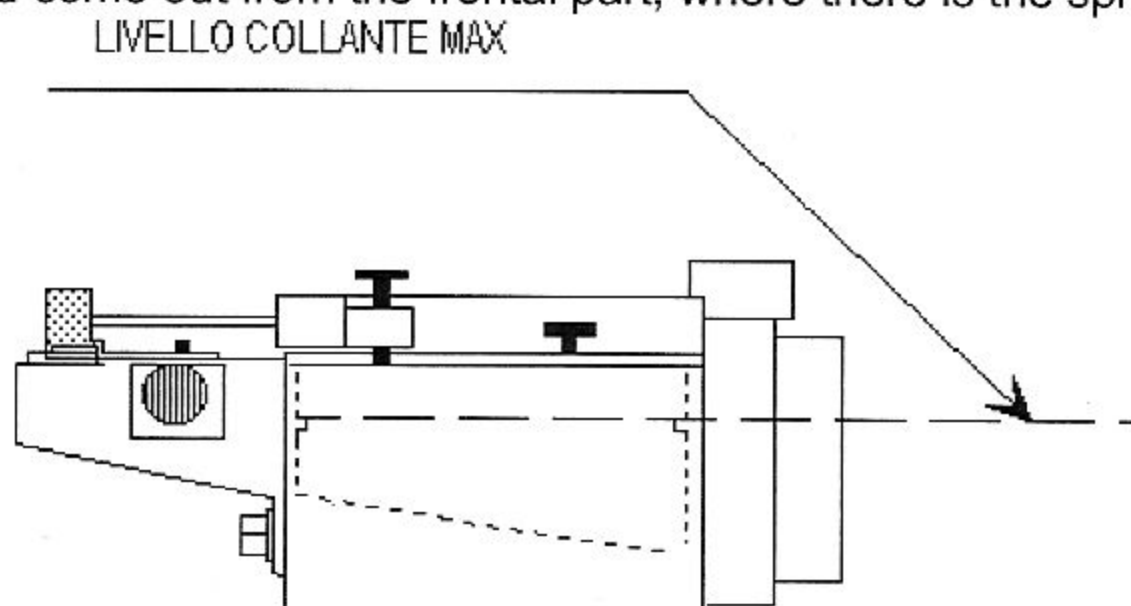
NOTES:

If the user has to cement straps or edge, he has to regulate the width according to the kind of material to be cemented.

8.2. Adhesive feed.

It is seldom necessary to verify if the adhesive quantity in the machine is enough to permit a correct working of it. To verify the adhesive quantity, operate as follows:

- Screw out the knobs that close the cap of the adhesive tank and lift it up by means of the knob F of picture, so to verify if there is some adhesive in it.
- If there isn't enough, pour the quantity you need paying attention to the new level; it mustn't be higher than the smallest part of the tank, see picture 11, because the adhesive could come out from the frontal part, where there is the spreading roller.



PICT.11

8.3. Emptying and change of the adhesive from the machine.

The constructor advise the user to do this operation whenever the adhesive has no more the right peculiarities for a good use.

In order to empty the adhesive from the machine, the user has to do as follow:

1. Place the container you want to use near the adhesive drain plug G (picture 9)
2. When the machine is off and the feed is disconnected, remove the gas plug G 3/4 (picture 9) by means of a wrench N 17.
3. Switch on the machine, the engine will set on a scroll that pushes the adhesive towards the outlet, making the tank emptying faster.
4. When the adhesive stream is finished, switch off the machine and verify visually if there is no more adhesive in the tank, paying attention not to touch the scroll, that could be in motion.
5. Rescrew the plug and restore the adhesive level, paying attention to the new level, that mustn't be over the one indicated in picture 11

WARNINGS:

- Don't scatter absolutely in the surrounding environment the adhesive recuperated after the cleaning operation (if it is dirty and unusable) and the water used to clean the tank, but deliver them to factories specialized for the elimination of such substances.

9 MAINTENANCE AND CLEANING.

9.1. Maintenance.

The mechanical parts in motion inside the machine needn't any lubrication. Chain gearings are lubricated by the constructor and they needn't further interventions. The constructor advises to check yearly wear condition of pinions and chains transmitting the motion to the spreading roller and to the transport roller.

9.2. Machine cleaning

The necessity of the machine cleaning depends on the kind of adhesive, chosen in conformity with the kind of material that the user wants to cement. The constructor advises to clean every day the machine externally. Such a cleaning has to be made with the switched off machine and with the stopped spreading roller. By means of a wiping rag soaked in solvent, clean the back and the front of that part, situated near the spreading roller and clean the transport roller if it is inadvertently dirtied from the adhesive.

