VERT 560

INSTRUCTIONS MANUAL

General Index

Chapter 1 General information

1.1 Documentation supplied

- Instruction manual (this booklet).

Other manual

- *Enclosure 2 PLC Instructions Manual* on page 55

Other documentation

- *Enclosure 3 Wiring diagrams* on page 55

1.2 This manual

Details about manual

Instruction manual:

- Edition: 2.0
- Year and month of printing: July 2005

Addressees

- Carrier.
- Installer.
- End user.
- Maintenance engineer.

1.3 Information property rights

NEW.MA s.r.l. Unipersonale reserves the right to introduce technical modifications or improvements both to the documentation and to the machines without prior notice. Modifications and improvements may also concern other machines of the same model described in this manual, but which have a different serial number. The information contained herein refers in particular to the machine specified in *1.6 Machine identification details* on page 5.

1.4 Conventions

Linguistic conventions

- On the left, on the right : when speaking of such, we refer to the operator's position when facing the control panel.
- Qualified workers : all those persons who thanks to their training, experience, education as well as their knowledge of standards, regulations, safety precautions and operation conditions, have been authorised by the person in charge of plant safety to carry out any necessary action and are capable of identifying and avoiding possible danger.

Printing conventions

Text in italics: : this indicates the title of a chapter, a section, a subsection, a paragraph, a table or a drawing in this manual or other reference document.

PSE : Personal Safety Equipment.

(N) where N represents a generic number (e.g. (3)): symbolic representation of a control or warning device (e.g. buttons, selectors and indicator lights).

(L) where L represents a generic letter (e.g. (B)): symbolic representation of a part of the machine.

NOTE Notes contain important information and are highlighted separately from the text to which they refer.

BEWARE Beware indications describe the procedures the partial or total non-observance of which can cause damage to the machine or to devices connected to it.

DANGER Danger indications describe the procedures the partial or total non-observance of which can injure or harm the operator's health.

1.5 Manufacturer identification details

NEW.MA s.r.l. Unipersonale
Via Val d'Aosta (z.i.) 7/B
36015 Schio (VI) ITALY
Tel. +39 445 575534
Fax. +39 445 575489
E-mail. info@newma.it / tecnico@newma.it
Internet. http//www.newma.it

1.6 Machine identification details

Type: VERT
Model: 560
Serial no.: 910
Year of manufacture: 2003

Fig. 1.1 Machine identificating plate

NOTE Any information, specification or spare parts request must show reference to the serial number as per *Fig. 1.1 Machine identificating plate* on page 5.

1.7 EC declaration of conformity "CE"

See *Enclosure 1 Declaration of EC conformity*.

1.8 Guarantee

General conditions

1. The machine is covered by a 12 months guarantee which comes into effect from the date of effective delivery and commissioned installation.

NOTE Any different guarantee condition will be agreed upon in the contract in accordance with the buyer.

BEWARE The guarantee takes effect only when NEW.MA s.r.l. Unipersonale having consigned the machine will receive by mail from the purchaser customer the following coupon completely filled in.

BE CAREFUL

CUT OUT AND SEND BACK

GUARANTEE COUPON		
MACHINE:	MODEL:	SERIAL NUMBER:
CUSTOMER TRADE NAME	ADDRESS	TELEPHONE
		FAX
VAT I.D. NUMBER		E-MAIL
UNDER OUR RESPONSABILITY WE DECLARE THAT: - THE MACHINE HAS BEEN CONSIGNED ENTIRE AND COMPLETE IN ALL PARTS. - THE MACHINE HAS BEEN CONSIGNED WITH ALL PROTECTIONS AND SAFETY DEVICES ACTIVE AND OPERATING. - THE MACHINE HAS BEEN CONSIGNED TOGETHER WITH THIS INSTRUCTIONS MANUAL. - ALL INFORMATION INCLUDED IN THIS MANUAL WILL BE READ AND UNDERSTOOD BY ALL THE PEOPLE WHO WILL IN ANY WAY GET IN CONTACT AND OPERATE WITH THE MACHINE. - THE NON-OBSERVANCE OF WHAT WRITTEN IN THIS MANUAL WILL RELIEVE NEW.MA s.r.l. Unipersonale OF ANY RESPONSABILITY IN CASE OF ACCIDENTS TO PEOPLE AND/OR THINGS OR ANY MALFUNCTION OF THE MACHINE.		
NAME AN SURNAME OF THE PERSON WHO SIGNS FOR ACCEPTANCE (LEGIBLE)	ROLE IN THE COMPANY	SIGNATURE FOR ACCEPTANCE

NOTE In case of repair in the same place where the machine is installed, the guarantee coupon must be shown to the technician encharged for the repair. The guarantee won't come into effect if the coupon has not been properly and completely filled in.

Any particular guarantee agreed upon - if any- must be clearly mentioned in the sales contract.

The guarantee will expire in the following cases:

- Improper machine use (see *Improper use* on page 9).
- Use of equipment different from the equipment specified in *Chapter 7 Maintenance.*
- Assembly of the machine in conditions different from those specified in *Chapter 5 Installation.*
- Connections which fail to comply with the specifications given in *Chapter 5 Installation.*
- Use of non-original spare parts or parts not specified by NEW.MA s.r.l. Unipersonale
- Use of spare parts not supplied by NEW.MA.

Claiming under guarantee

Method

Requests for spare parts or service visits under guarantee must be made to NEW.MA s.r.l. Unipersonale or to your authorised dealer as soon as possible after having encountered the defect which is covered by the *General conditions* on page 6.

To place any order for space parts further than subjected to wear material such as Teflon, sponges or other, make reference to the table or to the interested group as per *3.2 Description of the machine groups* on page 20 and mention the number of the drawing where the required piece is listed in.
Example:

Table no. 400-03-00A Piece no. 1 Quantity 1

BEWARE Making adjustments or tampering to machines pieces without prior authorization by the manufacturer is absolutely forbidden.
Morevor it is recommended to use original spare parts supplied by NEW.MA only. In case of the non-observance of the above recommendation NEW.MA declines any responsability for breakdowns or damages to people, things or domestic animals existing in the working place.

Type, model and serial number of the machine are always to be mentioned to make a request for spare parts under guarantee or technical interventions under guarantee. Please find these details as per *Fig. 1.1 Machine identificating plate* on page 5.

1.9 Assistance

As far as both the best exploitation of machine performances and extraordinay maintenance operations are concerned, this manual doesn't substitute the experience of trained and qualified installers, users and maintenance enginners. The Customer Technical Assistance grants and provides information by telephone, correspondence and interventions for training and maintenance.

Request for interventions of assistance

Service of Technical Assistance

To contact the Technical Assistance Service contact:
NEW.MA s.r.l. Unipersonale
Via Val d'Aosta (z.i.) 7/B
36015 Schio (VI) ITALY
Tel. +39 445 575534
Fax. +39 445 575489
E-mail. info@newma.it / tecnico@newma.it
Internet. http//www.newma.it

Requests for spare parts

When requesting spare parts please state the following information:

- Type of machine.
- Work Order Number printed onto the special label.
- Year of manufacture.

1.10 Use of the manual

Read the following chapters carefully: *Chapter 1 General information*, *Chapter 2 Safety information*, *Chapter 3 Machine specifications*, *Chapter 4 Operator interface*.

Consult the relevant chapter before attempting installation, operation, maintenance or dismantlement.

NOTE This manual must be kept for the whole technical span of the machine and it must be within easy reach in case of any need. In case the machine were resold (second hand), it must be sold together with this manual.

1.11 Description of the machine

Intended use

Target working

The NEW.MA vertical wrapping machines allow to package at intermittent movement the product starting from plane folded reel.
Suitable films are: heat-sealable, cold-sealable and polyethylene films.
The mechanical-pneumatic activation is controlled by PLC.
The wrapping material comes from the reel and by means of a particular tool its shape becomes tubular so to contain the product fed inside.
The machine is made out as follows:
film, which can be also printed, is fed-rolled from the back of the machine and following several passages made by idling rollers it arrives to some driving belts. The tubular is sealed both lenghtwise and then crosswise and cut crosswise so to make packages.
The wrapping machine allows all the adjustments required by the type of product that must be packaged.

BEWARE The machine has been constructed following the International accident prevention regulation in force. Therefore, anyone who used the machine with the special personal protection devices on and followed the prescriptions given by this manual is not in danger. Any failure in wearing the proper personal protection devices or in using the provided machine's safety guards will relieve NEW.MA from any responsability for any possible damage to things, people, domestic animals existing in the working place.

Improper use

Improper use means any operation not expressly stated in the *Intended use* on page 8, in particular:

- Use of products which do not suit this type of machine.
- Use of unsuitable wrapping materials or not clearly mentioned in this instructions manual.
- Operating the machine in an explosive environment.
- Operating the machine in a flammable environment.
- Washing the machine control area with jets of water.

Chapter 2 *Safety information*

2.1 Safety criteria

In the design and construction of this machine all criteria and expedients necessary to satisfy the safety essential requirements requested by the Machines Directive 98/37/CE, Low Tension Directive 73/23/CEE and following modifications and by the Electromagnetic Compatibility Directive 89/336/CEE and following mofications.

An accurate analyse effected by the manufacturer has allowed the aivoidance of the main parts of the risks connected to the machine conditions of use, both the expected use and that reasonably expected one.

The complete documentation of safety measures taken is contained in the technical brochure of the machine kept at NEW.MA s.r.l. Unipersonale

NEW.MA s.r.l. Unipersonale strongly recommends careful observation of the instructions, procedures and recommendations contained herein as well as strict observation of the current safety regulations regarding the work environment. This also applies to the use of both the correct personal safety equipment and machine protection devices.

DANGER Do not wear loose clothing, ties, chains, or watches that could get caught in the moving parts of the machine.

NOTE NEW.MA s.r.l. Unipersonale will not be liable for any damage or injury to persons, animals or things caused by non-observance of the safety rules and/or recommendations given in the documentation supplied.

2.2 Qualifications of personne

Stage in the technical life of the machine	Qualification of operator in charge
Transport	Qualified carrier informed of: *Chapter 2 Safety information*, *5.3 Transport* on page 39 of this manual.
Installation	Qualified electrician and qualified mechanic informed of : *Chapter 2 Safety information*, *Chapter 3 Machine specifications*, *Chapter 4 Operator interface* *Chapter 5 Installation*.
Programming and setting up	Qualified programmer and inspector informed of : *Chapter 2 Safety information*, *Chapter 3 Machine specifications*, *Chapter 4 Operator interface*, *Chapter 6 Use*.
Operation	Trained worker informed of : *Chapter 2 Safety information*, *Chapter 3 Machine specifications*, *Chapter 4 Operator interface*, *Chapter 6 Use*.
Maintenance	There are three different types of workers who can carry out interventions on the machine:: •Mechanical maintenance engineer: qualified engineer able to operate the machine in normal conditions and with the machine guards open. Able to carry out adjustments, maintenance and repairs on mechanical parts. This worker should not be assigned to electrical interventions on live parts.. • Electrician: qualified engineer able to operate the machine in normal conditions and with the machine guards open. Able to carry out electrical adjustments, maintenance and repairs. This worker can be assigned to electrical interventions on live parts inside the electric control box. • Manufacture's engineer : qualified engineer put at customer's disposal by NEW.MA s.r.l. Unipersonale to carry out complicated repairing in special conditions, according to the agreements taken with the customer.
Scrapping	Qualified mechanic informed of: *Chapter 2 Safety information*, *Chapter 8 Machine scrapping*.

NOTE NEW.MA s.r.l. Unipersonale will not be liable for damage or injury to persons, animals or things resulting from the action of unqualified operators.

2.3 Safeguards

DEFINITION

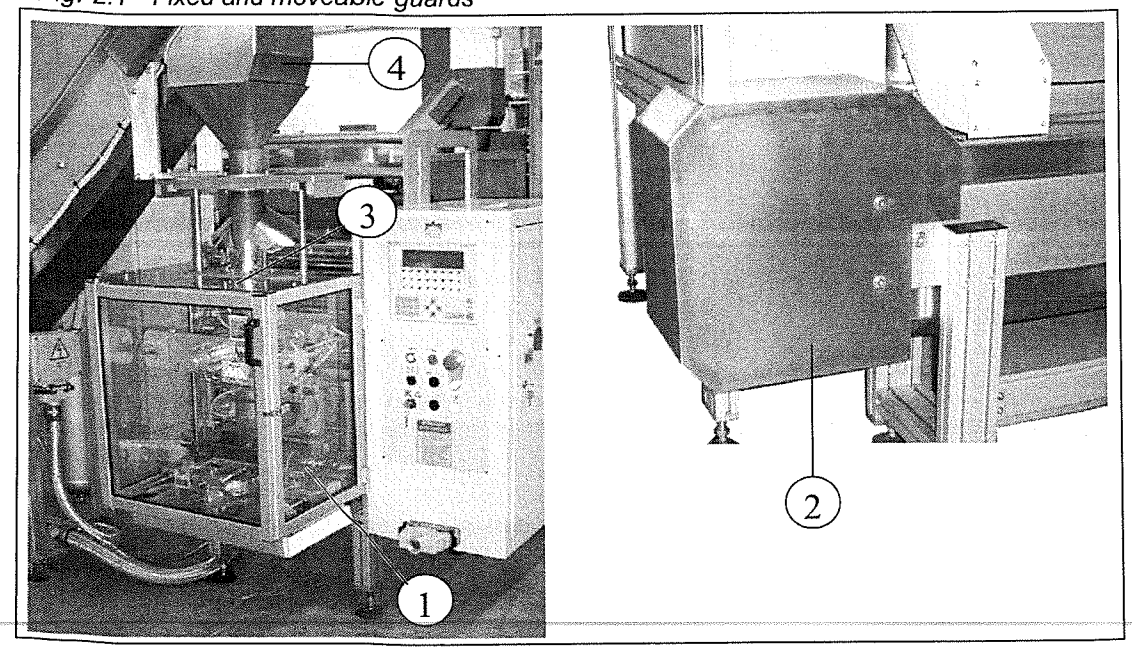
Safeguards are any safety measures which involve the application of specific technical mechanisms (guards, safety devices) to protect people from dangers which cannot be made sufficiently harmless through design.

Fixed and moveable guards

- All the conveyor belts are protected by fixed (screwed) safeguards, as prescribed by the safety specification EN 953, and are made in plexiglas in the upper part and in metal in lower part.
- The mechanisms situated in the main body of the machines are protected by a moveable guard. This is made in plexiglas and is provided with a limit switch to signal its opening to the autodiagnostic system.

1. Moveable guard in plexiglas
2. Fixed guard in metal
3. Fixed guard in plexiglas removable by special tool.
4. Hopper fixed guard in metal

Fig. 2.1 Fixed and moveable guards



Active safety devices

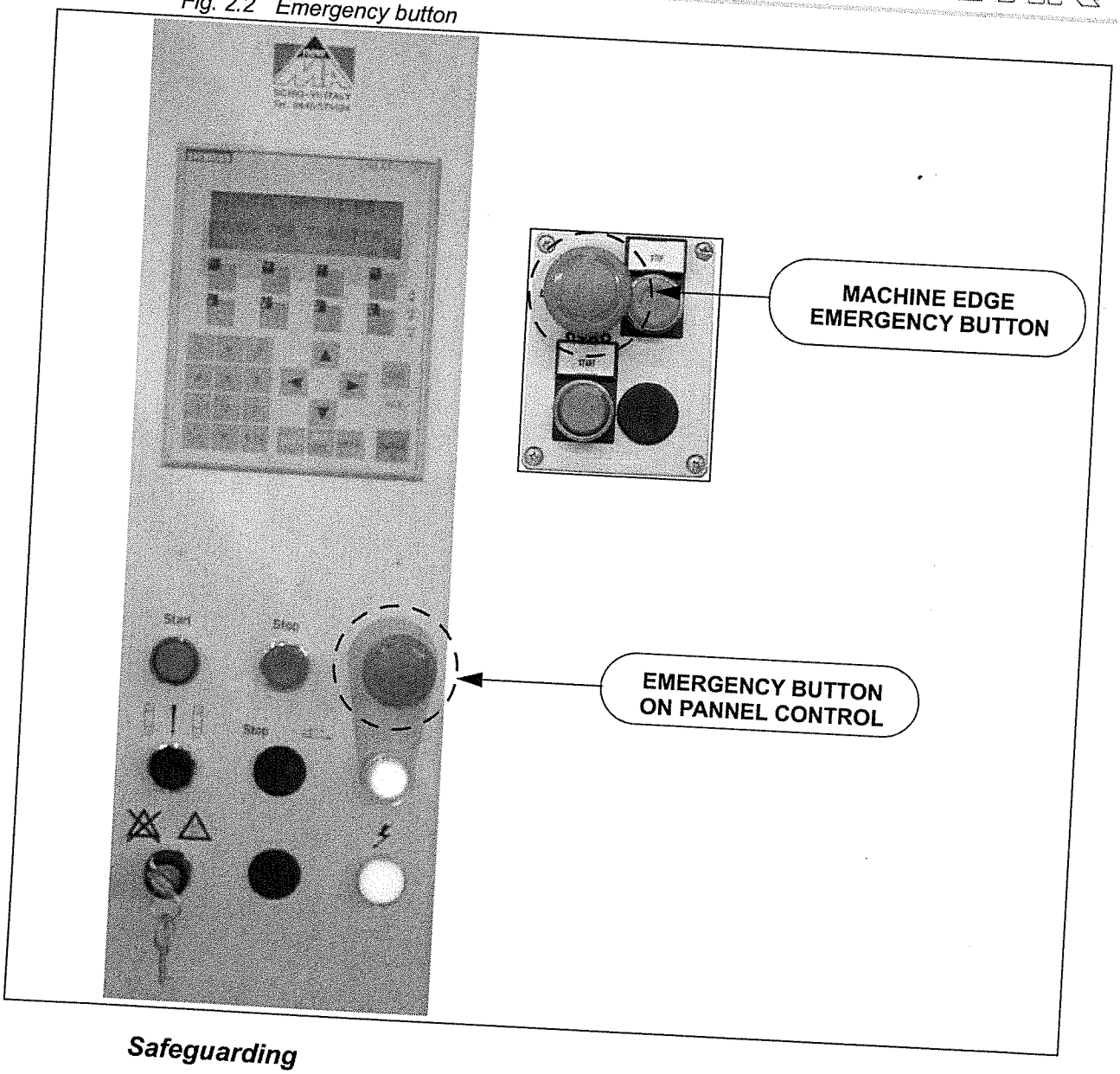
DEFINITION

Active safety devices are those devices or safeguarding techniques which eliminate or reduce potential hazards and which require active and conscious intervention by the operator in order to activate their accident preventative action.

Emergency stop

The machine is equipped with several emergency buttons, one placed in the main body of the machine and one for each of the manual operator's loading position.

Fig. 2.2 Emergency button



Safeguarding

- The electrical equipment offers protection against personal injury caused by electrical discharge due to direct and indirect contract in compliance with the CEI EN 60204-1 standard.
- All the electrical power parts and those with dangerous voltage are contained in the electrical box protected to IP54, in compliance with the CEI EN 60204-1 standard. The control and power supply voltages for all the accessible parts are 12 and 24V; moreover both these lines are protected against short-circuiting and accidental contact to earth.

DANGER Tampering with safety devices creates hazards for the machine operators and other exposed persons.

NOTE NEW.MA s.r.l. Unipersonale will not be liable for injury or damage to people, animals or things caused by tampering with the machine's safety devices.

2.4 Hazardous areas and residual risks

DEFINITION

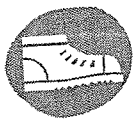
A hazardous area is any area inside or in the vicinity of the machine which would constitute a risk for the health and safety of an exposed person.

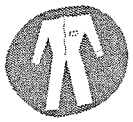
During some procedures of intervention on the machine, from time to time specified in this manual, there can be residual risks for the operator. Residual risks can be eliminated by carefully following the procedures indicated in this manual and by using/wearing the personal safety eqipment indicated.

BEWARE

Here to follow find the list of the P.S.E. of standard use.
In the manual, from time to time the proper P.S.E. to be used is specified so to avoid any of the residual risks likely to happen during transportation, use and machine's maintenance.


Protective gloves must be worn.

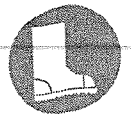

Protective footwear must be worn.


Protective overalls must be worn.


Protective glasses must be worn.

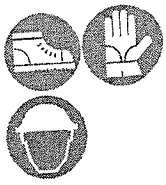

Skullguard must be worn.


Ear plug must be put on.


Antislip boots must be put on.

Zones of machine handling both if packed or unpacked . The following are the risks which may occur:

- Impact hazard for operator.
- Crushing hazard.



The following PSE must be used by the operator:

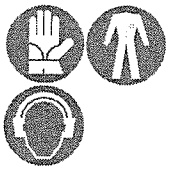
- Protective footwear.
- Protective gloves.
- Skullguard

Hazardous areas and residual risks during operation

Area surrounding the machine. The following risks are present here:

- Crushing hazard.
- Cutting hazard.
- High temperature hazard
- High acoustic pressure hazard

The following PSE must be used by the operator:



- Protective gloves
- Protective overalls.
- Ear plug.

BEWARE During the use of the machine, if the operator put his/her hands on the horizontal sealing bar, transpassing the safeguards, there will be a high rate of risk of being crushed, cut or due to the high temperature, burnt.

In order to enable the user to place an out-feed conveyor in the area of machine discharging, this risk has not been avoided. If the area had been protected against the above risks, the flexibility of the machine would have been strongly affected. As far as the risk of high temperature is concerned, the risk exists only if the sealing bar is heat-sealable. If the sealing bar is cold-sealable there is no risk of high temperature at all *Fig. 2.5 Horizontal sealing bar* on page 17.

Fig. 2.3 Warning signs shown on the machine

Any failure in the safety and protection devices running must be signnalled to the people in charge. Possible conditions of hazard which come to be known must also be reported.

Do not remove or modify the safety devices without prior authorizaton.

Moveable guards (able to be opened with handles) are preset so that, if opened while the machine is running, the machine is immediately stopped.
Fixed guards (able to be opened with a key or unscrewing them), if any, must be removed only after having sectioned the electric and pneumatic power.

Fig. 2.4 Danger sings shown on the machine

Do not touch moving parts unless it was strictly necessary. In that case follow the prescriptions in this manual *Chapter 7 Maintenance* on page 49.

In any case do not execute operations or interventions which are not of your own competence.

To remove a jamming of any kind, do not touch any part in movement.

Do not execute operations or interventions which are not of your own competence.

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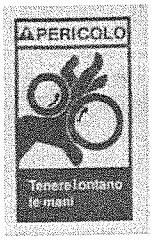


Do not touch moving parts unless it was strictly necessary. In that case follow the prescriptions in this manual *Chapter 7 Maintenance* on page 49.

In any case do not execute operations or interventions which are not of your own competence.

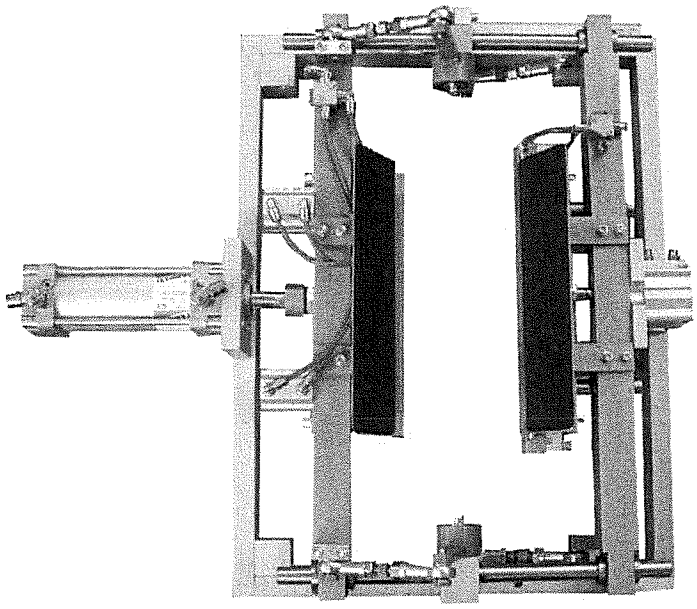
To prevent your hands and fingers from being injured, keep clear of the sealing bars horizontally positioned on the cut-and-seal device.

To check and adjust the cut-and-seal blade, lift the according safeguard and use heatresistant gloves. Do not lean any object on the cutting edge.

Before making any adjustment consult a qualified electrician. Use isolated tools only and avoid contact with any component.

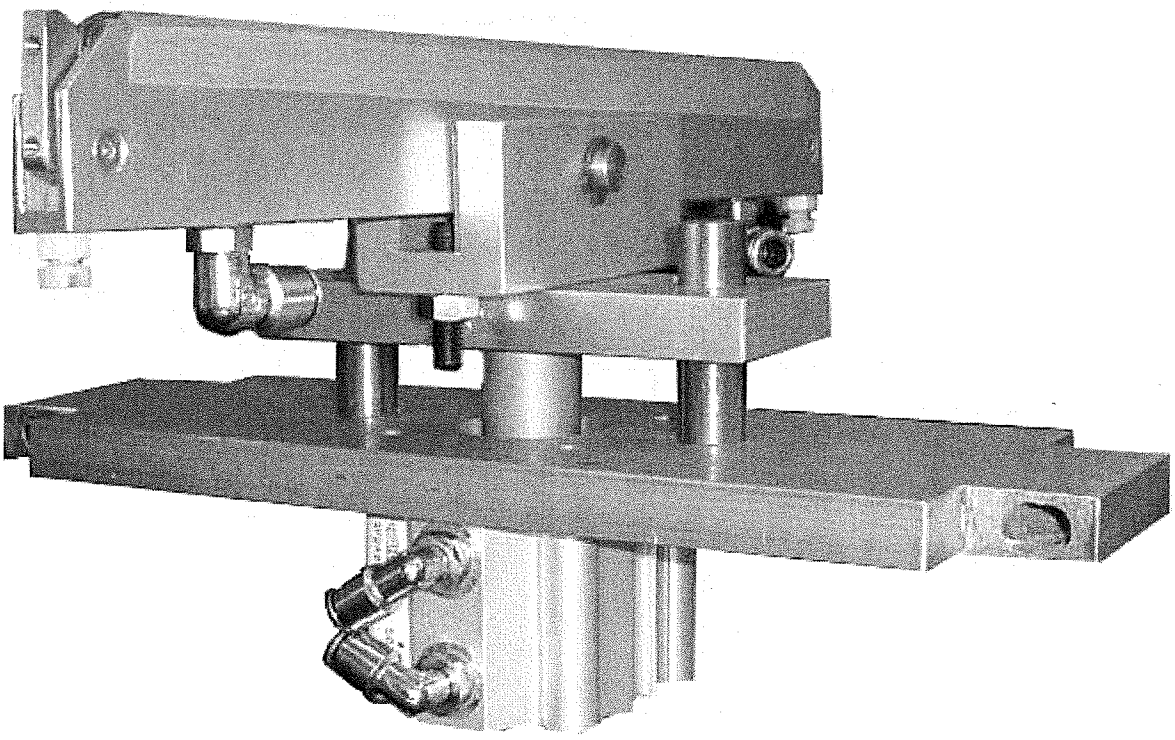
Check every day that all the switches and safety devices are operating.

Fig. 2.5 Horizontal sealing bar



NOTE NEW.MA s.r.l. Unipersonale will not be liable for damage or injury to persons, animals or things resulting from non-compliance with the safety rules or from the recommended PSE not being worn.

Fig. 2.6 Vertical sealing bar



2.5 Noise

The following details on machinery noise are measured following the indication given by the Directive on Machines (98/37/CE and following modifications). The regulation prescribes a maximum level of expósure to be not higher than 85 dB.

The cautious correspondant continuous acoustic pressure, re[illegible] at the working place, varies both in accordance to the dimensions of the products to be worked, and to that of the material these products are made of.

Information on hazardous noise

The quoted machinery noise levels do not necessarily imply safety exposure levels for the operator too. Exposure levels of the operator are obviously related to the machine emitted levels, nevertheless, there are other factors which affect the operator exposure levels. These include the duration of the exposure, the environment characteristics, the presence of other machines. The machine emitted levels allow the user to effect en evaluation of the risks coming out from the machinery noise.

DANGER The continuous use of the machine could cause a daily personal exposure equal or higher than the maximum Imit allowed.

PSE must be worn (i.e., ear plug).

For information on other safety measures to adopt in Italy, look through the Decree with the force of law N. 277, dated 15.08.91.

Chapter 3 *Machine specifications*

3.1 Technical specifications

Dimensions and bulk of the main body

Dimensions and bulk of the main body

Machine length	1455 mm
Machine width	1010 mm
Machine height	1670 mm
Total bulk	Kg
Maximum reel width	560 mm

Power supply details

Electrical installation

Electrical power

Tension	220 ±10% V trifase con neutro
Frequency	60 ±1% Hz
Total electrical power installed	KW

Pneumatic Installation

Pneumatic Installation Characteristics

Operating Pressure	6 bar
Maximum Pressure	8 bar

Responsability

NOTE NEW.MA s.r.l. Unipersonale declines any responsability for inconveniences, breakdowns or malfunctions which should occur as a consequence of the failure in following the supplied feed values.

3.2 Description of the machine groups

In the following section, to ease the customer to require the correct spare parts and to accomplish the ordinary maintenance, the several groups composing the machine are described.

- Main structure
- Reel holding device
- Shaping device
- Tightening device
- Sealing device
- Vertical sealing device
- Electric control device

Request for interventions under guarantee

Modality

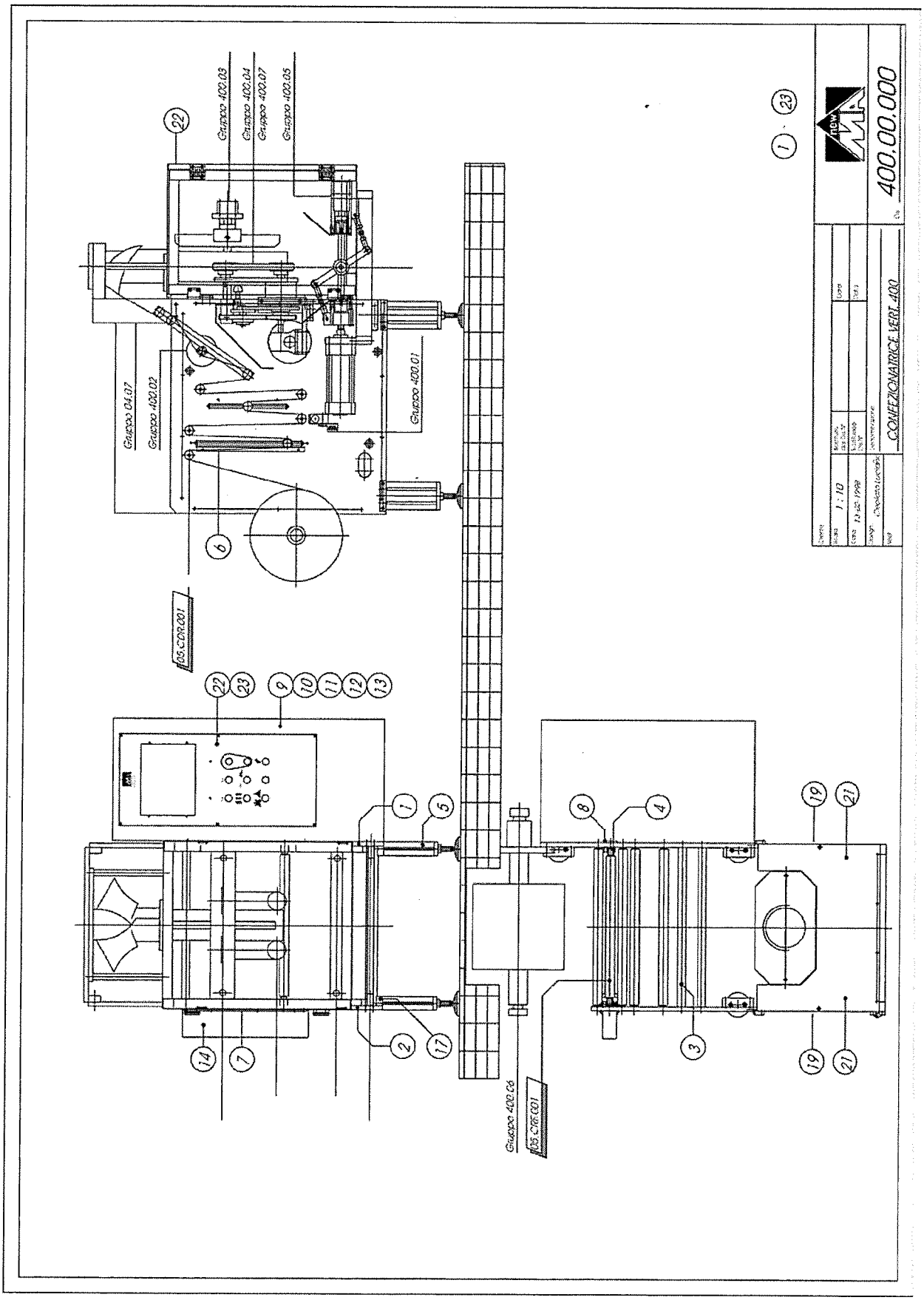
Any request for spare parts or technical interventions under guarantee must be made to NEW.MA s.r.l. Unipersonale or to the authorized reseller, as soon as a defect falling within the specifications at paragraph *General conditions* on page 6.

To place any order for space parts further than subjected to wear material such as Teflon, sponges or other, make reference to the table or to the interested group as per *3.2 Description of the machine groups* on page 20 and mention the number of the drawing where the required piece is listed in.

