

sarema

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-- MOD. 5000+5100+5201+5300 --

WORK CENTER FOR THE COUPLING OF THE UPPER, LINING AND
THE TOE-PUFF, PROVIDED WITH SPRAY DISTRIBUTOR
FOR WATER CEMENTS

OPERATING HANDBOOK VERSION 3.0



LAST:

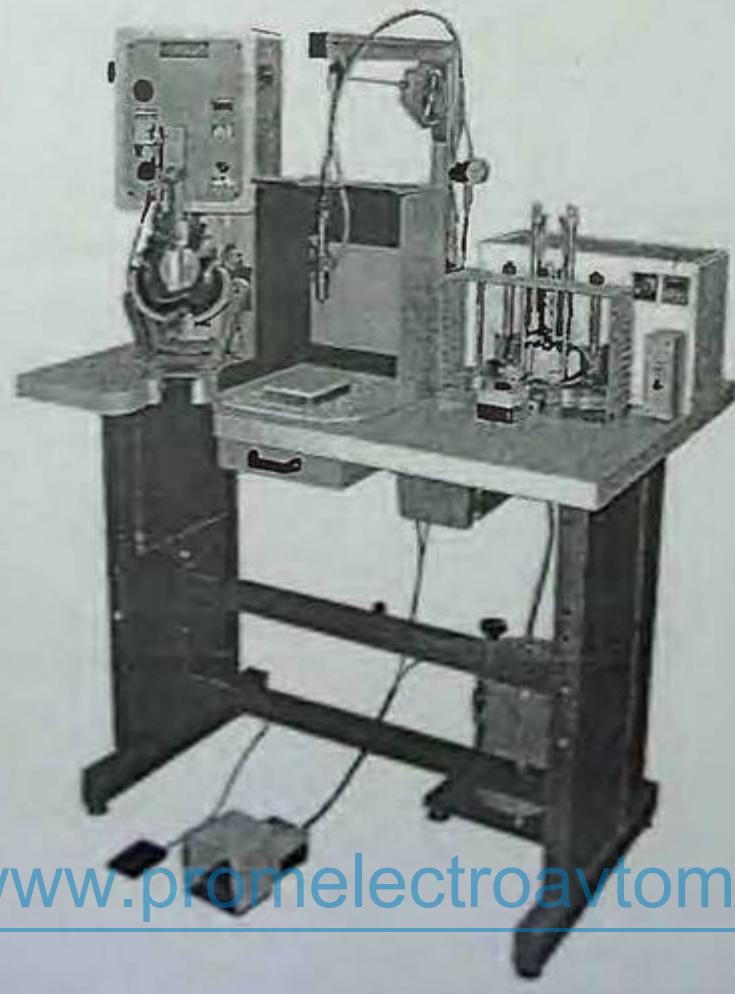
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HOOKING POINTS

Lift the machine as shown in fig. 1 (lifting by means of a fork lift) and fig. 2 (lifting by means of cables or straps); in the case of lifting by means of cables or straps be certain to secure the machine's tank and pedals to the structure.

In any case, it is preferable to set the machine onto a platform and therefore carry out handling operations with a fork lift truck, applying the precautionary measures described previously to avoid any possibility of the machine's tipping over.

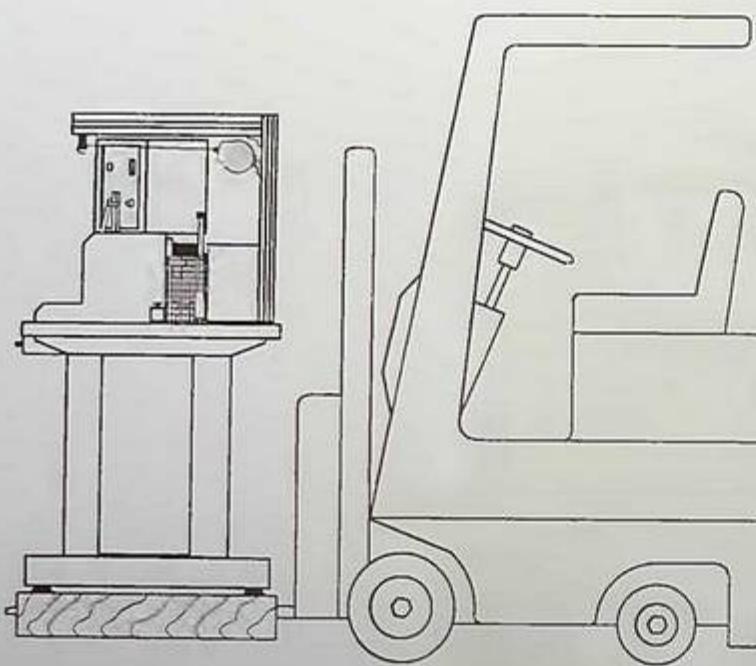


FIG. 1

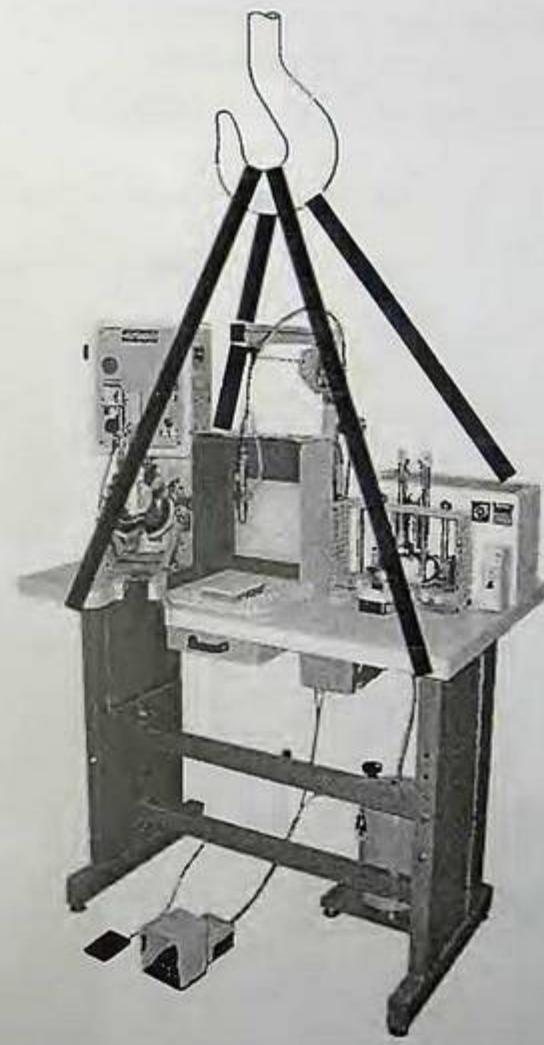
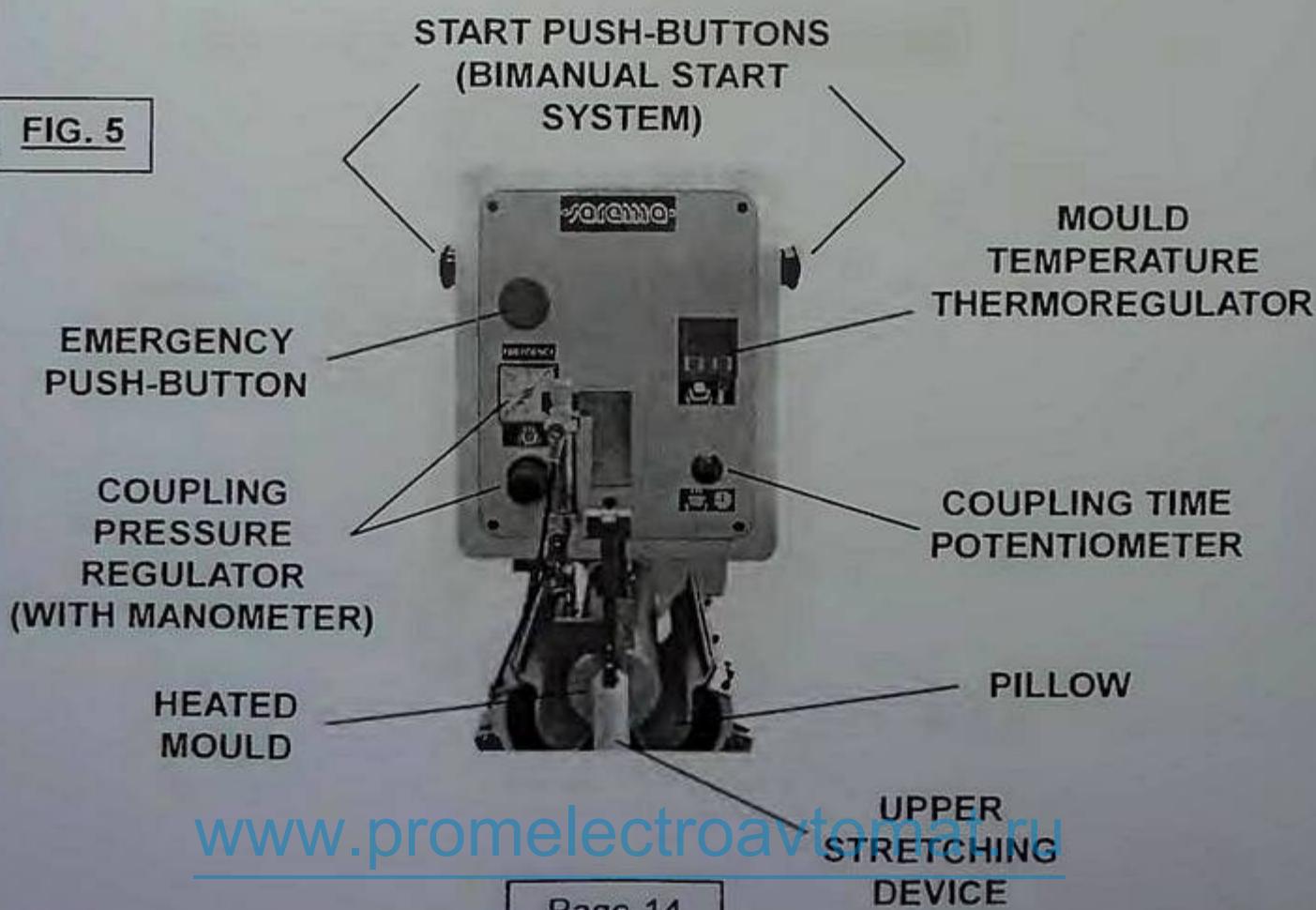
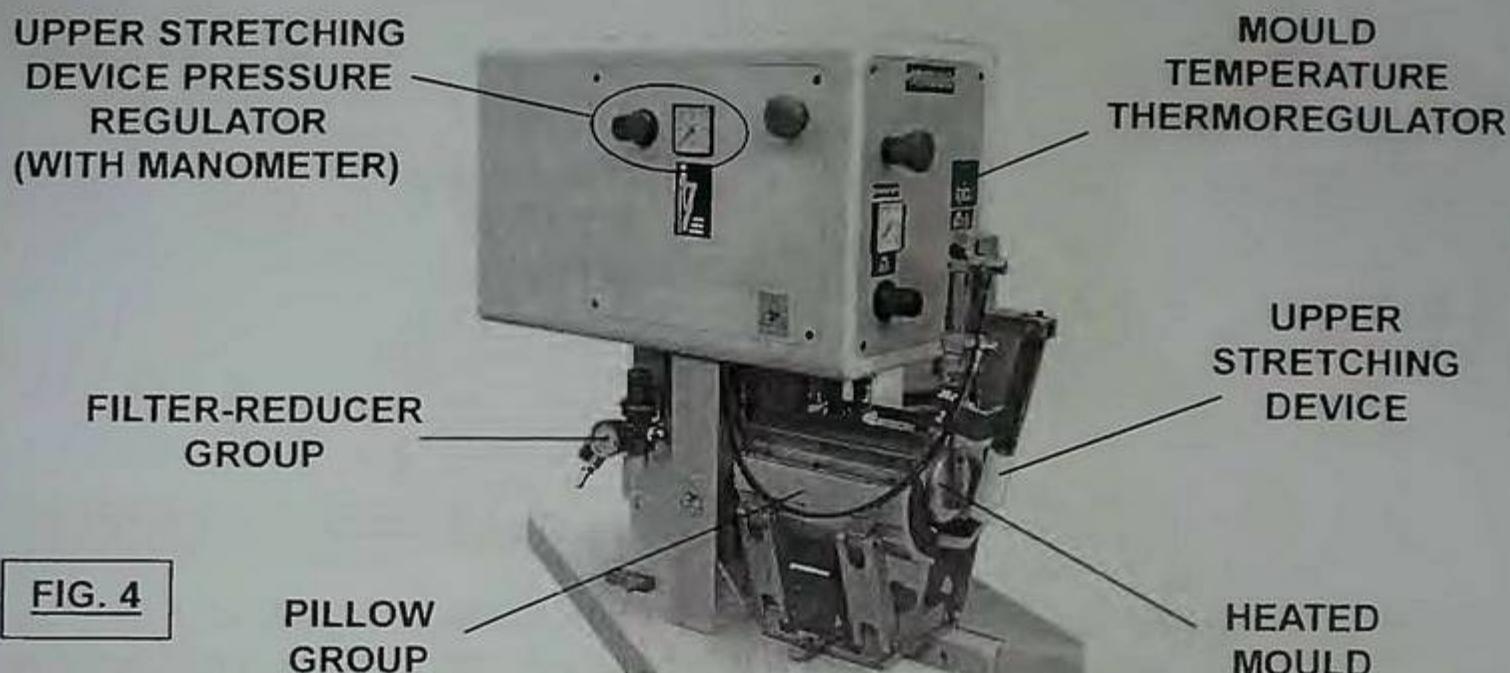


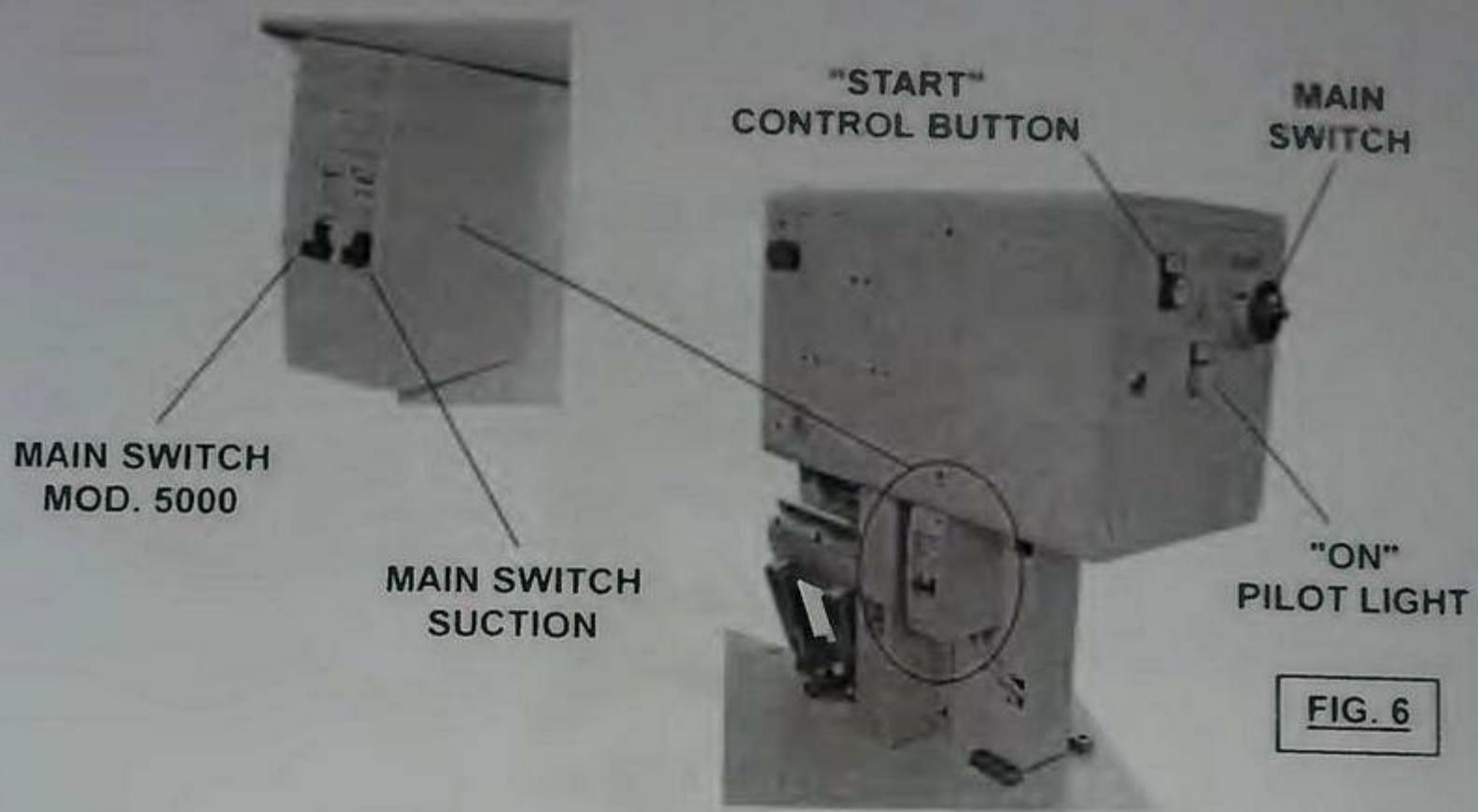
FIG. 2

DESCRIPTION OF MOD. 5000

The mod. 5000 (fig. 4, fig. 5, fig. 6) is a press to couple the lining, the upper and the toe-puff with a upper stretching device; the mould temperature can be adjusted by a digital thermoregulator, and the machine has adjustable coupling pressure and adjustable upper stretching pressure, too. The mould and the pillow are interchangeable.