9.4. Possible troubles

1. Failure

Pouring of the adhesive from the anterior side of the spreading roller with the stopped rollers caused by an excessive quantity of adhesive into the adhesive tank.

Cure:

Sink the adhesive level and carry on the work, without adding any other adhesive.

2. Failure

Even if there is the adhesive in the tank, it isn't pumped on the spreading roller.

Cure:

Probably there is something that obstruct the feeding slit of the pump. With the engine off and the rollers stopped, control with a screwdriver that the slit is clear, in any case start then the emptying operation of the adhesive, as indicated in the paragraph 8.3 of this manual.

9.5 Parts subjected to wear and to change

The machine parts subjected to wear are listed below. The constructor recommends to keep these components in stock.

	Machine parts	Code number
n°1	Scraper-regulator	MAV3230/143144
n°1	Composite fibre gear	MAV3230/20
n°1	Belt Z30	MAV3230/11

10 DISMALTING OF THE MACHINE 3230.

If the user wants to disable the machine, he has to respect some basic norms, so to protect our health and the environment where we live

- empty entirely the adhesive tank, as explained at the paragraph 8.3. of this manual. Gather the adhesive, that has not to be scattered in the surrounding environment, but to be treated by industries, specialized for the elimination of such substances.
- gaiters, plastic material components have to be disassembled and eliminated separately.
- electrical components, like motor and switches (circuit breakers), have to be disassembled for their reusing in case they are in good conditions or to be overhauled and recycled.
- casing, carters and any other metallic part of the machine have to be disassembled and gathered in conformity with the kind of material. The so gathered parts will be then scrapped and melted, so to recycle the original material of the machine.

11 NOISE LEVEL OF THE CEMENTING MACHINE MAV 3230

Full speed parameters of the machine without suction:

Leq at the user's position with operating machine < 70 db(A)

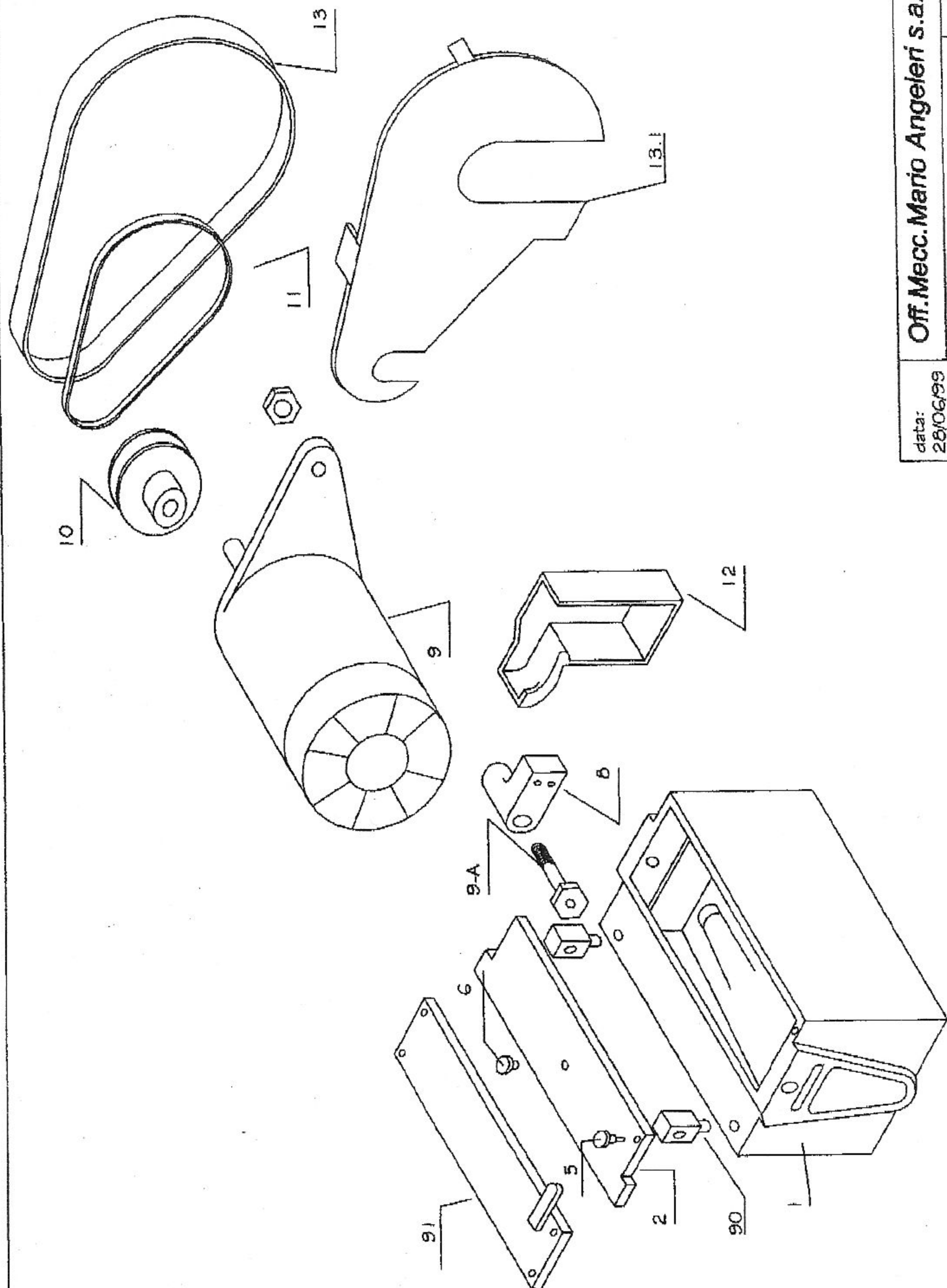
Lpc at the user's position with operating machine < 130 db(C)