Example:

Table no. 400-03-00A Piece no. 1 Quantity 1

Fig. 3.1 Planimetry



Film positioning (see *Fig. 3.2 Reel unwinding system* ***on page 23***)

Remove the reel pushing cone (22) by lifting the knurled knob (7).
Insert the reel in the holder and reposition the pushing cone. Check that the knurled knob has been inserted in the proper placing.
Tighten the reel in between the cones turning the knob in the opposite direction (23).
Unwind the film by feeding it between the rollers, as per scheme *Fig. 3.5 Vertical sealing device (cold-sealable)* on page 28. For a correct execution of this job take into consideration all the machine characteristics and feed the film through the shaping collar.
At this point, insert the film unwinding belts and use in manual their according control button to center the film to the tube.
The operation of feeding the film through the shaping collar is rather difficult but with a little bit of practice it will become easier.
The indicative reel width is calculated in relation to the outside diameter of the tube where the product to be wrapped is fed inside.
The calculation formula for all the materials, apart from the coupled (it means that one sealing inside with inside) is the following:

(TUBE OUTSIDE DIAMETRE X 3.14) + 25 mm APPROXIMATELY

the formula for the coupled is:

(TUBE OUTSIDE DIAMETRE X 3.14) + 40 mm APPROXIMATELY

Fig. 3.2 Reel unwinding system

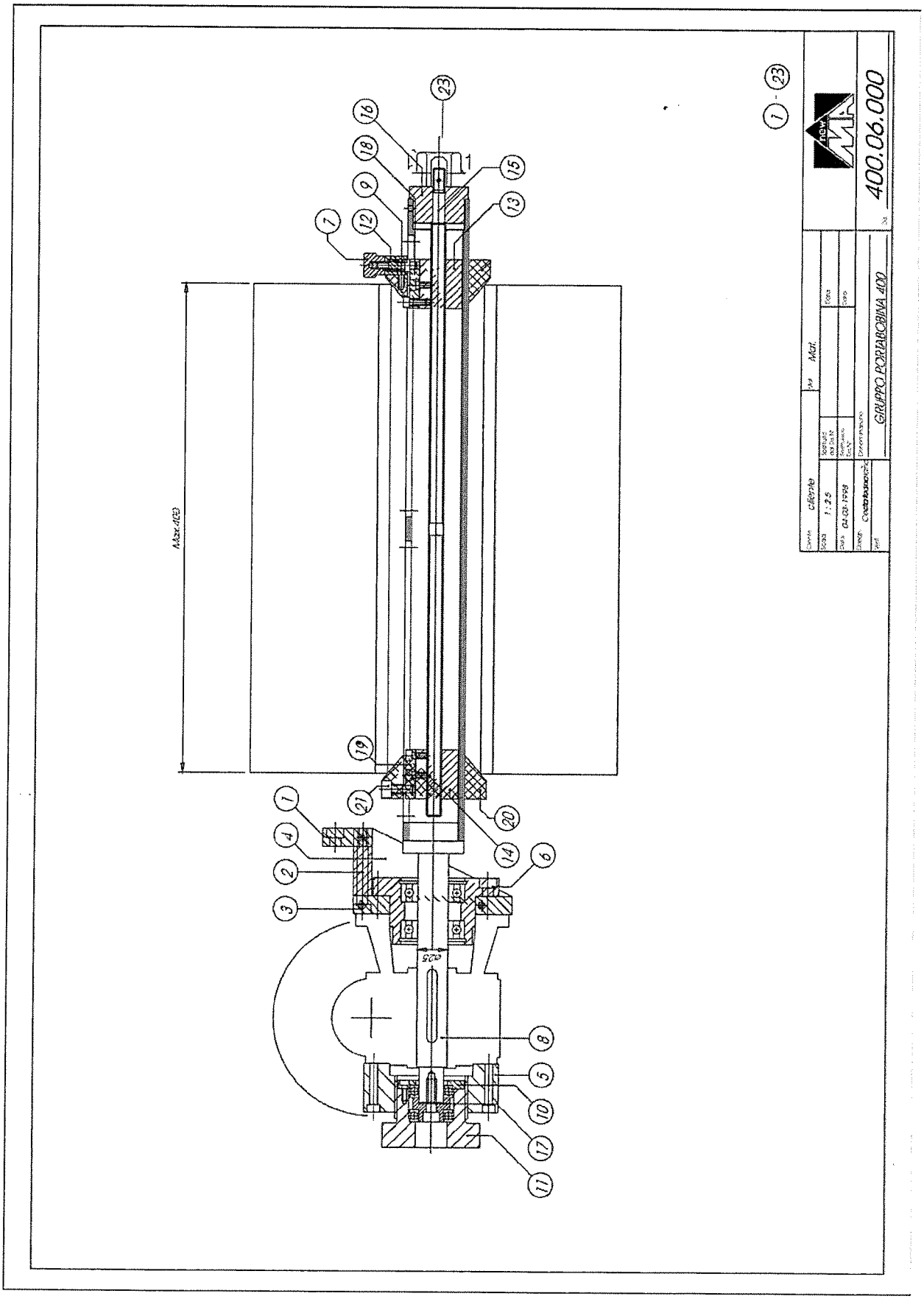
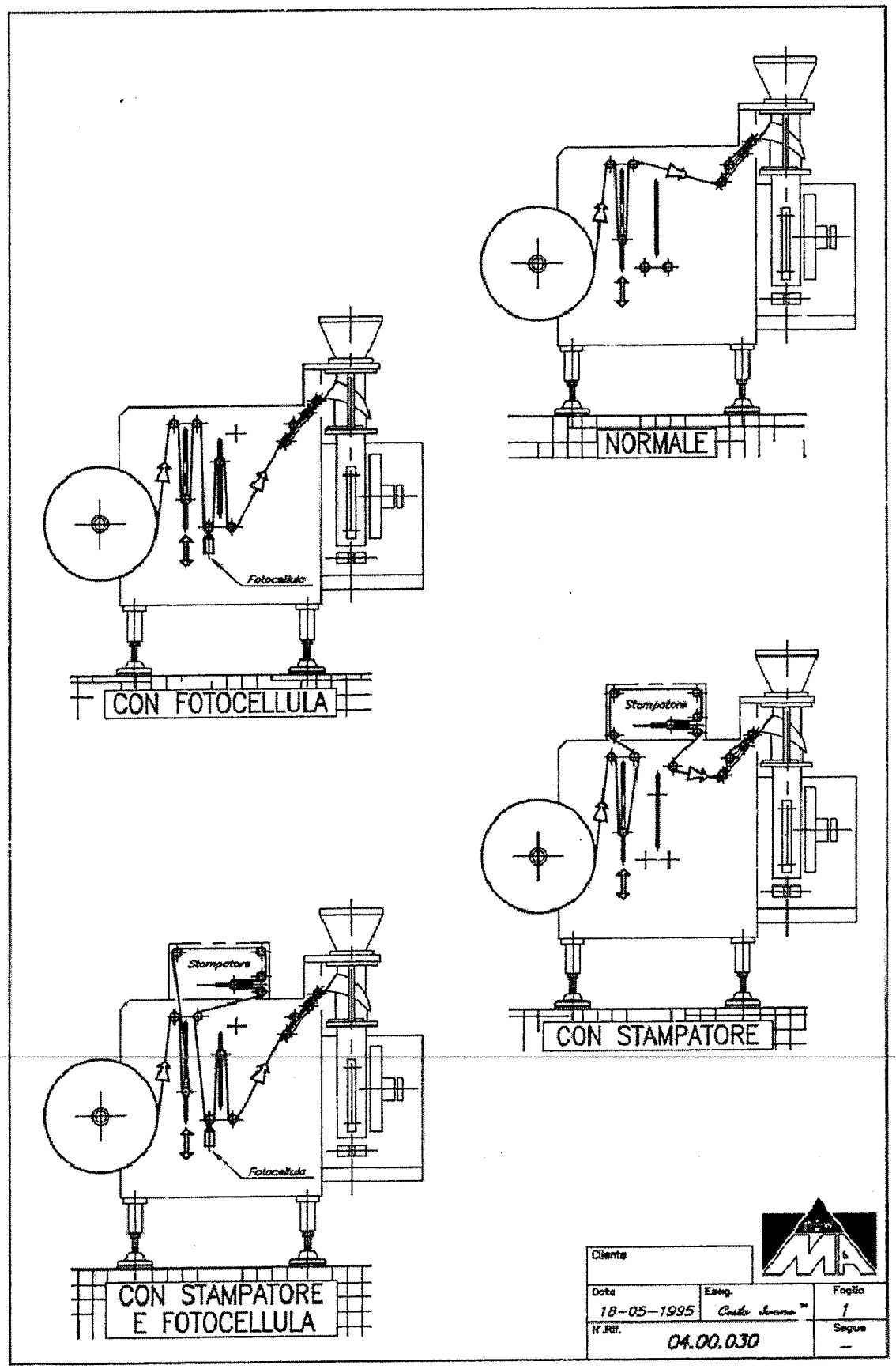


Fig. 3.3 Film positioning



Pulling Device (see *spread the belts apart from the tube by hand after unscrewing the blocking screws, Unloose the bolts placed on the back of the tightening pulleys and unscrew their according tightening screws* . ***on page 25***)

This device is pre-assembled and fixed onto the machine by means of two screws only.
The unwinding of the film is obtained thanks to two gearmotor activated belts.
A serie of gears made in Bakelite allows -by a simple manual operation- to move the pulling position so to allow the variation of the forming tubes diameters.

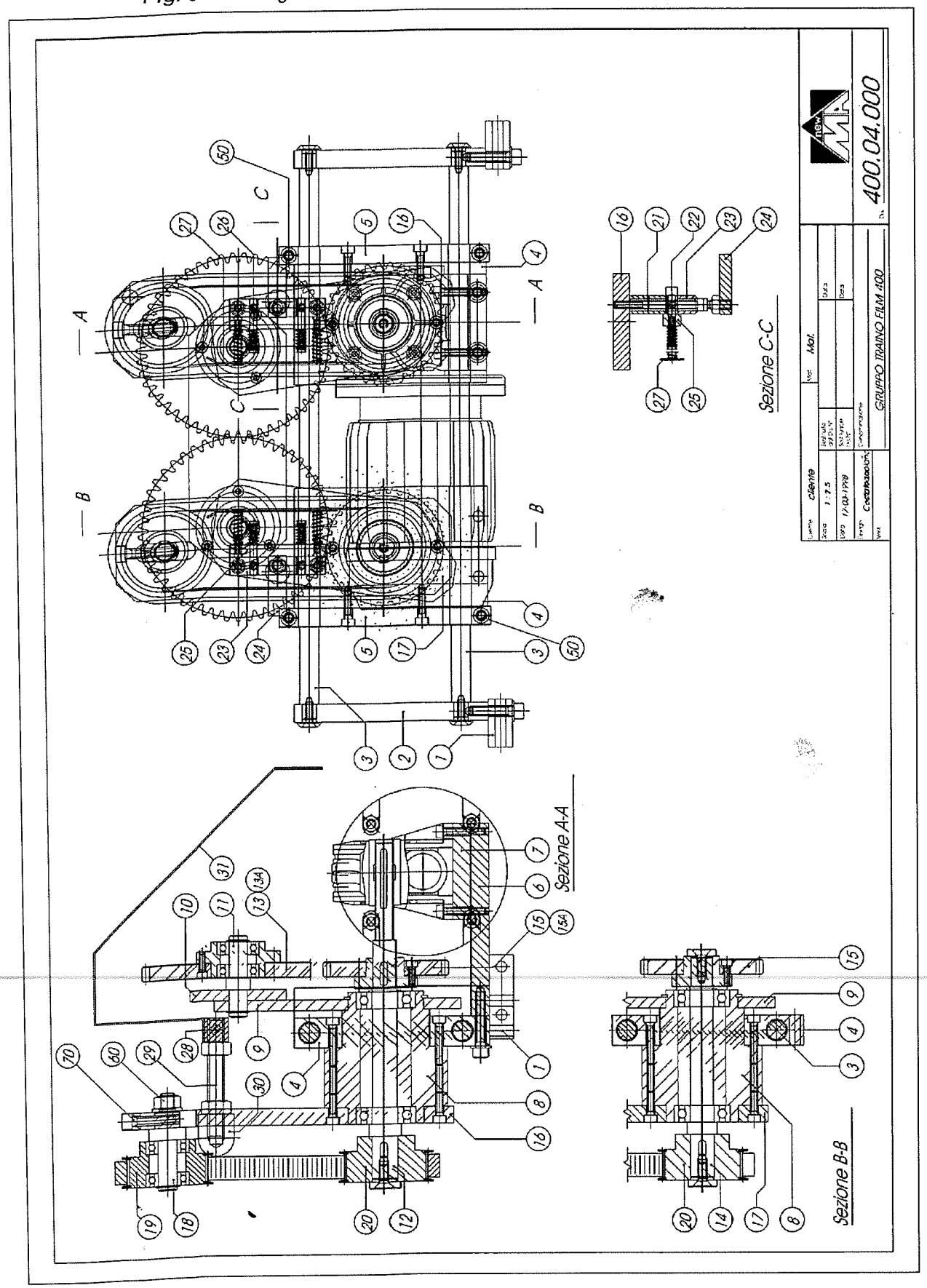
To execute the pulling follow these instructions:

Unloose the screws (50), push the belts by hand against the tube till skimming it. Re-fasten the screws (50) and with the eccentric levers (24) put the belts in contact with the film.
To ensure long life to the belts, it is very important to check in correspondence to these, onto the shaping tube, that there must be a string of Tefloned cloth. This reduces the film's attrition against the shaping tube and, as a consequence, eases the feeding of the film.

When it happens that the belts are very worn out, proceed with the replacement as follows:

spread the belts apart from the tube by hand after unscrewing the blocking screws, Unloose the bolts (60) placed on the back of the tightening pulleys and unscrew their according tightening screws (70) .

Fig. 3.4 Pulling Device



Transversal sealing device

The transversal sealing unit is a device with three indipendent pneumatic movements.

1. closing pressers movement
2. sealing bar movement
3. cutting movement

This device is complete pre-assembled and then fixed onto the machine by two M8 screws. The blade is protected by a proximity which makes it coming out only if the jaws are completely closed. This means that if between the jaws there were some material jammed, even if 2-3 mm high only, the proximity would not be activated and the blade would not come out.
If the cut would not be effected, the cause must be searched between:

— air pressure too low
— proximity too far away from the feeling device
— film slipping between the jaws because they do not shut properly
— poor smoothness over the knives-slide bar

To replace the knife pos (14) drawing 04.03.000 remove the fixing screws and position the new knife. Check then with a light pressure of your hand, that once fixed the screws, the slide bar movement to be smooth.

Fig. 3.5 Vertical sealing device (cold-sealable)

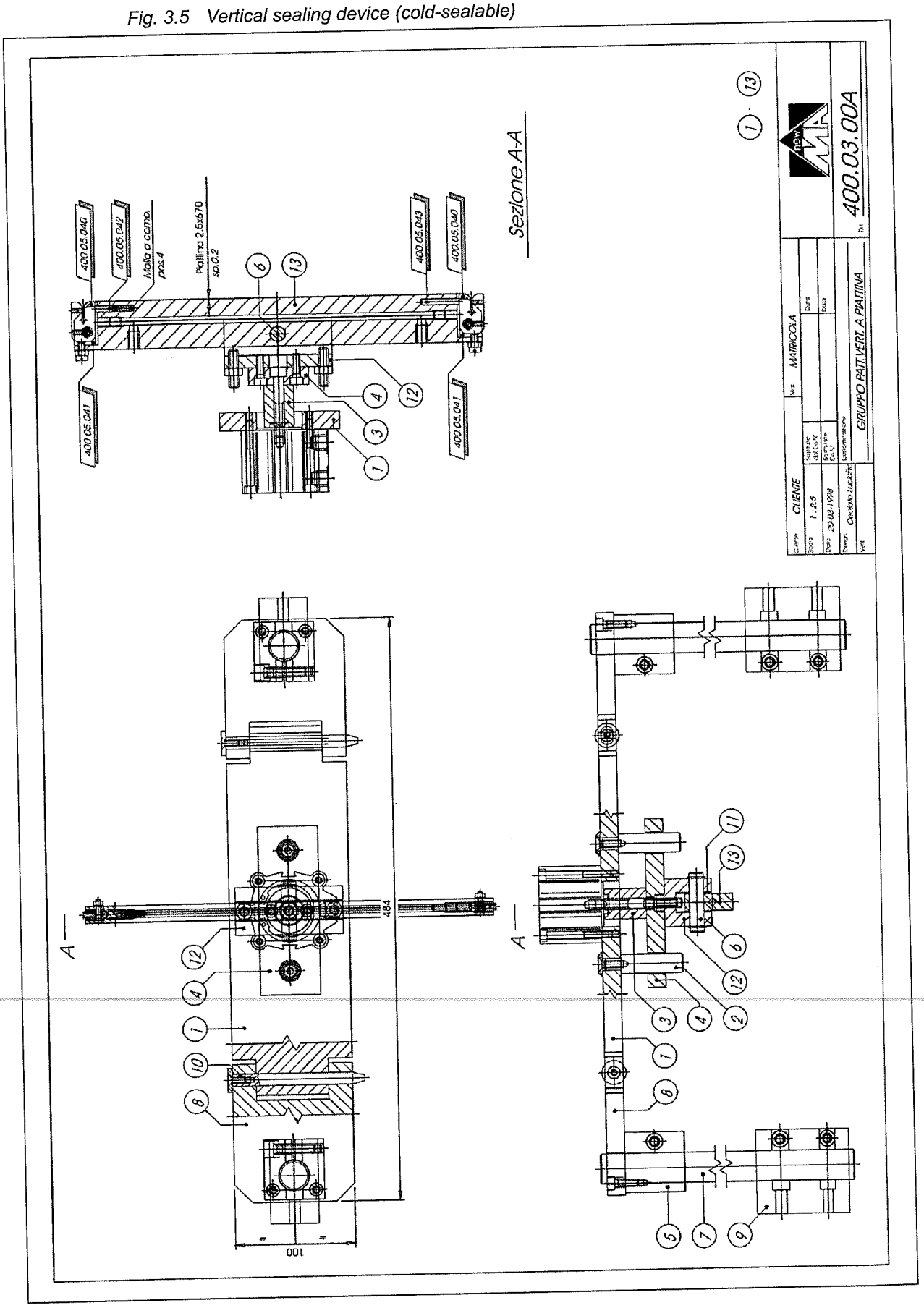
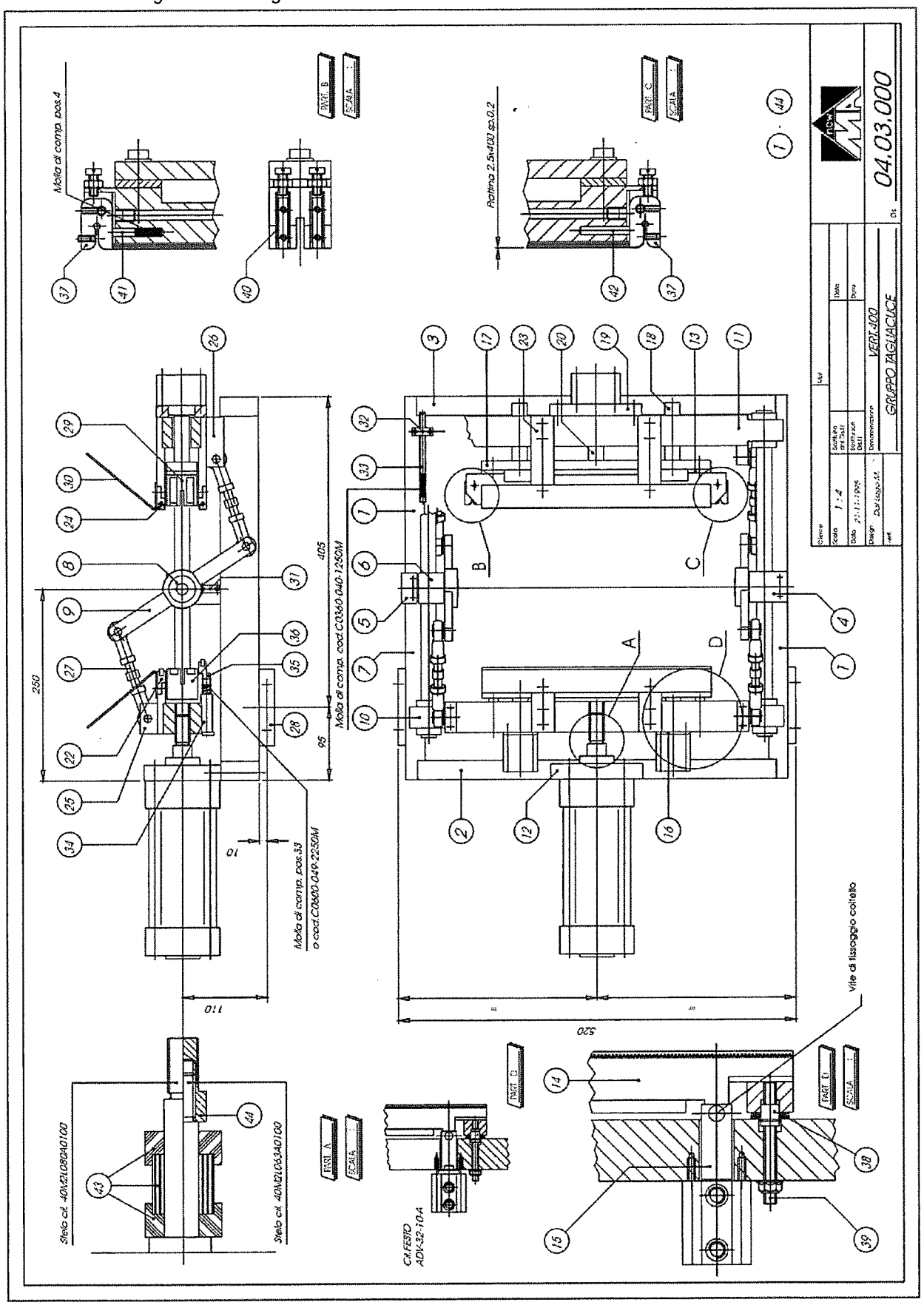


Fig. 3.6 Sealing unit



Sealing system at impulse

This system is made out of two aluminium sealing bars specifically milled and perfectly plane. The sealing is made by Ni Cr straps kept continuously tightened by a strap-toghtening device . Before starting with the test, check that the Teflon cloth over and under the straps are not burnt or in a state of low insulation otherwise they could damage the automatic fuses, or even worst, any of those electronic components placed to check the current flowing. The siliconed rubber, opposite to the strap sealer, must be assembled in its housing without any stretching.
In case its surface were not perfectly plane, it should be replaced.

Sealing adjustment

The adjustment of the sealing, both lenghtwise and crosswise, is effected through two independent adjusting cards.

The impulse to start the sealing is given when the jaws are closed and this is kept by the timers, which set the duration of this impulse.
To adjust the duration and the power of this impulse of sealing, it will be enough to change the transformers output tension by means of two potentiometers placed on the pannel control.
The higher the set time is, the higher the temperature will be. Once effected, the sealing will need a little bit of time to cool down. Therefore jaws closing time must be set to allow this cooling. These adjustments must be made in accordance with the type and the thickness of the polyethylene to be sealed.

Horizontal and vertical sealing strap replacement

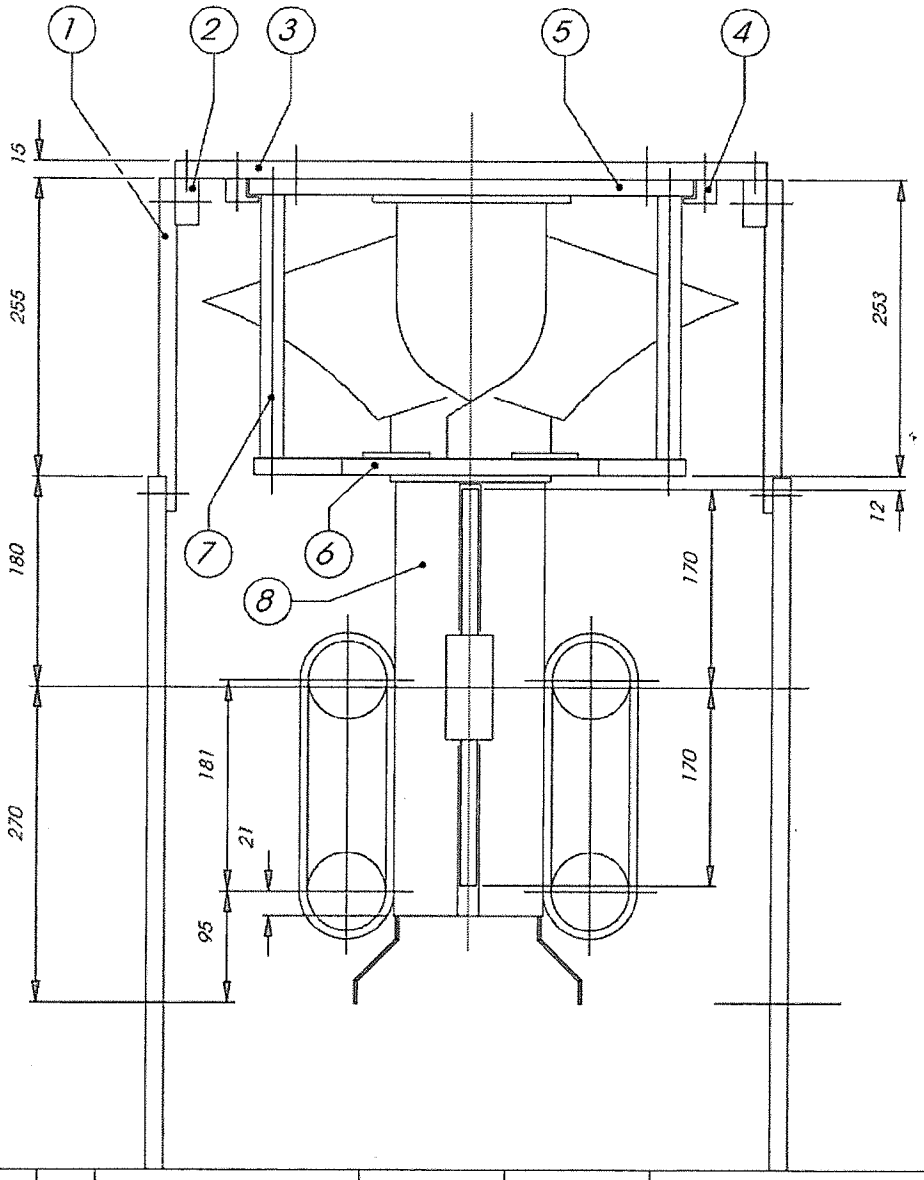
Remove the self-stick Teflon covering the strap. Unloose the (1) screw and the (2) removing the old strap, cut out a piece from strap and fold 20mm from the two edges laying it over itself. Insert the head of the strap in the special clamp (3), fasten with screws (1) and insert the other head of the strap under the clamp (4), push the clamp with a finger (4) till taking it into contact with the bar (5) fasten with screws (2) checking before the strap to be perfectly straight and well stretched.

Before covering with a new self-sticking Teflon cloth clean the surface with dry and volatile solvent so as to make a perfect assembling of the Teflon itself.

Shaping collars

NEW.MA supplies shaping collars complete with the relevant spacing anchor brackets and other brackets to make the tube replacing operation the easiest as possible. One person can replace the shaper alone rather quickly also because the operation does not require any adjustment or setting.
It is enough to open the plexiglas safeguard, remove the longitudinal sealing plug and turn it 90° turn, unloose the screws (A) and lift the complete shaping group.
In case of tube replacement with a bigger one enlarge the pulling belts before.
As ordinary maintenance to this group, it is enough to check the entireness of the self-sticking Teflon and of the silicone rubber in the sealing area.

Fig. 3.7 Shaping collar



Posizione		Q.tà Pezzi	Materiale	Sezione	Sviluppo	Trattamento	Kg
Quote senza indicazione di tolleranza : gradi di preci sione medio UNI 5307.63		Proiez. Assonometrica					
Dimensioni oltre	fino a	scost	Scala 1 : 5	Sostituito dal Dis N°		Data	
	6	±0,15	Data 08-06-1995	Sostituisce Dis N°		Data	
6	30	±0,20					
30	120	±0,30	Disegn. Costa Ivano	Denominazione ASSIEME DI MONTAGGIO			
120	315	±0,50	Verif.	TUBO E COLLETTO VERT.400		Dis. 04.07.000	
315	1000	±0,80					

Fig. 3.8 Pneumatic components table

Pos.	DENOMINAZIONE	Q.ta'	Tipo	Cod.	Marca Fornitore
11	Cil. (PATINO VERTICALE)	01	QP2A050A010		CAMOZZI
10	Cil. (PATINO ORIZZONTALE)	01	QP2A050A010		"
09	Regolatore di pressione 1/8" + Manometro	01	M008-R00 + M043.P6		"
08	Cil. (COLTELLO)	02	QP2A032A015		"
07	Elettrovalvola 5/2- 1/8"+ Bobina 24DC	03	E358-015 + AV3		"
06	Elettrovalvola 3/2- 1/8"+ Bobina 24DC	01	338L-015 + AV3		"
05	Cil. (TAGLIACUCE)	01	61M2P063A0100		"
04	Regolatore di portata unidirezionale 1/4"	01	SCU-606-1/4"		"
03	Elettrovalvola 5/2- 1/4"+ Bobina 24DC	01	454-015 + AV3		"
02	Lubrificatore a nebbia 1/4"	01	MC104-L00		"
01	Filtro riduttore 1/4"+ Manometro	01	MC104-D00 + M043.P12		"

SCHEMA PNEUMATICO

VERT.400-560 (BASE)

Mod.

Cliente

Data 31-01-1996

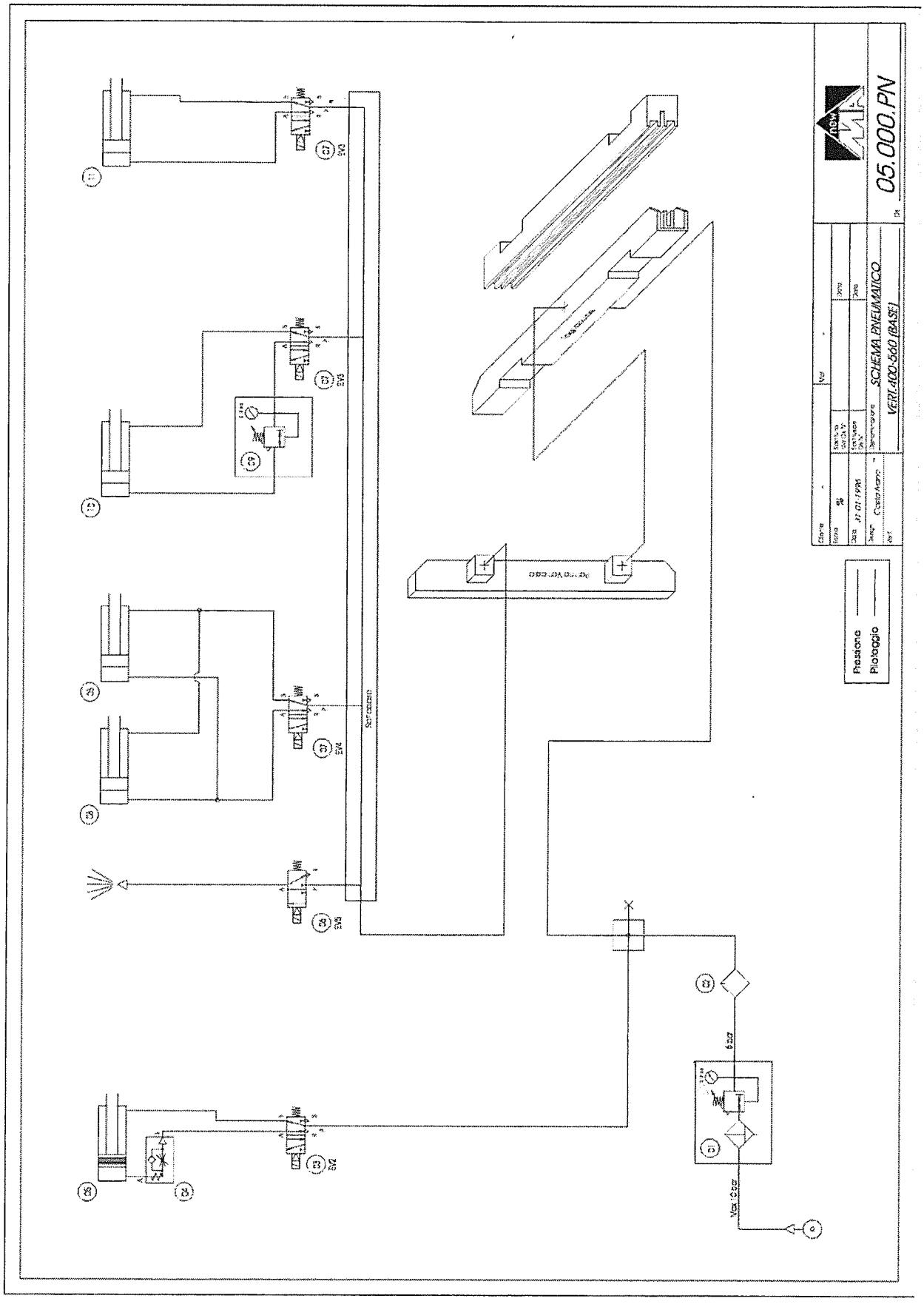
Scala Varie

Foglio 1

N° Dis. 05.000.IW

Segue -

Fig. 3.9 Pneumatic diagram



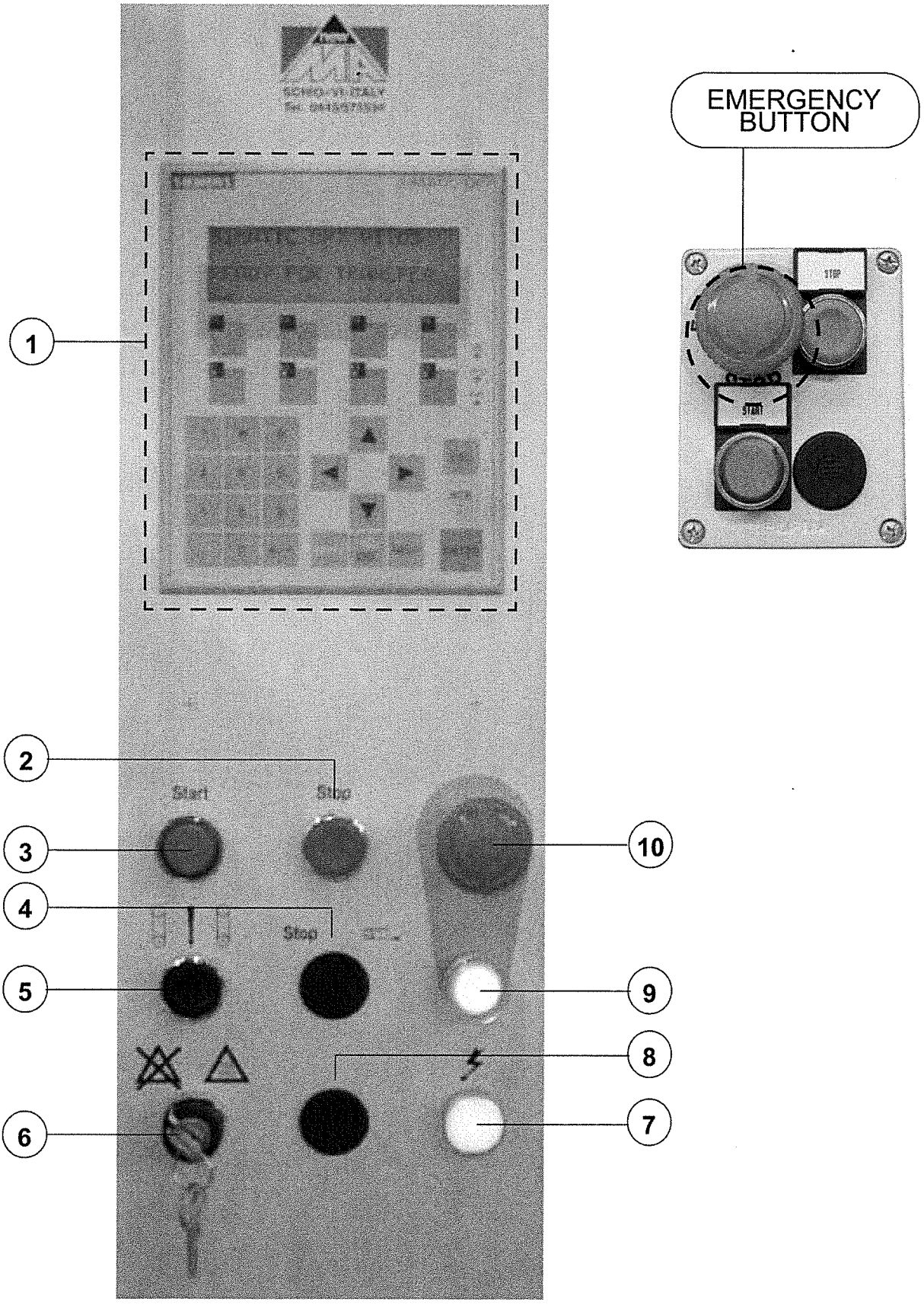
Chapter 4 *Operator interface*

4.1 Control panel

Controls

Symbol.	Description	Functions controlled
(1)	Keypad	It is used to write the commands to send to the machine PLC
(2)	STOP red button	When you press this button the working cyclus will be stopped.
(3)	Machine START green button	When you press this button after the machine has been reset, it will start working again.
(4)	Selector enabling the loading belt (supplied upon request only)	If selected it enables the loading belt
(5)	Black button	If selected it enables the film unwinding during the manual running function
(6)	Modal key selector	If turned it enables the execution of some maintenance operations with safeguards open
(7)	Pilot light	When lighted it shows that machine is under tension
(8)	Button without any function	
(9)	Pilot light	Cycle resetting button
(10)	EMERGENCY button	When you press this button the whole power supply input will be interrupted and all movements of the machine will be held up. To reset it, you have to manually turn this same button.