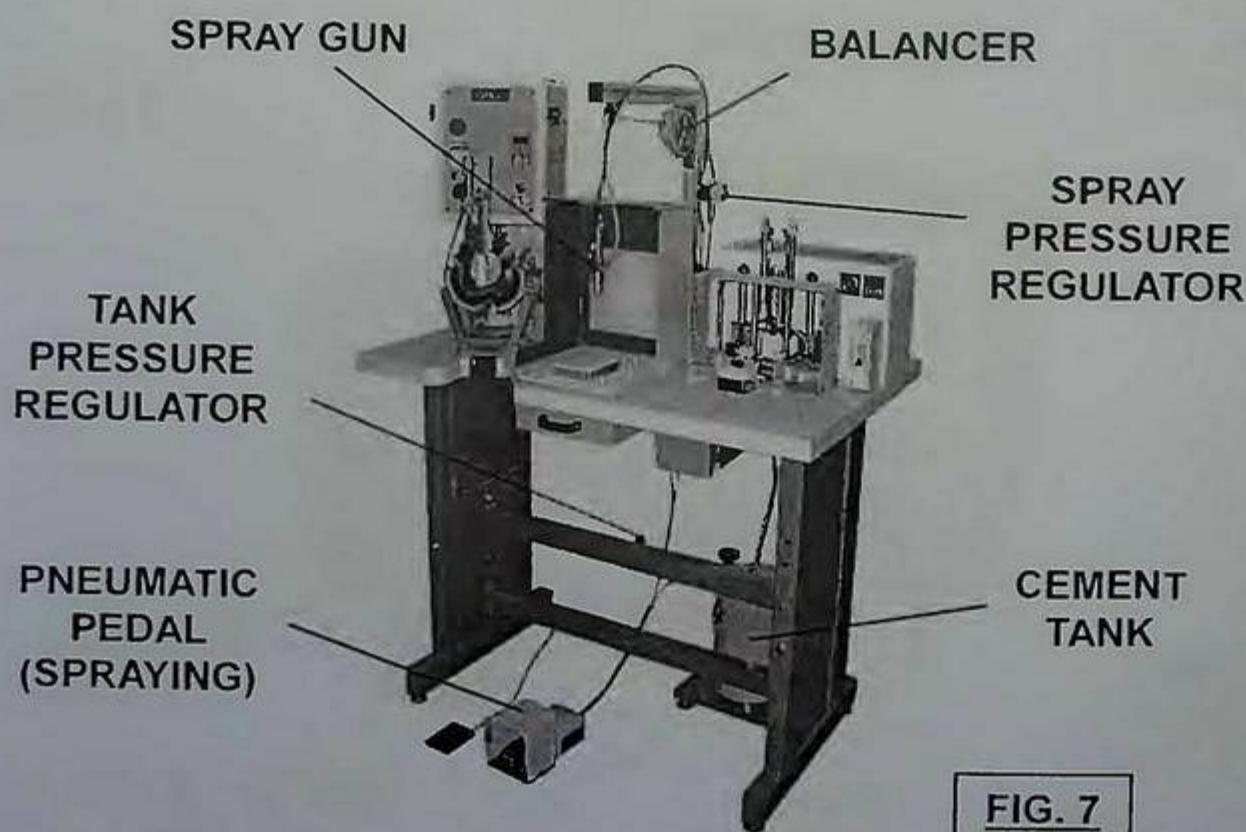
The machine is provided with an accident prevention bimannual cycle start system.





DESCRIPTION OF MOD. 5100

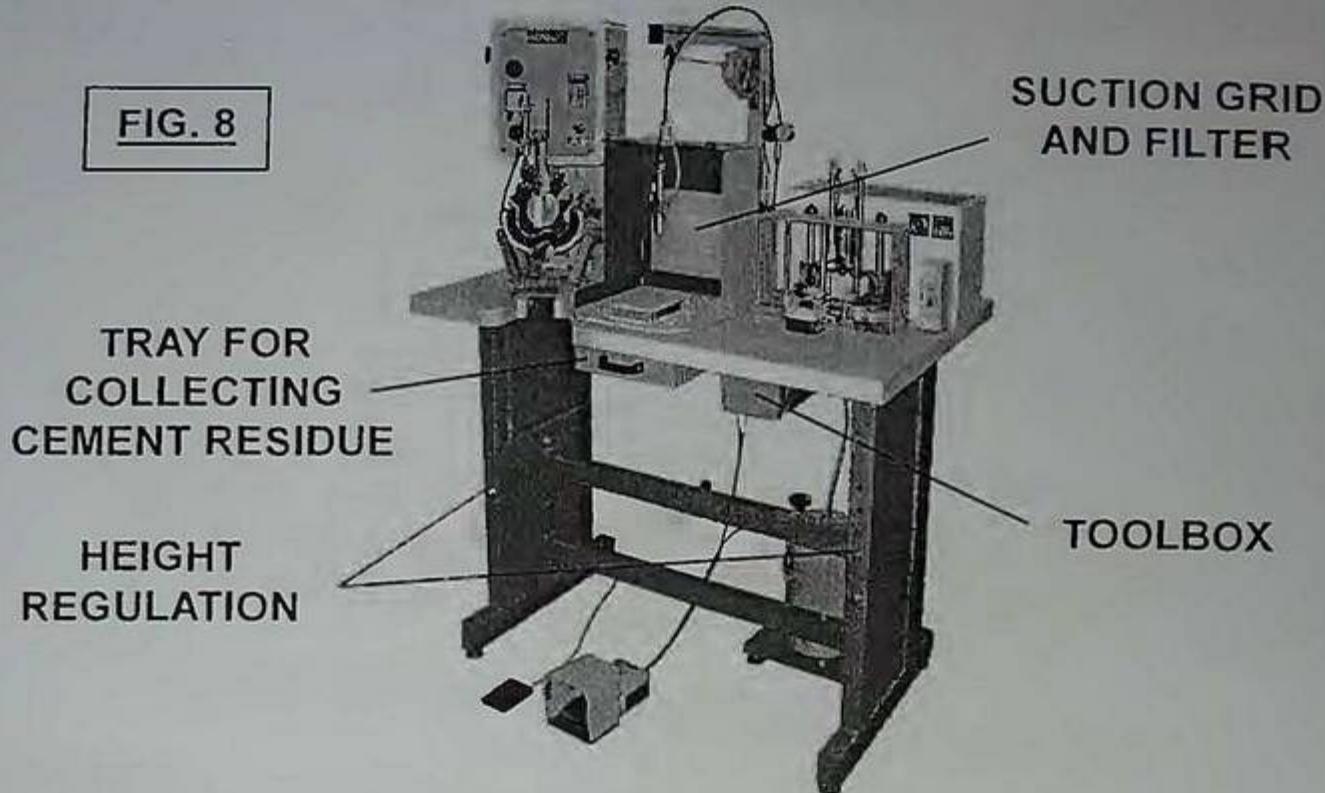
The mod. 5100 (fig. 7) is a system for spraying water-based cement adhesives, comprising a stainless steel tank for the cement adhesive, stainless steel spraying gun (assembled onto a balancer unit) with pedal control.



DESCRIPTION OF MOD. 5201

The mod. 5201 (fig. 8) is a 80x120 cm work table with adjustable height, provided with a suction grid and a filter made of a spongy material; the work table features a toolbox and a tray for collecting cement residue.

FIG. 8

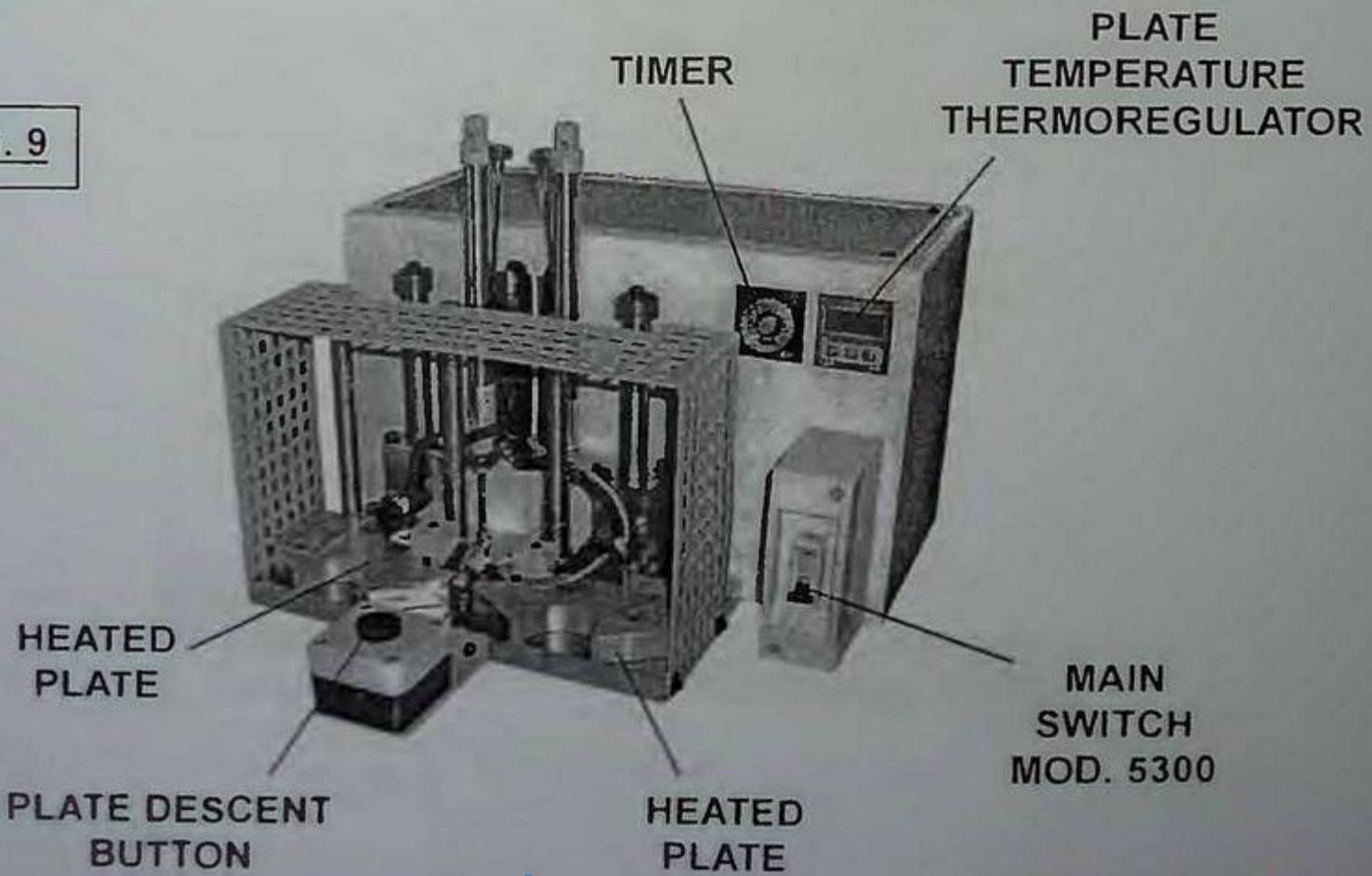


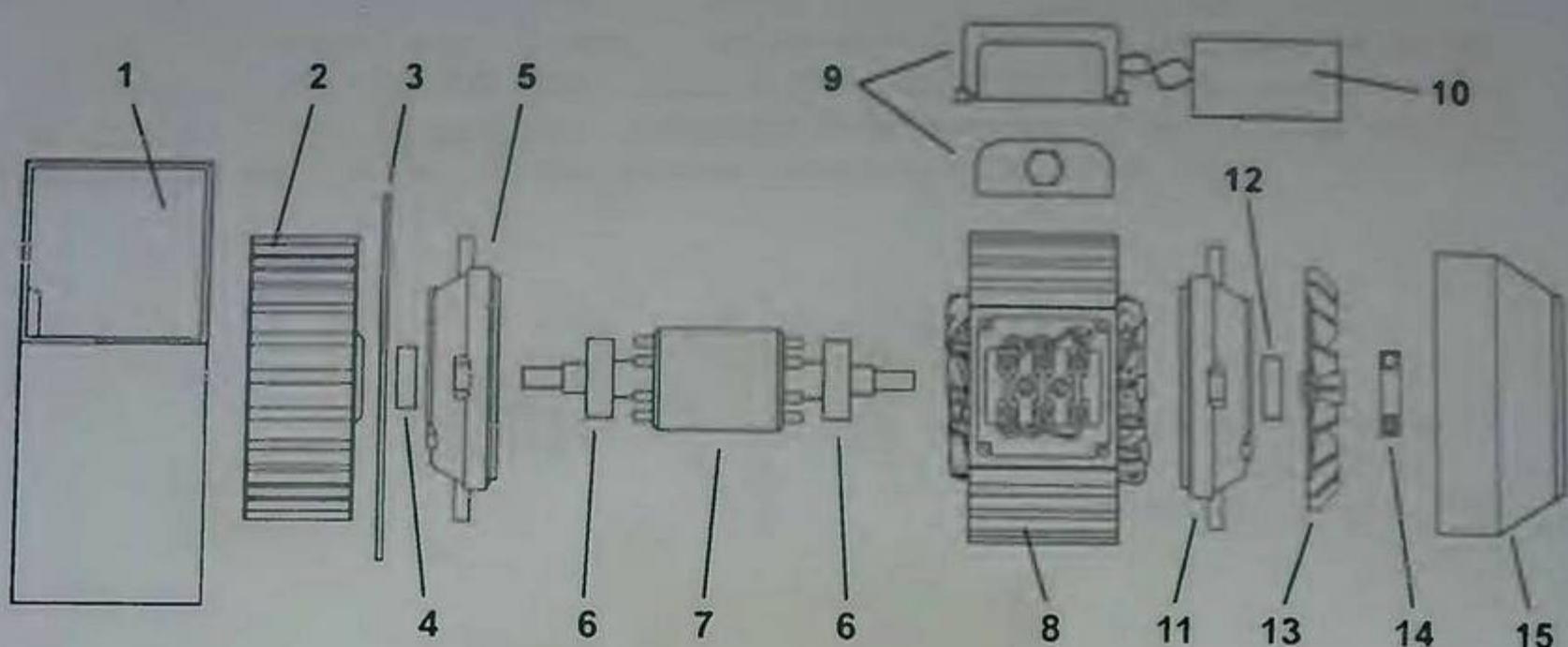
DESCRIPTION OF MOD. 5300 (optional)

The mod. 5300 (fig. 9) is a distributor and regenerating unit for thermoadhesive toe-puffs equipped with two hot stations.

The temperature of the two heated plates can be regulated by means of a digital thermoregulator, while a timer sets the heating time.

FIG. 9



DETAIL OF "TT" SUCTION UNIT**FIG. 10**

- | | | | |
|---|-------------------------------|----|--------------------------|
| 1 | suction fan volute | 10 | condenser |
| 2 | centrifugal fan | 11 | rear casing |
| 3 | flange | 12 | dust-proof rubber insert |
| 4 | dust-proof rubber insert | 13 | cooling fan |
| 5 | front casing | 14 | fan locking band |
| 6 | bearing | 15 | cooling fan cover |
| 7 | motor shaft | | |
| 8 | stator casing with winding | | |
| 9 | terminal cover with connector | | |

ALLOWED AND FORBIDDEN USE OF THE MACHINE

Machine models 5000+5100+5201+5300 have been designed and manufactured exclusively for spraying water-based cement adhesive, for coupling and cementing linings, uppers and toe-puffs. These machines must be employed for the above-mentioned operations exclusively: any other usage is to be considered improper to the machine's operating specifications.

It is absolutely forbidden to use the machine for any other use not foreseen by this operating handbook, in an explosive atmosphere or outside the standard values of temperature, pressure and humidity.

The machine model 5000+5100+5201+5300 has not been built to be used in places with deflagration risks.

The machine must be operated only with water or latex base glue; SAREMA S.r.l. is not liable in case that other solvent base glues are used.

SAFETY DEVICES

The machine model 5100 is equipped with a tank for the cement (fig. 11) where the cement is pushed to the gun by means of compressed air; the thrust pressure is adjustable and, also with very thick cements, is sufficient to let the cement arrive to the gun. On the tank lid there is a safety valve (which must be checked every month) adjusted at a pressure of approximately 2.5 bars. The suggested pressure for the tank is 0.5 ~ 1 bar.



The suction unit assembled on the mod. 5100 (fig. 7) can spray cements based on viscosity between 100 mPas and 10.000 mPas; for this kind of glues **the spraying pressure cannot overcome bar 0.8** to avoid the glue atomization.

The machine is equipped with a suction fan unit (situated close to the spray station) comprising a suction fan and filter made of spongy material (fig. 8); the filter serves to collect any cement residue, ensuring that even small amounts of cement adhesive do not end up in the work environment.

The operator must check frequently the filter cleaning status and eventually provide for the replacement (even every day).

For the mod. 5000 press (fig. 3, fig. 5), the descent of the mould last is controlled by an electric pedal, in low pressure; a bi-manual dual-button anti-repetition control starts up the final phase of the coupling cycle.

ADDITIONAL RISKS

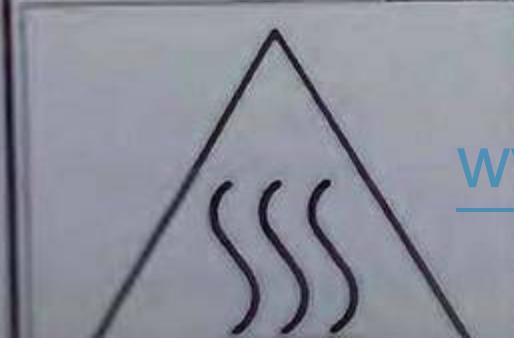
The thermo adhesive toe-puff dispenser mod. 5300 (fig. 15) features two plates which are heated to a temperature of ~90°. With the compressed air switched on, the plates descend themselves above, and the descent is triggered by a button at the front of the machine; the heated plates descend solely as a result of their own weight (approximately 0.5 kg. each). During the subsequent reascent phase, the toe-puff remains attached under the plates (due to the cement adhesive) and is removed by the operator, who must be careful not to touch the heated plate.