Leq at the user's position with idling machine < 70 db(A)

Lpc at the user's position with idling machine < 70 db(C)

12 MAIN WARNINGS

1. The protections preset by the constructor to protect the user safety during the carrying out of his job, have not to be removed absolutely.
2. If a particular small and thin thing, dragged by the spreading roller, falls in the adhesive reservoir, recover it only after having switched off the machine and stopped the rollers by means of a grasping tool (tweezers, screwdriver).
4. For the adhesive emptying, operate with the stopped rollers, as explained at the paragraph 8.3. Don't scatter the recovered adhesive, but deliver it to factories specialized for the elimination of such substances.
5. The constructor recommends to protect the feeding main line from possible overcurrents by means of circuit breakers.

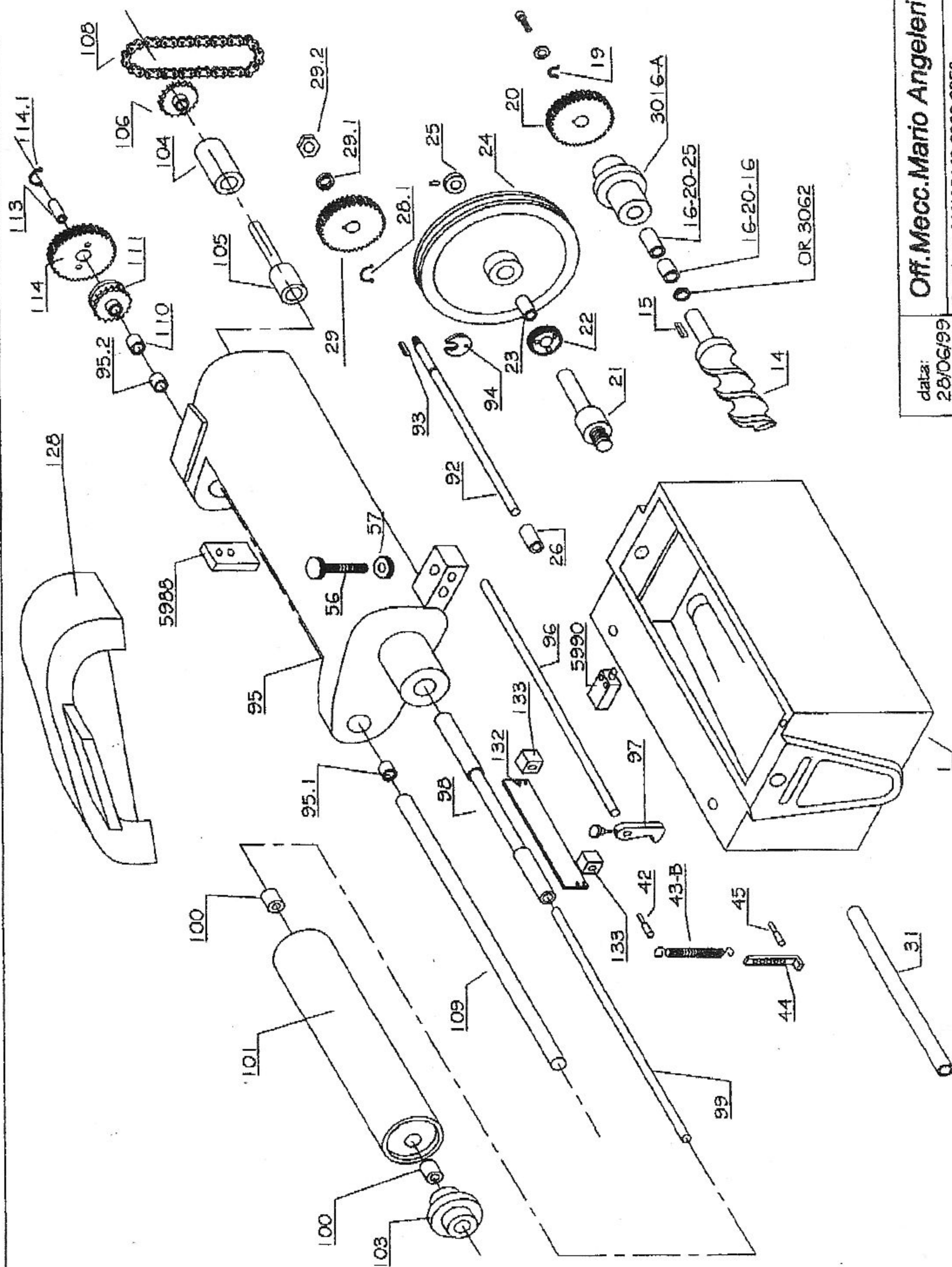


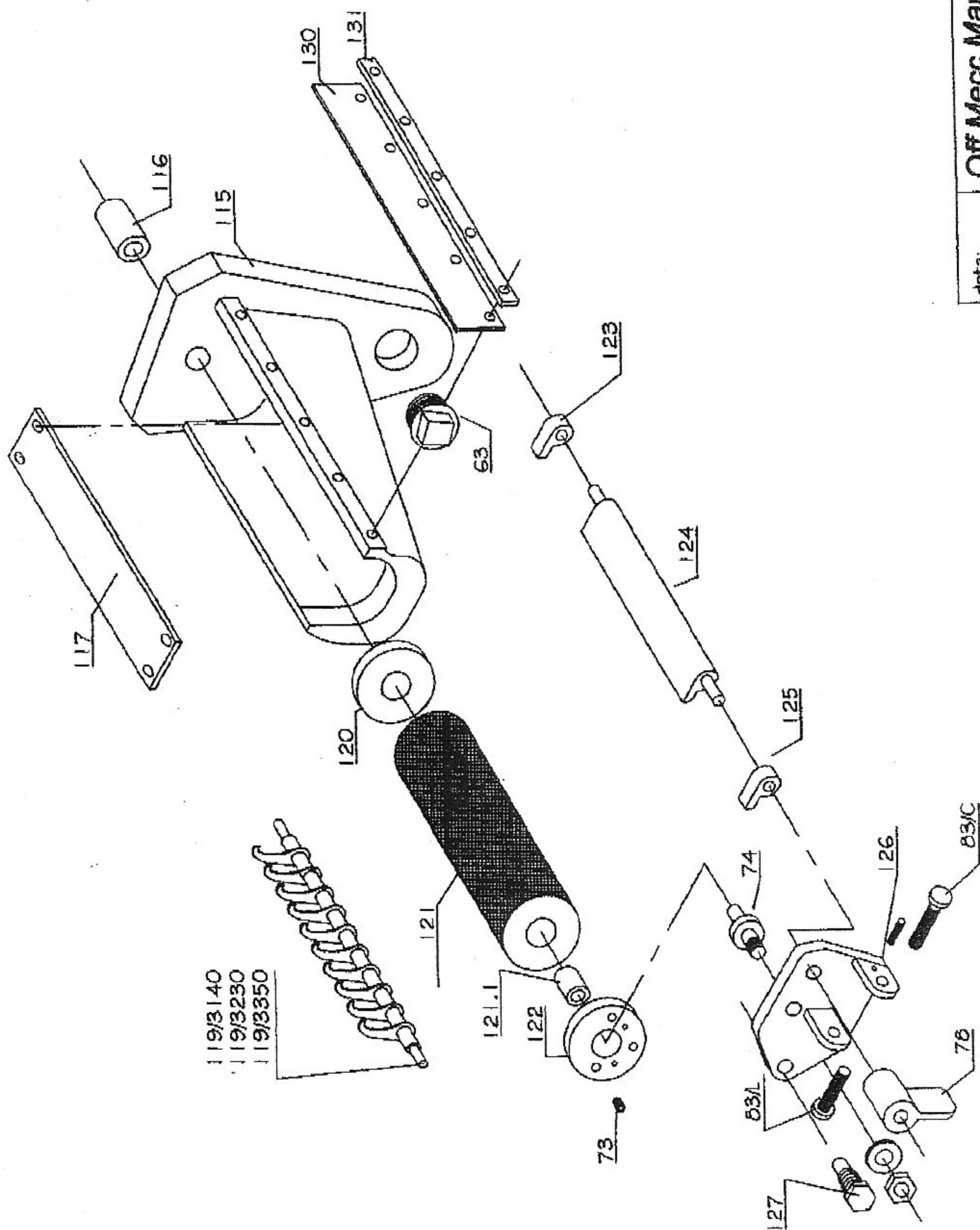
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Off.Mecc.Mario Angelini s.a.s.