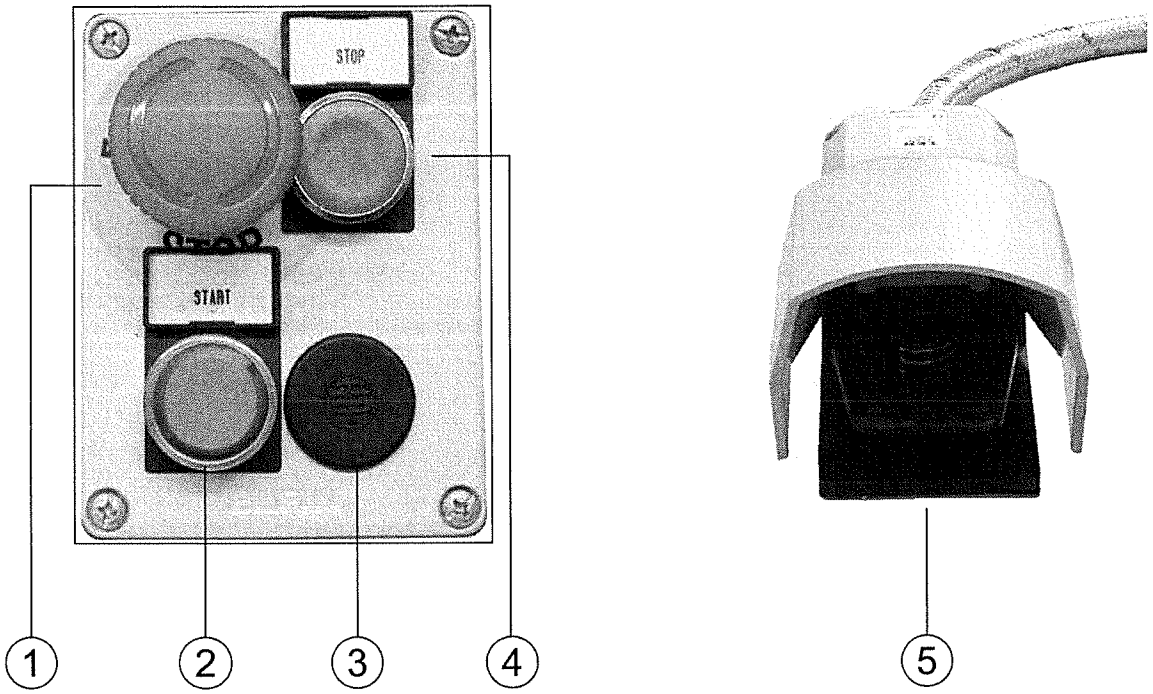
Fig. 4.1 Control panel



4.2 Other commands

Symbol.	Description	Functions controlled
(1)	Mushroom-head red push button.	EMERGENCY button. If pushed it blocks completely the machine clearing the tension to the electric circuits.
(2)	Machine START green button	If selected it enables the machine switching on
(3)	Button without any function	
(4)	STOP button.	If pushed it stops the machine running .
(5)	Pedal.	If pushed after the pilot light consent (3) it enables the elimination of a pitch.

Fig. 4.2 Other machine commands



Symbol.	Description	Functions controlled
(IG)	Cut-out switch	If turned to **0** clear the tension completely. If turned to **I** applies voltage to the machine

Fig. 4.3 Cut-out switch

Chapter 5 *Installation*

NOTE When reading this chapter refer to the pictures of the control panels given in *Chapter 4 Operator interface*.

5.1 Hazardous areas and residual risks during installation

BEWARE Here to follow the PSE of ordinary use are indicated.
In the manual, from time to time PSE to be worn to avoid residual risks during handling, use and machine maintenance are specified.


Protective gloves must be worn.

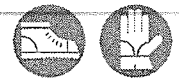

Protective footwear must be worn.


Protective overalls must be worn.

Handling area of the packed or unpacked machine. The following risks are present here:

- Impact hazard for operator.
- Crushing hazard.

The following PSE must be used by the operator:



- Protective footwear.
- Protective gloves.

DANGER When unloading. hoisting and handling the machine, personnel must wear the appropriate PSE, such as gloves, boots, helmet and use the appropriate tools.

5.2 Qualifications of operator

The installation of the machine should only be carried out by trained, qualified and authorised personnel after having read and understood the information given in this manual.

5.3 Transport

The instructions given in this section should be carefully followed when transporting the machine. This operation may include the following situations:

- Storage of the machine.
- Initial installation of the machine.
- Re-location of the machine.

Transport conditions

The machine and its equipment can be transported in the following ways, according to the customer's requirements:

- **In an "Open-Top" container.**
- **In a wooden box pallet**
- **By road vehicle.**

BEWARE In any case, before transportation or handling, the operations of packing and fixing the accessories to the machine must be accomplished.

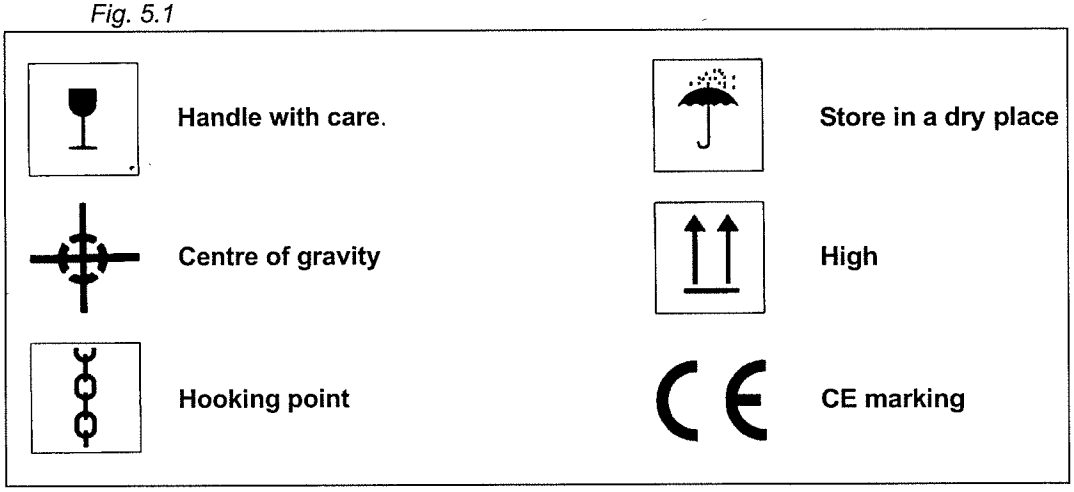
NOTE Follow the standard precautions to avoid crushing and overturning.

Symbols on the machine packing

The following symbols are shown on the machine packing:

- Handle with care.
- Centre of gravity.
- Hooking point.
- Store in a dry place.
- High.
- CE marking.

Fig. 5.1



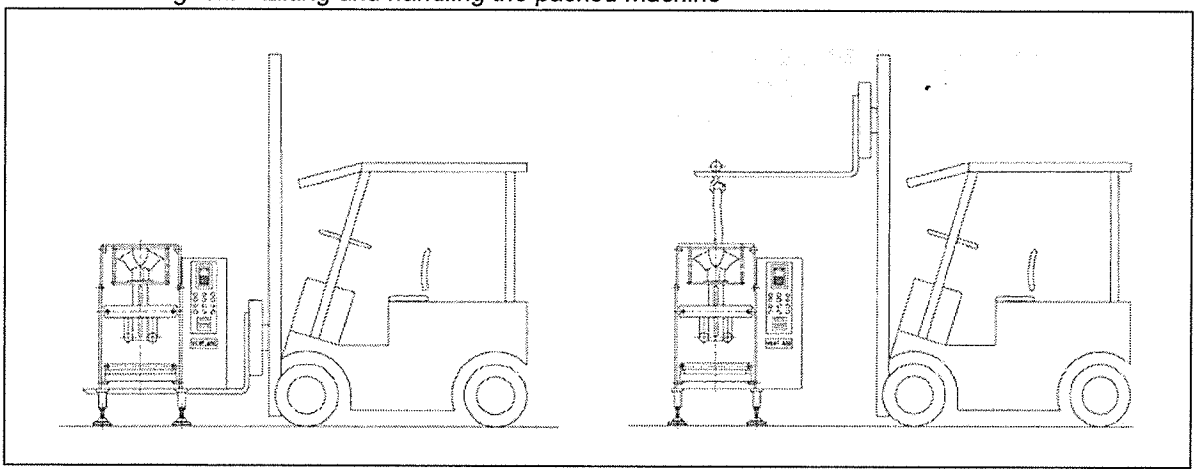
Lifting

DANGER

- It is forbidden to climb onto the machine and/or its packing or stop and/or pass under the machine during handling.
- Access to the lifting and handling area is denied to all personnel except those directly involved in the operations.
- All operators should remain at a safe distance in order to avoid being hit by the machine or any of its parts which may accidentally fall.
- Before starting the lifting operations the whole of the machine handling area, including the parking area for the means of transport and the machine installation area, should be identified and inspected in order to detect any potentially hazardous areas.
- Use a bridge crane, a crane or a forklift truck with adequate lifting capacity. The use of inadequate lifting equipment may cause damage to the machine or injury to personnel..
- Check lifting ropes to be equipped with bell and label showing manufacturer data to be clearly readable.
- Inspect the ropes before using them: they do not have to show any damage at all, nor broken strands or wearing signs
- Do not twist or knot the ropes together and follow the use instructions given by the manufacturer.
- The same warnings must be cautiously followed in case of use of chains or belts.

Lifting and handling the packed machine

Fig. 5.2 Lifting and handling the packed machine



Unpacking

BEWARE

- Before unpacking the machine, check the case/container not to have any relevant sign of breakages or dentings. In the opposite case advise immediately the person encharged who effected the delivery.
- For the disposal or re-use of the packing, customer must follow the relevant domestic regulations in force.
- The equipment for lifting the machine must be used every time the machine must be lifted or handled.

- Case:
  - **a.** Lift the case and deposit it on the truck placing the ropes/chains/belts as shown in *Lifting*.
  - **b.** Deposit the case on the ground.
  - **c.** Remove the cover by unriveting it.
  - **d.** Unrivet the case walls.
  - **e.** Take the accessories out.

BEWARE If the machine has been damaged during transport, inform NEW.MA s.r.l. Unipersonale immediately. NEW.MA s.r.l. Unipersonale should also be informed if there are differences between the "Packing list" and the goods actually delivered.

BEWARE The machine and its equipment should be protected from external atmospheric agents. In particular water and damp can cause certain machine components to rust, causing irreversible damage.

5.4 Preliminary operations

Check if the machine has been damaged during transport

Check the condition of the machine taking a close look at the outside and the inside. Any deformation of the visible parts indicates that the machine has been hit by something during transport.

Check the tightening of screws, bolts and fittings.

If damage has occurred:

Damage caused by transport should be attributed to the carrier and NEW.MA s.r.l. Unipersonale or its agent should be informed immediately of the situation.

Cleaning the machine

- Remove the dust and dirt deposited on the surface during transport.
- Carefully clean and dry each part (varnished or unvarnished) using soft, clean, dry cloths.

BEWARE It is strictly forbidden to climb onto the box pallets and/or to stow them one on top of the other.

- Should the box pallets remain outdoors for some time, waiting to be transported inside the building, these box pallets should be covered with adequately-sized waterproof tarpaulins.
- If storage exceeds 3 months the box pallets should be stored inside, sheltered from bad weather and protected from excessively high or low temperatures.
- Unpainted parts are coated with an oil film: check the protecting conditions and in case coat the uncoated parts with protective grease to avoid oxidations.
- If the machine is unpacked, it should be covered in order to prevent the build-up of dust and dirt.

5.5 Placing

Physical characteristics of the placing zone

Further than the machine overall dimensions, supplied at paragraph *3.1 Technical specifications* on page 19, it is necessary to follow these conditions:

- In the vicinity of the placing zone the energy supply sources must be prearranged, as per *Power supply details* on page 19.
- The operator must operate and move without any hindrance around the machine. The distance from the closest wall or object must be longer than 1m.
- Any control box must be always accessible and the doors must be able to open without hindrances and completely.
- Calculate enough room for the ordinary use and for the machine maintenance, peripheral devices room, if any, inlcuded.

Protection against external atmospheric agents

The machine should be installed in a covered building, shielded from direct contact with atmospheric agents.

Lighting

Adequate lighting is necessary to carry out both normal operation and servicing of the machine in a safe way. The machine has no built-in lighting system.

A proper environmental lightning -with standard value- allows work interventions without risks arising from blind zones.

Acceptable environmental conditions for the installation site:

- **Accepted temperature:** from 5°C to +40°C with the average temperature not exceeding 35 °C over a period of 24 hours.
- **Accepted relative humidity:** from 50% at a temperature of 40 °C up to 90% at a temperature of 20 °C.

NOTE The temperatures limits have been established taking into account the electrical equipment of the machine.

5.6 Preparation for start-up

Connections

NOTE Customer must provide electric and pneumatic sources of energy so to ease the connections.

Electrical connections

The machine has a unique external electric power supply point in the control box.

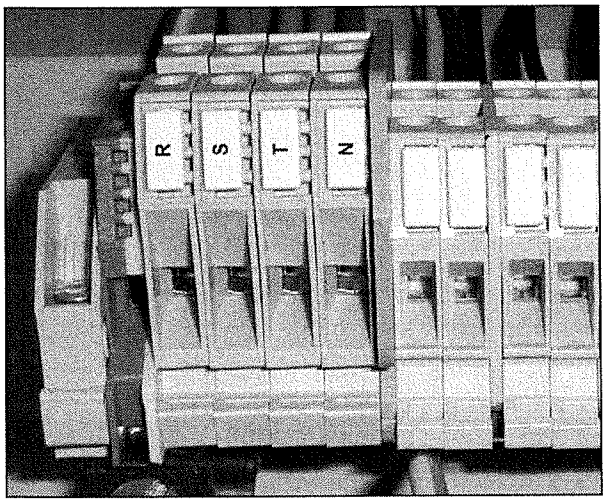
The machine has one terminal only (PE) for the external connection of the earthing installation.

DANGER Check the electric distribution line to be proportioned to the machine power installed.

Risks of electric nature. Before any other connection to the electric distribution line connect the earthing installation .

1. Use a knife switch ahead of the machine connection to the power supply of the plant. The knife switch must have a handle 0,6 - 1,9m high from ground level. The maximum height of 1,7 m would be preferable. The handle must be red on a yellow background.
2. Check the external power supply to be sectionned.
3. Turn the cut-out switch (IG) on the control panel to the **O** position (see *Cut-out switch* on page 37).
4. Open the door of the electric panel.
5. Insert the wire in the special fairlead of the electric box.
6. Make the three power wires harness to their relevant terminal R, S, T, N (A) and of the earth wire to the PE terminal (B).
7. Fix to the electric box side wall the raceway and place it so that the beam can move without any problem. Fix the chain to the special support.
8. Insert the supply cable being careful not to tighten it too much.
9. Connect it to the pull box using the necessary precautions.

Fig. 5.3 Electrical connections



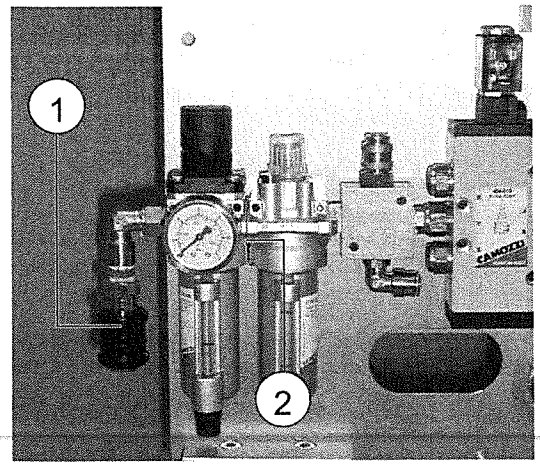
Pneumatic connections

The machine has got a unique pneumatic external point of supply.

1. Connect the pnuematic supply tube to the special point (1) see *Fig. 5.4 Pneumatic connection* on page 44,
2. Set the manometer (2) *Fig. 5.4 Pneumatic connection* on page 44 to 6 atm of pressure.

DANGER Check the pneumatic distribution line to be proportioned to the machine power installed.

Fig. 5.4 Pneumatic connection



5.7 Testing

Before delivery the machine is tested at NEW.MA s.r.l. Unipersonale works where the following operations are carried out::

- General setting of the machine, of the ancillary equipments and of the safety protections provided.
- Running tests to check the effected settings (such as engines correct exchange, pneumatic circuit seal, efficacy of the safety devices and limit switches).
- Trial cycles performed under safety conditions.

Chapter 6 *Use*

NOTE When reading this chapter refer to the pictures of the control panels given in *Chapter 4 Operator interface* .

6.1 Qualifications of operator

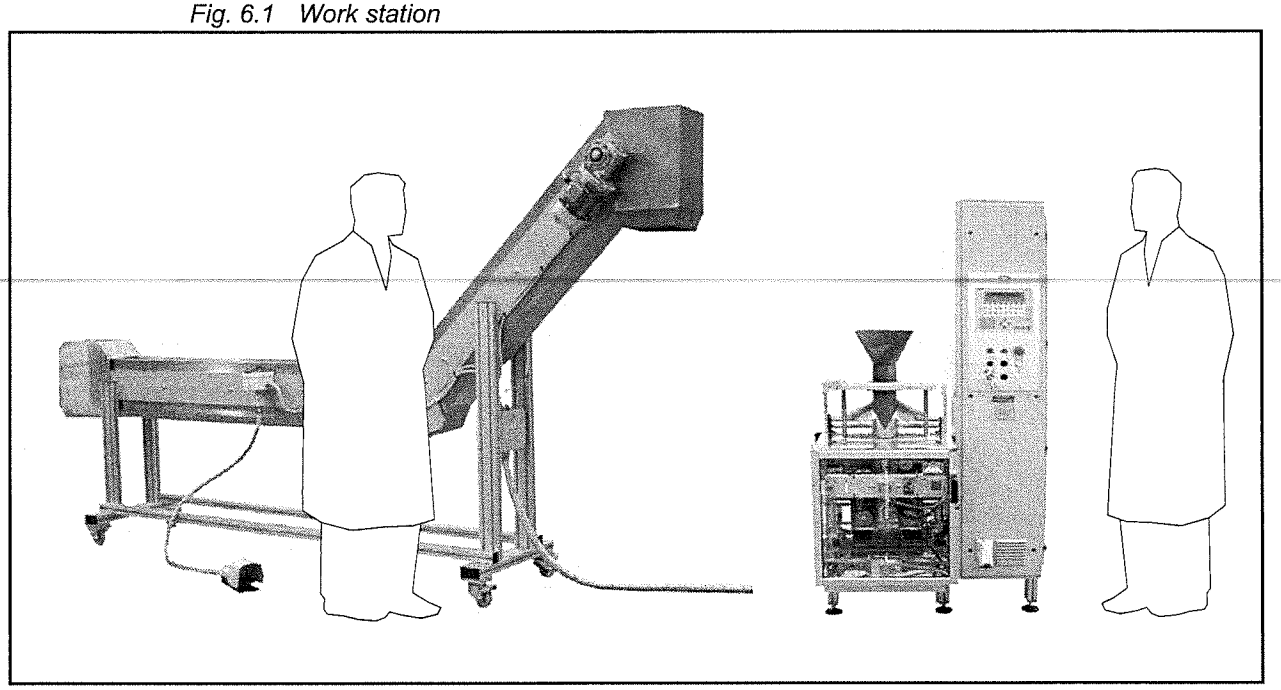
The machine should be operated only by trained, qualified and authorised personnel who have read and understood the information contained in this manual.

6.2 Work station

In *Fig. 6.1 Work station* shows the working positions in which the operator can operate the machine safely.

NOTE During the machine running there must be no admittance to the work station.

Fig. 6.1 Work station



6.3 Operating modes

- **Manual:**
  When this mode is selected the machine performs one working cycle only and then stops to the starting position or in phase. This condition is signaled by a flashing green light.
- **Automatic:**
  Once pushed the start button (*Fig. 4.1 Control panel* on page 35) the machine will perform several working cycles and won't stop till the stop button is pushed /*Fig. 4.1 Control panel* on page 35). This condition is signaled by a fix green light.

6.4 Equipment, setting and setup

Warnings for the settings

1. Any setting intervention, to control or clean must be made with the machine stopped and electric box switched off. The cut-out switch must be to the **O** position and padlocked. The pneumatic exclusion valve must be closed.

NOTE **Any operation effected with the electric installation alive can cause serious injuries to people.**

2. Be careful to those parts of the machine which are in movement.
3. Select the start buttons with particular caution and only after checking that there will be no danger for people or things.
4. In case of remove of the safeguards or other protecting barriers, ensure their correct refresh afterwards.
5. Any setting to be made when safety devices are desactivated or safeguards removed must be accomplished by one person only, during this operation it is necessary to forbid the admittance to the machine to not authorized persons.
6. Do not lean tools or other objects onto the machine while this is running or stopped.

6.5 Starting

Starting procedure:

- Ensure that there is no hindrance to the machine starting.
- Turn the cut-out switch, see *Fig. 4.3 Cut-out switch* on page 37 to **I** position.
- Select the suitable programme from the PLC.
- Select the operating mode, automatic or manual.
- Push start.

6.6 Emergency stop

To stop the machine in an emergency, press the EMERGENCY button (3) (*Control panel* on page 35).

- The machine stopsa.
- The mushroom-head button will remain blocked.

NOTE The emergency button controls the power supply of the moving parts only. The general power supply of the machine is therefore excluded. For any maintenance or intervention turn off the power from the cut-out switch (IG) placed on the electric panel door.

6.7 Switching off the machine

To switch the machine off:

1. Select the stop button *Fig. 4.1 Control panel* on page 35.
2. Turn the cut-out switch to the **O** position (IG) *Fig. 4.3 Cut-out switch* on page 37 and lock it.
3. Close the compressed air supply circuit by turning clockwise the handle placed on the filter group.

NOTE Always clean the machine and the working area at the end of the working cycle.

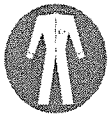
Chapter 7 *Maintenance*

BEWARE For the machine maintenance and the parts replacement, see the drawings at the paragraph (*3.2 Description of the machine groups* on page 20)

7.1 Hazardous areas and residual risks during the maintenance

BEWARE Here to follow are mentioned the PSE of ordinary use.
In the manual, from time to time the proper P.S.E. to be used is specified so to avoid any of the residual risks likely to happen during transportation, use and machine's maintenance.

Protective gloves must be worn.



Protective overalls must be worn.

Area with the horizontal bar equipped with cutting device. These are the risks to be mentioned:

- Cutting hazard for the operator.
- Tearing and abrasion hazard.

The following PSE must be used by the operator:

- Protective gloves.

NOTE The emergency button controls the machine general power supply only. For any maintenance or intervention turn off the power from the cut-out switch (1) placed on the electric panel door.

DANGER Electric shock hazards and untimely movements during the maintenance.

Isolate the machine from the power and pneumatic suppy sources .

Dissipate and/or check the residual energies (see *Chapter 6 Use*).

7.2 Routine maintenance

Any operation that can be carried out by the user is considered routine maintenance. It includes operations of cleaning, inspection and prevention carried out to ensure safe operation of the machine.

Qualifications of operator

To carry routine maintenance safely, the user should first read carefully and understand the instructions and recommendations given in this section.

Cleaning

DANGER Effect the operations of cleaning only with the machine switched off and sectioned from the power and pneumatic supply sources.

Regular cleaning of your machine will ensure its good working order. We recommend the following:

- Clean the machine at the end of each shift.
- The cleaning of the machine keeps the most delicate parts in good working order and helps to spot any loosening of parts and any abnormal wear and tear.

BEWARE Do not use jets of water to clean the control panels and the electric control box.

Suitable cleaning tools and products

Cleaning methods

WARNING It is forbidden to use solvents which might damage the varnished surfaces and synthetic materials present in the machine. Above all it is forbidden to use petrol, nitro - perchlorate thinners and tricloroethane.

Part to be clean	Methods and tools
Varnished steel parts	Clean them with water, detergent and a clean cloth. Dry them afterwards with a dry cloth.
Gear-motor	Clean them with water, detergent and a clean cloth. Afterwards clean them with some jets of air compressed.
Control panel	Clean with a dry clean cloth
Electric parts	Use a vacuum cleaner
Slideways	Use water and detergent and rub them with a clean cloth. Add some grease.
Electric box filter	Dry clean the air filter. Clean with air jets

Frequency of cleaning

Frequency	Parts to be cleaned
Weekly	Control panels
Weekly	Control panels
Monthly	Sliding parts of the sealing device
Monthly	Air lubrication
Monthly	Electric parts, lamps check
Monthly	Other parts in movement
Monthly	Air filters

7.3 Planned maintenance

Planned maintenance includes all those operations which can be executed only by authorized persons. These operations are periodic precautionary inspections and interventions to the machine which allow the safety use of the machine.

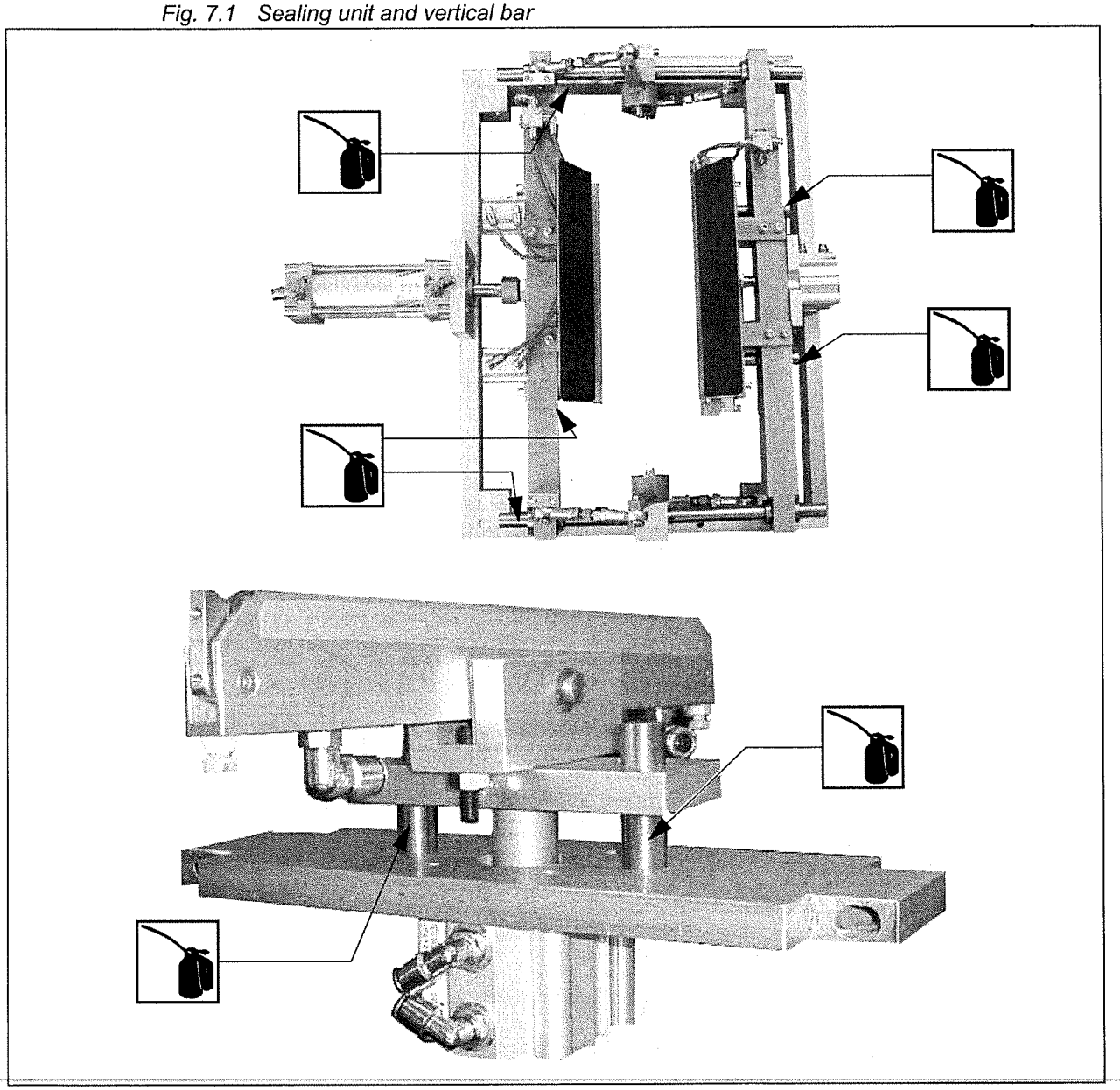
Qualifications of operator

The planned maintenance operations can be executed under safety conditions by specialized personnel only who have been formed and enabled to the use, the preparation and the maintenance. It is necessary that this personnel carefully read and understand the recommandations and instructions given in this section.

Lubrification

The devices mainly in need of lubrication are the sealing unit and the vertical bar, its sliding guides especially, see (*Fig. 7.1 Sealing unit and vertical bar* on page 52).

Fig. 7.1 Sealing unit and vertical bar



Regular inspections

Regular checks and adjustments

Name of parts to be checked and adjusted	Frequency	Method
Interblock devices	Every 40 working hours	Check the correct operating
Emergency stop control	Every 40 working hours	Check the correct operating

Chapter 8 *Machine scrapping*

8.1 Qualifications of operator

Qualified mechanic who has read and understood *Chapter 2 Safety information* e *Chapter 8 Machine scrapping*.

8.2 Disconnecting the machine

At the end of its technical and working life the machine has to be disconnected. Even though de-commissioning has taken place and the machine is no longer suited to the purpose for which it has been designed and built, it must still be possible to re-cycle the raw materials from which the machine was built.

NOTE NEW.MA will not be liable for any damage or injury to persons, animals or things caused by the re-use of individual parts of the machine for operations or assemblies other than those for which they were originally designed.

8.3 Disconnection procedure

DANGER The machine disconnecting and scrapping operations must only be carried out by trained and appropriately equipped personnel.

1. Switch off the machine, as described in *6.7 Switching off the machine* on page 48.
2. Disconnect all the power supplies. The power connections and the instructions for carrying out the operation are the same as described in *Chapter 5 Installation*.
   a. Electric power supply. Disconnect the power supply cable from the terminal board of the electric control box.
   b. Pneumatic power supply. Disconnect the machine from the pneumatic power supply net.
3. Remove the following parts:
   a. Electrical and electronic components
   b. Non-metallic parts and components.