The plate's special design facilitates this operation, while a grid plated safety cover avoids accidental contacts. The operator must in any case wear personal safety devices for his/her hands (heat resistant gloves).

FIG. 14

FIG. 15

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HEATED PARTS

PNEUMATIC CONNECTION

The compressed air line powering the work centre must be of adequate size, based on the machine's expected air consumption (illustrated in the "TECHNICAL SPECIFICATIONS" table), so as to avoid any possible drops in operating pressure during the work cycle; the air must be properly treated, and devoid of condensation or oil.

To pneumatically connect the machine model 5000+5100+5201+5300, it is necessary to connect the compressed air line to the filter-reducer group (picture 16) checking that the running pressure is 5-6 bar.

The machine maximum running pressure is 8 bar.

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сжатого воздуха



FIG. 16

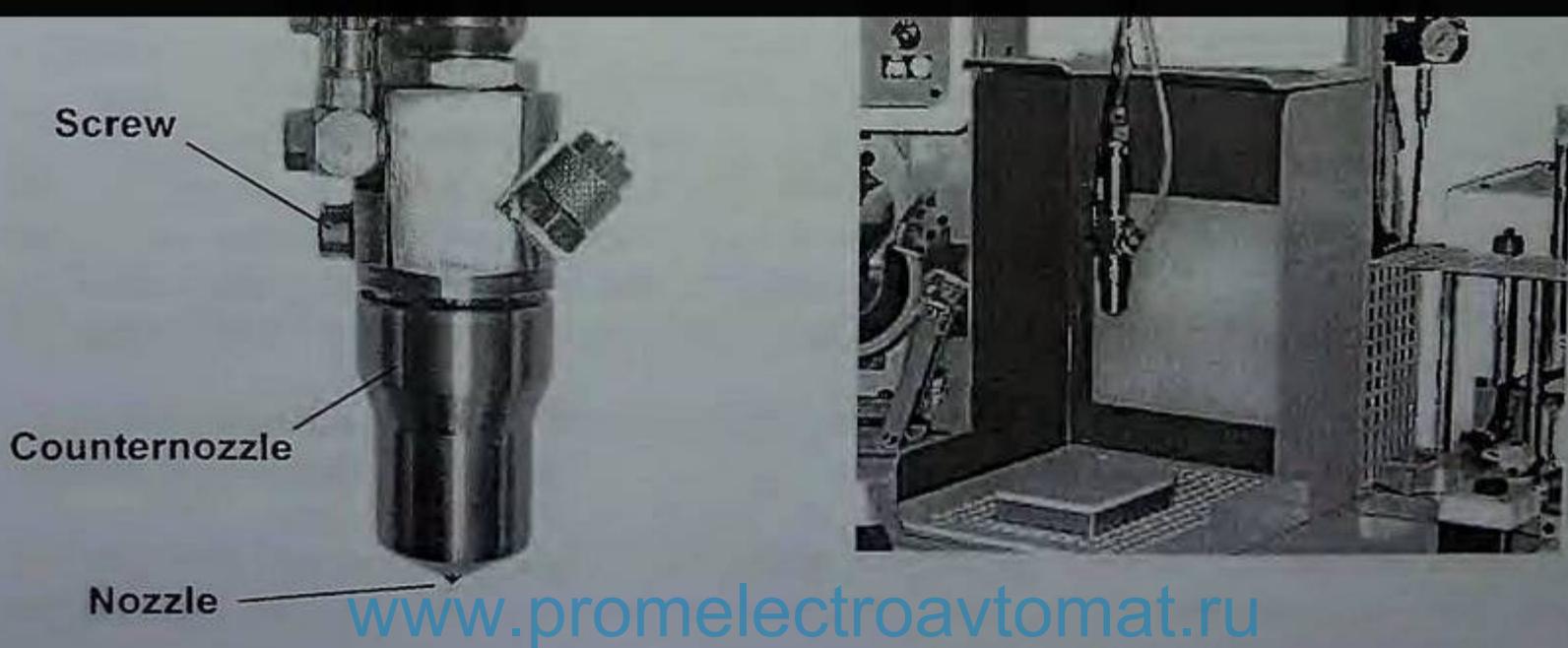
SETTING THE CEMENT SPRAYING GUN

The glue quantity can be batched by the glue adjusting knob (fig. 18) placed on the pistol upper side. By turning the knob clockwise (pistol seen from above) the quantity of cement is reduced while by turning it counterclockwise, the quantity of cement to be sprayed is increased.

The spray pressure can be modified by means of a pressure regulator indicated in picture 19 and **must be set at a max. value of 0.8 bar**.

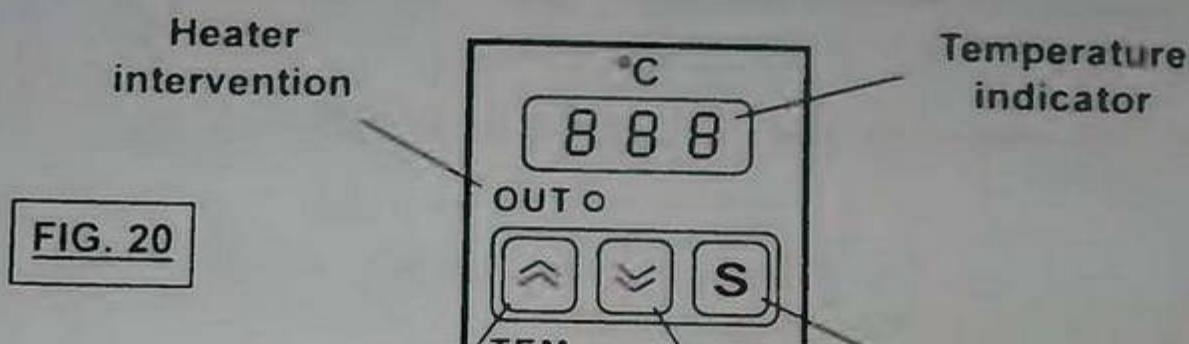
The width of the spraying depends on:

- distance between the gun and the material to be cemented
- viscosity and specific composition of used glue
- air quantity passing between the nozzle and the counter-nozzle



SETTING THE TEMPERATURE

The work centre is equipped with two digital thermoregulators (fig. 20), which allow for setting and viewing the operating temperature. The first thermoregulator, on the press mod 5000 (fig. 5), sets the mould temperature; the second thermoregulator, on the mod. 5300 (fig. 9), regulates the temperature of the heated plates.



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- 2) discharge and release the air in the tank, opening the tap (by unscrewing the knurled ring nut) at the side of the safety valve on the cover (fig. 11).
- 3) once it has completely been blown off, close it again;
- 4) unscrew the 4 knobs (picture 11) and remove the lid;
- 5) fill the cement container inside the tank;
- 6) close again the lid checking that it is placed correctly;
- 7) open again the faucet placed on the reducer-filter group (fig. 16).

Cross-tighten the knobs, without forcing too much so that the gaskets placed under the lid is pressed uniformly.

Every time you want to refill the plastic container placed inside the tank, it is necessary to use a filter (strainer or sifter) to avoid the formation of cement clots.



1) lift the lining and spray the cement on the upper.



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4) put the upper on the support and start the press.



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OPERATING PROCEDURE (THERMOADHESIVE TOE-PUFF)

- 1) take the pre-heated toe-puff from the toe-puffs dispenser mod. 5300.

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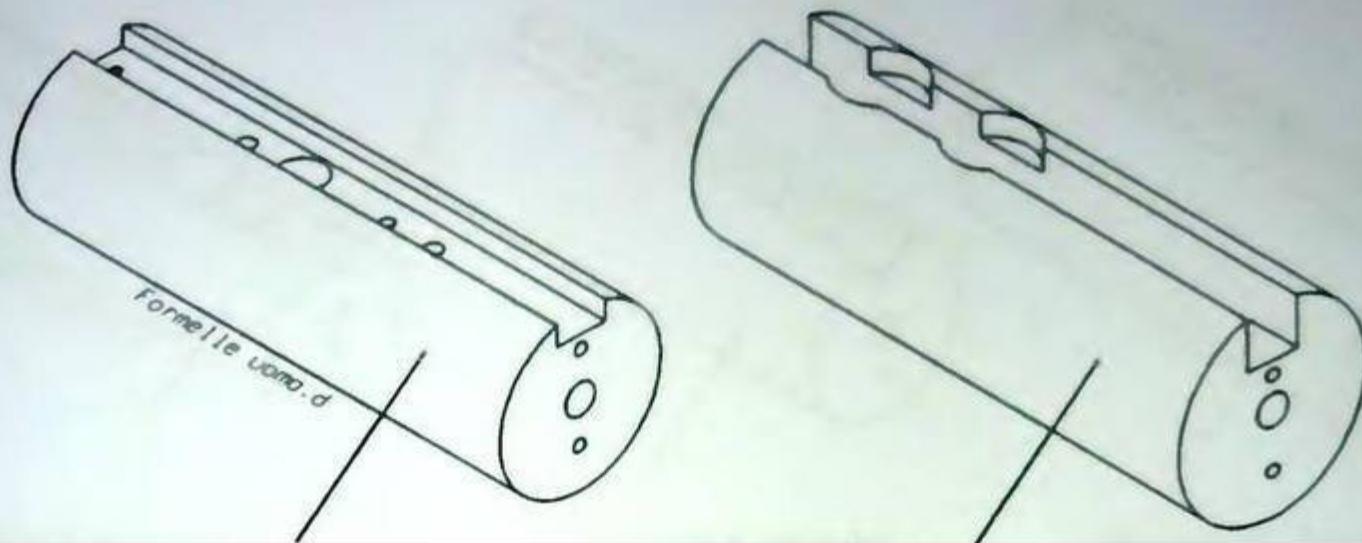


- 4) put the upper on the support and start the press.

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MOULDS FOR MEN'S UPPERS



Standard men's mould
ø85x260 - code 100086

(Teflon lining)
code 100086/U

Men's mould
ø80x260 - code 100087

(Teflon lining)
code 100087/U

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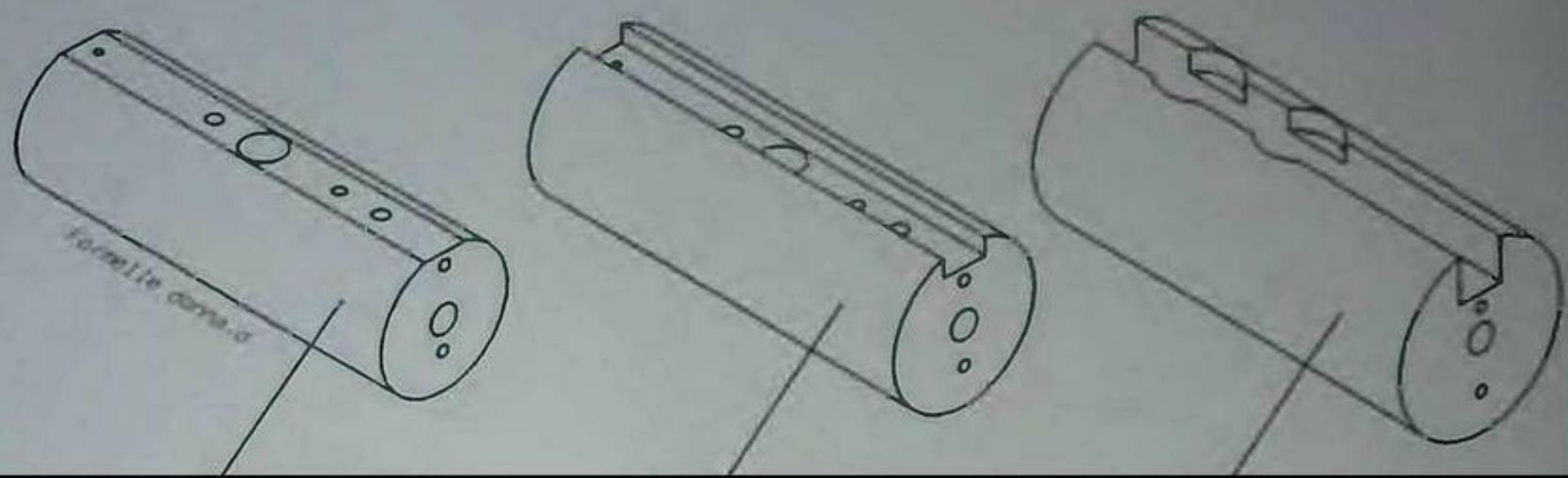
Silicone 250x315 code 100632/U

Microporous ... 250x305x20 ... code 100630/U

Men's sprung shells code 100009

Silicone/microporous spare parts code 100632/U and code 100630/U are always supplied NOT SPRUNG (that is, without cuts); it is up to the Customer to give them their proper profile, adapting them to the size of the shells.

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MOULDS FOR WOMEN'S UPPERS

Standard woman's mould
075x230 - code 100003
(Полная форма)
code 100003

Woman's mould
085x220 - code 100004
(Полная форма)
code 100004

Woman's mould
090x220 - code 100005
(Полная форма)
code 100005

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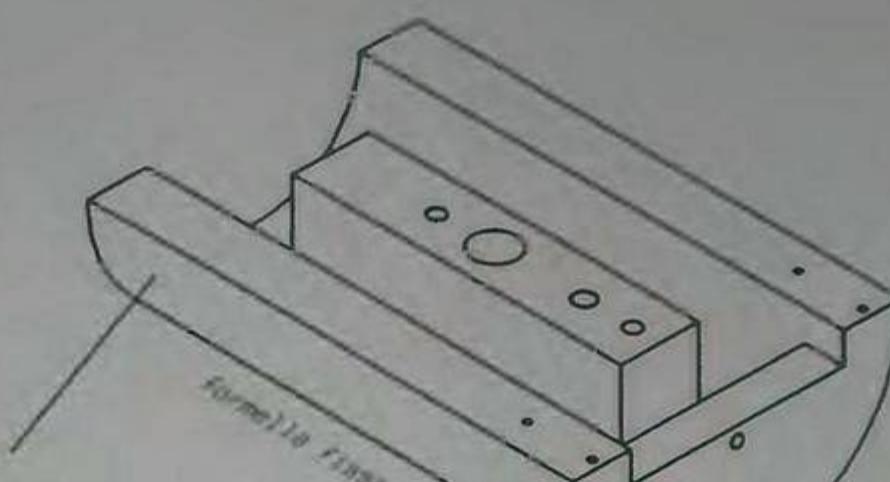
**Women's pillow group
code 100003
(sprung)**

Silicone 200x275 code 100632
Microporous .. 200x265x25.. code 100630
Women's sprung shells code 100005

**Women's pillow group
code 100002
(not sprung)**

Silicone 200x275 code 100632
Microporous .. 200x265x25.. code 100630
Women's unsprung shells... code 100005/S

Silicone/microporous spare parts code 100632 and code 100630 are always supplied **NOT SPRUNG** (that is, without cuts); it is up to the Customer to give them their proper profile, adapting them to the size of the shells.

MOULD FOR FIXED PILLOW

Mold for fixed pillow
350x260 - code 111310
(Teflon liner)
code 111300

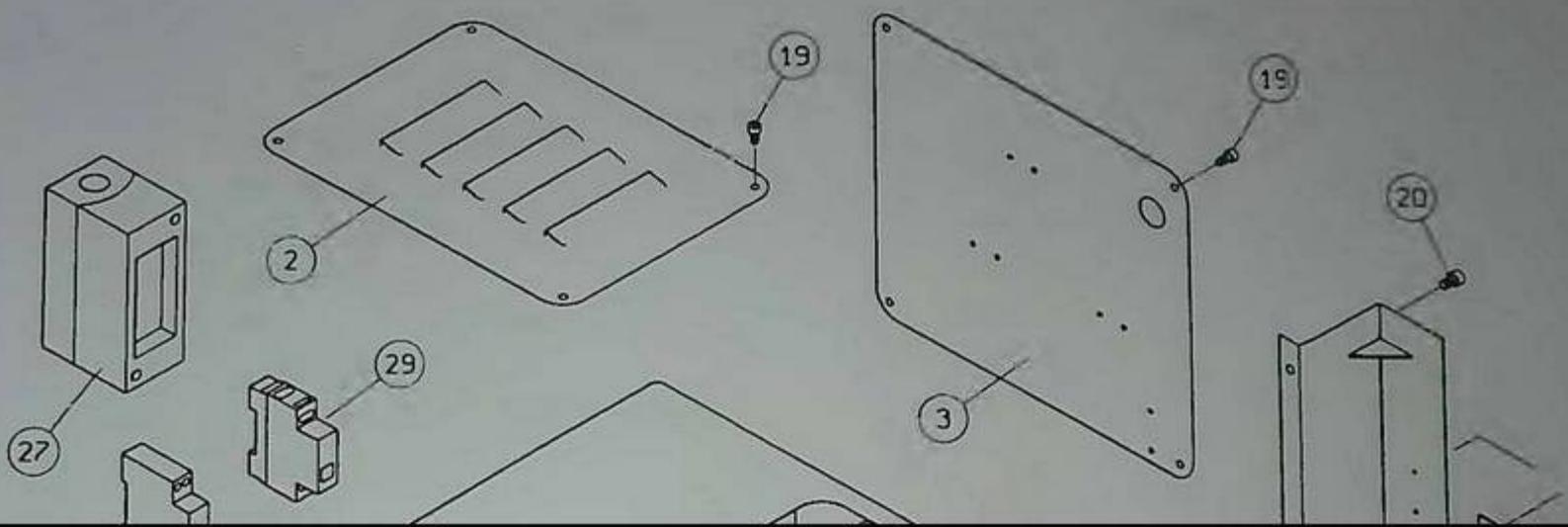
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Teflon 350x260 code 111310
Microporous 305x260x15 code 111300
Plated sprung shell..... code 111010