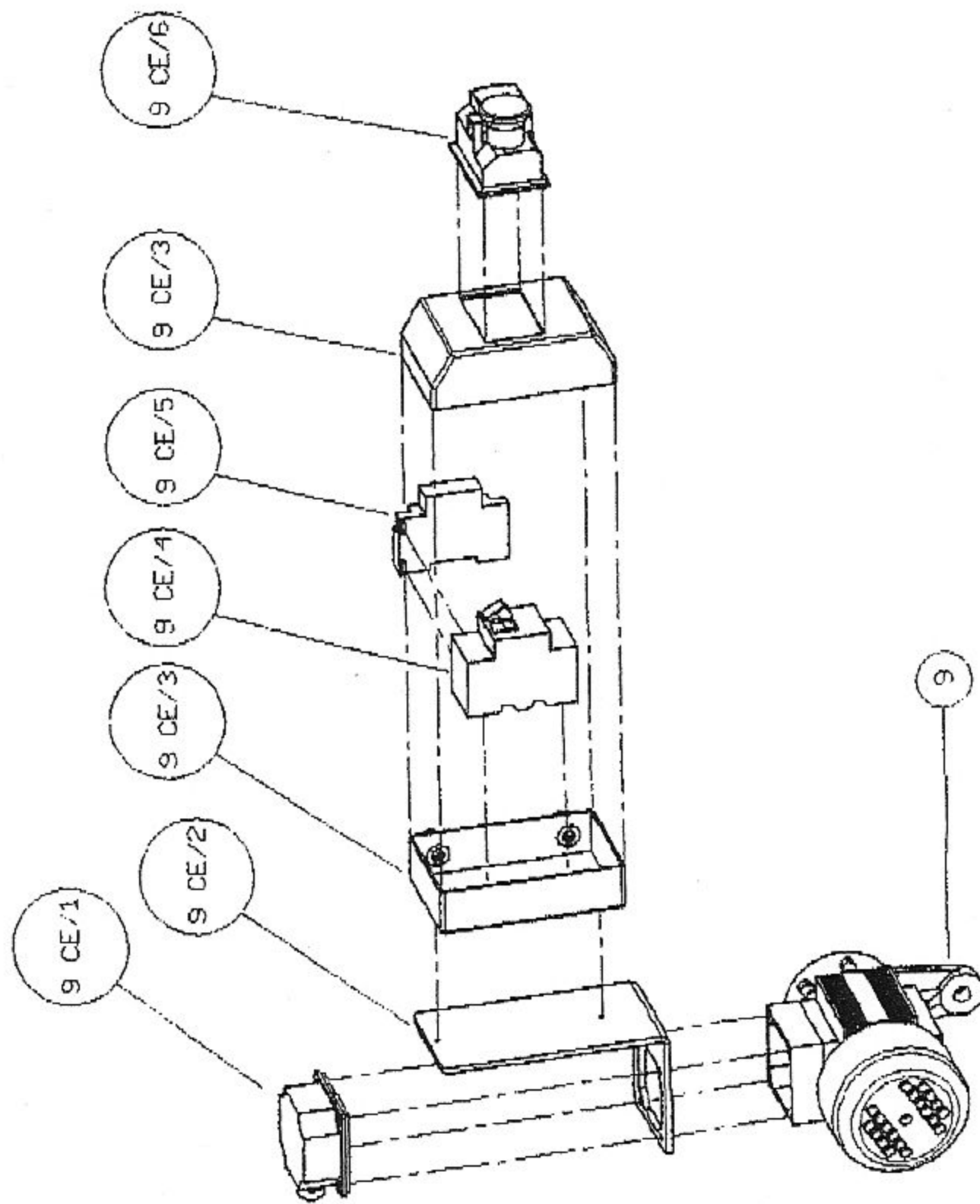
Catalogo MAV 3140-230-350

Pag. 1

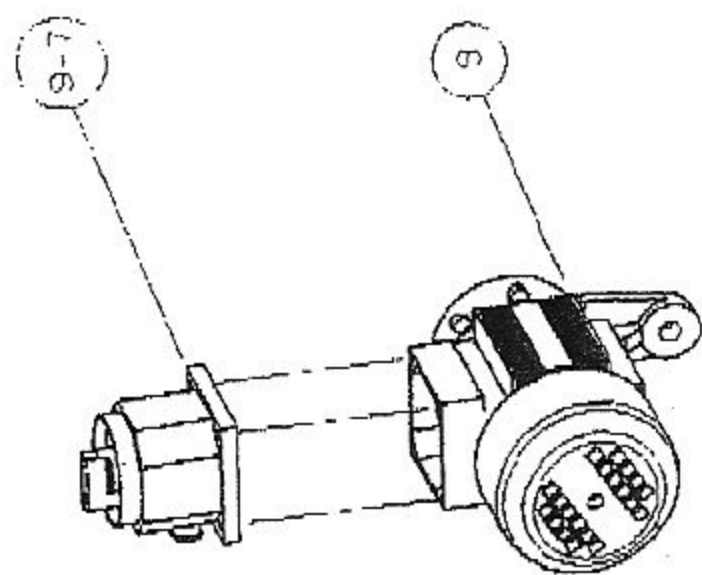




INTERRUTTORE CE CE SWITCH



INTERRUTTORE EXTRA CE EXTRA CE SWITCH



Codice Pezzo	Pag.	N°	Descrizione
MAV 3140-230-350-1	1	1	Basamento
MAV 3140-230-350-2	1	2	Coperchio anteriore
MAV 3140-230-350-5	1	5	Volantino
MAV 3140-230-350-6	1	6	Volantino
MAV 3140-230-350-8	1	8	Supporto motore
MAV 3140-230-350-9	1	9	Motore
MAV 3140-230-350-9-A	1	9-A	Bullone fissaggio motore
MAV 3140-230-350-10	1	10	Puleggia motore
MAV 3140-230-350-11	1	11	Cinghia trapez. Z.30
MAV 3140-230-350-12	1	12	Carter copri ingranaggi
MAV 3140-230-350-13	1	13	Carter per cinghia
MAV 3140-230-350-13.1	1	13.1	Carter il lamiera per cinghia
MAV 3140-230-350-90	1	90	Supporto per braccio
MAV 3140-230-350-91	1	91	Coperchio
MAV 3140-230-350-14	2	14	Pompa
MAV 3140-230-350-15	2	15	Chiavetta
MAV 3140-230-350-OR3062	2	OR3062	Guarnizione Or 3062
MAV 3140-230-350-16-20-16	2	16-20-16	Bussola
MAV 3140-230-350-16-20-25	2	16-20-25	Bussola
MAV 3140-230-350-3016A	2	3016A	Supporto pompa
MAV 3140-230-350-19	2	19	Anello seeger
MAV 3140-230-350-20	2	20	Ingranaggio in fibra
MAV 3140-230-350-21	2	21	Alberino porta puleggia
MAV 3140-230-350-22	2	22	Ingranaggio
MAV 3140-230-350-23	2	23	Bussola per puleggia 15-20-40
MAV 3140-230-350-24	2	24	Puleggia in alluminio
MAV 3140-230-350-25	2	25	Anello di spallamento
MAV 3140-230-350-26	2	26	Bussola
MAV 3140-230-350-28.1	2	28.1	Anello seeger
MAV 3140-230-350-29	2	29	Ingranaggio in fibra
MAV 3140-230-350-29.1	2	29.1	Ranella
MAV 3140-230-350-29.2	2	29.2	Dado 12 MA
MAV 3140-230-350-31	2	31	Tubo protezione albero
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