DANGER Consign the oils to the Institution appointed of the exhausted oils disposal.

Electronic components such as batteries, condensators and so on, must be disposed of following the directives of the regulations in force

4. In case of machine handling, see paragraph *5.3 Transport* on page 39.

8.4 Residual risks after machine disconnection

Provided the instructions given in *8.2 Disconnecting the machine* on page 53 have been followed carefully, there are no residual risks after the machine has been disconnected.

BEWARE The materials used for building the machine are non-biodegradable. The machine must therefore be taken to an authorised scrap yard for disposal.

Chapter 9 *Enclosures*

Enclosure 1 Declaration of EC conformity

Enclosure 2 PLC Instructions Manual

Enclosure 3 Wiring diagrams

Enclosure 1

Declaration of EC conformity

(as per Enclosure II.A of the 98/37/EC)

Trade name of the maker
NEW.MA s.r.l. Unipersonale

Address of the maker
via Val d'Aosta
36015 SCHIO (VI)
Italia

DECLARES that the machine

Called: **VERT 560**
Model: VERT560
Serial Number: 910
Year of manufacturing: 2005

It is designed in conformity with the safety basic requirements of the following Directives:

- Machines Directive 98/37/EC
- Low tension Directive 73/23 EC modified by 93/68/EC
- Directive of electromagnetic compatibility 89/336/EC, modified by 92/31/EC (Renamed in Italy as D.Lgs 476 of 4th December 1992)

Other matched rules applied:

- EN 292-1
- EN 292-2
- EN 60204-1

Schio, 31/07/05

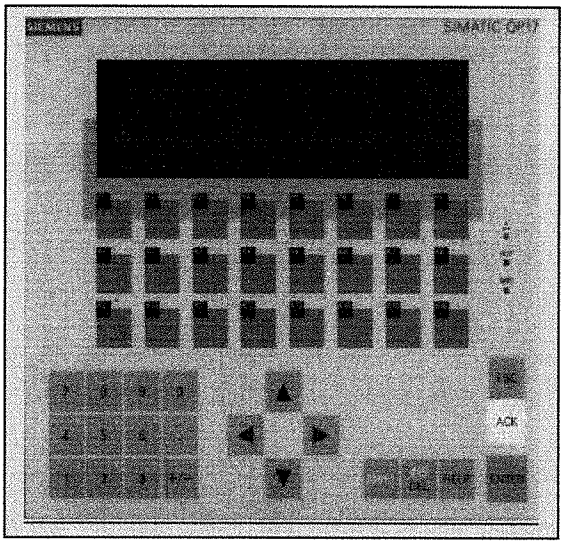
Legal Representative
(Name and surname)

NEW-MA s.r.l.
Via Val d'Aosta, 7/B
36015 SCHIO (VI)
Partita IVA 02029820244
Tel. 0445 575534 - Fax 0445 575489

PLC DESCRIPTION

VERTICAL PACKING MACHINE MODEL VERT 560

KEYS DESCRIPTION



WHEN THE FOLLOWING KEYS WILL BE ACTIVATED, A GREEN LED WILL SWITCH ON

KEY	*FUNCTION OF THE KEYS ON THE CONTROL PANEL*
F1	MAIN MENU
F2	FREE
F3	COUNTERS RESET
F4	ACTIVATE/DEACTIVATE COUNTERS
F5	ACTIVATE FUNCTIONS
F6	ACTIVATE FUNCTIONS
F7	SCROLL UP PAGES (LIKE ARROW KEYS)
F8	SCROLL DOWN PAGES (LIKE ARROW KEYS)
K 1	MANUAL/AUTOMATIC FUNCTIONING
K 2	ACTIVATE / DEACTIVATE COUNTERS
K 3	ACTIVATE / DEACTIVATE WORKING CYCLE
K 4	EMPTY LOADING BELT
K 5	FREE
K 6	ACTIVATE / DEACTIVATE BOX CHANGING SYSTEM
K 7	ACTIVATE / DEACTIVATE MANUAL LOADING TABLE
K 8	RESET WEIGHT CHECKER
K 9	FREE
K 10	FREE
K 11	FREE
K 12	FREE
K 13	FREE
K 14	FREE
K 15	FREE
K 16	FREE

MAIN MENU

*PRESS **F1** TO CHECK THE VARIOUS PAGES OF THE MAIN MENU:*

PAGE	***DESCRIPTION***
01	MAIN MENU
02	BAGS COUNTER
03	BAG LENGTH
04	SEALING PARAMETERS
05	VARIOUS TIME PARAMETERS
06	DISCHARGE, CUT AND LOADING BELT PARAMETERS PRINTER AND UNLOADING BELT
07	WEIGHT CHECKER
08	BOX CHANGING SYSTEM
09	PROGRAMME SELECTION
10	COUNTER 1
11	COUNTER 2
12	COUNTER 3
13	COUNTER 4
14	COUNTER 5
15	COUNTER 6
16	COUNTER 7
17	COUNTER 8
18	COUNTER 9 (FOR FUTURE APPLICATION)
19	COUNTER 10 (FOR FUTURE APPLICATION)
20	COUNTER 11 (FOR FUTURE APPLICATION)
21	COUNTER 12 (FOR FUTURE APPLICATION)
22	DWC
23	MANUAL LOADING STATION
24	DISPLAY
99	

Use the arrow keys to scroll up or down both, all pages inside the main menu and all parameters of those pages.

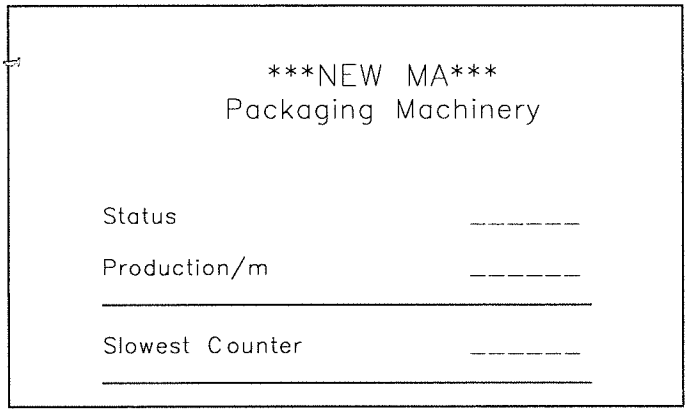
IMPORTANT NOTES:

PRESS THE KEY "HELP" TO VISUALISE A COMPLETE DESCRIPTIONS OF THE VARIOUS FUNCTIONS OF THE KEYS ON THE CONTROL PANEL.

PRESS THE KEY "ACK" TO IGNORE THE CURRENTLY DISPLAYED ALARM, AND RETURN TO THE MAIN MENU TO COMPLETE THE OPERATIONS INTERRUPTED BY THE ALARM ITSELF. THEN PRESS "ESC" TO RETURN TO THE ALARM PREVIOUSLY DISPLAYED.

PRESS THE KEY "*ESC*" TO RETURN TO THE EXISTING ALARM.

MAIN PAGE



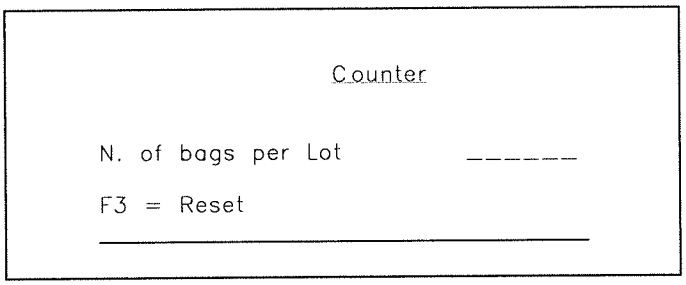
Machine Status Indicates the present working condition of the machine.

Manual	The machine is working in manual mode.
Automatic	The machine is working in automatic mode.
Waiting To Start	The machine is set to work automatically, but it is now waiting to be started.
Waiting For Product	The machine has been switched on and the loading synchronism has been activated, but it is now waiting for the product to be loaded.

Production / m' Number of bags produced in 1 minute.

Last Counter In this section you will be able to see which counter was the slowest one during the last working cycle.

BAGS COUNTER



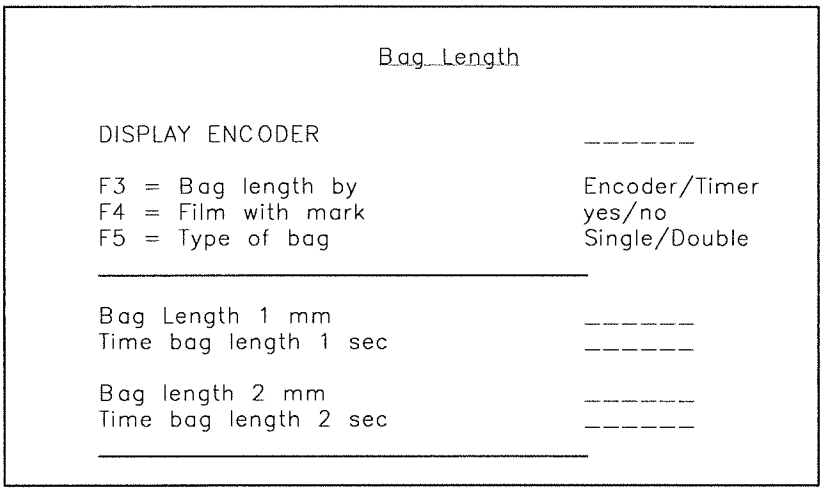
N. of Bags Per Lot

In this parameter you can set the total number of bags you want to produce in each lot. When this quantity will be reached, the machine stops and the display will indicate that the lot production is over.

F3 = RESET

When the machine is working automatically, this parameter shows the number of bags which have been counted so far, as part of the current lot. When the machine is working manually, this function is not activated.

BAG LENGTH



Display Encoder — This function shows the real measure of the last bag produced

F 3 =Bag Length By Timer – Encoder — Press the key **F3** to select how to measure the bag length. The two options are: **Encoder** or **Timer**.

F 4 =Film Mark — Press the key **F4** to measure the bag length by eye-mark detection.

F 5 = Type of bag — Press the key **F5** to choose whether the bag to be produced will be single or double.

Bag Length 1 (mm) — In this parameter you can enter the bag length in millimetres. The real bag length will be shown on the display.

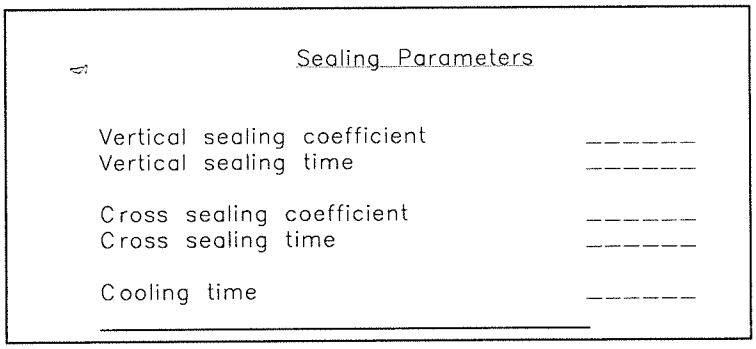
Time Bag Length 1 (Sec) — Enter the time the film should keep unwinding for, in order to reach the length you want the first bag to be.

Bag Length 2 (Mm) — Enter the length of the second bag in millimetres. The real bag length will be shown on the display.

Time Bag Length 2 (Sec) — Enter the time the film should keep unwinding for, in order to reach the length you want the second bag to be.

In order to change the way in which the bag length should be determined, please proceed as follows:
Press the keys F 3 and F 4 to recall the following functions:
ENCODER; EYE MARK DETECTION PHOTOCELL; TIMER.
Press the key **"ENTER" to confirm your selection.**

SEALING PARAMETERS



Vertical Sealing Coefficient — Corrective factor going from "0" to "20", which automatically modifies the sealing time in accordance with the normal pausing times of the machine.

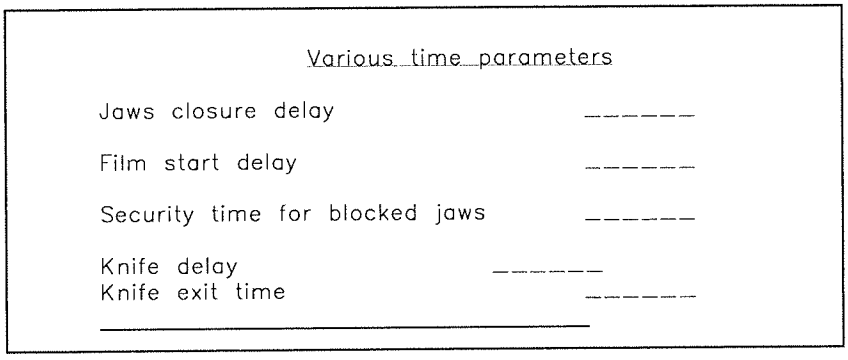
Vertical Sealing Time — Time necessary for the vertical sealing operations to be carried out, when the machine is in normal working conditions.

Cross Sealing Coefficient — Corrective factor going from "0" to "20", which automatically modifies the sealing time in accordance with the normal pausing times of the machine.

Cross Sealing Time — Time necessary for the horizontal sealing operations to be carried out, when the machine is in normal working conditions.

Cooling Time — Determines how long the air blow in the sealing area has to last for, in order to cool down the sealing area

VARIOUS TIME PARAMETERS



Jaws Closure Delay — This is the time the jaws have to wait before they close, in order to let the film settle.

Film Start Delay — This is the time the pulling belts wait before starting to unwind the film.

Security Time for Blocked Jaws

This is to give the film enough time to settle.
Security time set in order to let the jaws close properly. If the jaws are not closed by the end of this time value, the alarm goes off and it pops up on the display. At this point do remove the object between the jaws and reset the alarm.

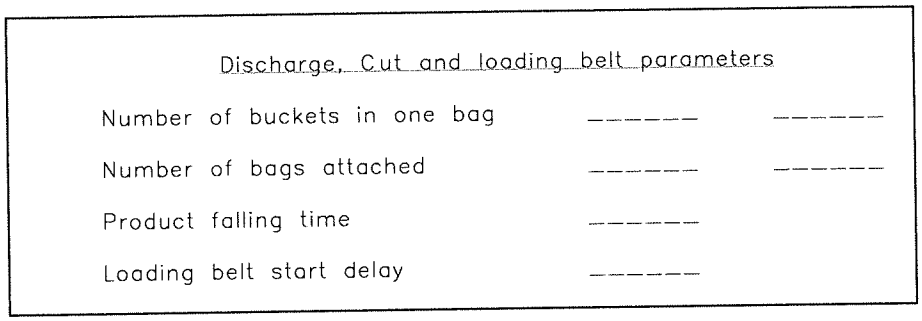
Knife Delay

Determines how long the activation of the cutting knife has been delayed for.

Knife Exit Time

This value indicates the real time in which the knife remains outside its usual housing, to carry out the film cutting process.

DISCHARGE, CUT AND LOADING BELT PARAMETERS



Number of discharges In One Bag

Set on the first variable section of this parameter how many times you want to discharge the set quantity of product inside the same bag. You can discharge up to a maximum of 9 buckets inside the same bag.
In the second variable you will see how many discharges have been made so far.

Multibags Attached

Set on the first variable section of this parameter how many bags you want to produce at once, before you cut the film. You can make up to 99 multi-bags attached.
In the second variable line you will see how bags attached have been made so far

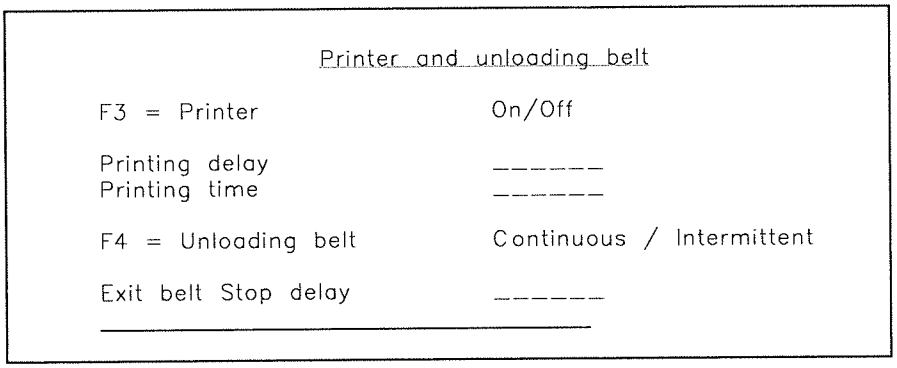
Product Falling Time

Time necessary for the product to fall from the buckets to the jaws. During all of this time the jaws remain closed.

Loading Belt Start Delay

This delay time on the starting process of the belt, starts to be counted once the counters have finished counting the product and have discharged it into the buckets of the conveyor belt.

PRINTER (optional) & UNLOADING BELT



F 3 = Printer — Activate / deactivate printer PRESS THE KEY **F3** TO SWITCH ON / OFF THE PRINTING UNIT

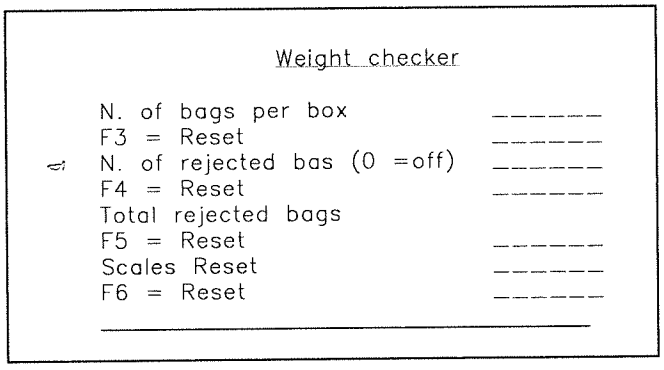
Printing Delay — Once the jaws have closed, the delay time on the printer starts being counted in order to allow the film to settle.

Printing Time — This is the time necessary for the printing signal to reach the printing device.

F 4 = Exit Belt — **CONTINUOUS / INTERMITTENT MOTION**
The exit belt can rotate either intermittently or continuously. This is to be chosen according to product packed.

Exit Belt Stop Delay — With this parameter you can set the time for which you would like the exit conveyor belt to keep rotating.

WEIGHT CHECKER



No. Of Bags per Box — You can choose how many bags you would like to place in a box. Once you have reached this quantity the cylinder will bring forward a new and empty box.

F3= Reset — In this section you will see the exact quantity of bags reached so far.

N. of Rejected Bags

In this parameter you can set the maximum number of bags the machine can reject consecutively before going on alarm. These bags are rejected because their weight is not within the tolerance parameters set beforehand.

F4 = Reset

In this section you will see the exact quantity of bags reached so far.

Total Bags Rejected

This parameter displays the number of bags, which have been consecutively rejected so far.

F5 = Reset

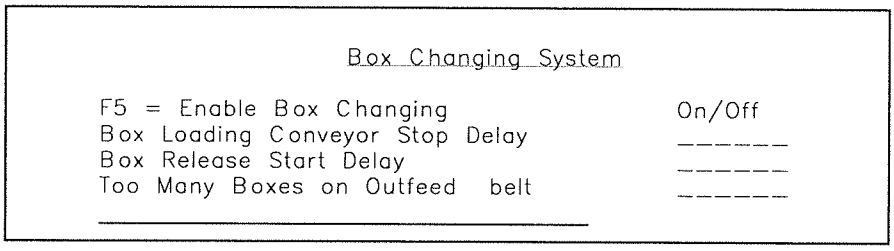
Scales reset (0=Off)

In this parameter you can set a fixed number of bags after which the machine will give you the opportunity to carry out manually the calibration of the weight checker.

F6 = Reset

This parameter displays the number of bags which have been weighed since the last time the weight checker has been reset.

BOX CHANGING SYSTEM



F5 = Enable Box Changing

ON / OFF
Press **F5** to activate/ deactivate the box changing system.

Box Loading Conveyor Stop Delay

In this parameter you should set a delay time on the activation of the infeed belt for empty boxes, this is to allow the boxes to correctly settle in the product loading position.

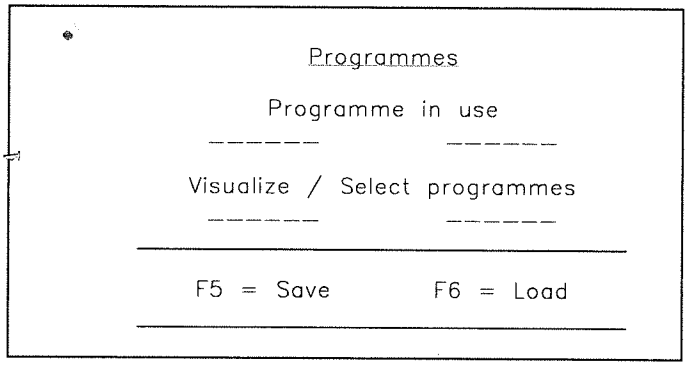
Box Release Start Delay

In this parameter you should set a delay time to be counted before the box leaves the loading positioning, this is to make sure that also the last bag falls into the box.

Too Many boxes on Outfeed belt

In this parameter you should set a delay time on the activation of the alarm which indicates that there are too many boxes on the outfeed belt, and therefore that the operator has to remove some.

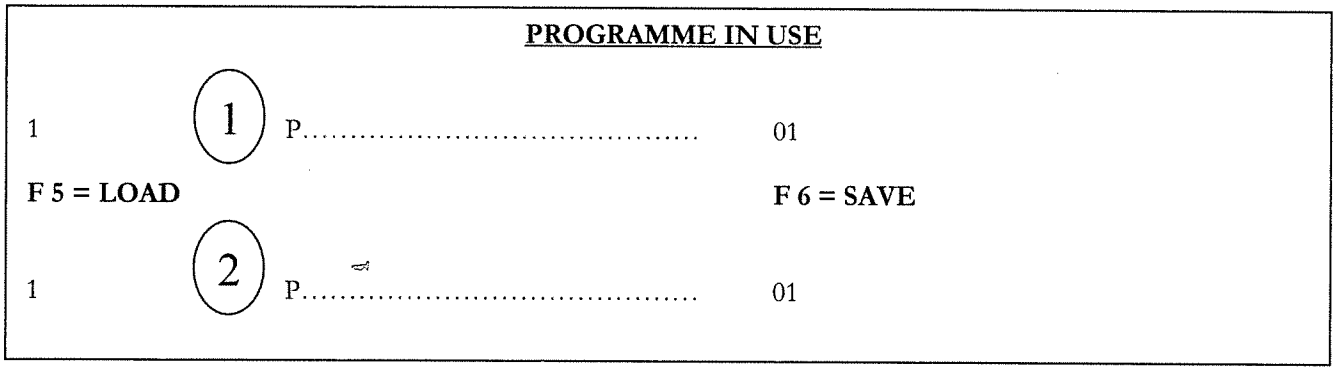
PROGRAMMES



PROGRAMMES

F5 = Load The key F5 allows you to load the settings for a new programme.

F 6 = Save The key F 6 allows you to save the data entered beforehand on the programme and define it with a new name.



In order create *a new programme*;:
first of all modify all of the parameters and settings you require for the new working session (change all parameters relative to quantities, number of items per bags, vibration speed, bag length etc.).

After this, move from the main menu to the "**Programmes**" page and chose an identification code to select this programme in the future. Write this code on the first (**1**) line appearing on the display.

Press **ENTER** to confirm it.

Move down to the second (**2**) line on the display, and select a number /position where you want to save this new programme.

Press **ENTER** to confirm it.

Press **F 6** to save the new programme. Keep it pressed until this writing pops up: *****OK*****
At this point the code entered on line one (1) will move down to line two (2). This is a confirmation of the fact that the new programme has been saved.

If you want to start using this newly saved programme, move with the cursor on line one (1) and press **F5.** Keep it pressed until this writing pops up: *****OK*****
When the code will move from line two (2) up to line one (2) you will have the confirmation that the programme has been loaded.

In order to *select an old programme* saved in the archive:
move from the main menu to the "**Programmes**" page and insert the number / position of the programme you want to use on the second variable line appearing on the screen (2).

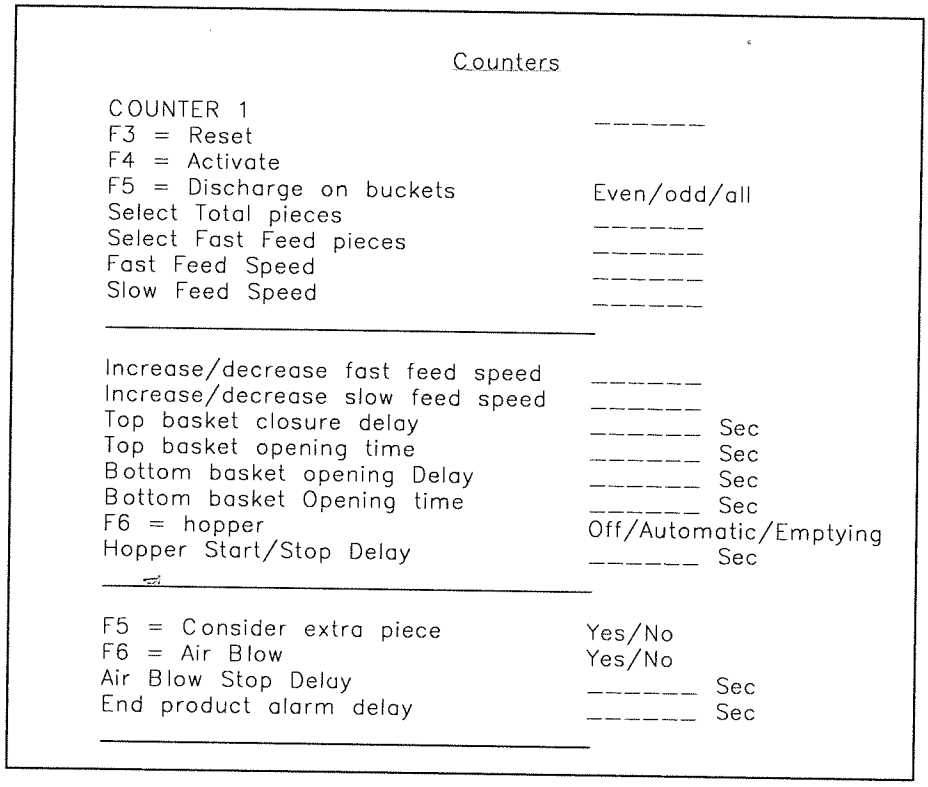
In case you do not remember the exact position in which you saved the programme, scroll down all the programme saved. Once you have made your selection press **"ENTER"** to confirm it.
Then press the key **F 6 i**n order to load the chosen programme.

N.B. To write letters instead of numbers press SHIFT and the number-Keys.

Remember that you can save up to a maximum of **20** programmes.

WARNING! Make sure you *do not use the same code to memorise two different programmes*, otherwise the new one will replace the old one, and the old programme will therefore be cancelled.

COUNTERS



Counters

COUNTER 1	_____
F3 = Reset	
F4 = Activate	
F5 = Discharge on buckets	Even/odd/all
Select Total pieces	_____
Select Fast Feed pieces	_____
Fast Feed Speed	_____
Slow Feed Speed	_____
Increase/decrease fast feed speed	_____
Increase/decrease slow feed speed	_____
Top basket closure delay	_____ Sec
Top basket opening time	_____ Sec
Bottom basket opening Delay	_____ Sec
Bottom basket Opening time	_____ Sec
F6 = hopper	Off/Automatic/Emptying
Hopper Start/Stop Delay	_____ Sec
F5 = Consider extra piece	Yes/No
F6 = Air Blow	Yes/No
Air Blow Stop Delay	_____ Sec
End product alarm delay	_____ Sec

Counter 1 — In this section you will see the quantity of pieces which are progressively counted in the currently selected counter.

F 3 = Reset

F 4 = Enable — **YES / NO**

F 5 = Discharge On Buckets — **EVEN / ODD /ALL**

Select Total Pieces — Select the total number of pieces to be placed in each bag.

Select Fast Feed Pieces — Select the number of pieces to be counted while the vibrator is working at its maximum speed.

Fast Feed Speed — Value from 0 to 900, relative to the speed of the vibrators in the first phase of the counting process, the fast phase.

Slow Feed Speed — Value from 0 to 900, relative to the speed of the vibrator during the final phase of the counting process, the slow phase.

Increase / Decrease Fast Feed Speed

Once you will have set this value on the PLC, you will be able to increase/decrease the speed of the vibrations thanks to the push buttons placed beside the counters.

Increase / Decrease Slow Feed Speed

Once you will have set this value on the PLC, you will be able to increase/decrease the speed of the vibrations thanks to the push buttons placed beside the counters.

Top Basket Closure Delay

This parameter is to prevent any piece of product in excess from falling from the vibrator inside the buckets.

Top Basket Opening Time

Minimum opening time of the upper flap.

Bottom Basket Opening Delay

Delay on the closure of the lower flap in order to allow all of the counted pieces to fall inside the bucket.

Bottom Basket Opening Time

Time the bottom flap remains open in order to allow the pieces to fall inside the buckets on the conveyor belt.

F 6 = Hopper

OFF / AUTOMATIC / EMPTYING

If the emptying function is activated while the counter is not working, you can activate/deactivate the vibrations on the hopper by pressing the increase/decrease buttons placed beside the counters.

Thanks to this function you will be able to unload the product completely.

Hopper Start/Stop Delay

Delay time on the activation / deactivation of the hopper.

F5 = Consider extra piece

ON/OFF

Thanks to this function you can start / stop counting the pieces in excess. If this function will be activated, one possible extra piece in excess will anyway be introduced on the current bag, but in the following bag there would be as many pieces missing as those exceeding in the previews bag. If this function will not be activated, the unload process will be carried out normally.

F6 = Air blow

ON / OFF

Thanks to this function you can activate / deactivate the solenoid valve for the air jet. The air jet system is to simplify the product selection on the vibrators.

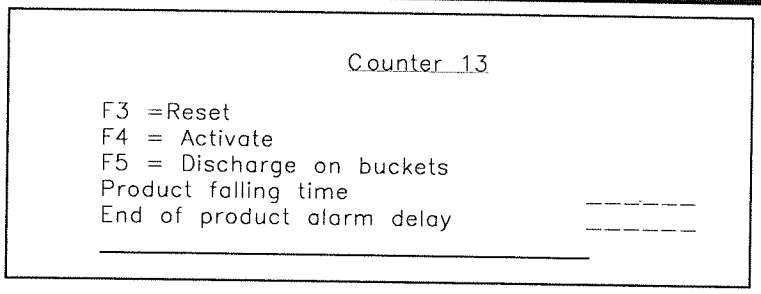
Air Blow Stop Delay

Time the air jet still blows after the counter has been switched off.

End product alarm delay

In this parameter you can enter how long the machine will wait for, after it has detected that there is no product on the counter, .before displaying the alarm.

DWC



F3 = Reset

F4 = Activate

Press the key F4 to activate / deactivate the manual loading station.

F 5 = Discharge on Buckets

EVEN / ODD / ALL
EVEN / ODD: This function allows you to unload the product from the vibrators into every other bucket on the conveyor belt.
ALL: If you select this function the product will be discharged into every single bucket.

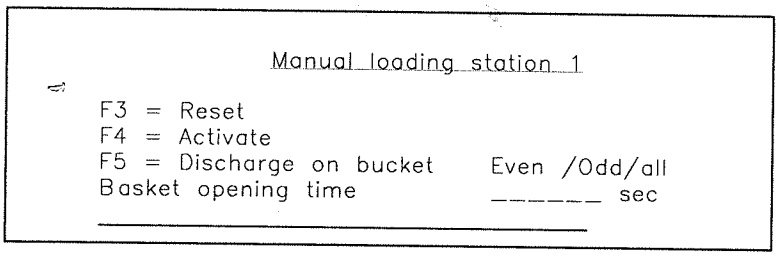
Product Falling Time

Time necessary for the product to fall from the buckets to the jaws. During this time the jaws remain closed.

End product alarm delay

In this parameter you can enter how long the machine will wait for, after it has detected that there is no product on the counter, .before displaying the alarm.

MANUAL LOADING STATION 1



F3 = Reset

F4 = Activate

Press the key F4 to activate / deactivate the manual loading station.

F 5 = Unload on Bucket:

EVEN / ODD / ALL
EVEN / ODD: This function allows you to unload the product from the vibrators into every other bucket on the conveyor belt.
ALL: If you select this function the product will be discharged into every single bucket.

Basket opening time: Time during which the flaps remain open in order to allow the pieces to fall from the table inside the buckets of the conveyor belt.

IF YOU WISH TO LOAD THE PRODUCT MANUALLY YOU MUST ACTIVATE THE MANUAL LOADING STATION FROM THE KEYBOARD AND THEN PRESS THE PEDAL EVERY TIME YOU WANT THE BELT TO MOVE AHEAD.

DISPLAY

In order to change the language used on the display, please follow these instructions:
Press at the same time the keys SHIFT + F3, enter the password "100", press ENTER. Afterwards, press at the same time SHIFT + the arrow keys to chose the language you prefer. Press ENTER to confirm your selection.

LOADING BELT EMPTYING PROCESS

WHENEVER YOU WANT TO EMPTY THE LOADING BELT, PRESS "**STOP**" TO STOP THE MACHINE; WAIT UNTIL THE BUCKETS ON EACH COUNTER ARE COMPLETELY LOADED AND PRESS "**K 4**" TO DEACTIVATE THE COUNTERS.

AS SOON AS THE EMPTYING OPERATIONS ARE OVER, RESET THE ALARM BY PRESSING "**STOP**" AND PRESS **K4** TO ACTIVATE THE COUNTERS.

COUNTERS RESET

IN ORDER TO RESET THE COUNTERS, PLEASE PROCEED AS FOLLOWS:

PRESS "**STOP**" TO STOP THE MACHINE, SELECT THE COUNTER YOU WISH AND PRESS **F 3** TO ACTIVATE THE EMPTYING PROCESS OF THE BUCKETS OF THAT COUNTER. THEN PRESS "START" TO START WORKING AGAIN.