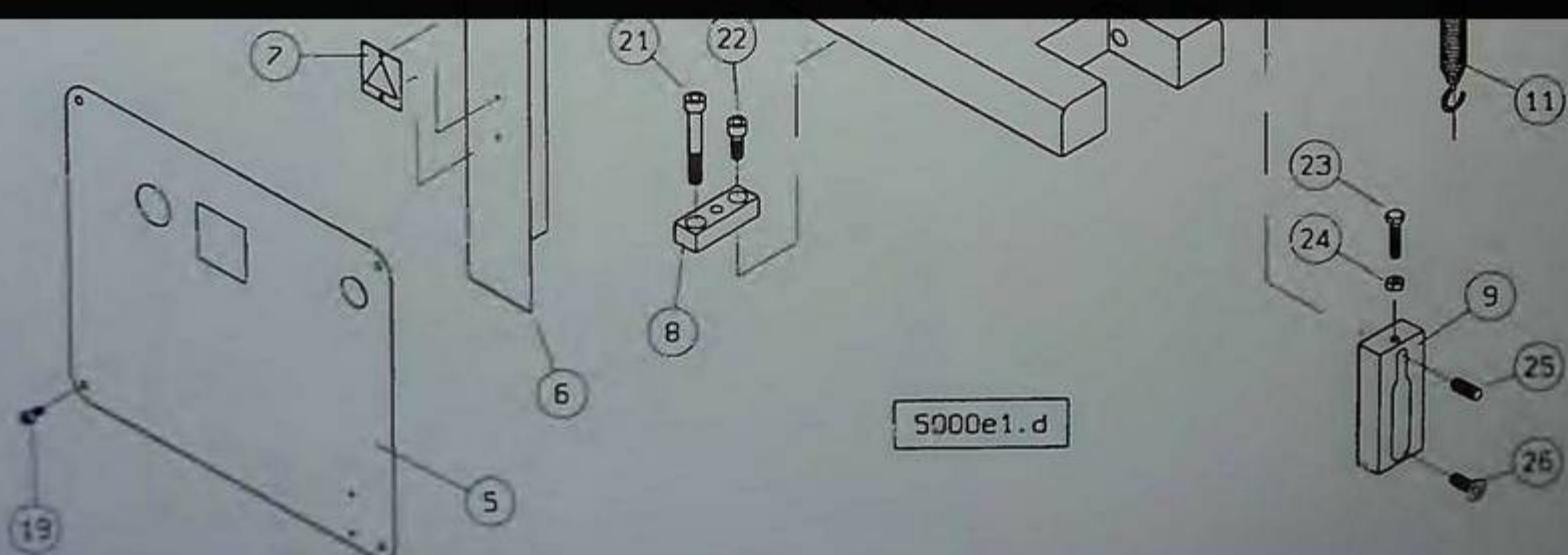
Teflon/microporous spare parts code 111310 and code 111300 are always supplied NOT SPRUNG (that is, without cuts); it is up to the Customer to give them their proper profile, adapting them to the size of the shells

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TAVOLA 1 - PARTI DI RICAMBI



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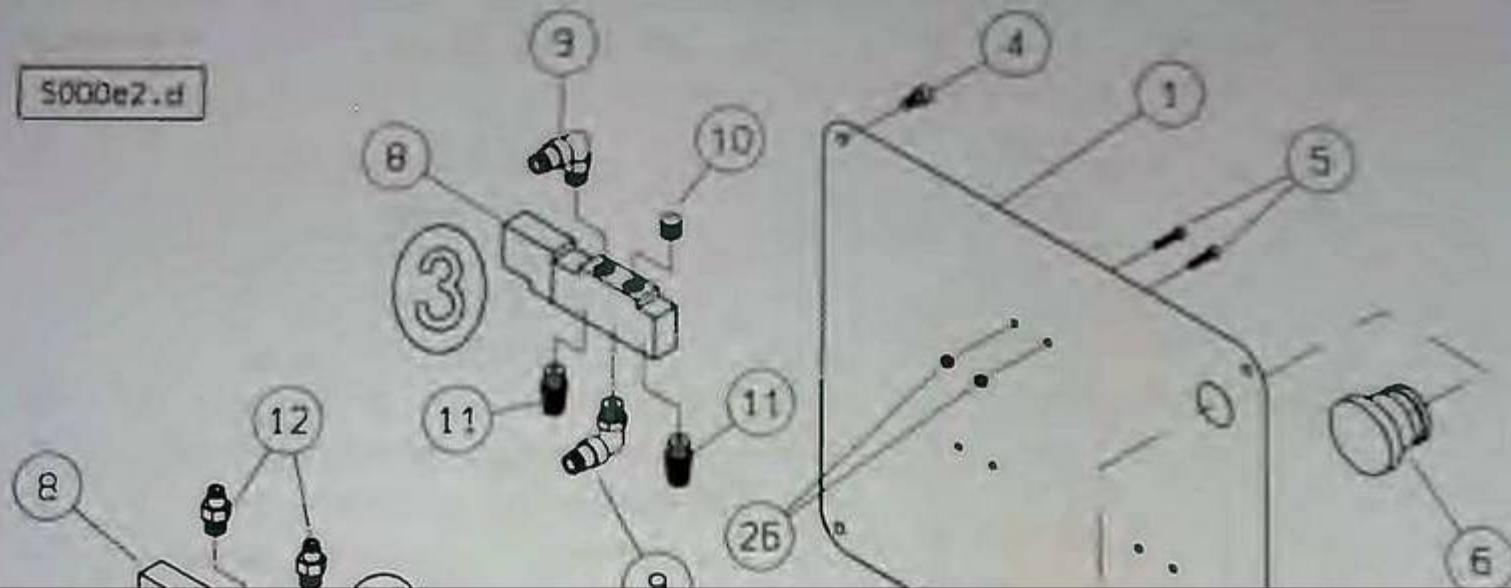
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TAVOLA 1 - PARTI DI RICAMBIO

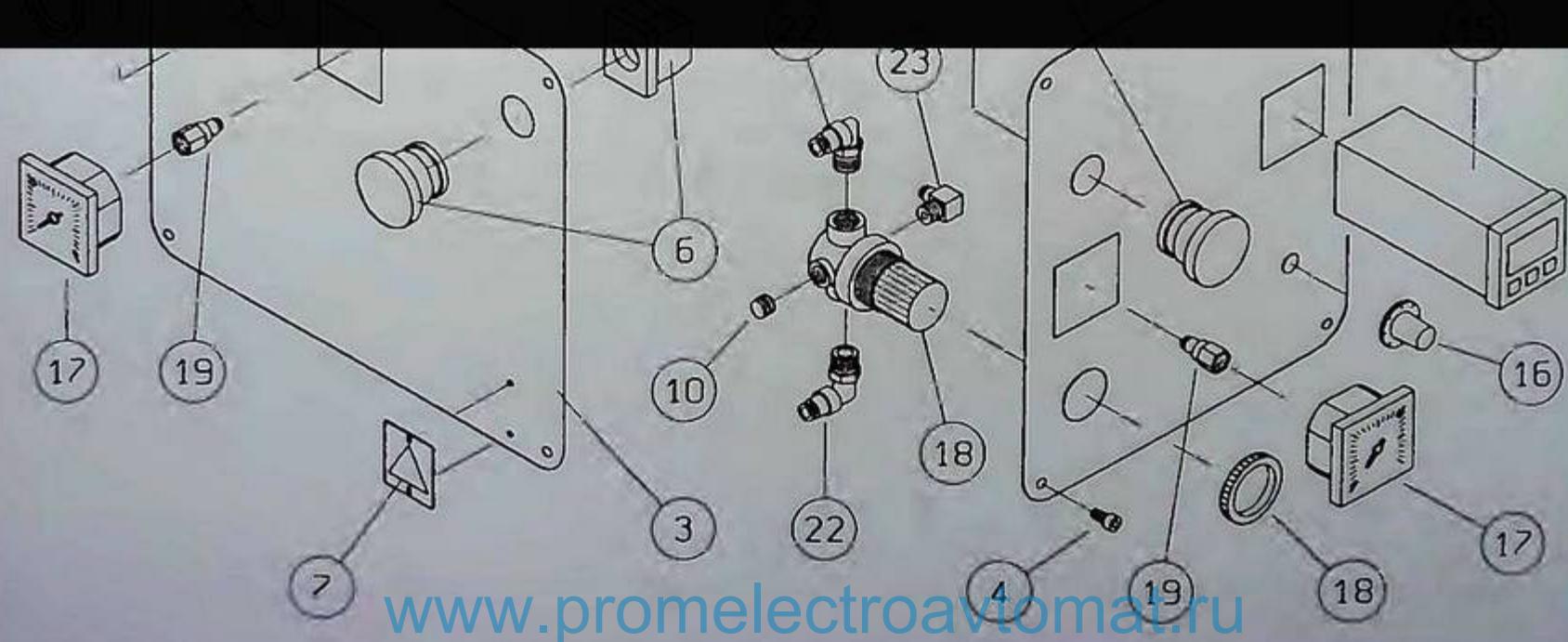
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3	Carter laterale destro	100204
4	Carter frontale	100202
5	Carter laterale sinistro	100206
6	Carter riparo laterale	100232
7	Targhetta schiacciamento mani	3430
8	Riportello	100205
9	Guida	100203
10	Tendine	100207
11	Molla	100206
12	Maniglia	100208
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229	Scatola porta interruttori	100425
230	Interruttore pressa	100426
231	Interruttore aspirazione	100427
232	Maniglia	100428
233	Scatola porta interruttori	100429
234	Interruttore pressa	100430
235	Interruttore aspirazione	100431
236	Maniglia	100432
237	Scatola porta interruttori	100433
238	Interruttore pressa	100434
239	Interruttore aspirazione	100435
240	Maniglia	100436
241	Scatola porta interruttori	100437
242	Interruttore pressa	100438
243	Interruttore aspirazione	100439
244	Maniglia	100440
245	Scatola porta interruttori	100441
246	Interruttore pressa	100442
247	Interruttore aspirazione	100443
248	Maniglia	100444
249	Scatola porta interruttori	100445
250	Interruttore pressa	100446
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252	Maniglia	100448
253	Scatola porta interruttori	100449
254	Interruttore pressa	100450
255	Interruttore aspirazione	100451
256	Maniglia	100452
257	Scatola porta interruttori	100453
258	Interruttore pressa	100454
259	Interruttore aspirazione	100455
260	Maniglia	100456
261	Scatola porta interruttori	100457
262	Interruttore pressa	100458
263	Interruttore aspirazione	100459
264	Maniglia	100460
265	Scatola porta interruttori	100461
266	Interruttore pressa	100462
267	Interruttore aspirazione	100463
268	Maniglia	100464
269	Scatola porta interruttori	100465
270	Interruttore pressa	100466
271	Interruttore aspirazione	100467
272	Maniglia	100468
273	Scatola porta interruttori	100469
274	Interruttore pressa	100470
275	Interruttore aspirazione	100471
276	Maniglia	100472
277	Scatola porta interruttori	100473
278	Interruttore pressa	100474
279	Interruttore aspirazione	100475
280	Maniglia	100476
281	Scatola porta interruttori	100477
282	Interruttore pressa	100478
283	Interruttore aspirazione	100479
284	Maniglia	100480
285	Scatola porta inter	

TAVOLA 2 - PARTI DI RICAMBI

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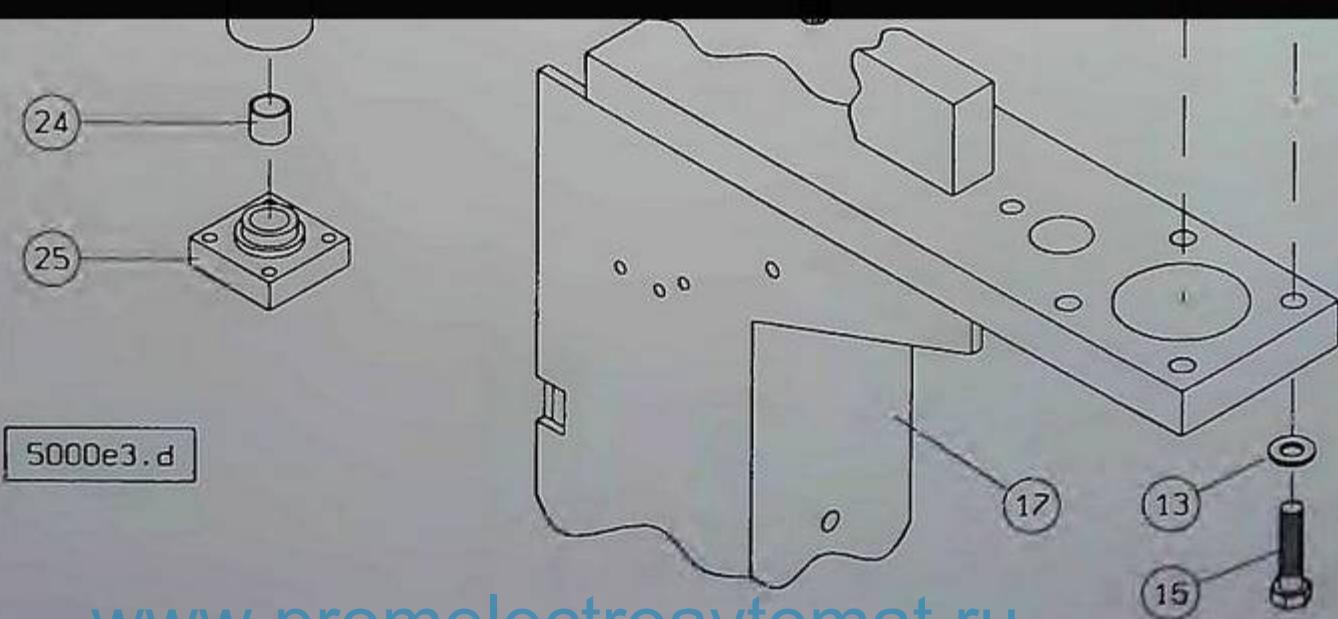
**Демо-файл.
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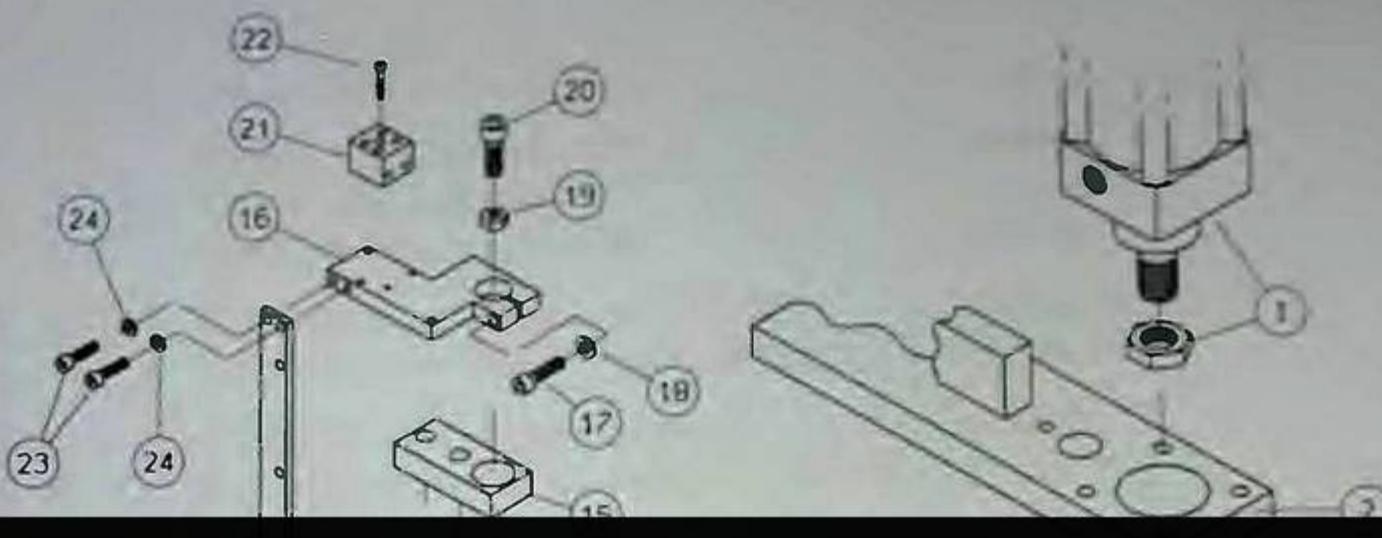
TAVOLA 3 - PARTI DI RICAMBIO

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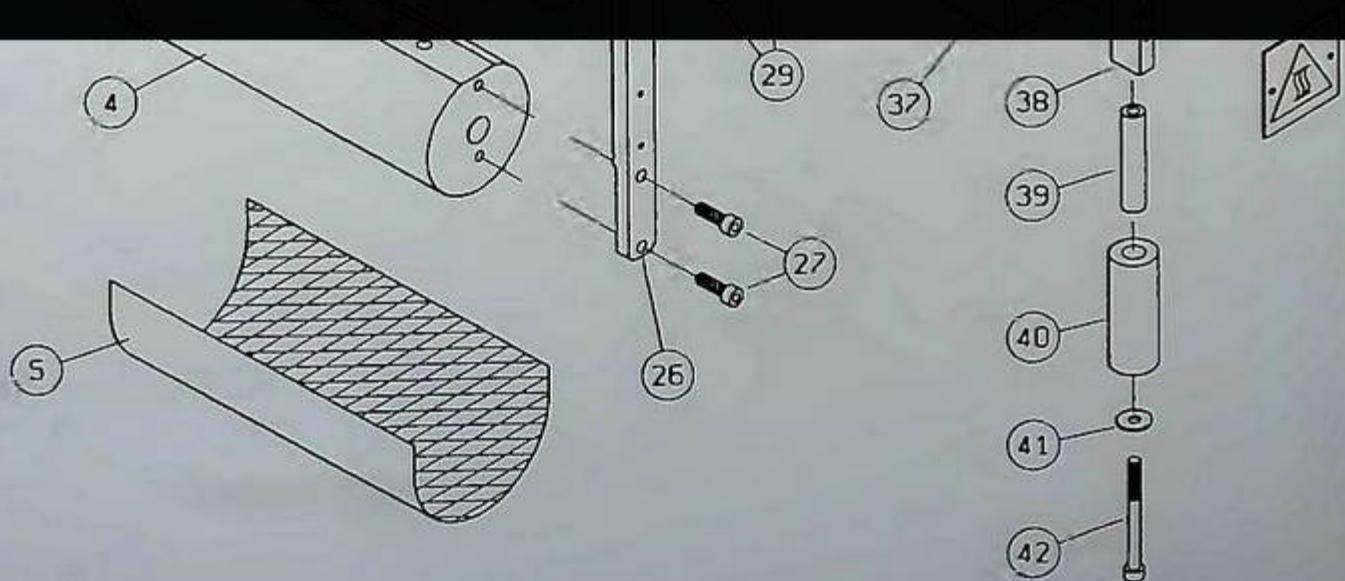