ALARMS

Emergency	Indicates an alarm in the system. Please check whether you have left any of the protections open and whether any of the emergency buttons are pressed. Make also sure that all of the fuses in the electric board are working correctly.
Safety Guards Open	Make sure the key in the control panel is not in the "caution" position.
Sealing Wire Broken	The sealing band might be broken. If this is the case **it must be immediately replaced.** Please check the condition of the fuses inside the electric board too.
Jam on Cross Jaws	Make sure there are no pieces blocked between the jaws
Motors Overloaded	Control the thermic device placed inside the electric panel and check what made it go off
Film Jam Or Encoder failure	This alarm indicates that the film is not being pulled properly because it might be broken or jammed. It could also be that the encoder determining the length of the film to be unwound is not functioning correctly.
No mark on printed film	The ENCODER failed to detect the eye-mark. Check if the position of the tube on the ENCODER is correct and check also if the detector is placed perfectly on the eye-mark.
No Air	Please check the possible lack of air pressure in the system.
End Of Emptying Operation	The product unloading session is over. Please press "**STOP**" and then "**START**" to start again.
End Film	This alarm shows that the film reel is finished. Check if the support of the film reel has been fixed well or if the film-reel has to be replaced.
Box Filling Completed	This alarm indicates that the box filling operations are now over. Press the red button "**STOP**" to start counting again. Press "**-/T**" to reset the count reached at that point; you will then be allowed to start off with a new batch.
Batch Production Completed	The batch has been concluded. In order to start counting again for a new batch, press the red button, "**STOP**". If you want to reset the total amount of bags produced so far, and press "**F3**" to start with a new batch.

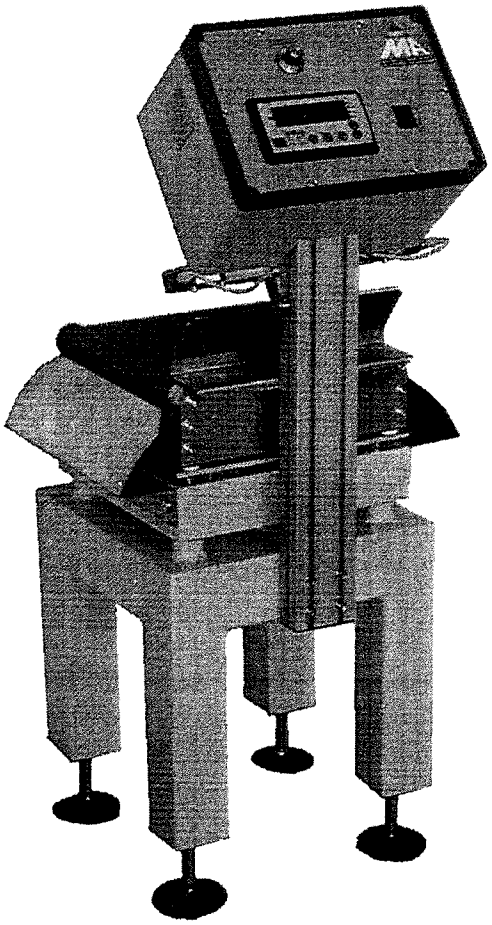
ALARMS

Timeout Cross Jaws Open	This safety time goes from the moment in which the impulse to close the jaws is sent to when the jaws are actually closed. In case the time you had set on the parameter "**Security Time For Blocked Jaws**" is over and the jaws are still not closed, this alarm goes off, since there might be some pieces stuck between the jaws
Printer Alarm	The printer might not be working properly. Please check whether it is working correctly.
Failure Open / Close Manual Station Flap	Control whether the sensor and the cylinder on the basket are working properly (there might be some pieces stuck in the bucket)
Waiting For Manual Station Discharge	When the manual loading system is activated this alarm indicates that the machine is waiting for the operator to press the pedal and let the bucket conveyor move on
Failure Open / Close Top Flap on Counter 1-4	Please control whether the sensors and the cylinders on the upper flap are working properly, because there might be some pieces stuck in that position
Failure Open / Close Bottom Flap on Counter 1-4	Please control whether the sensors and the cylinders on the lower flap are working properly, because there might be some pieces stuck in that position
Failure Photocell on Counter 1-4	This alarm indicates the possible presence of pieces jammed or dust before the photocell reading area.
No Product On Counter 1-4	If the photocell on the counter does not detect any product for a period longer than 1 minute, both, the machine and the counter will stop working. Press "**STOP**" and then "**START**" to reset the alarm.

TO RESET ANY OF THESE ALARMS PRESS "**STOP**" AND THEN PRESS "**START**" TO RESTART.

Packaging Machinery Specialists

WEIGHT CHECKER CPV30



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I - 36015 Schio (VI)
Tel. +39 0445/575534 Fax. +39 0445/575489
Web : www.newma.it
e-mail: info@newma.it

GENERAL NOTES

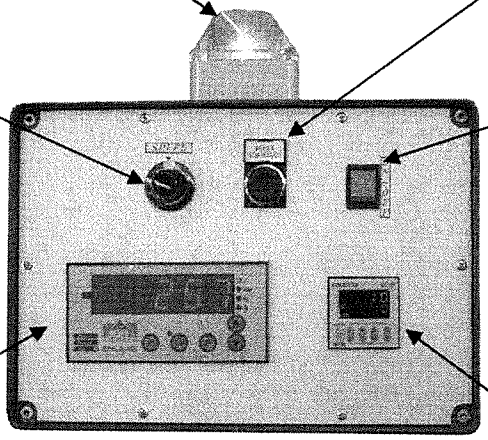
The weight checker model CPV 30 special version, with additional counting system as an option, directed to checking the weight of finished bags and counting them.

KEYS DESCRIPTION

VISUAL SIGNAL (optional)
Allows you to quickly notice that the set batch of correct bags has been reached.

RESET COUNTING: (optional)
Allows you to reset the counting of all bags which have been counted so far.

POTENTIOMETER:
Allows you to modify the belt rotation speed.

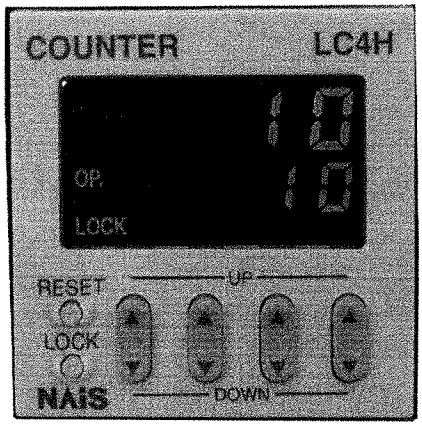


SWITCH ON / OFF:
Press this button to switch on/off the weight checker.

KEYPAD 1:
Allows you to set the weight tolerance and to calibrate the weight checker .Please check page 4 and 5 for a more detailed description.

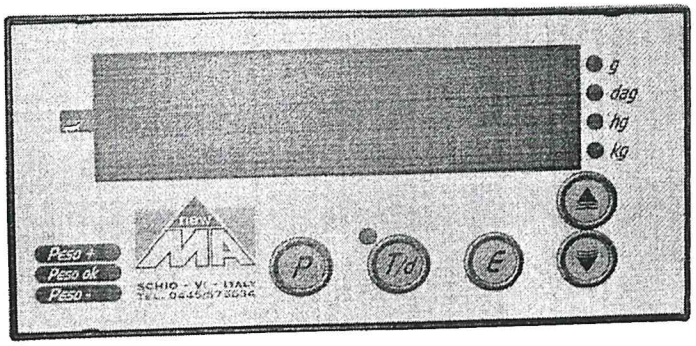
KEYPAD 2: (optional)
Allows you to set the total number of correct bags to be counted and to display the quantity of correct bags produced so far. Please check page 3 for a more detailed description.

KEYPAD 2: *COUNTING SYSTEM (optional)*



USE THE KEYS *UP/ DOWN* to select the number of correct bags which you wish to produce.
This quantity will be shown on the *lower part of the display*.
In the *upper part of the display* you will see the real quantity of bags, with the correct weight, which have been counted so far.
Once the total quantity set has been reached, the light on top of the control panel will switch on.
Then you can press the black "Count Reset" button and restart with a anew batch.

WEIGHTS AND TOLERANCE SETTINGS



PRESS KEY "P" + "E"

DISPLAY: "SET"

PRESS KEY "E"

DISPLAY: "0,000"

PRESS "TD" TO MOVE THE CURSOR

ARROW KEYS TO:	
INCREASE	⇧
DECREASE	⇩

PRESS KEY "E"

DISPLAYS: "TOL 1". THIS IS THE TOLERANCE 1 = + (OVER)

PRESS"E"

DISPLAY: "0,000"

ARROW KEYS TO:	
INCREASE	⇧
DECREASE	⇩

PRESS KEY "TD" TO MOVE THE CURSOR

PRESS KEY "E"

DISPLAY: "TOL 2". THIS IS THE TOLERANCE - = (UNDER.

PRESS KEY "E"

DISPLAY: "0,000"

ARROW KEYS TO:	
INCREASE	⇧
DECREASE	⇩

PRESS KEY "TD" TO MOVE THE CURSOR

PRESS KEY "E"

DISPLAY: "T1"
Delay time on the activation of the weight control sysytem from the photocell detecting the passage of the bag

PRESS KEY "E"

DISPLAY: "0,0"

ARROW KEYS TO:	
INCREASE	⇧
DECREASE	⇩

PRESS KEY "E"

DISPLAY: "T2"
Time for the Weight Control

PRESS KEY "E"

DISPLAY: "0,0"

ARROW KEYS TO:	
INCREASE	⇧
DECREASE	⇩

PRESS KEY "E"

DISPLAY: "T3"
Time required by the belt to remove the product from the weighing system

PRESS KEY "E"

DISPLAY "0,0"

ARROW KEYS TO:	
INCREASE	⇧
DECREASE	⇩

PRESS KEY "E"

DISPLAY: "T4"
Time required to reset the weight control system

PRESS KEY "E"

DISPLAY: "0,0"

ARROW KEYS TO:	
INCREASE	⇧
DECREASE	⇩

PRESS KEY "E"

DISPLAY:
"C. AUT. 0"
Number of weight controls to be carried out before resetting

PRESS KEY "E"

DISPLAY: "000"

PRESS KEY "E"

IF YOU PRESS AGAIN "E"

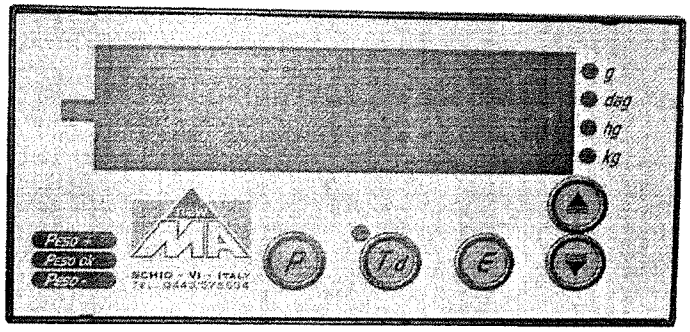
DISPLAY: "HOL"

0 =	*set the display on dynamic weighing, so that the weight value will progressively increase while it is being checked*
1 =	*The display shows the weight after having checked it*

PRESS KEY "E"

EXIT THE PROGRAMME

ACTIVATION OF THE WEIGHING PROCESS WITH NO PHOTOCELL



In order to activate the weight checker while keeping the photocell excluded, please proceed as follows:

PRESS ⇧

S.P. 0 WILL APPEAR

= WEIGHING THRESHOLD: 0

0=

SET UP THE WEIGHT CHECKER IN ORDER TO CARRY OUT THE WEIGHING PROCESS WHEN THE BAG FALLS ON THE BELT, WITH NO INTERVENTION OF THE PHOTOCELL

= WEIGHING THRESHOLD: 1

1=

SET UP THE WEIGHT CKECKER IN ORDER TO CARRY OUT THE WEIGHING PROCESS AFTER EXTERNAL SIGNAL **"START"**

PRESS ⇩

TO ENTER THIS FUNCTION

P. ST. = PESATA DI START

PRESS "E"

"00000" WILL APPEAR

THIS IS THE PARAMETER ON WHICH YOU MUST SET THE "START WEIGHING" DETECTION THRESHOLD

PRESS "E"

TO CONFIRM THAT VALUE

"T5" WILL APPEAR

PRESS "E"

ON THIS PARAMETER YOU MUST SET THE DELAY TIME ON THE START OF THE NEXT WEIGHING PROCESS PRESS "E" TO CONFIRM

N.B. In order to set a weight sample, you must press the upwards arrow key on position "1", meaning "start" after external signal

WIRING DIAGRAMS

VERTICAL PACKING MACHINE
MODEL VERT 560

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

WIRING DIAGRAMS

VERTICAL

PACKING MACHINE

WITH 9 COUNTERS + PREDISPOSITION FOR 2 FUTURE COUNTERS

230 Vac 60 Hz
3PH+N

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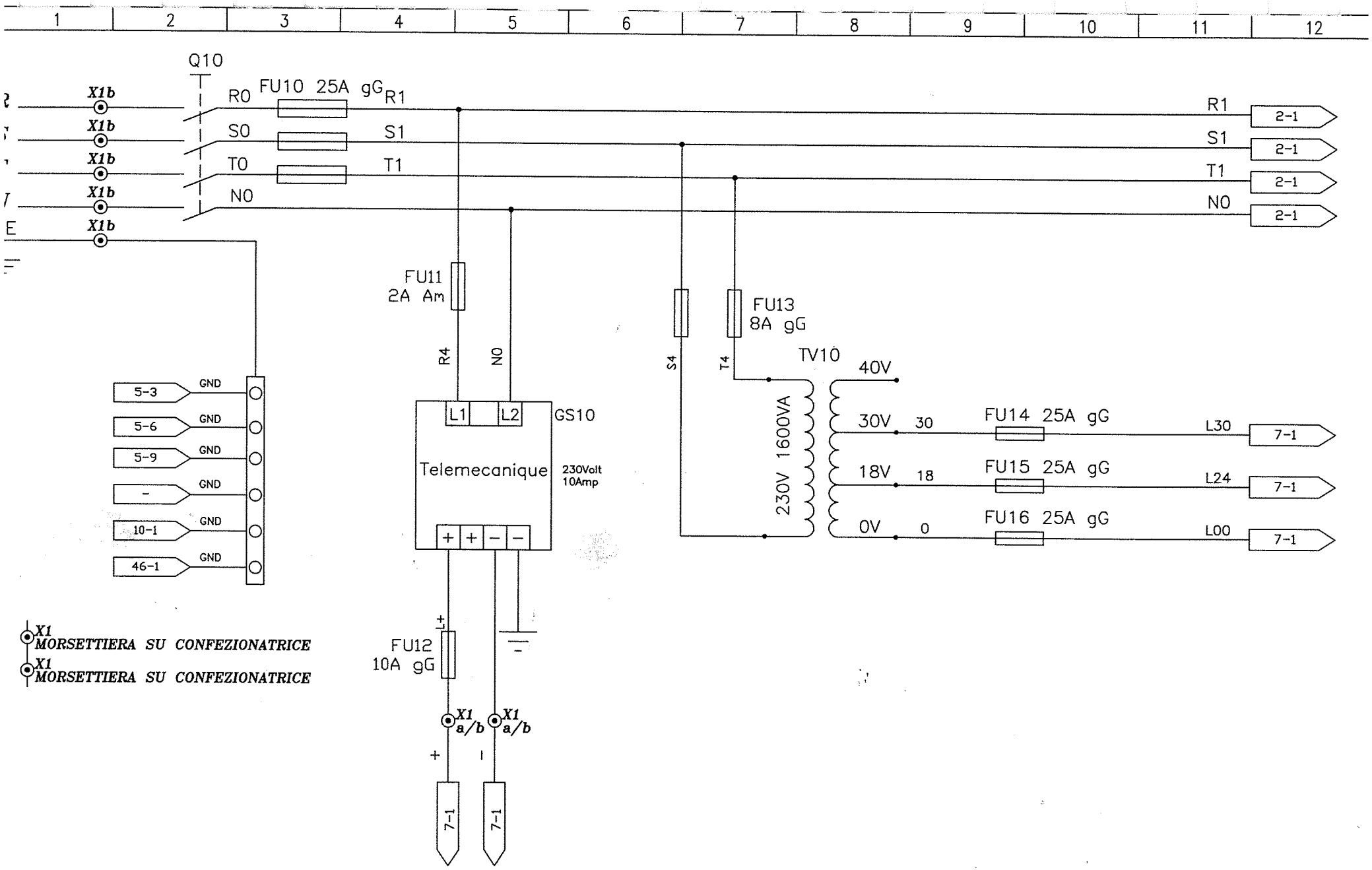
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	0 / 1
Gruppo	**Esec.**	**Data**	**Dis. N°**
	C.f.	23/05/2005	910



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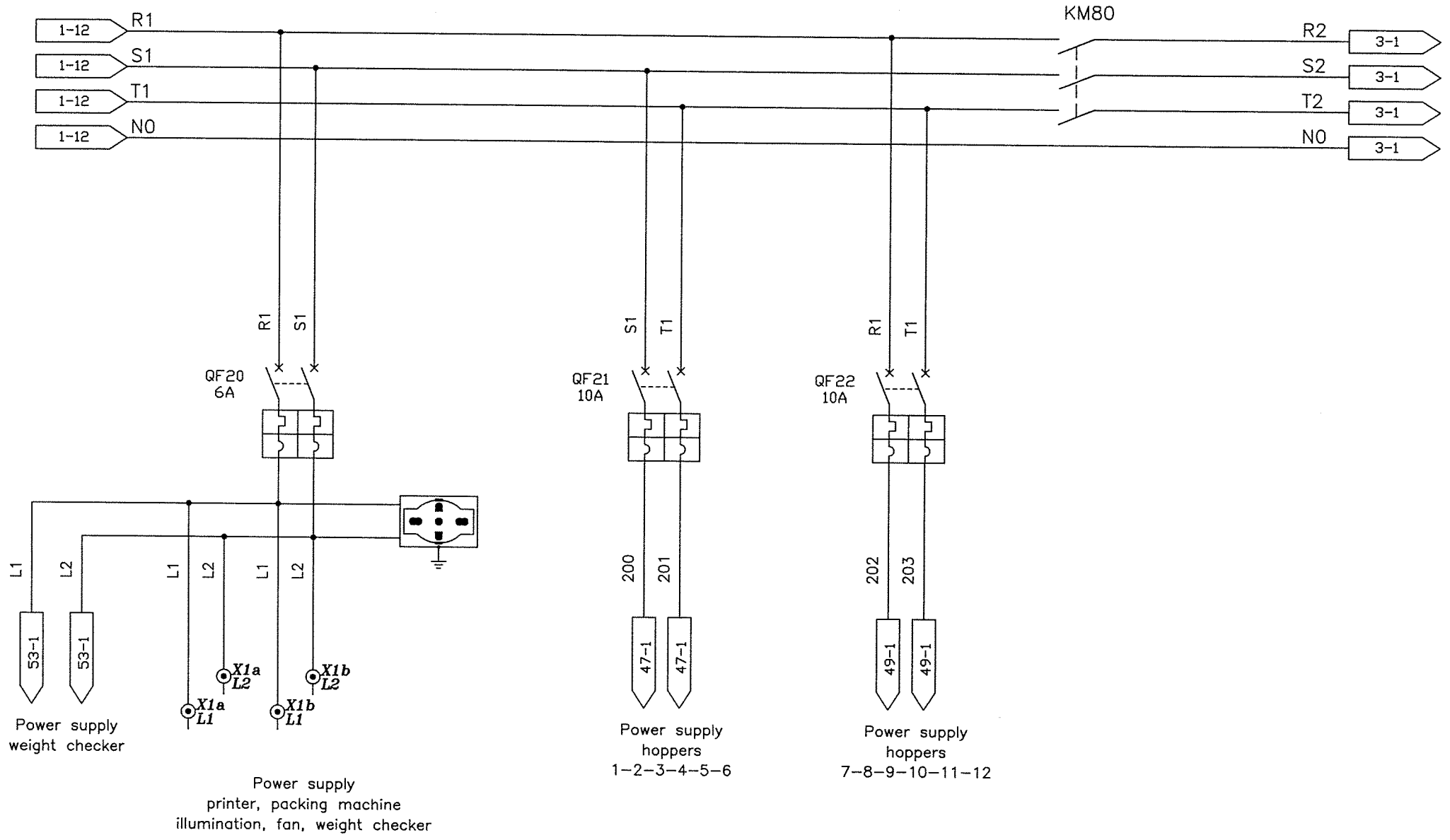
	Gruppo: *ALIMENTAZIONI*	Esec.: *C.J.*	Data: *23/05/2005*	Dis. N°: 910



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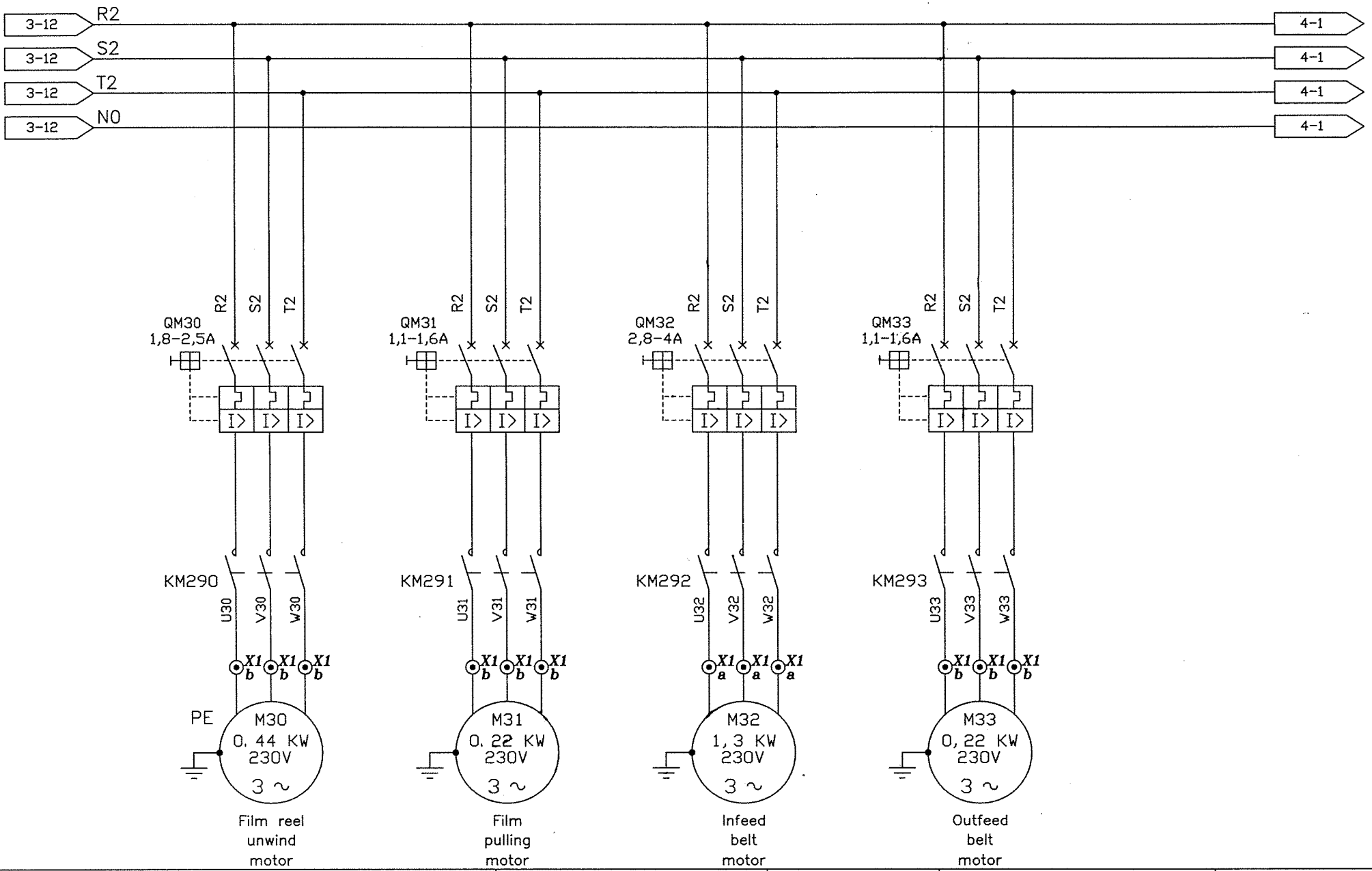
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	2 / 3
Gruppo	**Esec.**	**Data**	**Dis. N°**
ALIMENTAZIONI	C.f.	23/05/2005	910



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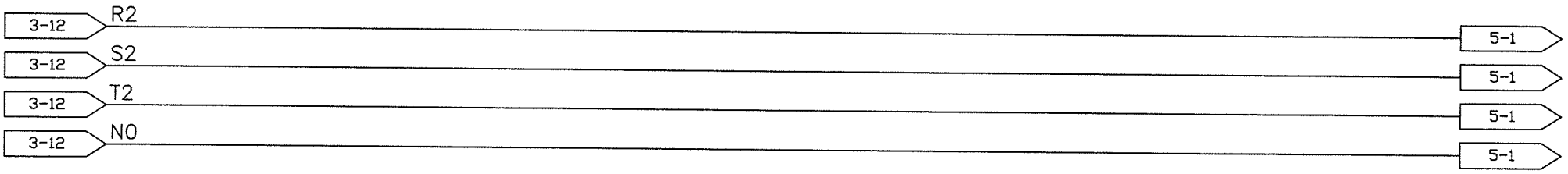
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*3 / 4*
Gruppo	**Esec.**	**Data**	**Dis. N°**
POTENZA	*C.f.*	*23/05/2005*	910

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



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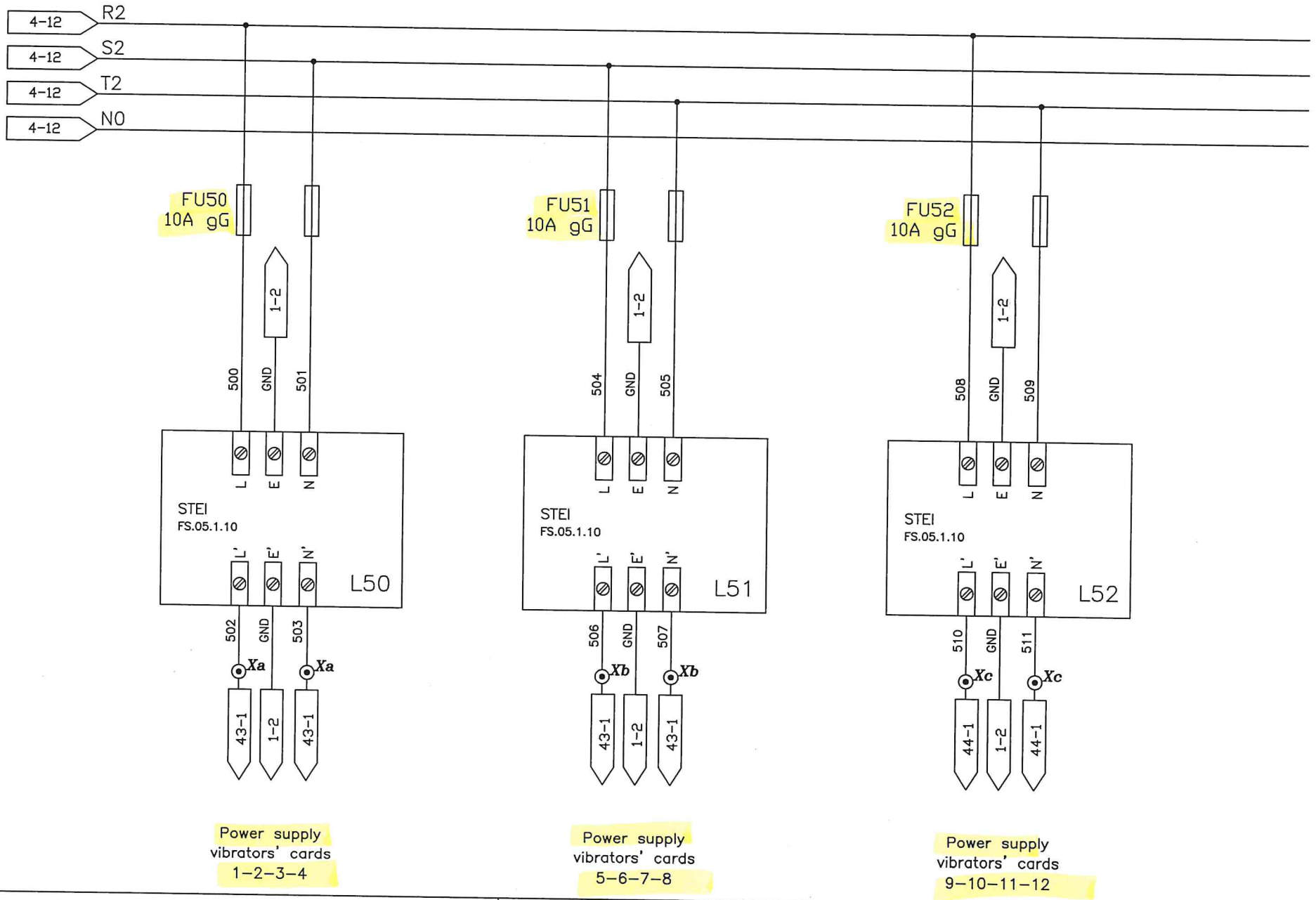
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*4 / 5*
Gruppo	**Esec.**	**Data**	**Dis. N°**
POTENZA	*C.f.*	*23/05/2005*	*910*



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Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	5 / 6
Gruppo	**Esec.**	**Data**	**Dis. N°**
ALIMENTAZIONI	C.f.	23/05/2005	910

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

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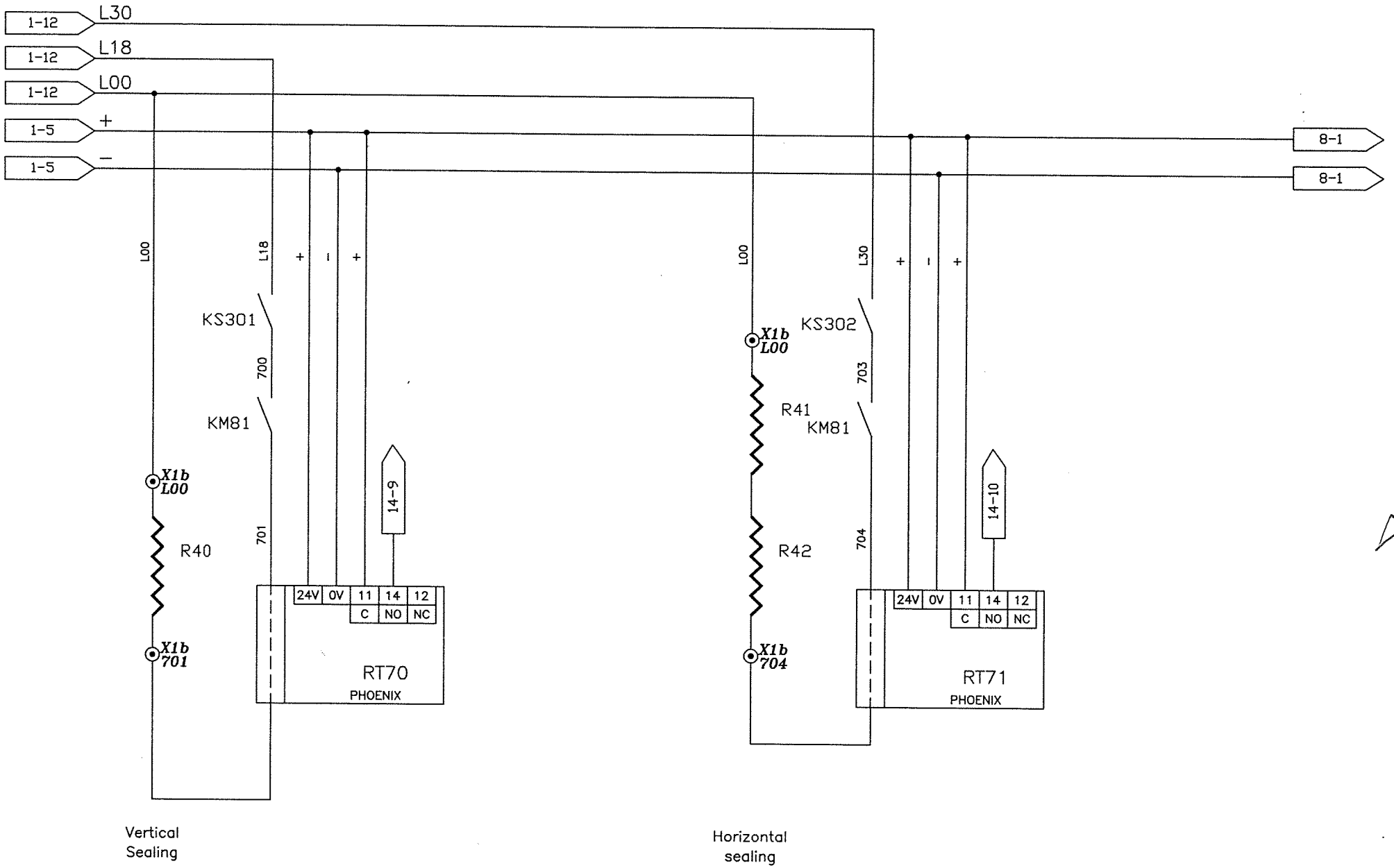
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*6 / 7*
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	*C.f.*	*23/05/2005*	*910*



Vertical Sealing

Horizontal sealing

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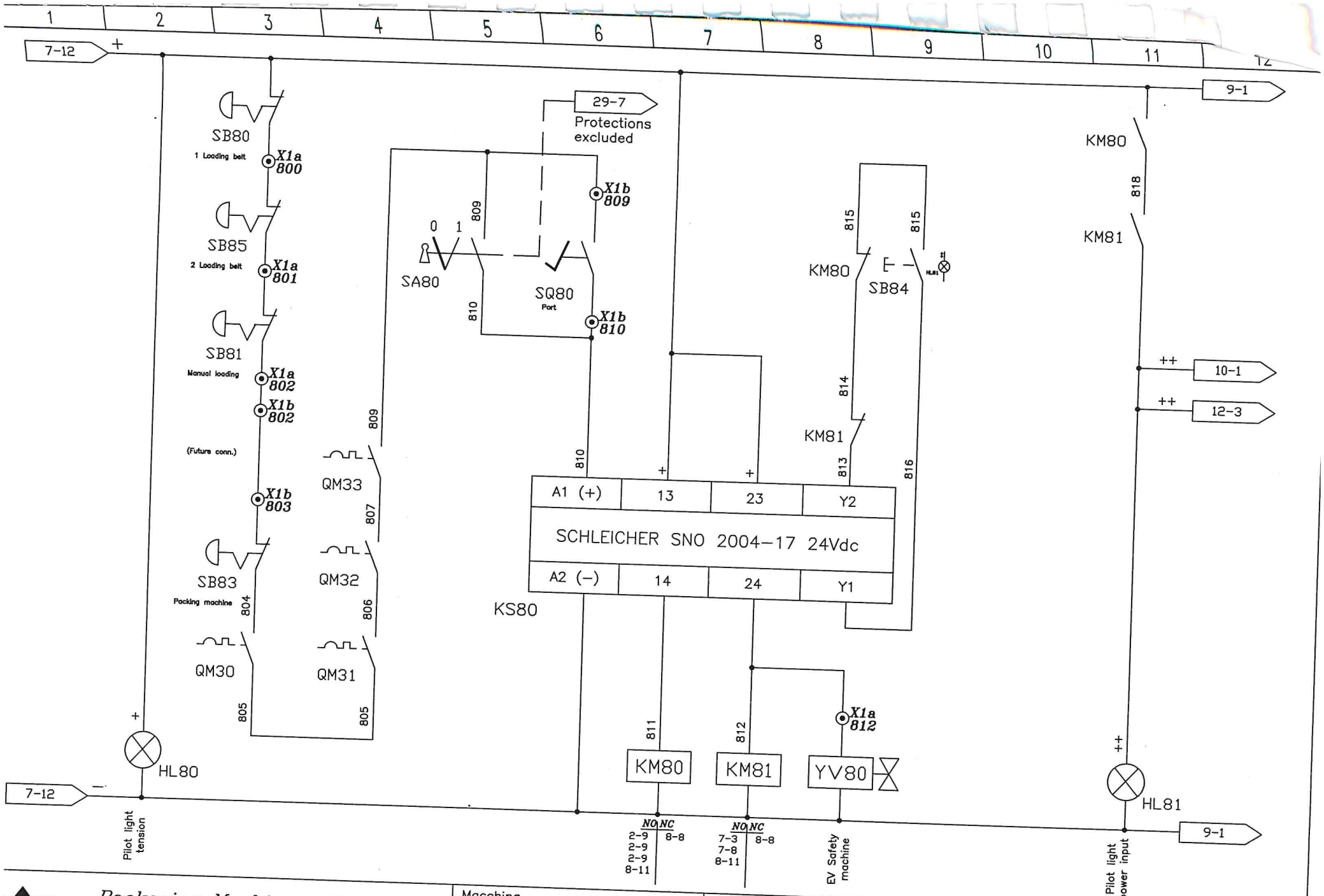
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*7 / 8*
Gruppo	**Esec.**	**Data**	**Dis. N°**
CONTROLLO SALDATURE	*C.f.*	*23/05/2005*	910



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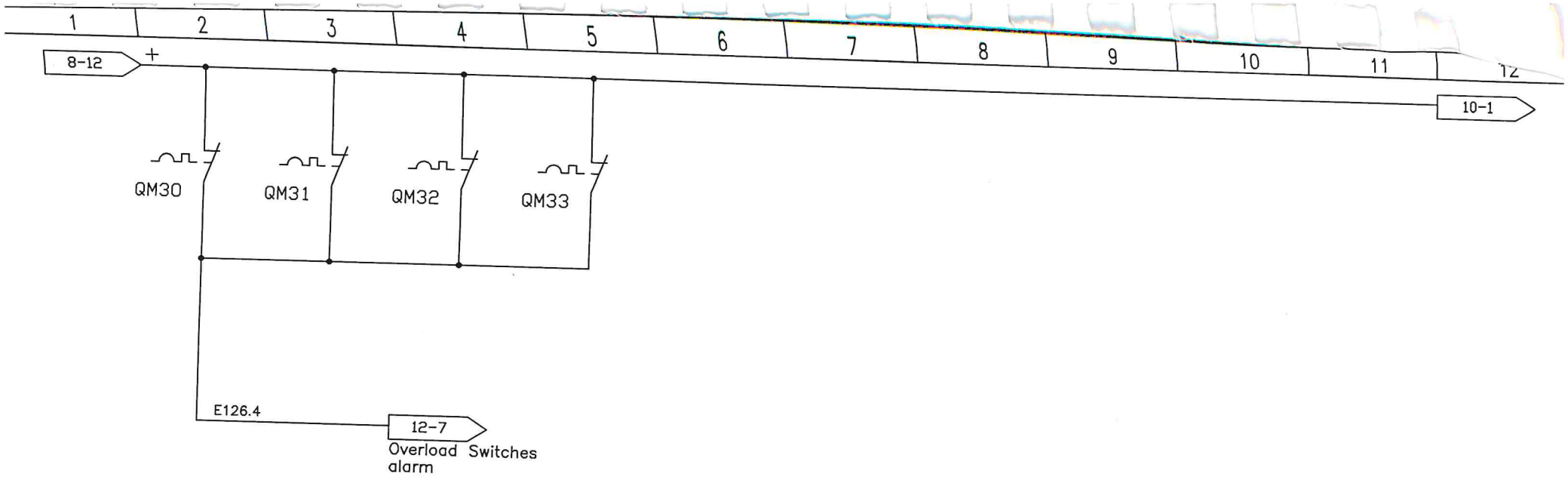
	Gruppo: *EMERGENZE*	Esec.: *C.f.*	Data: *23/05/2005*	Dis. N°: *910*



8-12 −

10-1

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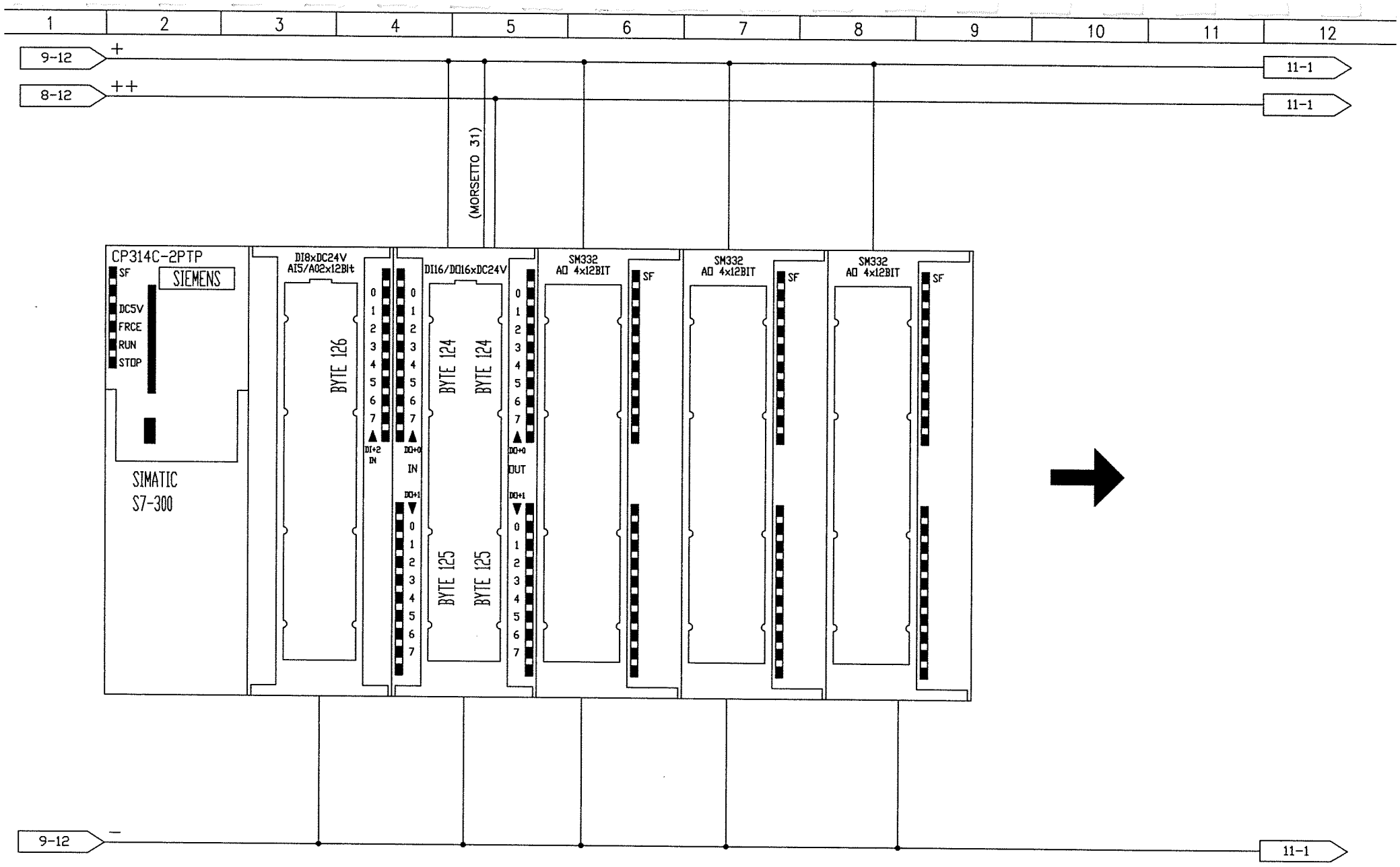
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	9 / 10
Gruppo	**Esec.**	**Data**	**Dis. N°**
EMERGENZE	C.f.	23/05/2005	910



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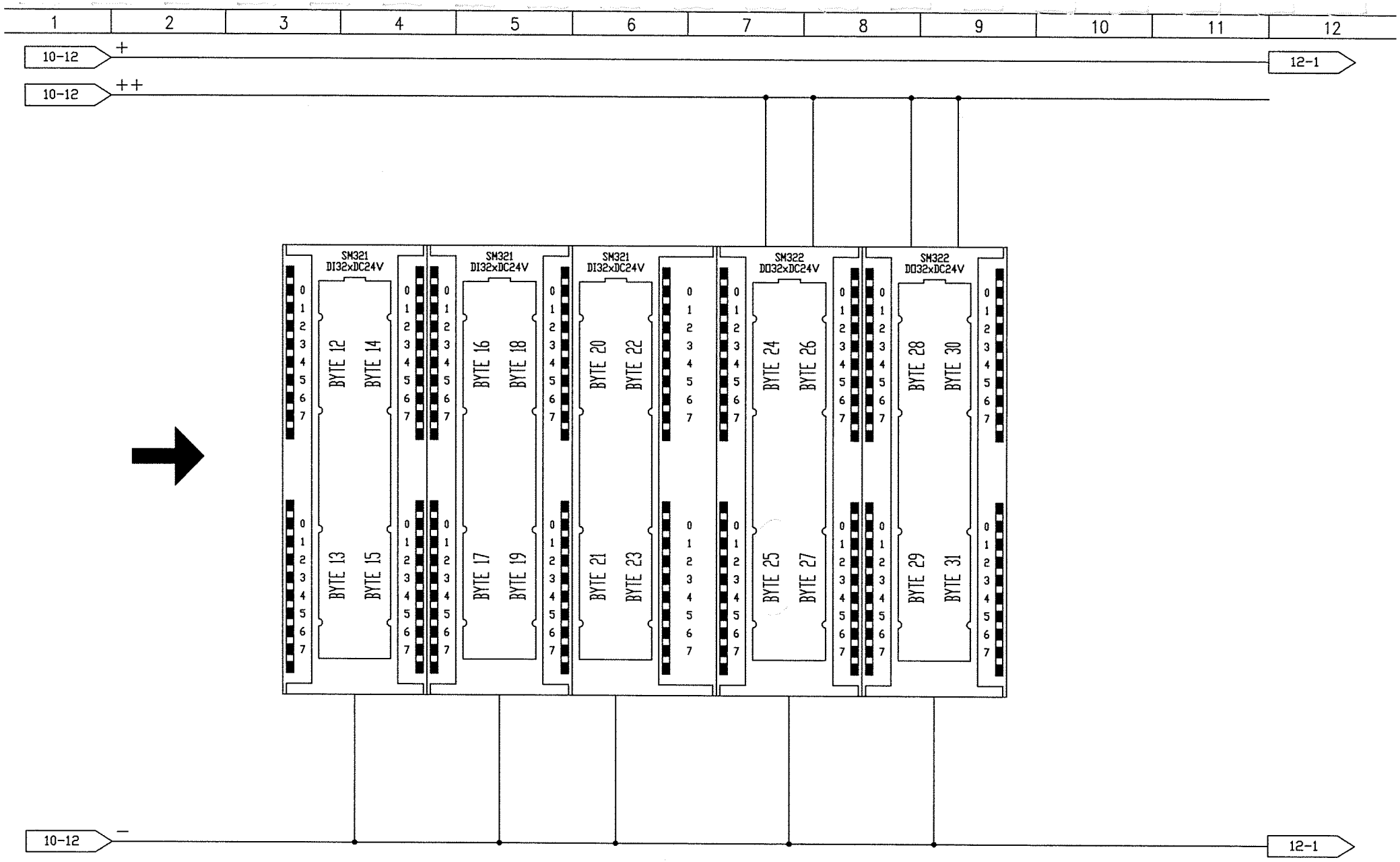
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	10 / 11
Gruppo	**Esec.**	**Data**	**Dis. N°**
ALIMENTAZIONE PLC	C.f.	23/05/2005	910



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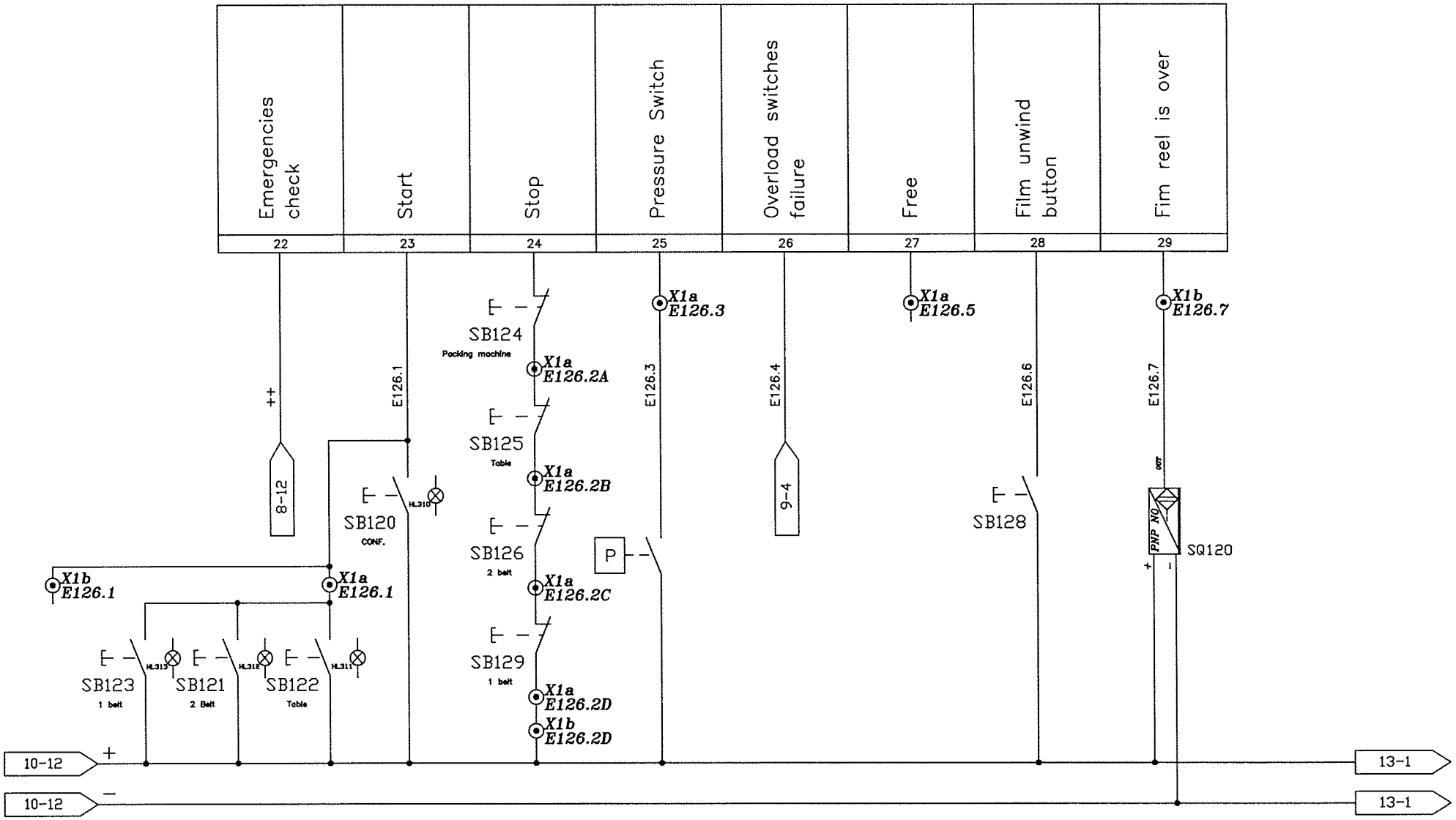
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*11 / 12*
Gruppo	**Esec.**	**Data**	**Dis. N°**
ALIMENTAZIONE PLC	*C.J.*	*23/05/2005*	910

INPUTS 126



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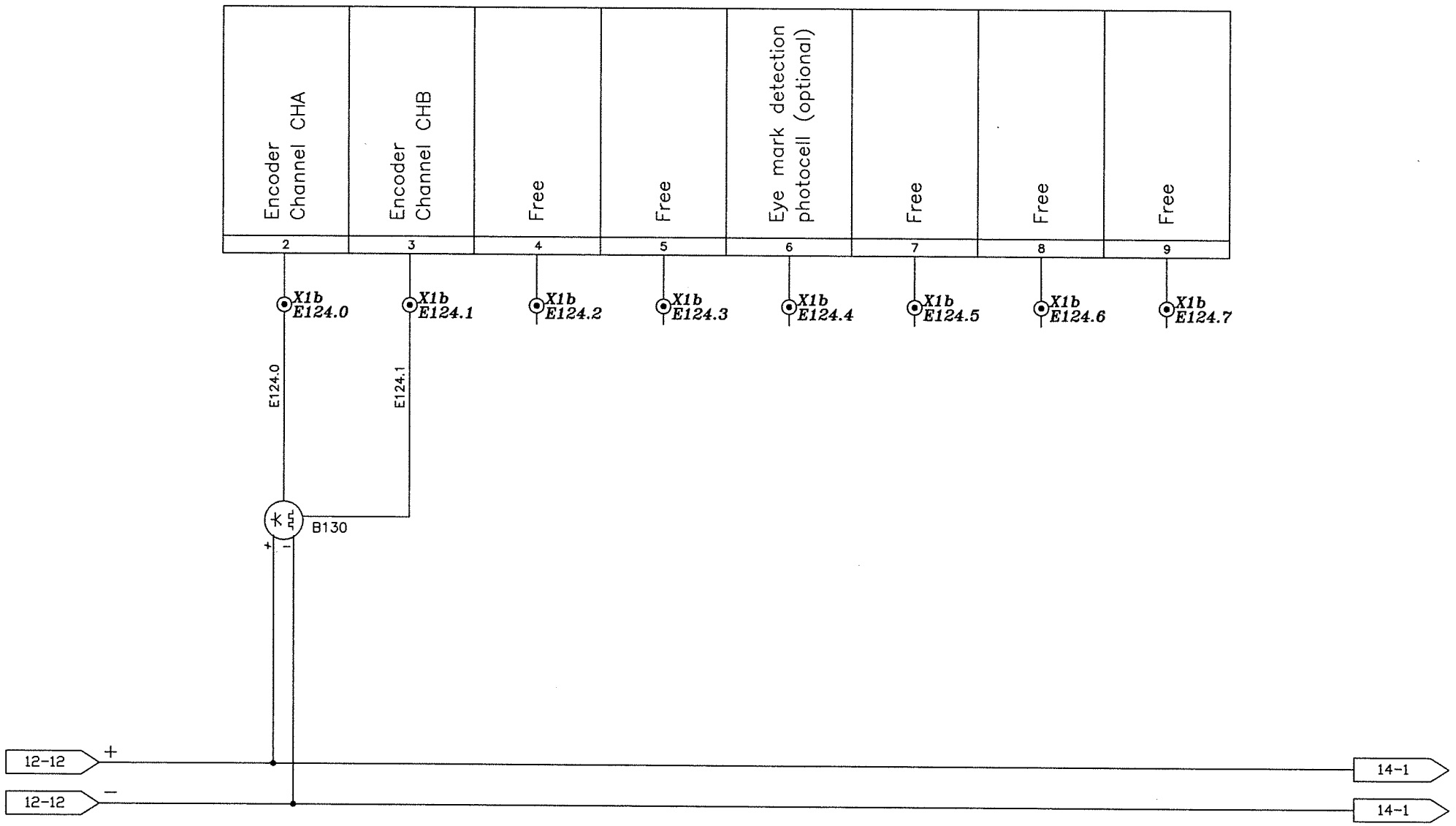
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*12 / 13*
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	*C.f.*	*23/05/2005*	910

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

INPUTS 124



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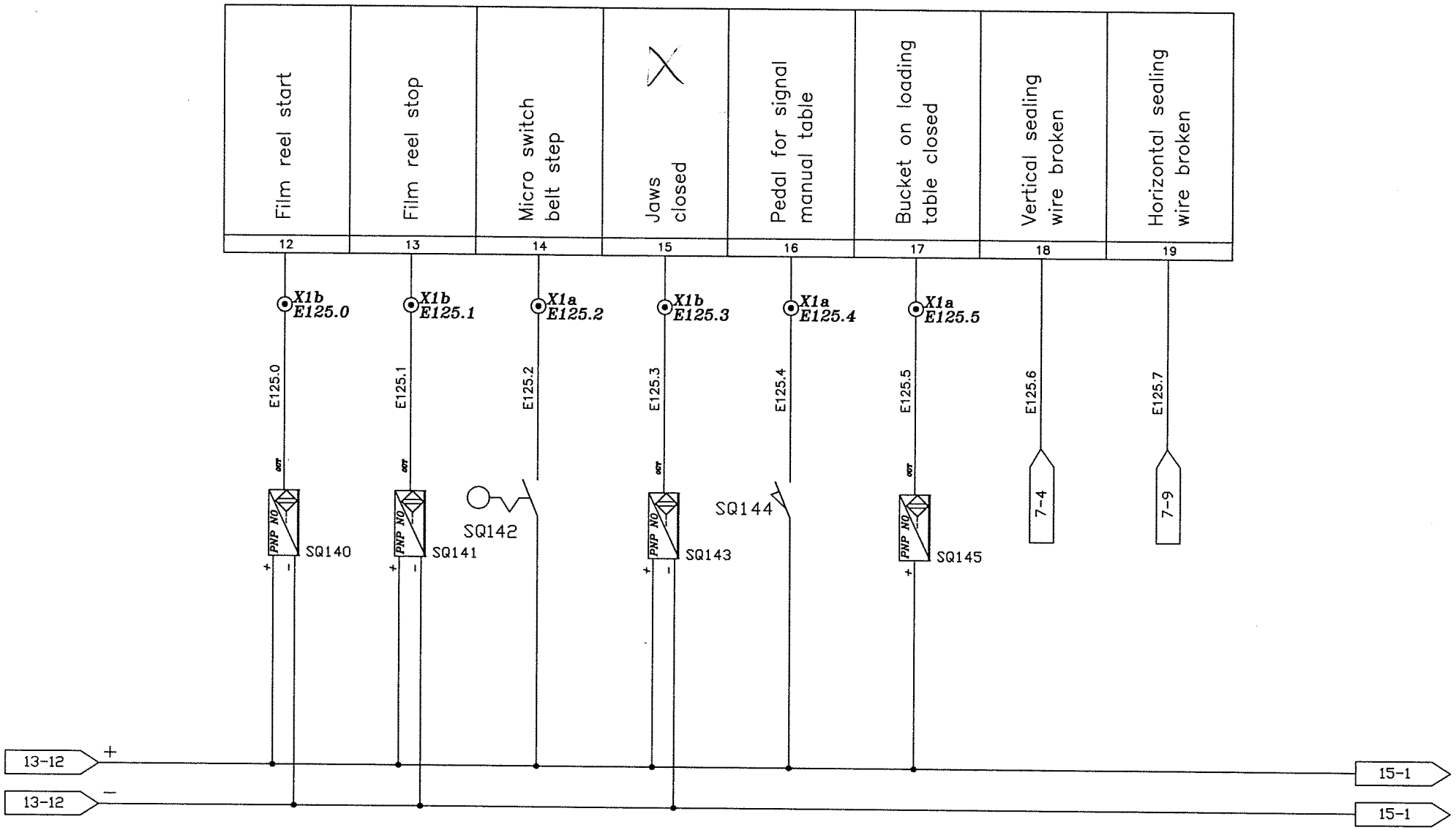
Macchina	Mat.	Cliente	Foglio Segue
Vert.560	*910*	*Canmade Inc.*	*13 / 14*
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	*C.f.*	*23/05/2005*	910

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

INPUTS 125



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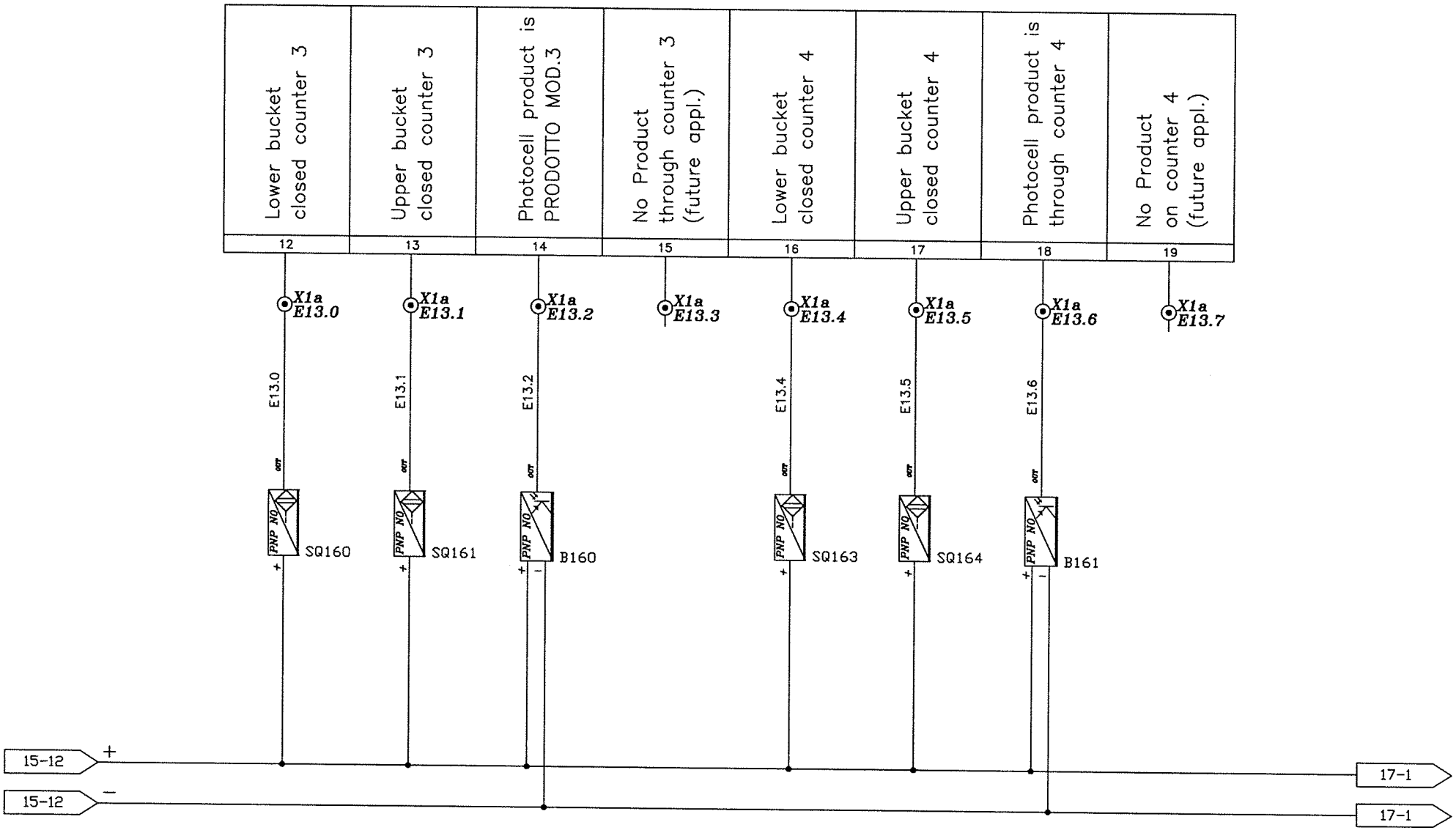
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*14 / 15*
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	*C.f.*	*23/05/2005*	910

INPUTS 13



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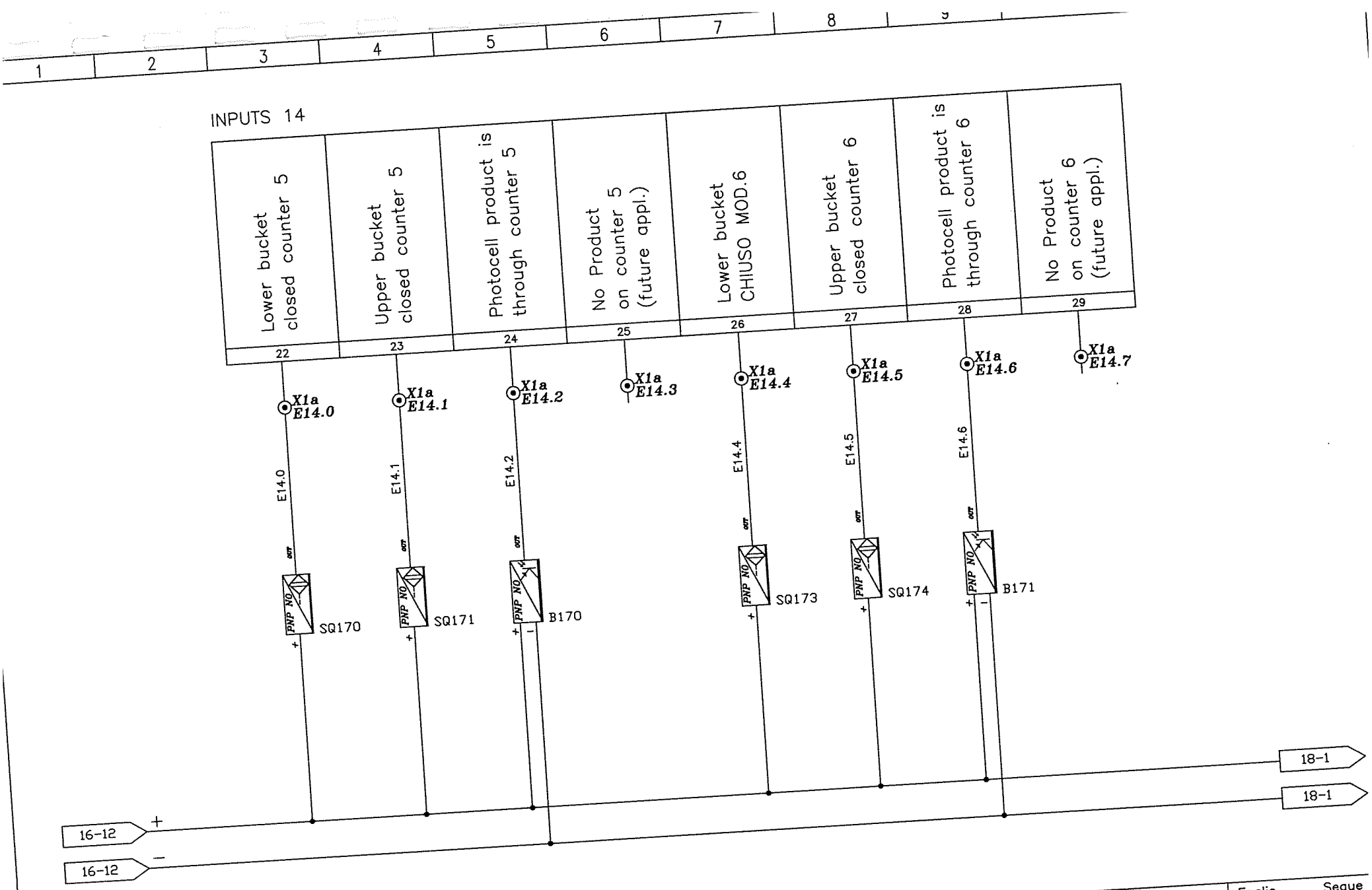
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*16 / 17*
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	*C.f.*	*23/05/2005*	910