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TAVOLA 4 - PARTI DI RICAMBIO



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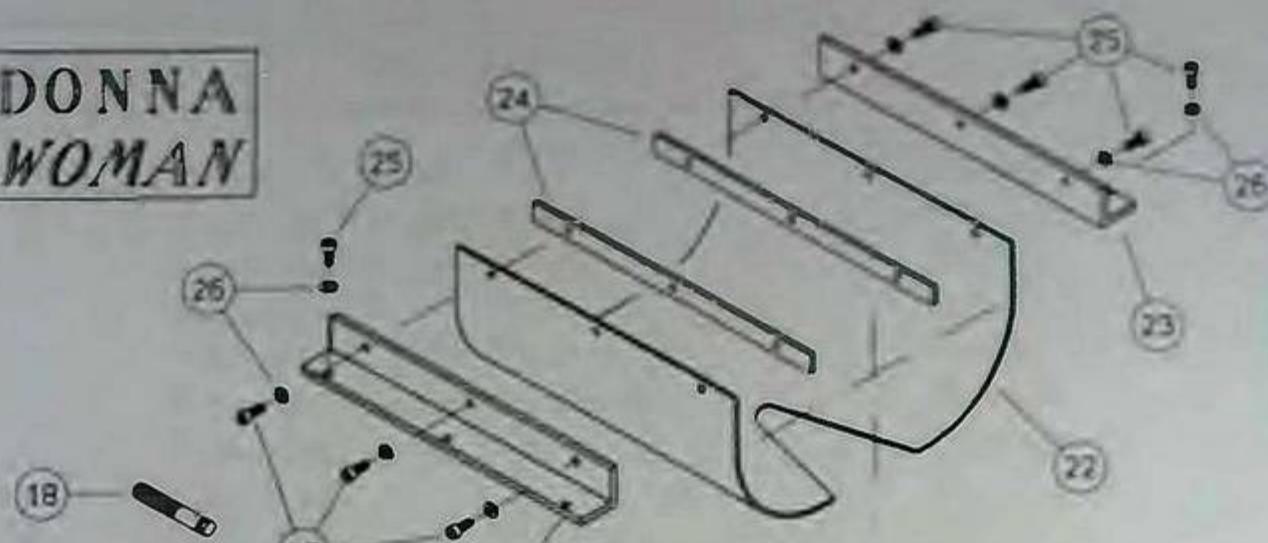


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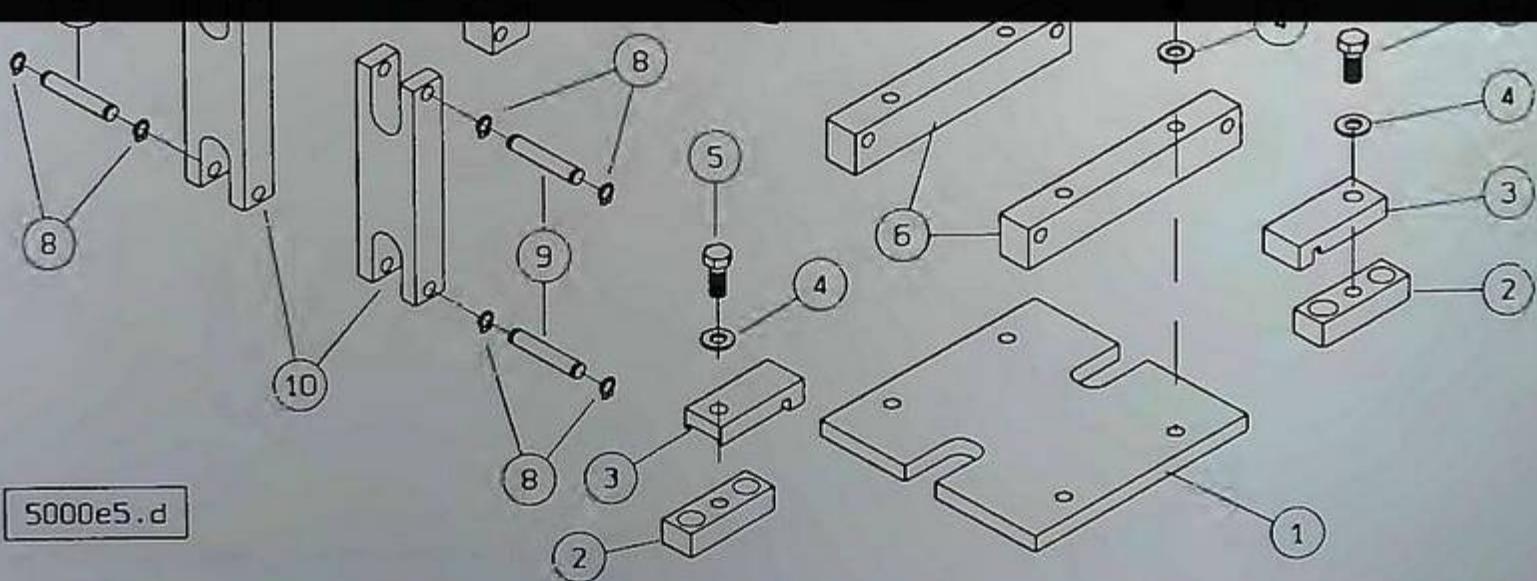
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TAVOLA 5 - PARTI DI RICAMBIO

DONNA
WOMAN



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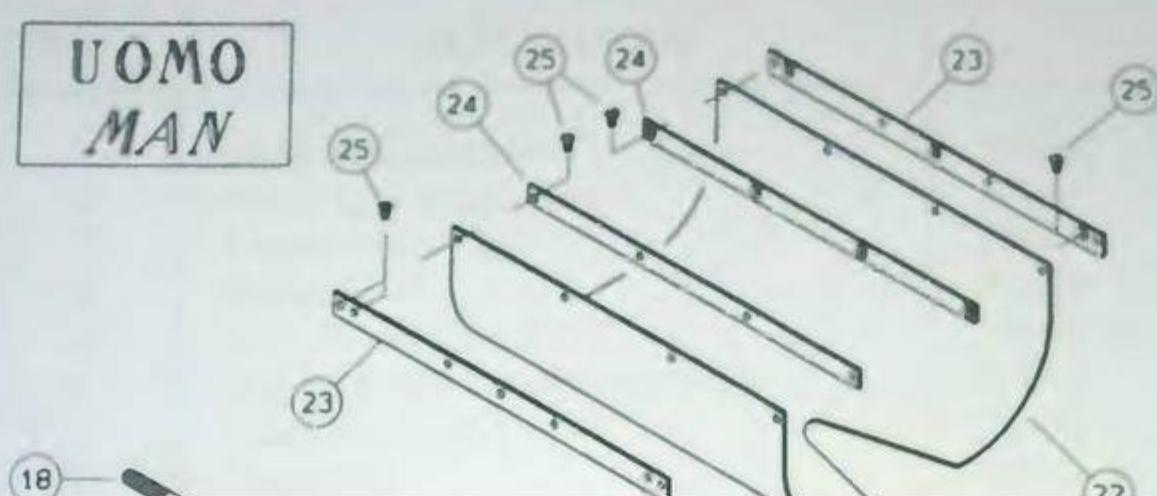


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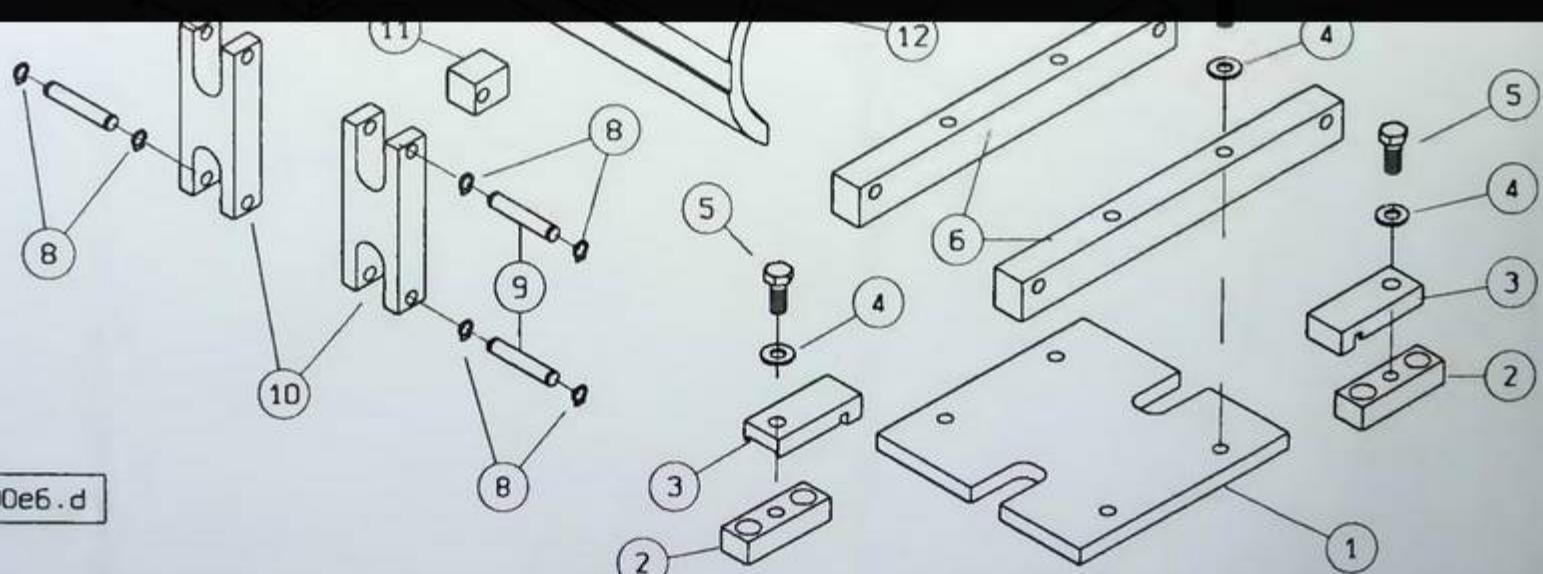
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TAVOLA 6 - PARTI DI RICAMBI

**UOMO
MAN**



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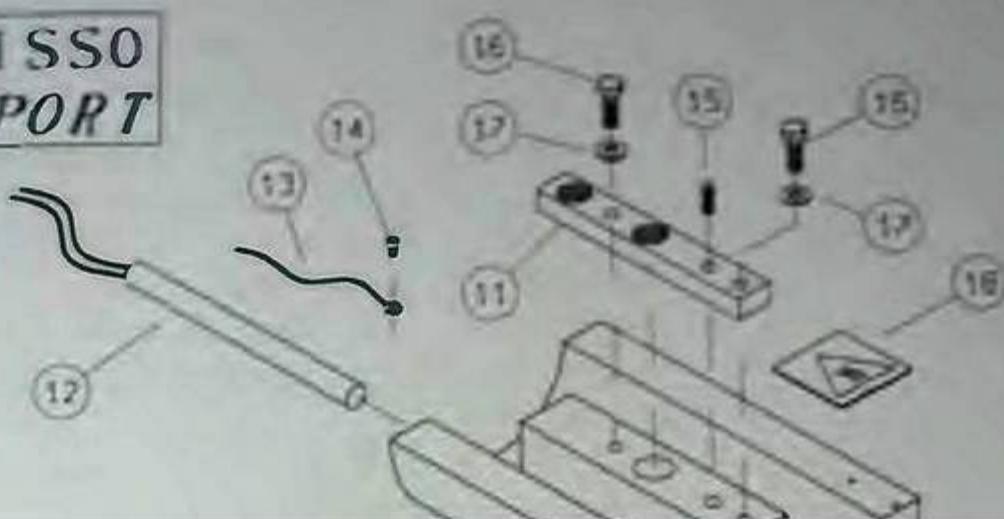


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TAVOLA 7 - PARTI DI RICAMBIO

**CUSCINO FISSO
FIXED SUPPORT**



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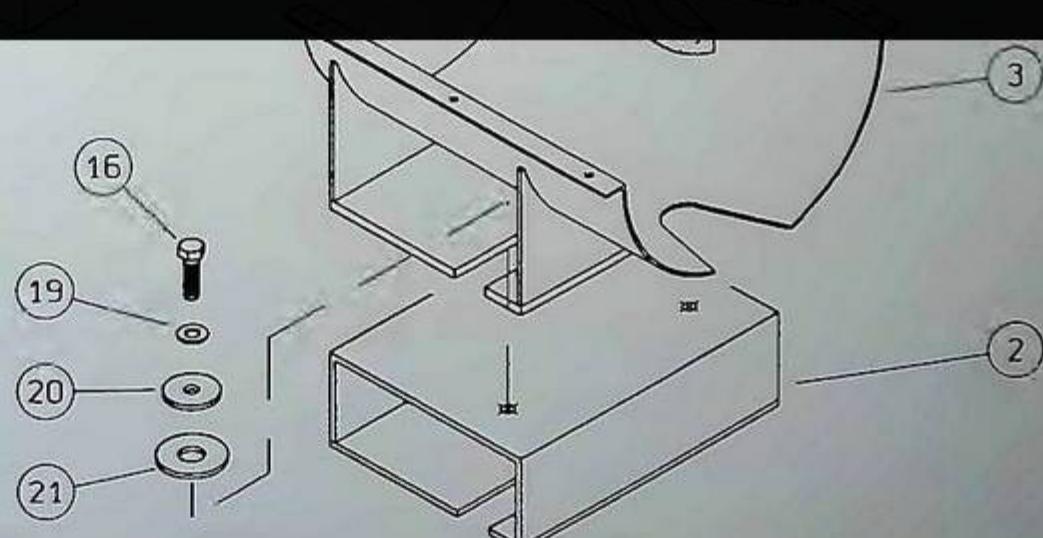
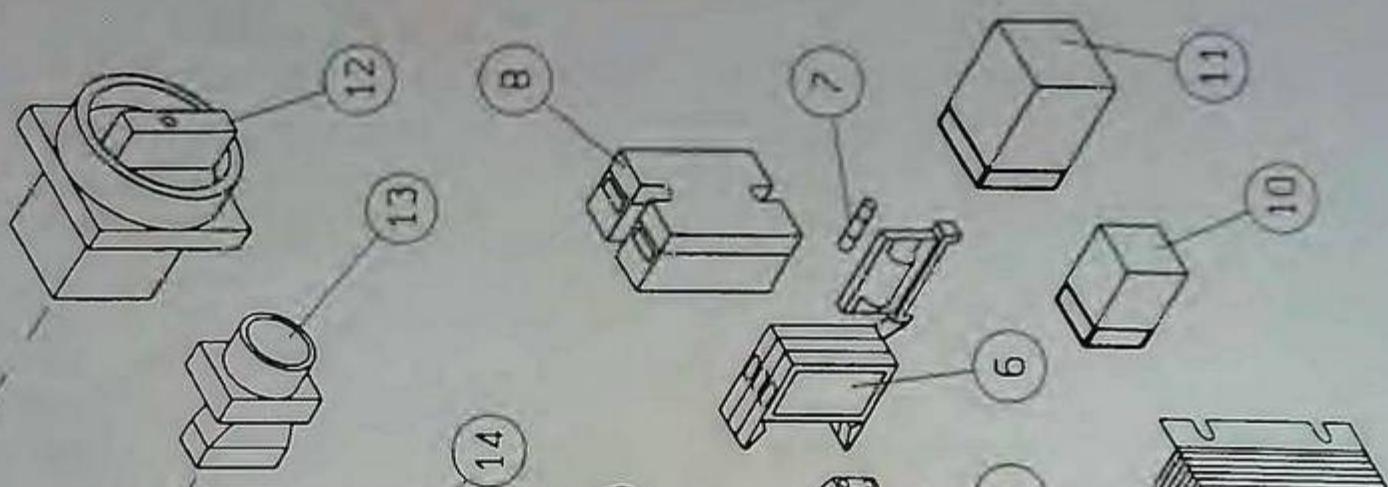
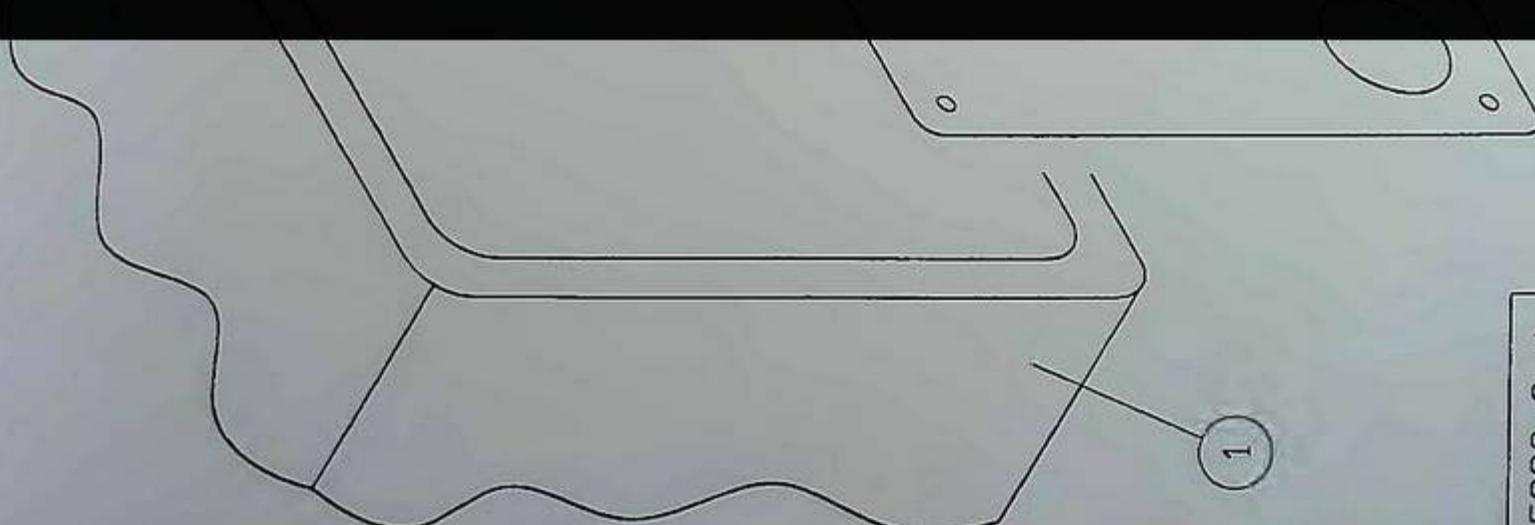


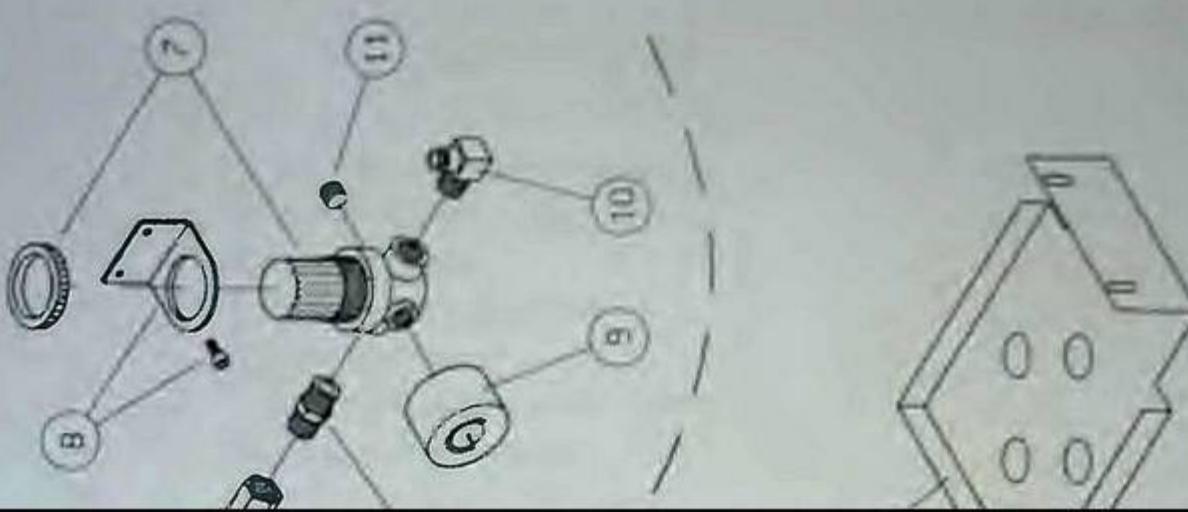
TAVOLA 8 - PARTI DI RICAMBIO

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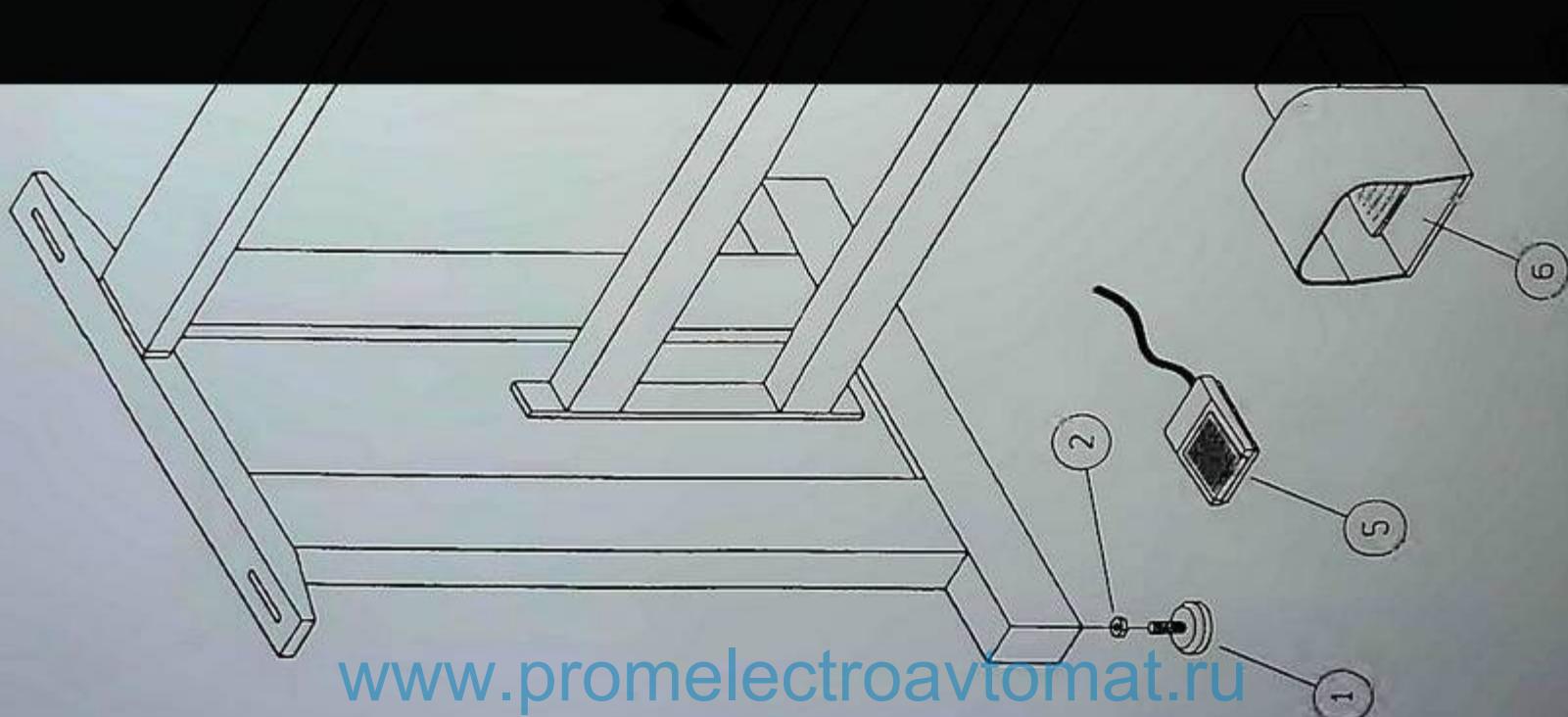
P. 8
5000e8

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TAVOLA 9 - PARTI DI RICAMBIO

5000+5100+5201+5300

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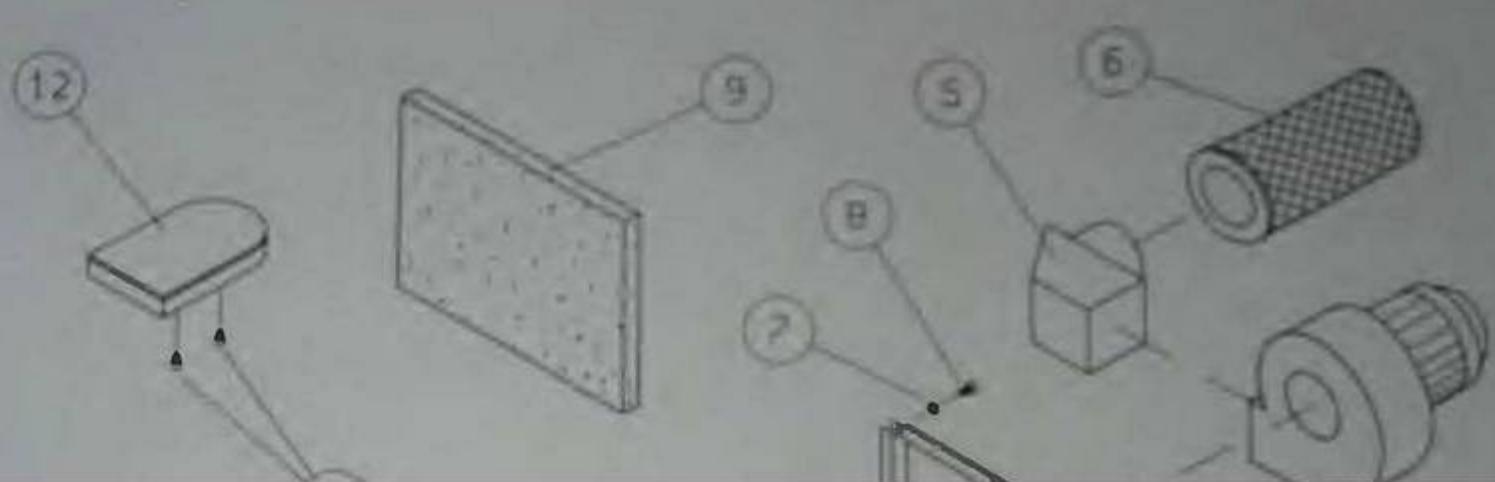
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TAVOLA 9 - PARTI DI RICAMBIO

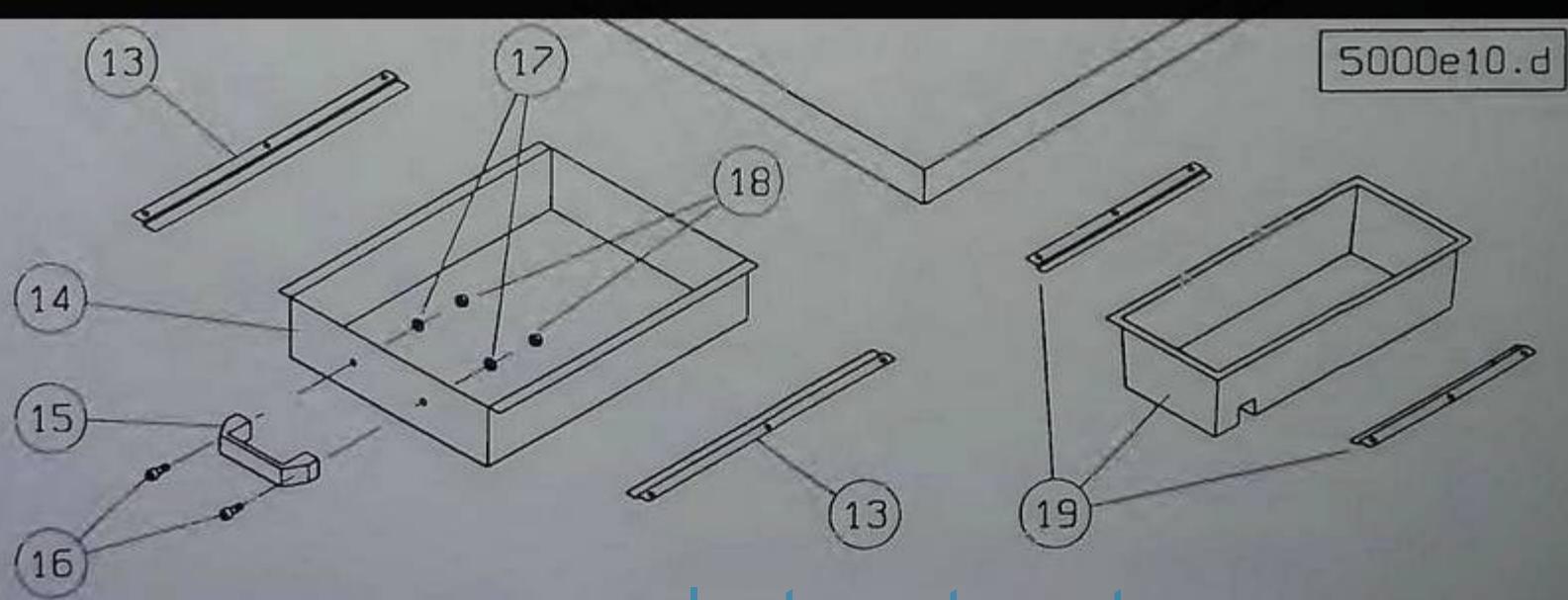
OS. N.	DESCRIZIONE	CODICE
1	Telaio completo per tavolo	101020
2	Dado M10 UNI 5589	MD 10MA
3	Rondella piana	ROND. 9X32X2,5
4	Vite M8x20 UNI 5730	TE 8X20

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TAVOLA 10 - PARTI DI RICAMBIO

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TAVOLA 10 - PARTI DI RICAMBIO

POS. N.	DESCRIZIONE	CODICE
1	Piano di lavoro in legno	101000
2	Carter aspirazione (cappa)	100555
3	Carter attacco aspiratore	100830
4	Aspiratore TT	106100
5	Attacco filtro aspiratore	106103
6	Filtro aspiratore	106112

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TAVOLA 1 - PARTI DI RICAMBIO

POS. N.	DESCRIZIONE	CODICE
1	Telaio pressa (testina)	100001
2	Carter superiore	100208
3	Carter laterale destro	100204
4	Carter frontale	100202
5	Carter laterale sinistro	100206
6	Carter riparo laterale	100232
7	Targhetta schiacciamento mani	3430
8	Piastra fissaaggio testa	100612

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TAVOLA 2 - PARTI DI RICAMBIO

POS. N.	DESCRIZIONE	CODICE
1	Carter laterale destro	100204
2	Carter frontale	100202
3	Carter laterale sinistro	100206
4	Vite M5x10 UNI 4168	VTB 5X10
5	Vite M3x25 UNI 5931	TCE 3X25
6	Pulsante START + contatto NO	ZA2BC3 + ZA2-BZ101

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Винт с головкой резьбовой 1/4" x 4
Винт с головкой резьбовой 1/4" x 4
Дюбель М3 (UNI 5547)

R104040
R104040
D ES 07MA

Болт с головкой 1
Болт с головкой 2
Болт с головкой 3

Дюбель с головкой
Торцевая головка
Промежуточная

TAVOLA 3 - PARTI DI RICAMBI

POS. N.	DESCRIZIONE	CODICE
1	Cilindro speciale ø63x100	100063
2	Nipplo di riduzione conico 1/8"-3/8"	R2020-18-38
3	Silenziatore 1/8" in bronzo	SIL 1/8
4	Valvola scarico rapido 1/8"	VSR 1/8

Демо-файл.

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Spira guida

23

Tubo cilindro

24

Battuta KU 1212 (PAR 1212 P10)

25

Flangia attacco

26

Vite M5x90 UNI 5931

22

100290

KU 1212

100270

TCE 5X90

TAVOLA 4 - PARTI DI RICAMBIO

POS. N.	DESCRIZIONE	CODICE
1	Cilindro speciale ø63x100	100063
2	Telaio pressa (testina)	100001
3	Piastra sostegno formella	100560
{ 4	Formella standard da uomo ø85x260	100086
5	Rivestimento teflon (formella ø85x260)	100086 T
{ 4	Formella da uomo ø100x260	100087

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Онда
Микротыре шайба
Vite M6x25 UNE 5931
Бандажа ø6
Дюбель М6 UNE 5589
Винт М6х25 UNE 5931
Микротыре шайба
Vite M6x25 UNE 5931
Vite M6x25 UNE 5931
Бандажа ø5

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100310
TCE 6X25
ROND. 06
M6 06MA
TCE 8X25
10157
TCE 5X25
TCE 5X25
ROND. 06
ROND. 06

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TAVOLA 4 - PARTI DI RICAMBIO

POS. N.	DESCRIZIONE	CODICE
26	Staffa	100350
27	Vite M6x20 UNI 4168	VTB 6X20
28	Vite M8x20 UNI 5739	TE 8X20
	Vite M6x30 UNI 5739	TE 6X30

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TAVOLA 5 - PARTI DI RICAMBIO

POS. N.	DESCRIZIONE	CODICE
1	Piastra supporto leve	100661
2	Piastrina fissaggio testa	100612
3	Fermo piastra leve	100671
4	Rullo tappetino	RONDO 04

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Зеркало для линзы из стекла
Рамка для линзы из стекла
Винт M4x10 UNE 2931
Комплект из 4

100614
100625
TCE 4X10
RONDO 04

TAVOLA 6 - PARTI DI RICAMBIO

POS. N.	DESCRIZIONE	CODICE
1	Piastra supporto leve	100661
2	Piastrina fissaggio testa	100612
3	Spina di testa	100671
4	Лампа накаливания рулевого колеса	100612/U
5	Лампа накаливания рулевого колеса	100612
6	Пластина фиксации микротормоза	1006123
7	Резинка для крепления изоляции Von Mises LNU 5933	VSP 4008
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TAVOLA 7 - PARTI DI RICAMBIO

POS. N.	DESCRIZIONE	CODICE
1	Telaio pressa (testina)	100001
2	Distanziale per guscio freno	111181

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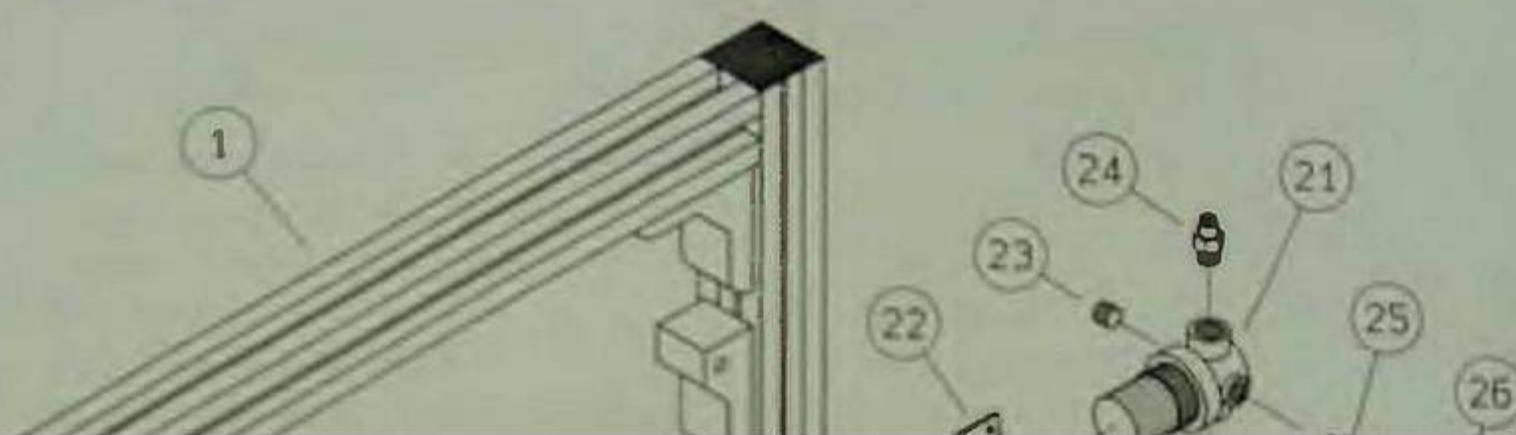
TAVOLA 8 - PARTI DI RICAMBIO

POS. N.

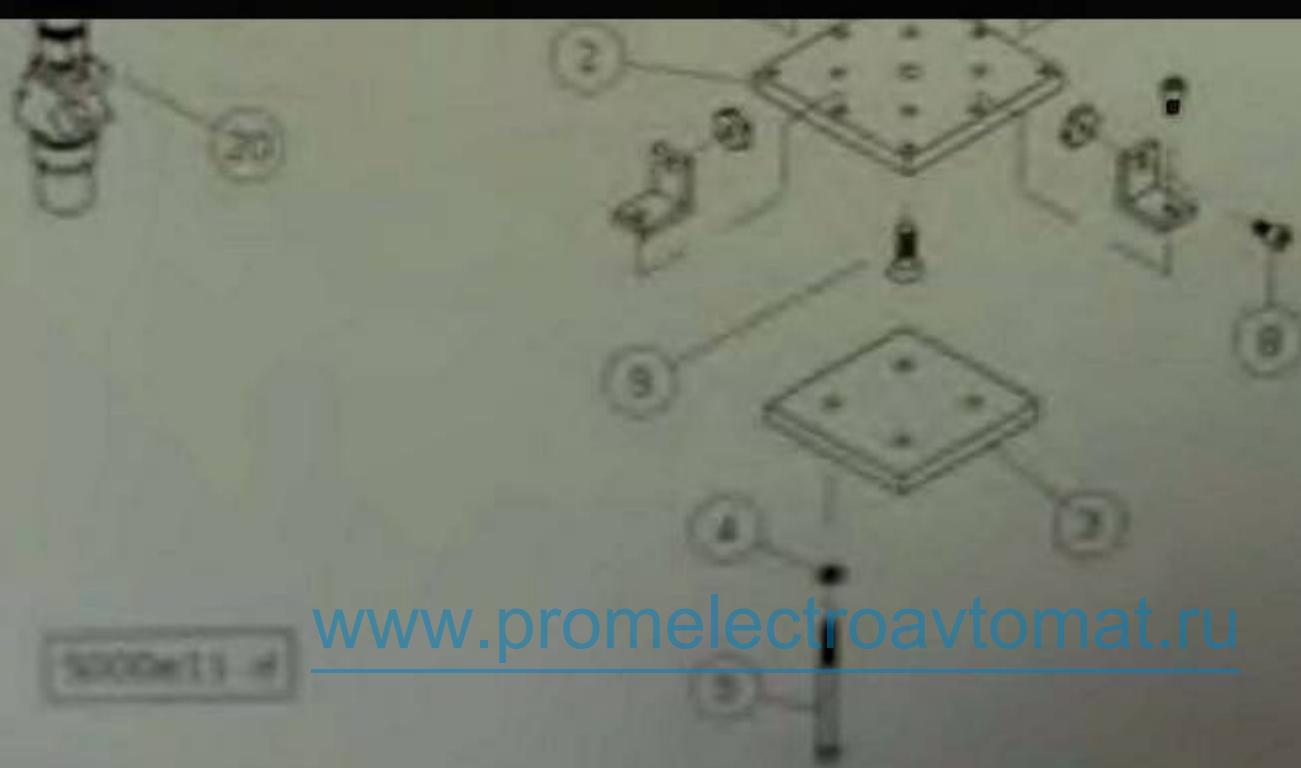
DESCRIZIONE

CODICE

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TAVOLA 11 - PARTI DI RICAMBIO

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TAVOLA 11 - PARTI DI RICAMBIO

POS. N.	DESCRIZIONE	CODICE
1	Supporto completo in alluminio 450x590	105200
2	Piastra base asta bilanciatore	100453
3	Piastra di rinforzo in ferro	100451
4	Rondella ø6	ROND. 06
5	Vite M6x60 UNI 5931	TCE 6x60
6	Squadra supporto asta bilanciatore	100454

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26	Accoppiatore a U, diametro 10 mm, lunghezza 1/8"
27	Manometro 1/8" ø 2.5 mm
28	Accoppiatore a T, diametro laterale = 1/4"
29	Accoppiatore fissaggio 1/4" 1/8"

R5020-1/8
J157
R4050-1/4
K104060

TAVOLA 12 - PARTI DI RICAMBIO

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TAVOLA 12 - PARTI DI RICAMBIO

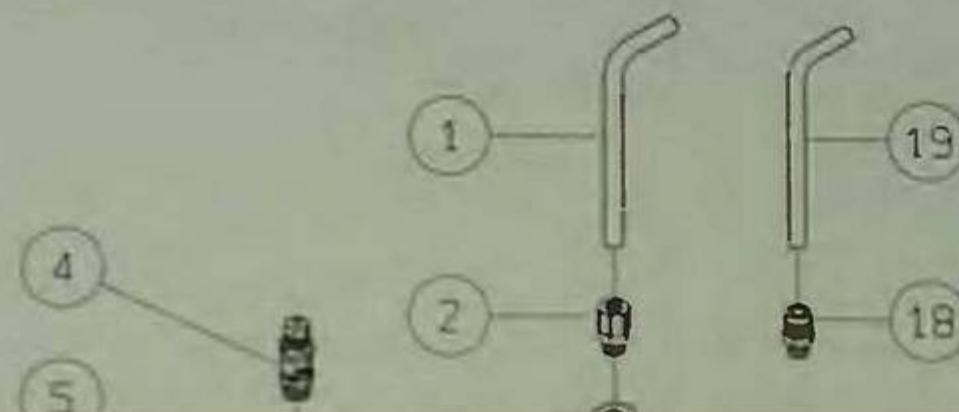
POS. N.	DESCRIZIONE	CODICE
1	Occhiello M6 aggancio pistola	102086
2	Dado M6 UNI 5587	D.E.S. 06MA
3	Molla ritorno spillo	102120
4	Pistone	103352
5	Grano M4x8 UNI 5923	VCE 4x8
6	Guarnizione pistone	PK 16

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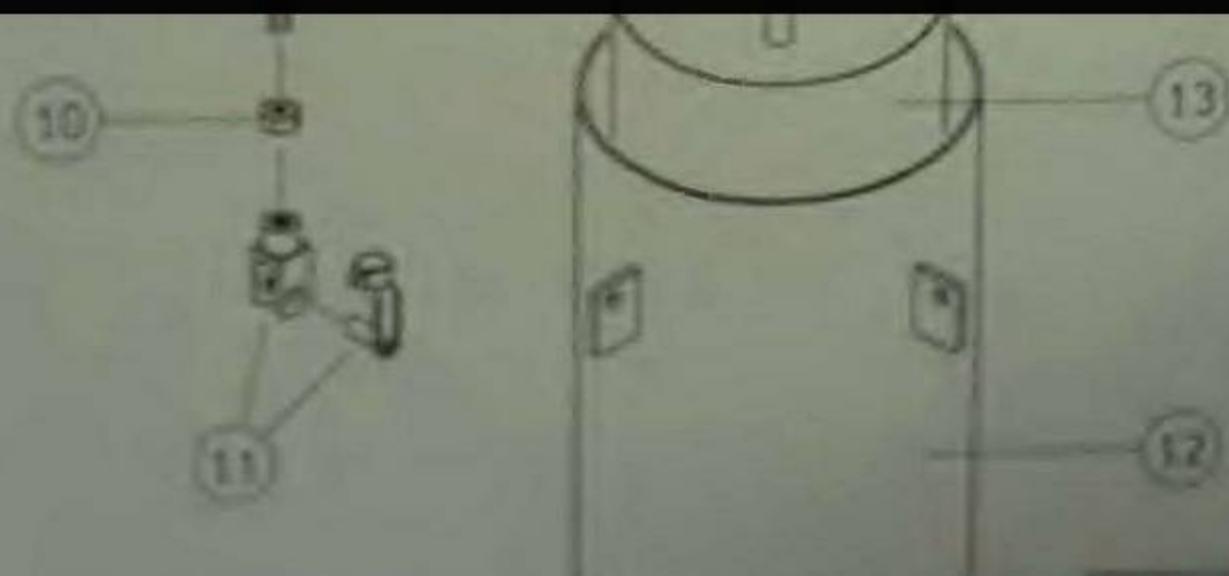
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Одноточечное
Обивка пружин
Удлинительная

DR 2100
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103151

TAVOLA 13 - PARTI DI RICAMBI

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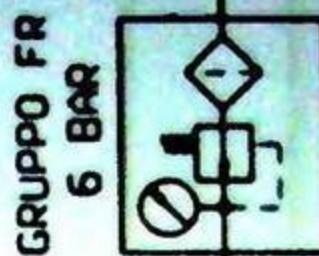
TAVOLA 13 - PARTI DI RICAMBIO

POS. N.	DESCRIZIONE	CODICE
1	Tubo per collante a base acqua ø9x6	PVC 06-9
2	Raccordo diritto 1/8" tubo 9-6 calz.	RCK-1/8-PK6-KU
3	Manicotto inox AISI 303	105410
4	Valvola di sicurezza 1/4"	105020

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18
19Raccordo diritto 1/8" tubo 8-6 calz.
Tubo per collante a base acquaR 1000-08-1/8
RIL. 06-8

TENDITORE
TOMATA



5300
(OPTIONAL)

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ПРОСТОРИЯ

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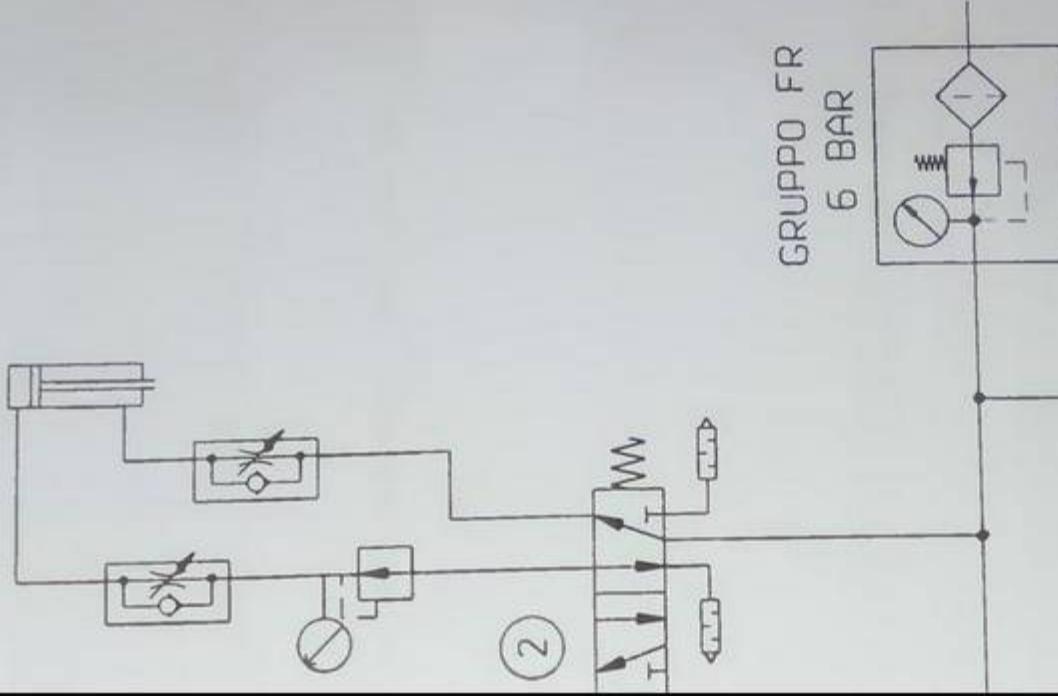
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DISCONE

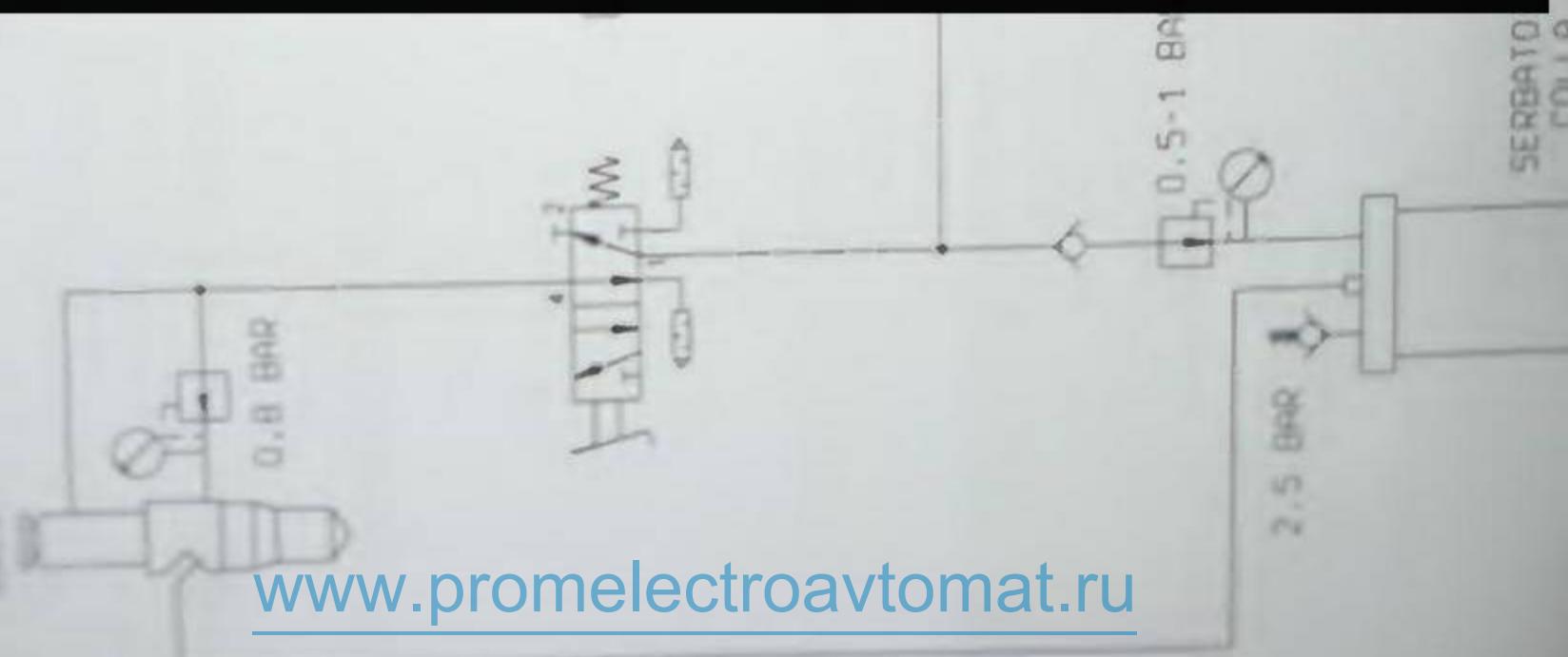
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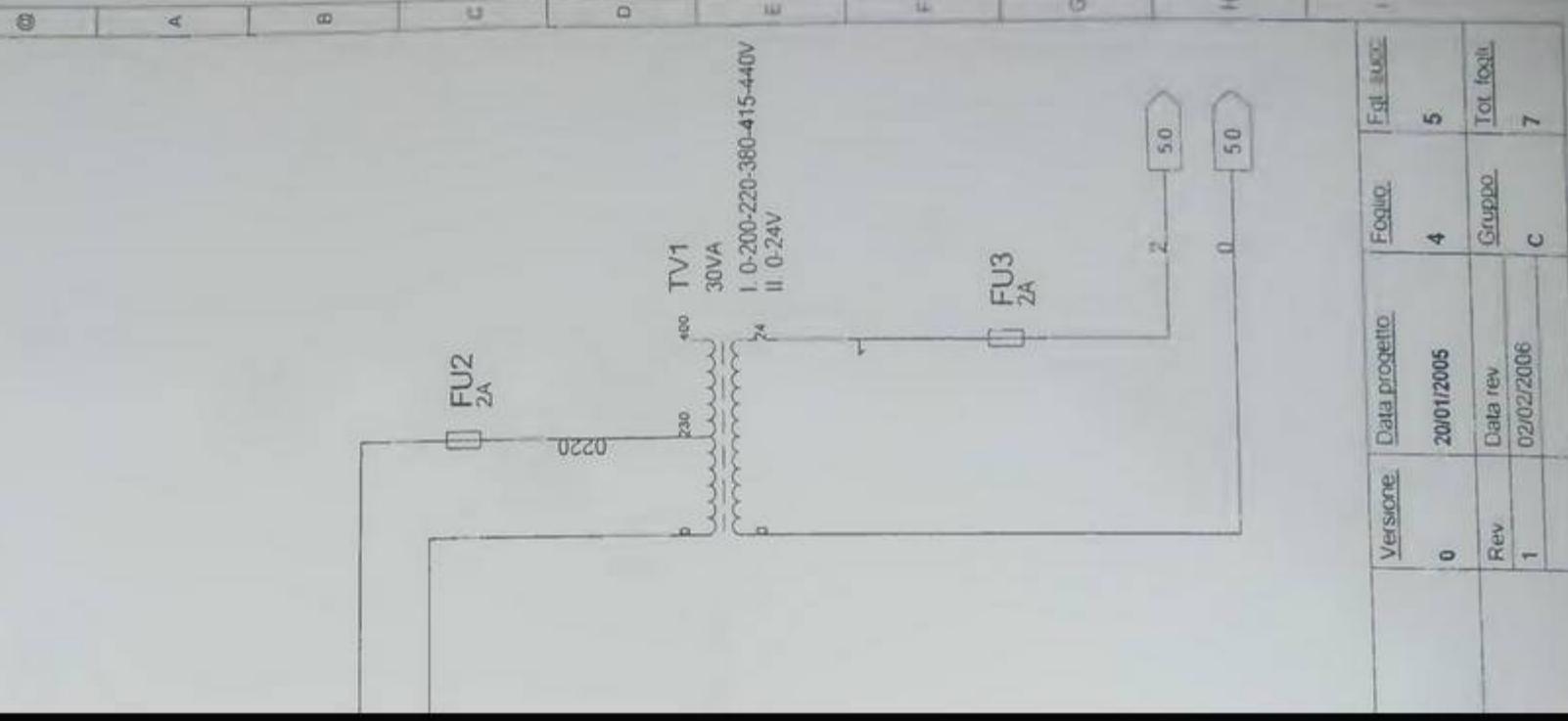
TENDITORE
TOMAIA



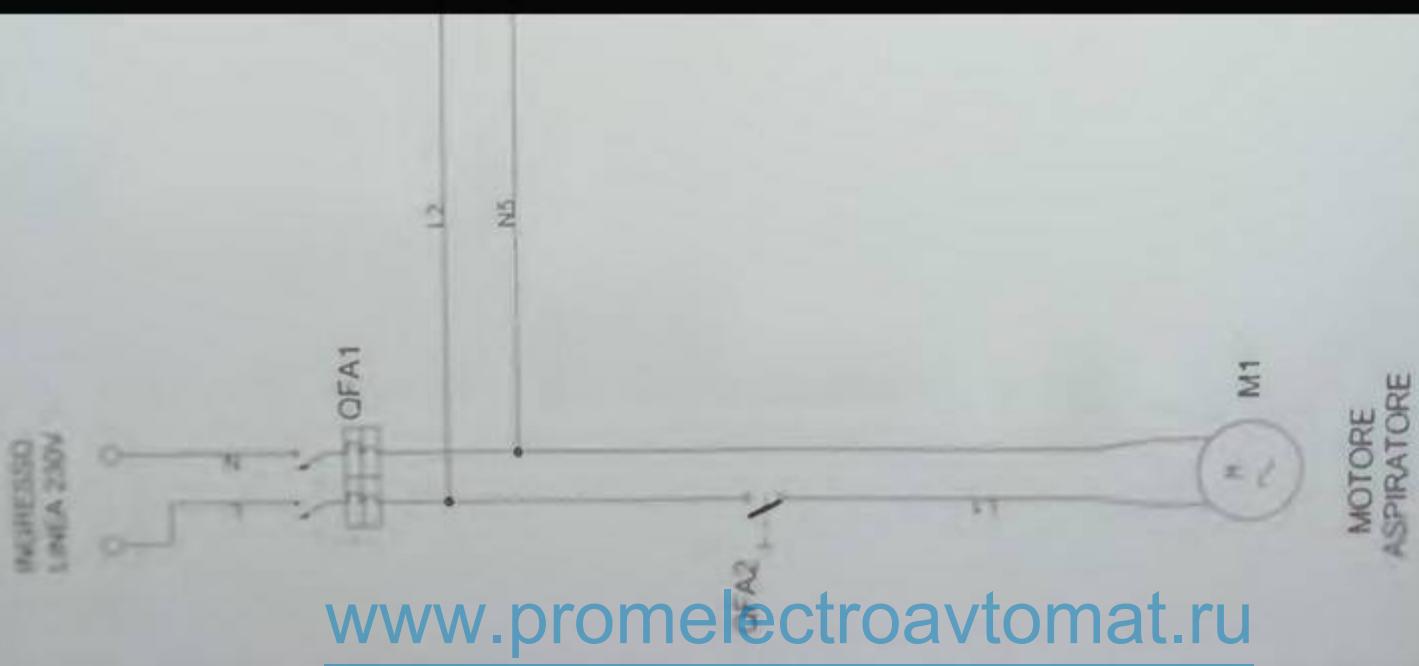
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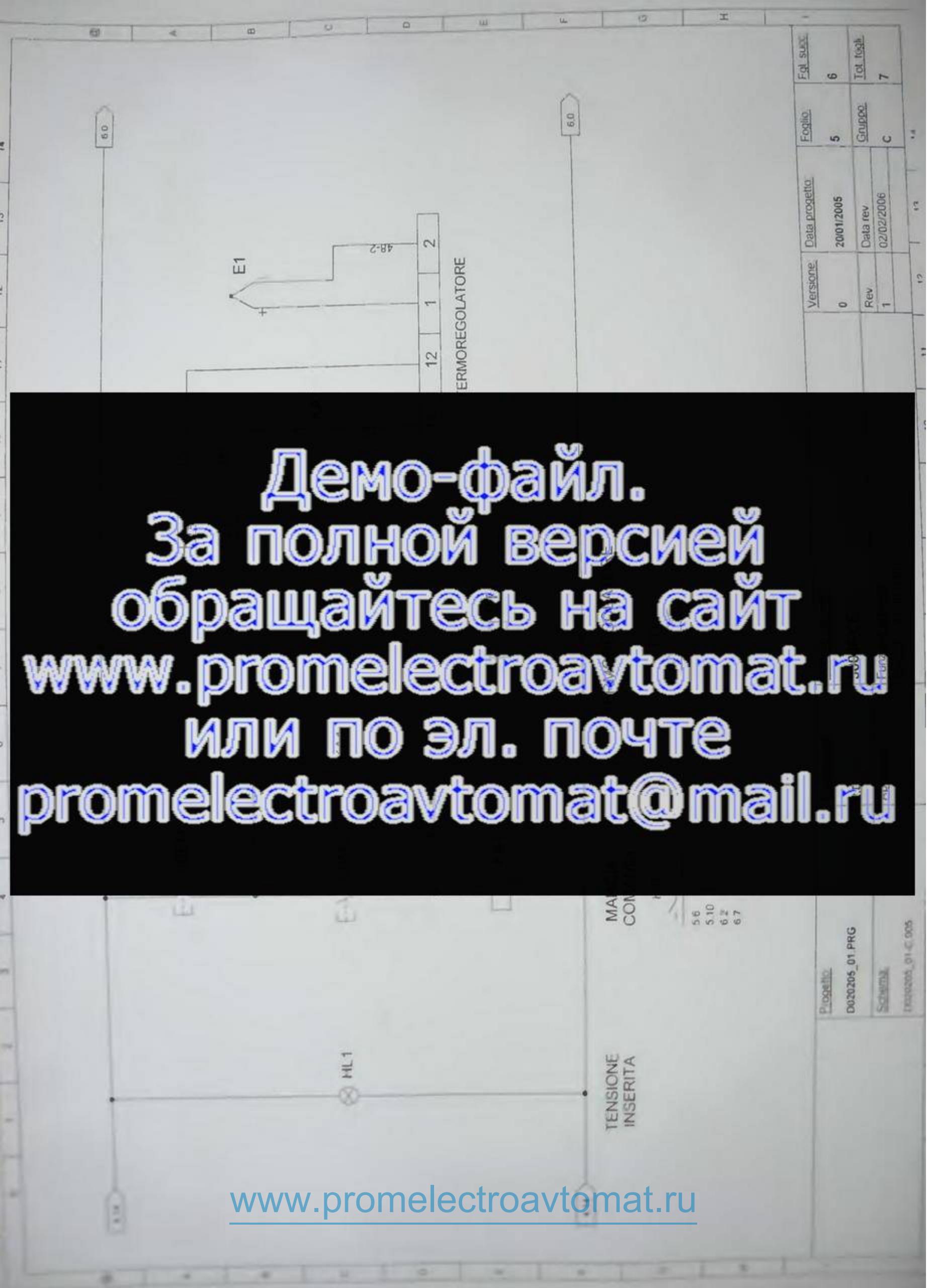
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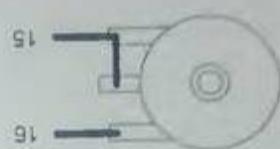
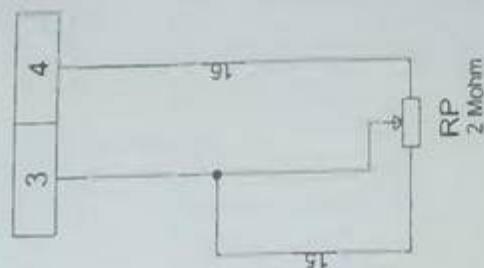
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Progetto	Foglio	Foglio
D020205_01.PRG	4	5
Schemata	Gruppo	Tot fogli

D020205_01.C.004



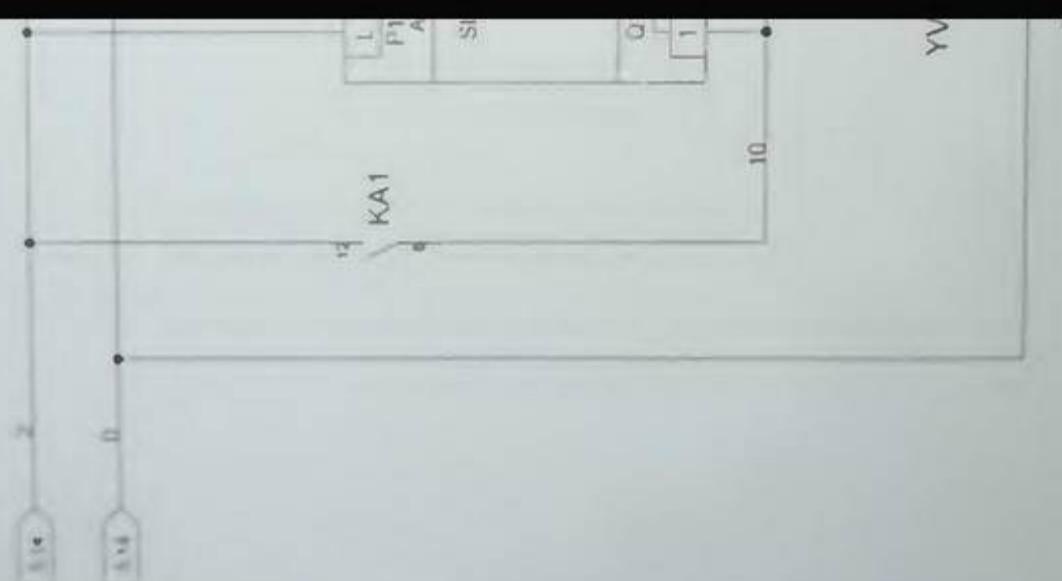
COLLEGAMENTO
POTENZIOMETRO TIMER



POTENZIOMETRO
VISTA POSTERIORE

Versione	Data progetto:	Foglio	Foglio successivo
0	20/01/2005	6	7
1	03/02/2006	C	7

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Progetto	D020205_01.PRC
Schema	D020205_01.C00

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FT1

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	Versione:	Data progetto:	F.0000:	F.0000:
0	2001/2005	7	Cognito	Tel. 7
Rev	Data rev:	02/02/2006		
1			C	7

Progetto:	D020205_01.PRG
Schemma:	D020205_01-C00

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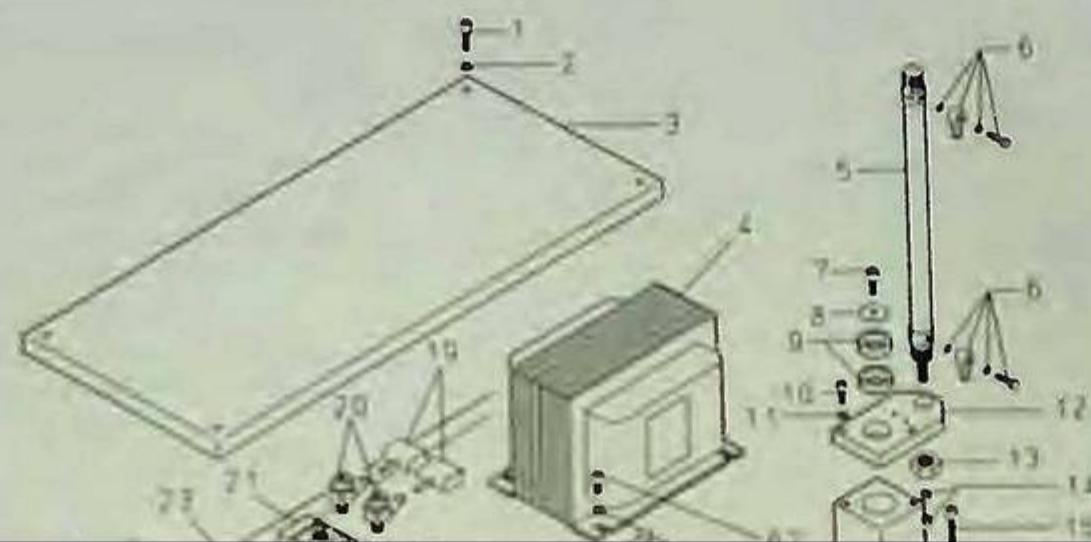
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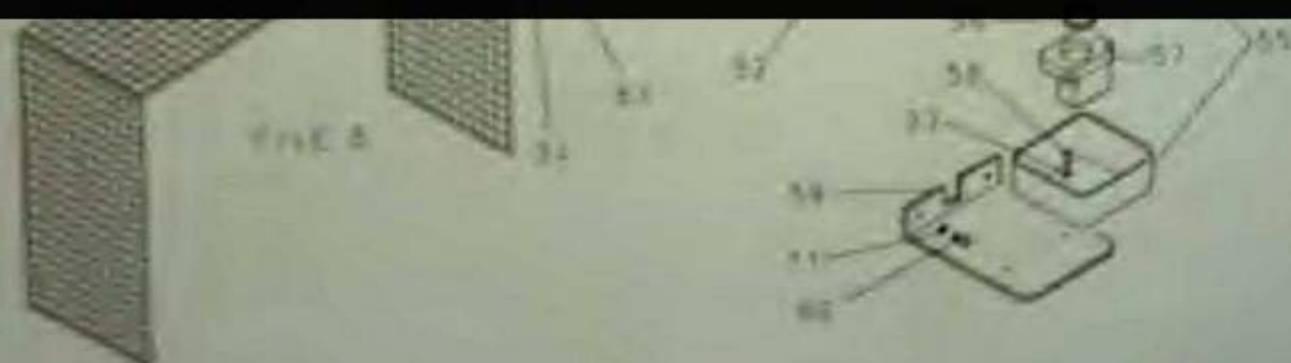
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POS.N.	DESCRIZIONE	CODICE	DESCRIPTION
1	Vite M6x20 UNI 5931		Screw M6x20 UNI 5931
2	Rondella M6		Washer M6
3	Carter Superiore	110090	Upper carter
4	Trasformatore 600 Watt		600 Watt transformer
5	Calindro ISO 16x60		ISO cylinder 16x60
6	Raccordo a gomito M5 tubo 4	AA385040	Elbow connection M5 tube 4
7	Vite M6x15 UNI 5931		Screw M6x15 UNI 5931
8	Rondella d.6x24		Washer d.6x24
9	Guarnizione CSC 2820		Packing CSC 2820
10	Vite M5x15 UNI 5931		Screw M5x15 UNI 5931
11	Rondella d.5		Washer d.5
12	Piastrina supporto cilindro	110040	Cylinder support plate
13	Dado M16x1.5		Nut M16x1.5
14	Dado M6		Nut M6

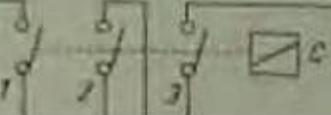
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40	Винт M4x20 (UNI 5931)	10157	Сcrew M4x20 UNI 5931
41	Накидка на гайку	GVEB9012504	Patent clamp
42	Термопары 0-12 мс	TDNEUV-3-24-199	0-12 мс. timer
43	Термоконтроллер		Thermocontroller
44	Симистор для индикатора		Simistor for
45	Индикатор вспомогательных		Magnetothermic switch AA
46	Решетка подогрева руки	110009	Toe-puff heating plate
47	Винт M4x10 (UNI 5931)		Screw M4x10 UNI 5931
48	Зажим Fe-Cu	101674	Holder
49	Блок питания 150W 150 watt	110006	Resistance 150 watt 150 watt
50	Планка базы	110004	Base plate
51	Рамка	110170	Frame
52	штекер M6x20 (UNI 5931)		Socket M6x20 UNI 5931
53	штекер M6x15 (UNI 5931)		Socket M6x15 UNI 5931
54	Шайба	110150	Pad

POS.N.	DESCRIZIONE	CODICE	DESCRIPTION
56	Ghiera pulsante		Push ring nut
57	Contatto NO		Push contact NO
58	Vite M4x6 UNI 5931	ZB2-BE101	Screw M4x6 UNI 5931
59	Squadra per pulsante		Push square
60	Vite M5x8 UNI 5931	110130	Screw M5x8 UNI 5931
61	Rondella d.4x16		Washer d.4x16
62	Fusibile 5x20 2A		Fuse 2A

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