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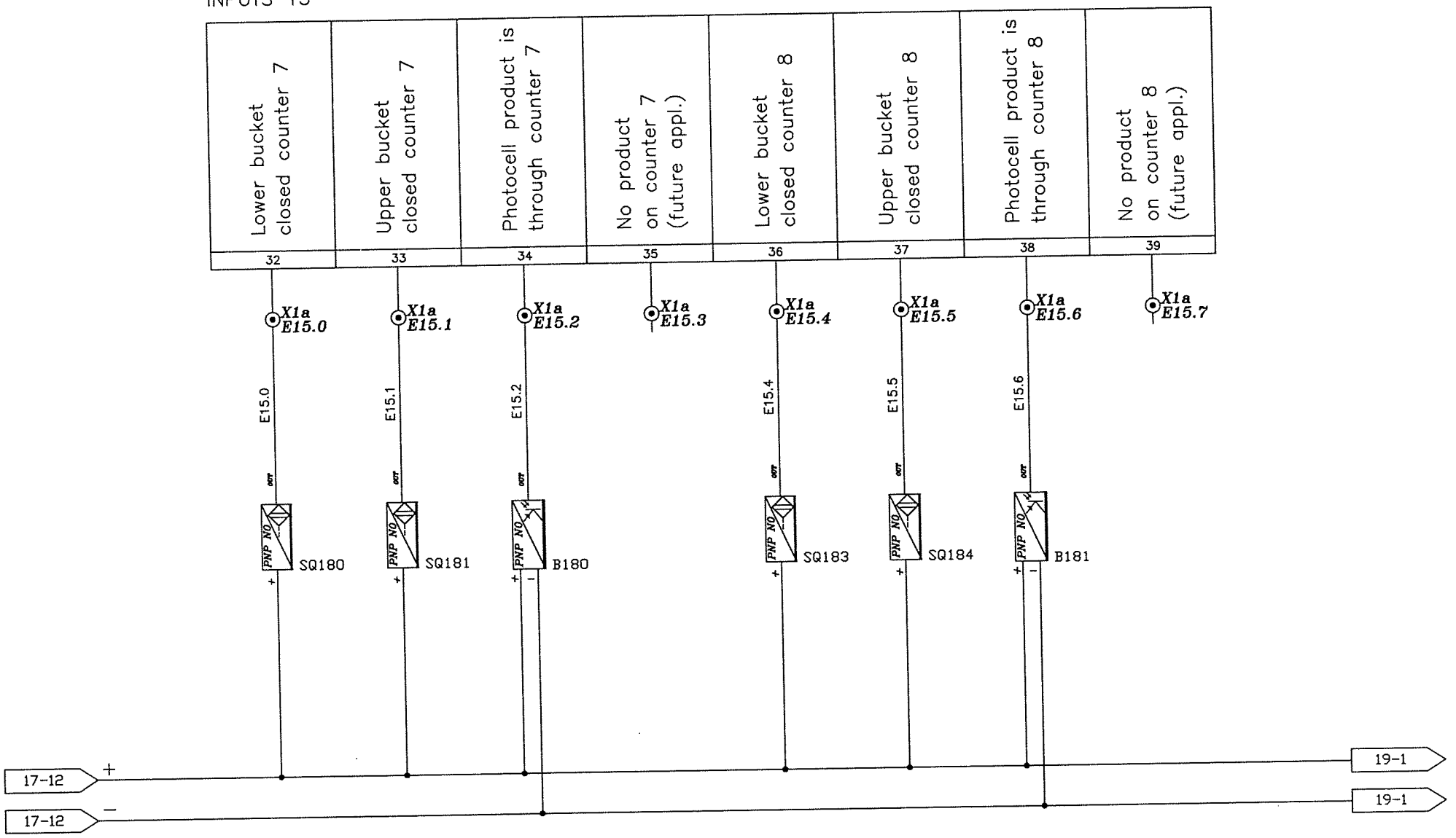
Macchina: *Vert.560*	Mat.: *910*	Cliente: *Canmade Inc.*	Foglio: *17* / Segue: *18*	
Gruppo: *INGRESSI*	Esec.: *C.f.*	Data: *23/05/2005*	Dis. N°: *910*	

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

INPUTS 15



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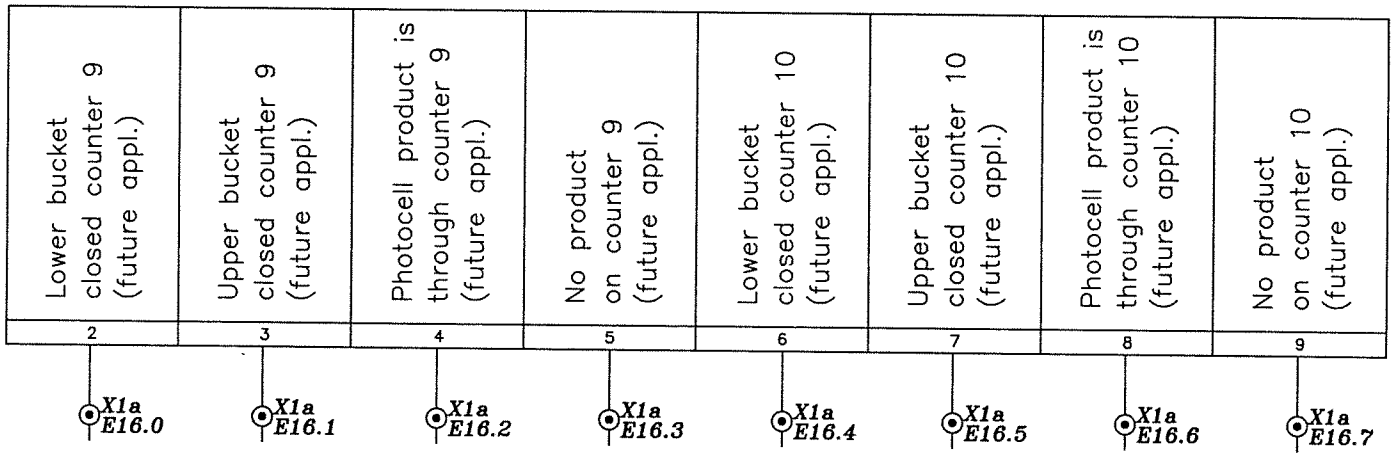
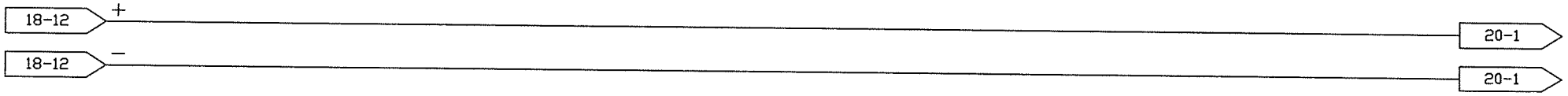
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	18 / 19
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	C.J.	23/05/2005	910

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

INPUTS 16





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Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*19 / 20*
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	*C.f.*	*23/05/2005*	*910*

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

INPUTS 17

12	13	14	15	16	17	18	19
Lower bucket closed counter 11 (future appl.)	Upper bucket closed counter 11 (future appl.)	Photocell product is through counter 11 (future appl.)	No Product on counter 11 (future appl.)	Lower bucket closed counter 12 (future appl.)	Upper bucket closed counter 12 (future appl.)	Photocell product is through counter 12 (future appl.)	No Product on counter 12 (future appl.)
X1a E17.0	X1a E17.1	X1a E17.2	X1a E17.3	X1a E17.4	X1a E17.5	X1a E17.6	X1a E17.7

19-12 + → 21-1

19-12 − → 21-1

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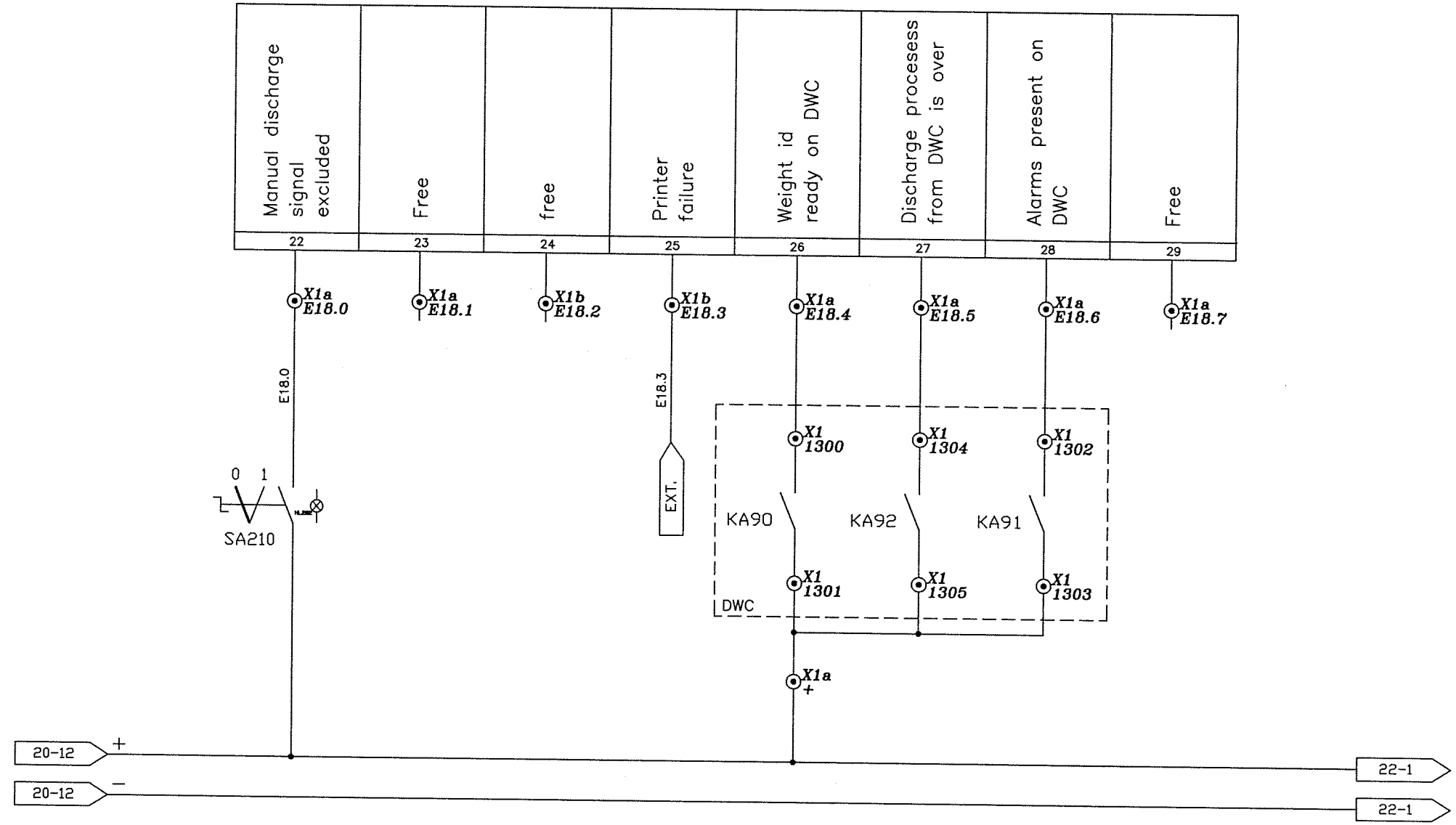
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	20 / 21
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	C. f.	23/05/2005	910

INPUTS 18



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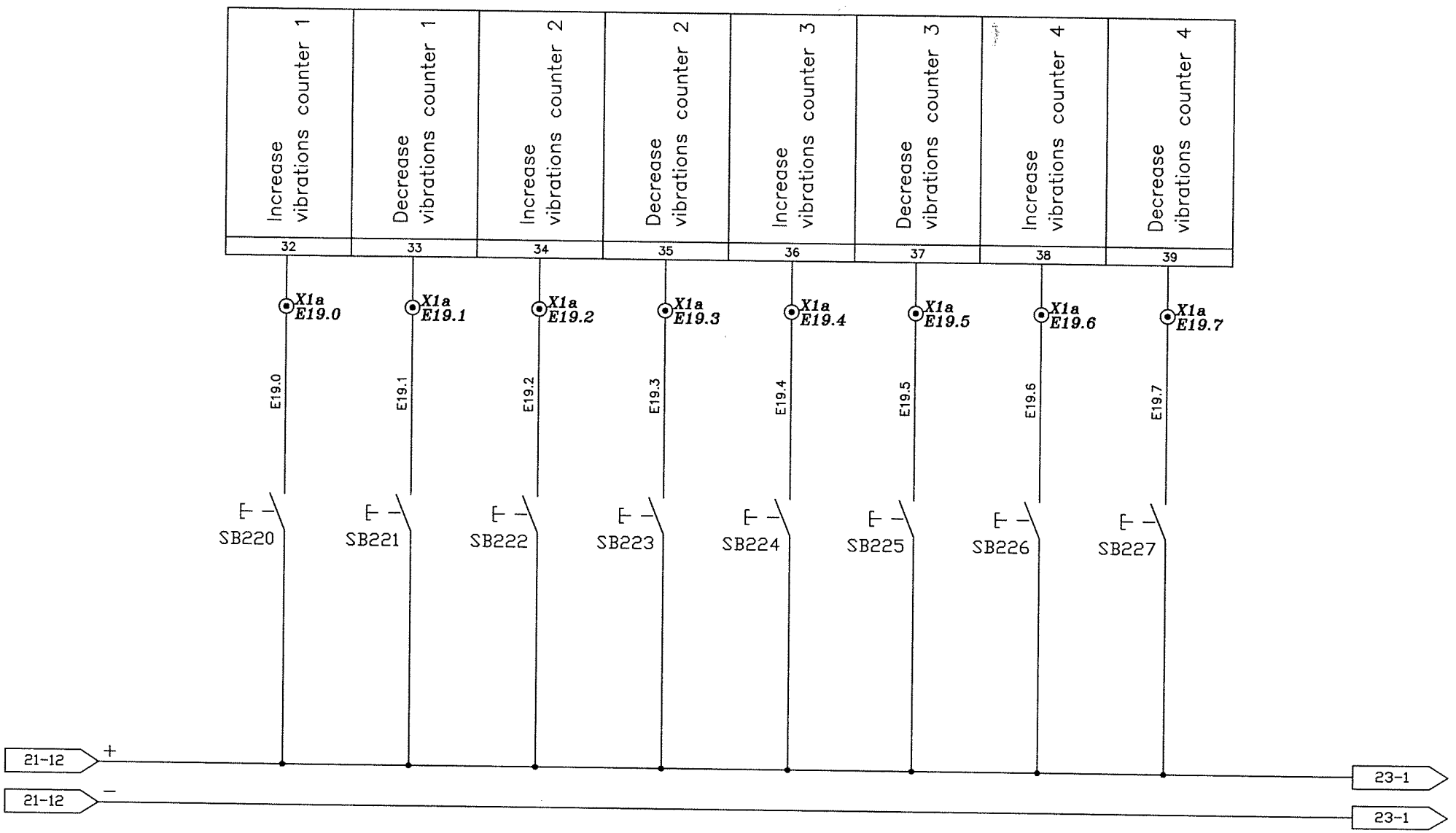
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*21 / 22*
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	*C.f.*	*23/05/2005*	910

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

INPUTS 19



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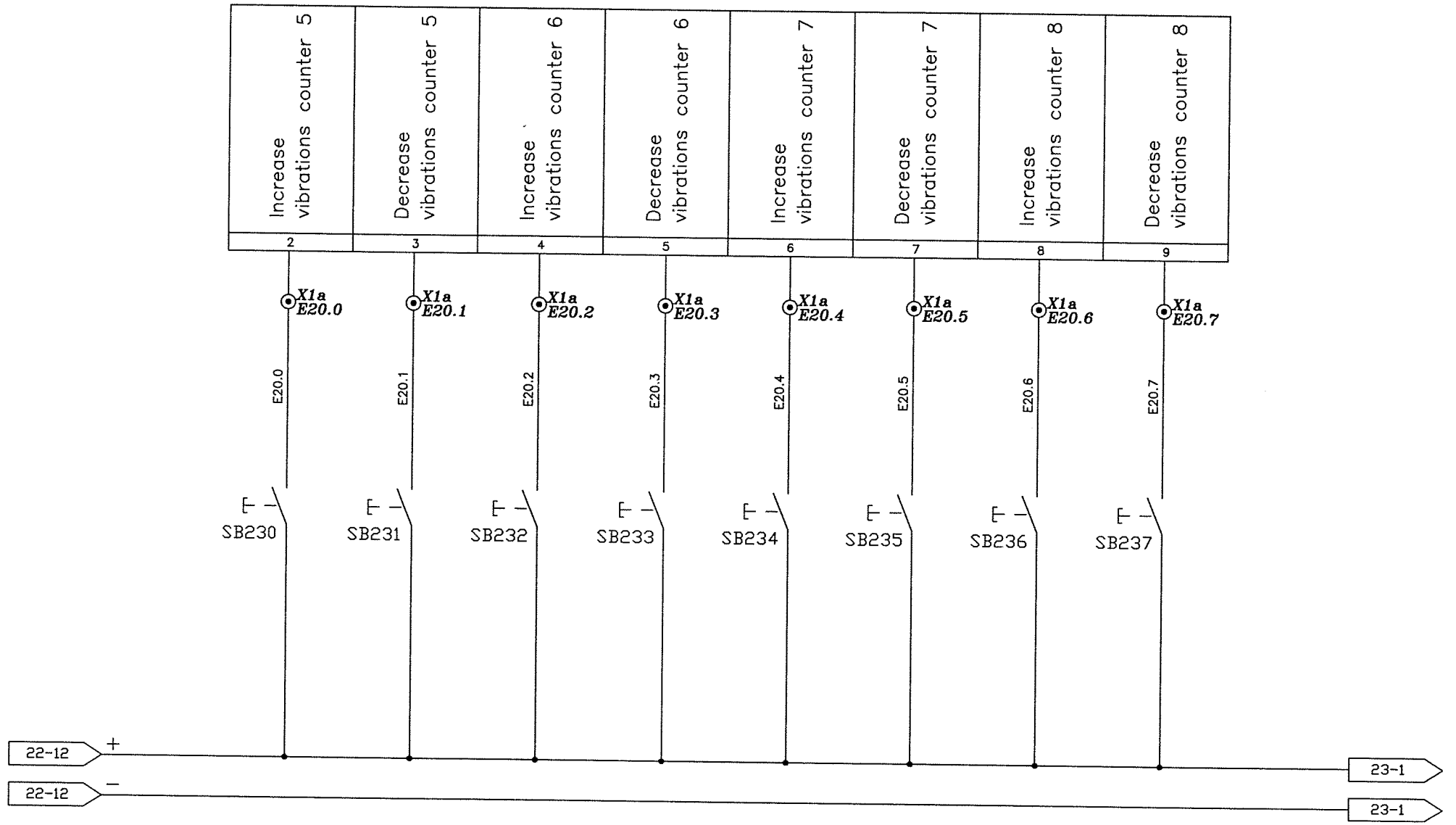
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	22 / 23
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	C. J.	23/05/2005	910

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

INPUTS 20



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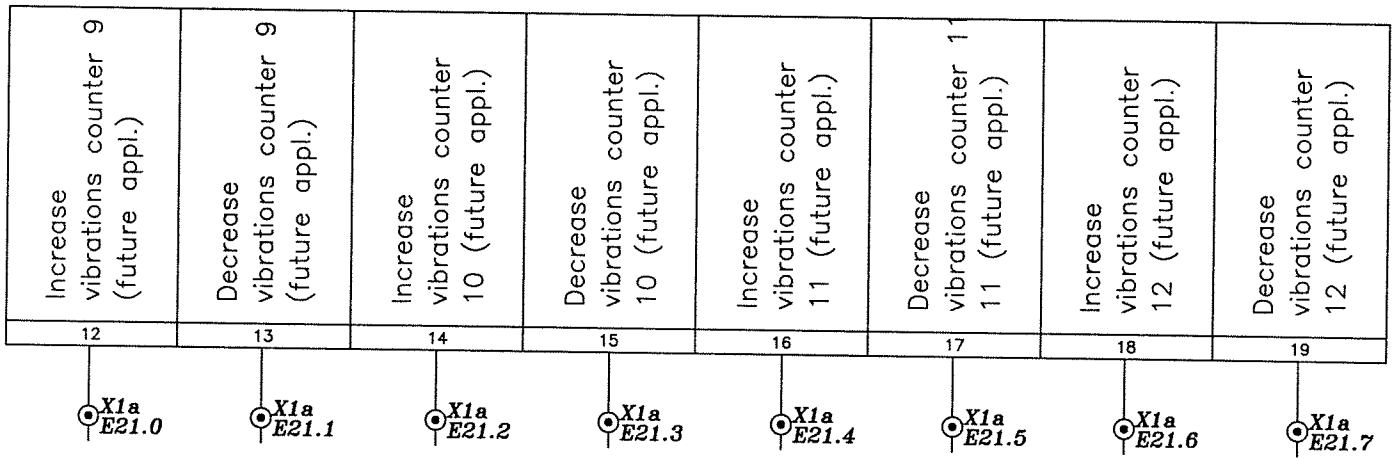
Web: www.newmapackaging.com

Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	23 / 24
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	C.f.	23/05/2005	910

INPUTS 21



23-12 +

23-12 −

25-1

25-1

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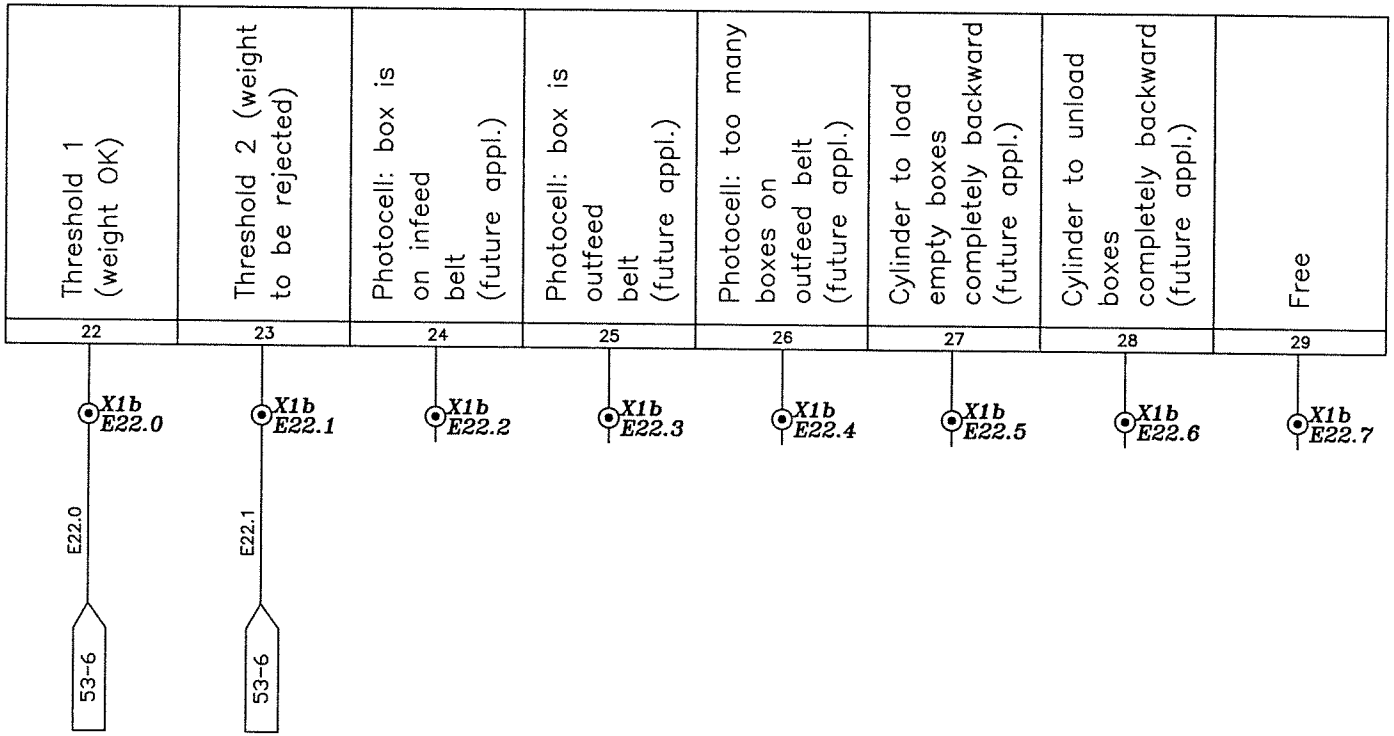
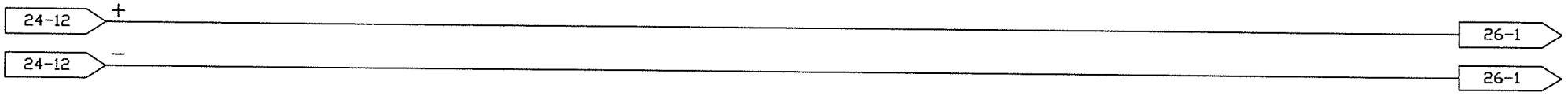
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	24 / 25
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	C.f.	23/05/2005	910

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

INPUTS 22





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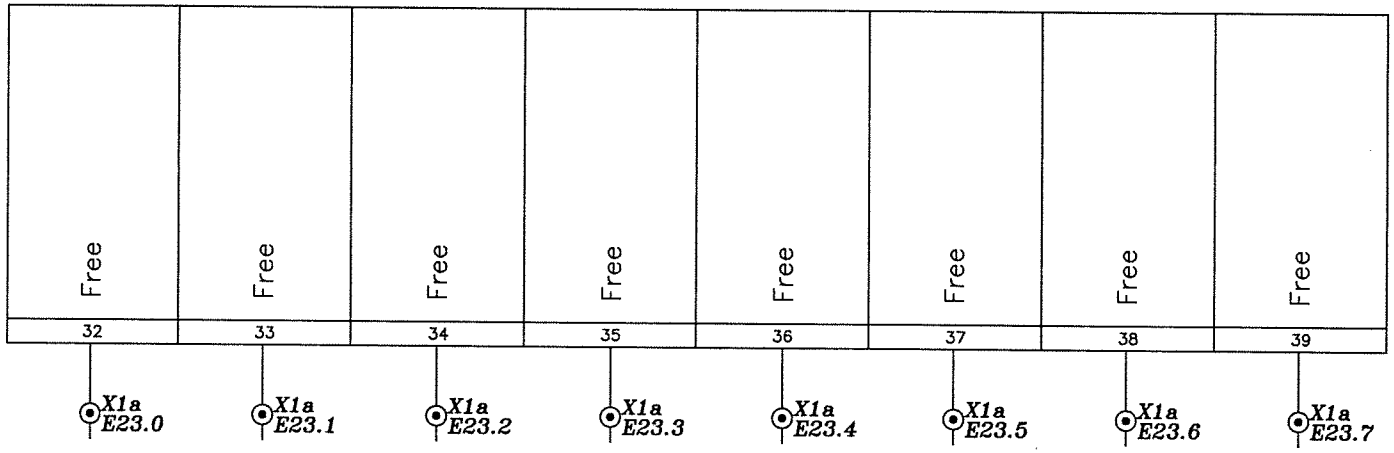
Web: www.newmapackaging.com

Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*25 / 26*
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	*C.f.*	*23/05/2005*	*910*

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

INPUTS 23



25-12 +

25-12 −

31-1

29-1

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Web: www.newmapackaging.com

Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*26 / 27*
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	*C.f.*	*23/05/2005*	910

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

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Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*27 / 28*
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	*C.f.*	*23/05/2005*	910

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

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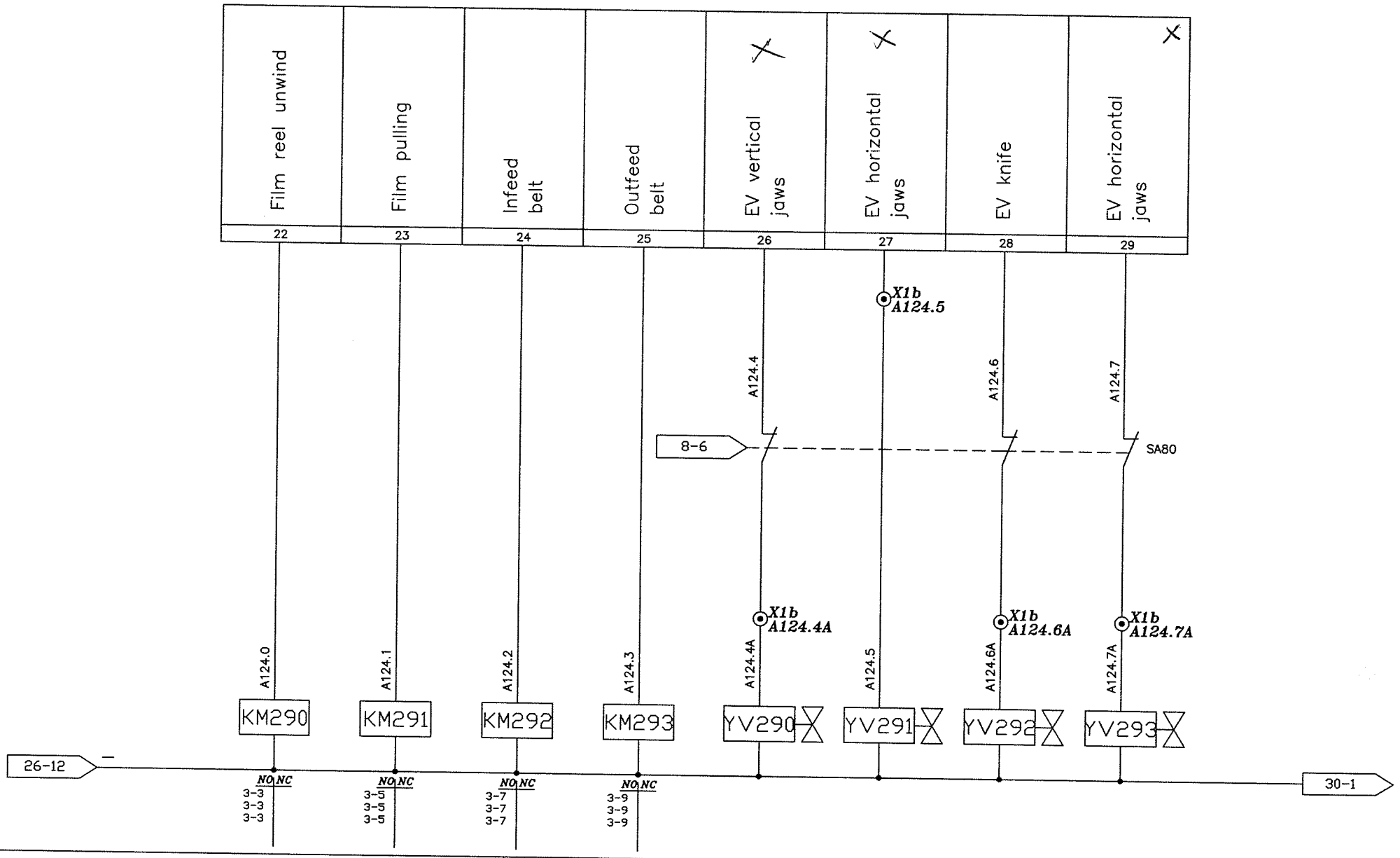
Web: www.newmapackaging.com

Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*28 / 29*
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	*C.f.*	*23/05/2005*	910

OUTPUTS 124



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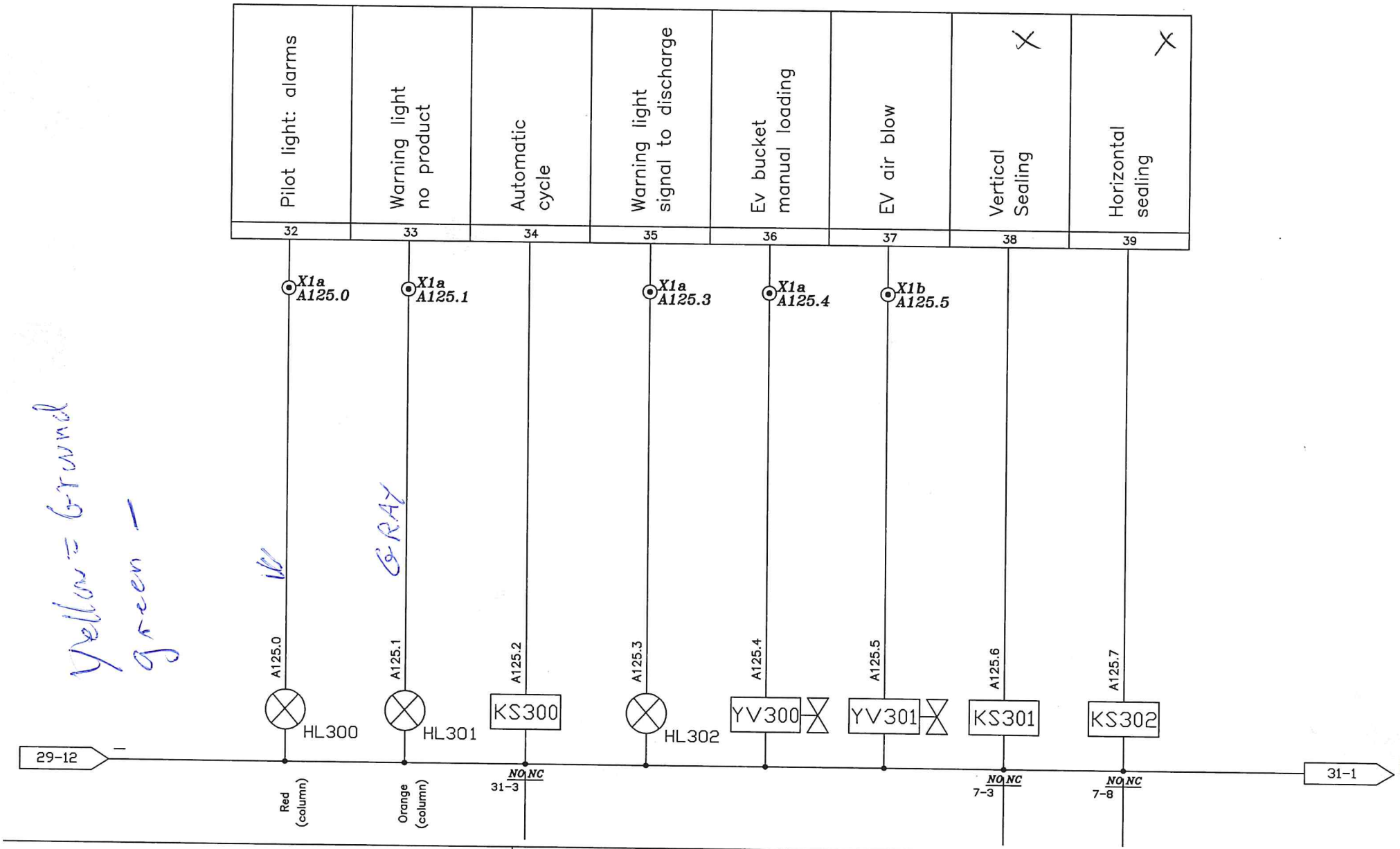
Web: www.newmapackaging.com

Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	29 / 30
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE	C.f.	23/05/2005	910

1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12

OUTPUTS 125



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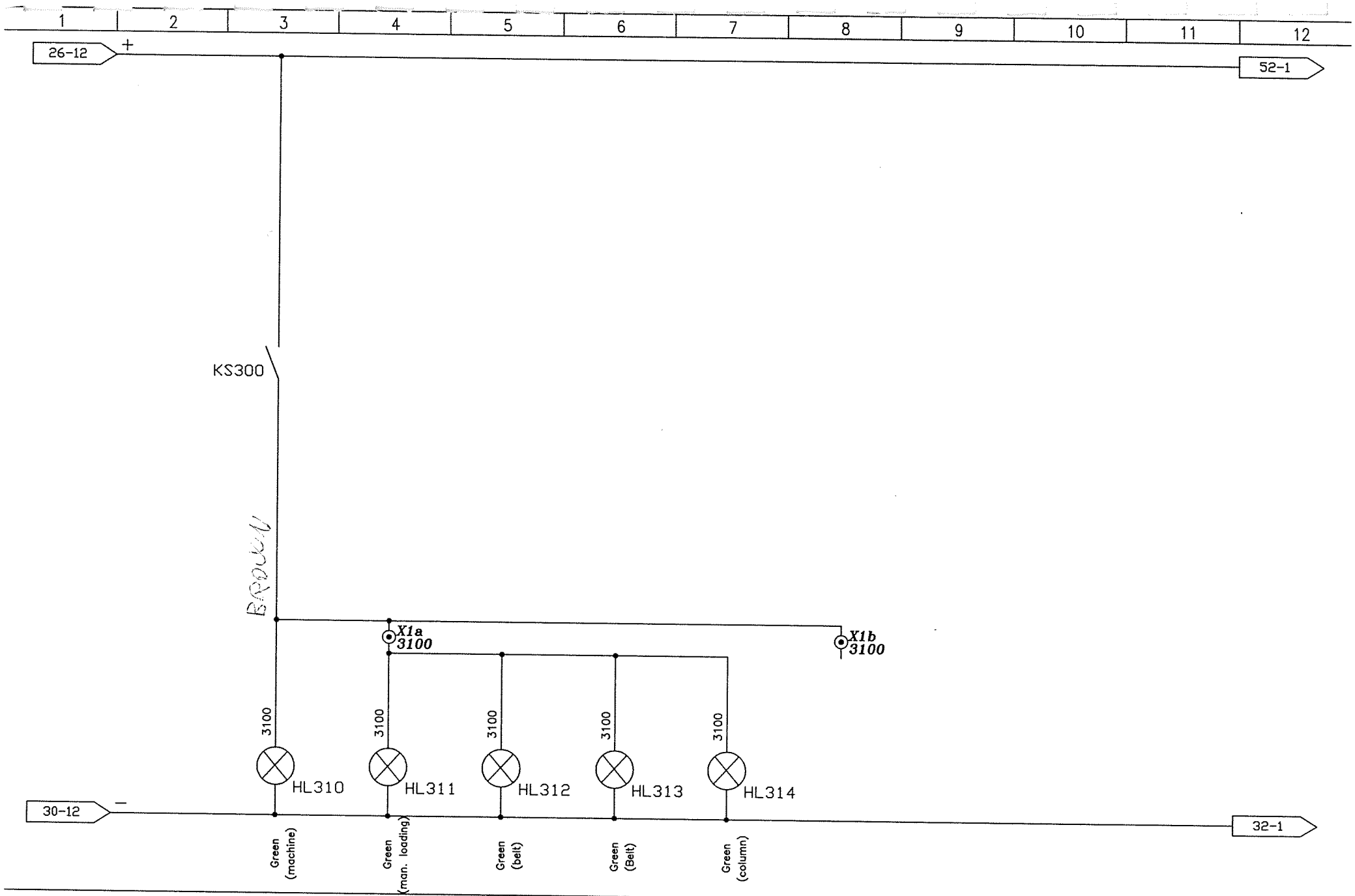
Web: www.newmapackaging.com

Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	30 / 31
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE	C.f.	23/05/2005	910



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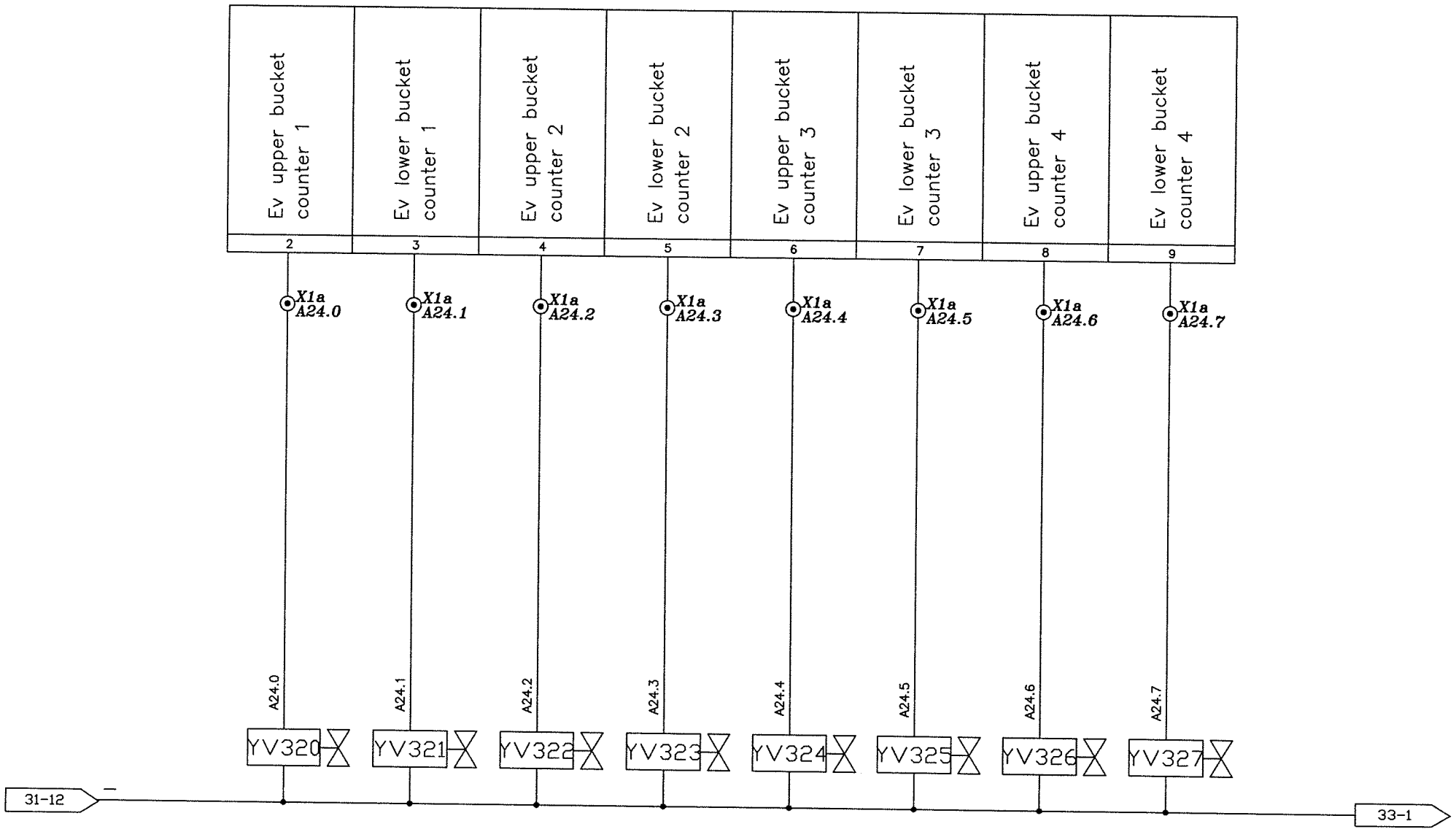
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	31 / 32
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE	C. f.	23/05/2005	910

OUTPUTS 24



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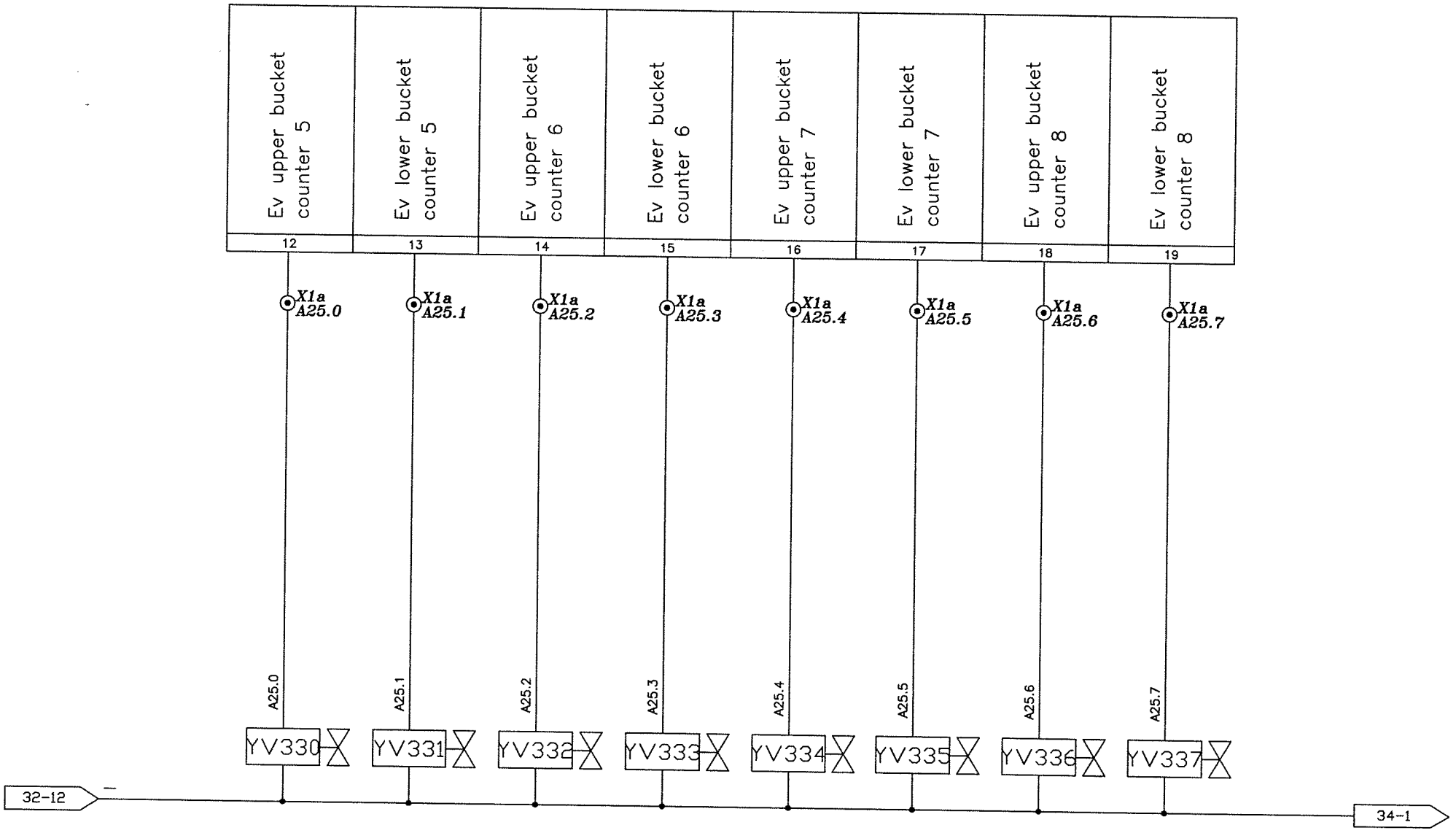
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*32 / 33*
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE	*C.f.*	*23/05/2005*	*910*

OUTPUTS 25



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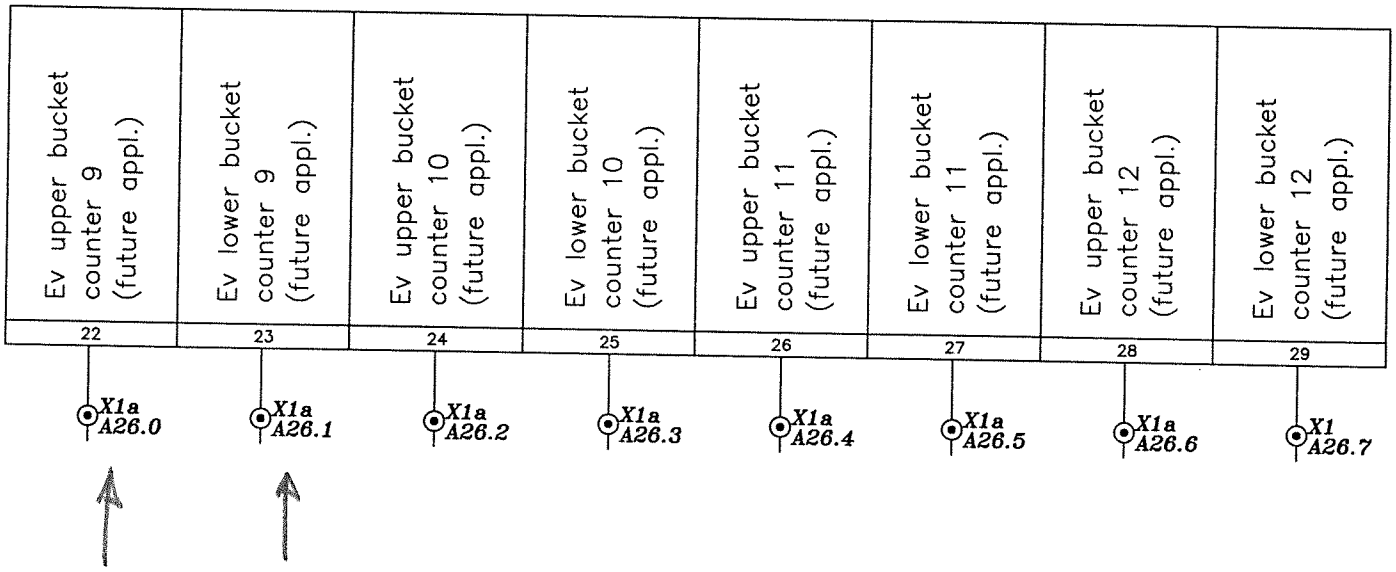
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*33 / 34*
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE	*C. f.*	*23/05/2005*	910

OUTPUTS 26



33-12

35-1

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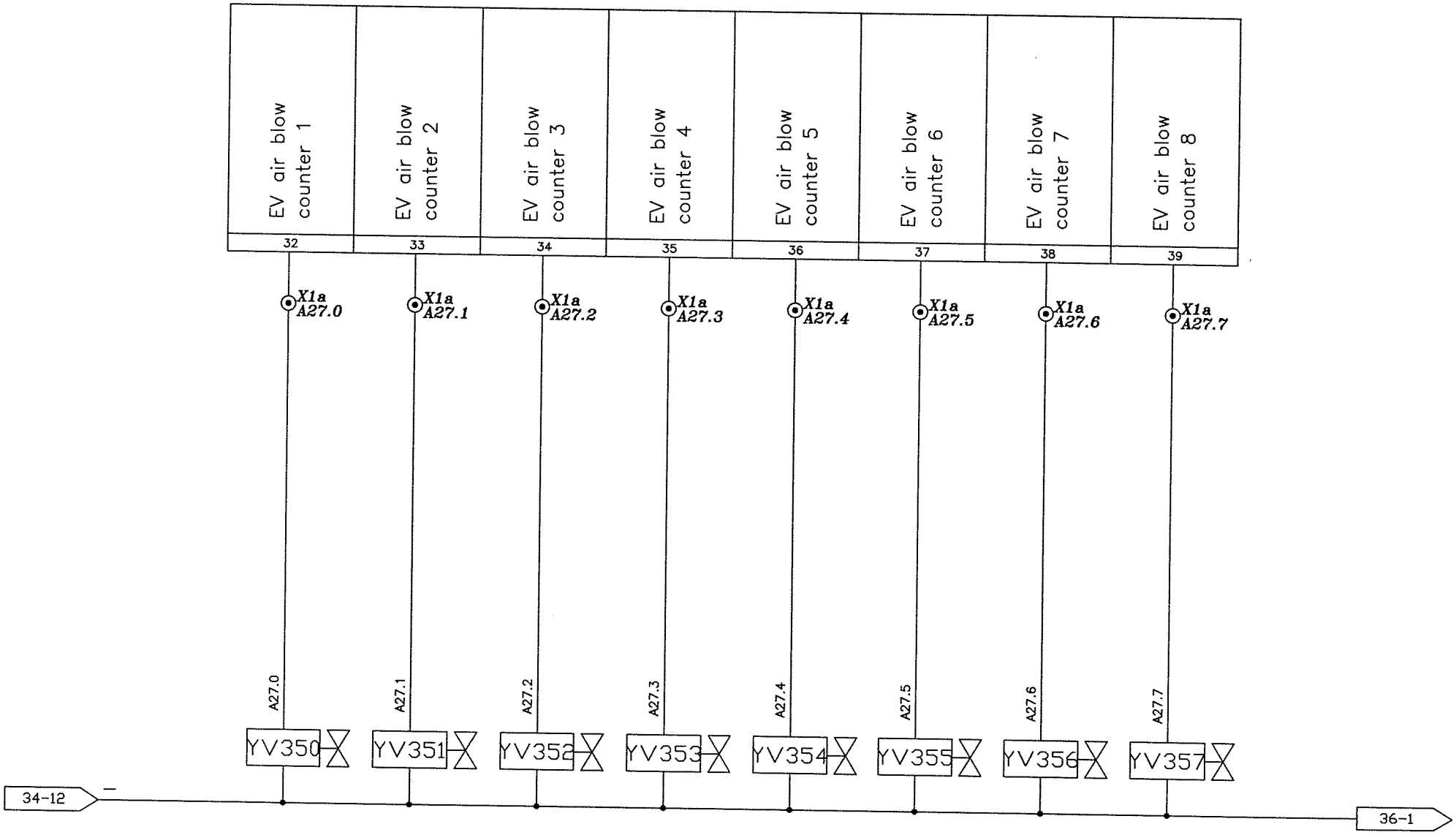
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	34 / 35
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE	C.f.	23/05/2005	910

OUTPUTS 27



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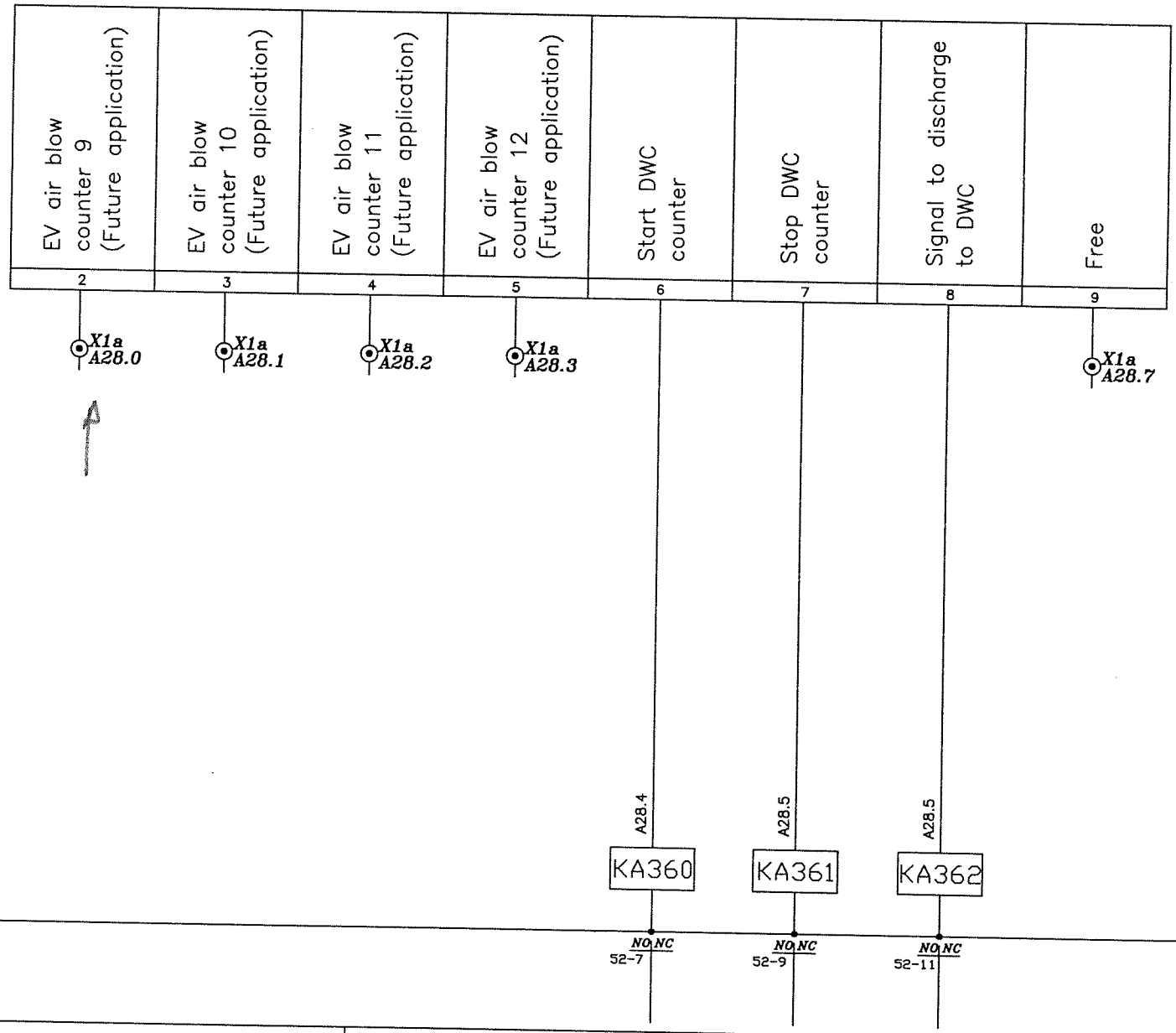
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*35 / 36*
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE	*C.J.*	*23/05/2005*	*910*

OUTPUTS 28



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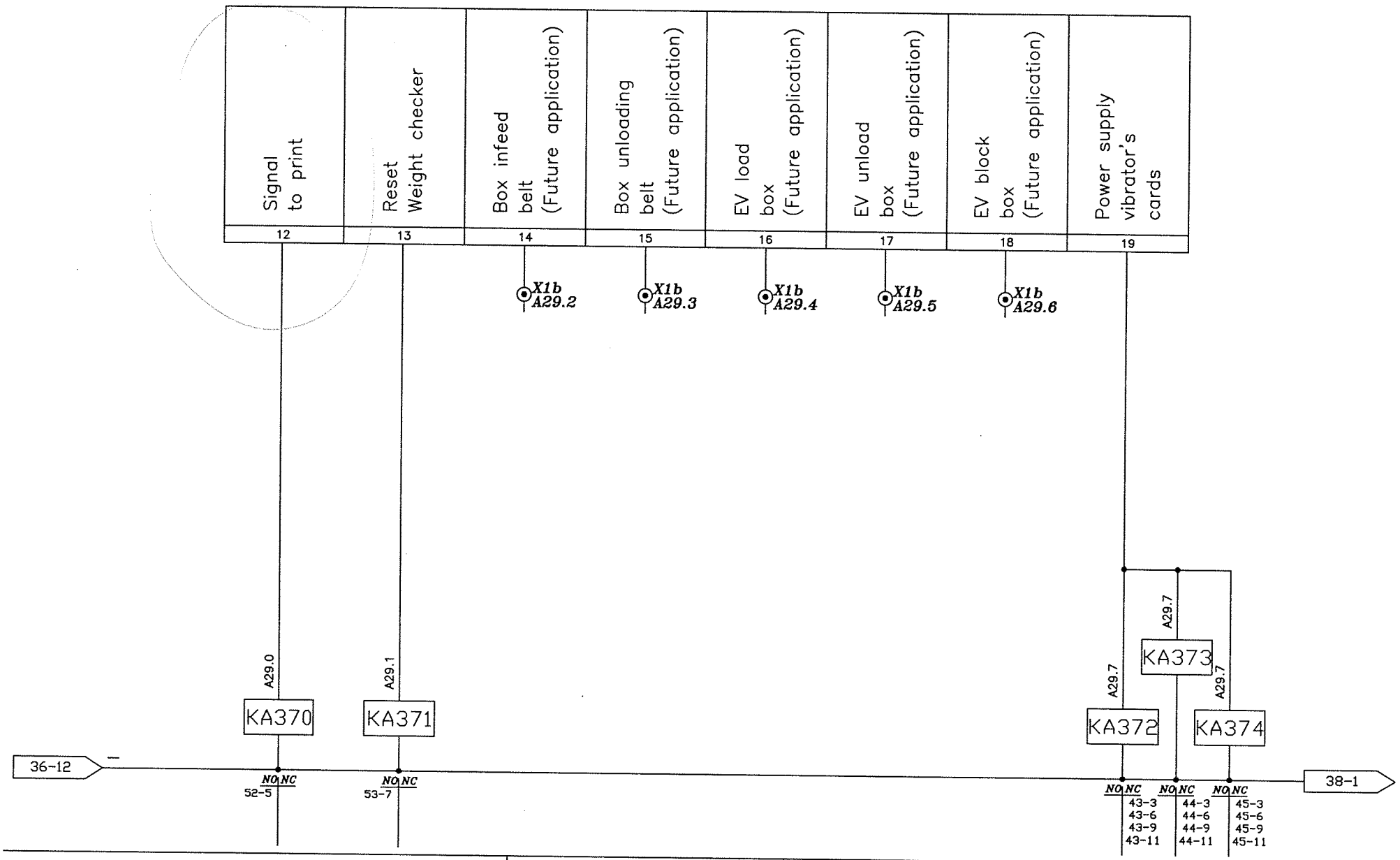
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	36 / 37
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE	C.J.	23/05/2005	910

OUTPUTS 29



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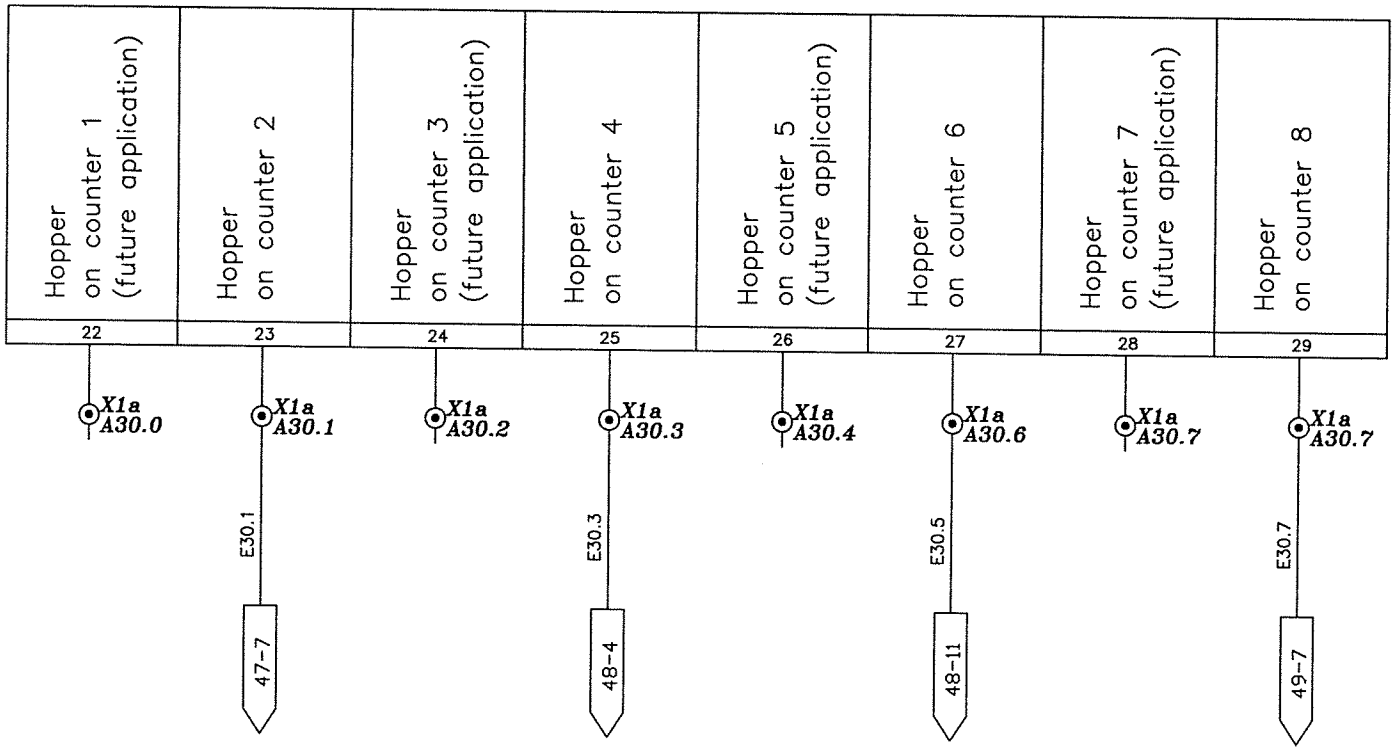
Web: www.newmapackaging.com

Macchina: *Vert.560*	Mat.: *910*	Cliente: *Canmade Inc.*	Foglio: *37* / Segue: *38*
Gruppo: *USCITE*	Esec.: *C.J.*	Data: *23/05/2005*	Dis. N°: 910

OUTPUTS 30



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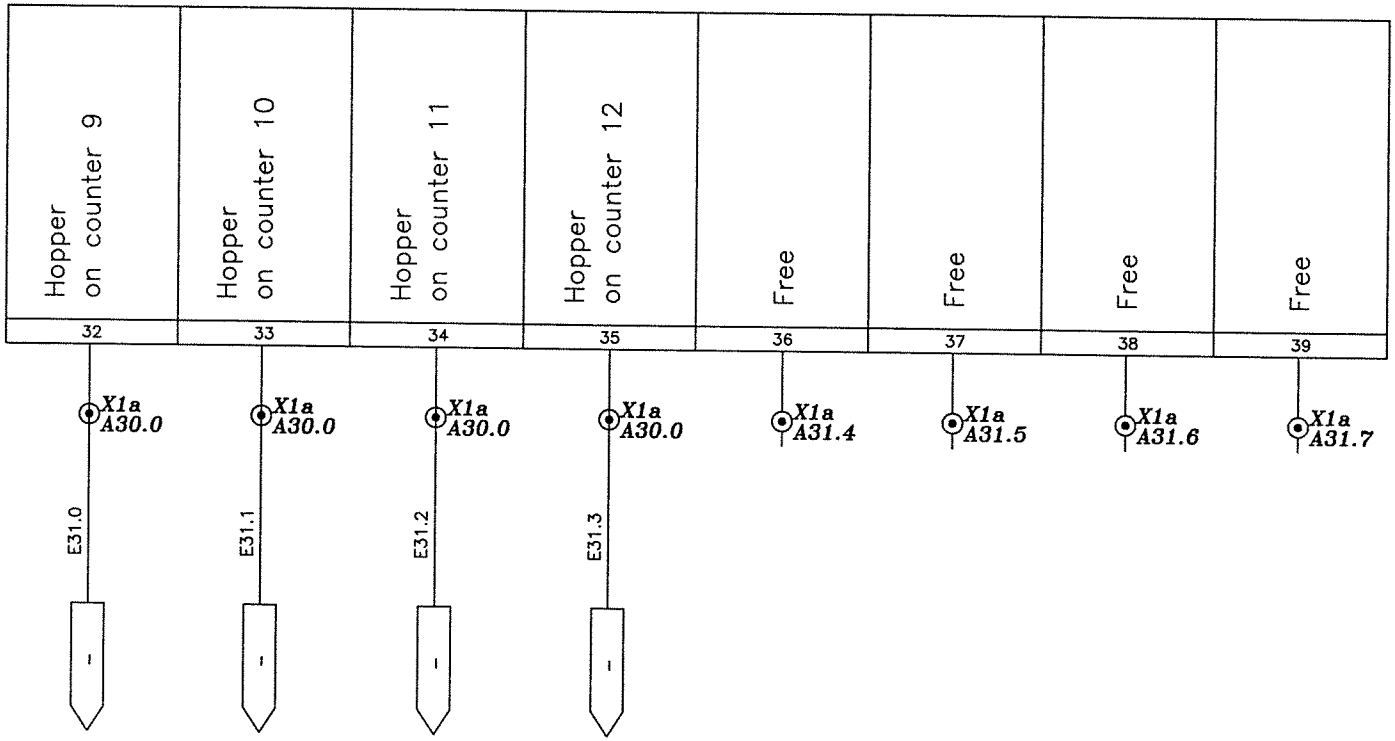
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	38 / 39
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE	C.f.	23/05/2005	910

OUTPUTS 31



39-12

47-1

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Tel: +39 0445 575534 – Fax +39 0445 575489
Web: www.newmapackaging.com

Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*39 / 40*
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE	*C.J.*	*23/05/2005*	*910*

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

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Tel: +39 0445 575534 – Fax +39 0445 575489
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Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*40 / 41*
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	*C.J.*	*23/05/2005*	*910*

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

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Web: www.newmapackaging.com

Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*41 / 42*
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	*C.f.*	*23/05/2005*	910

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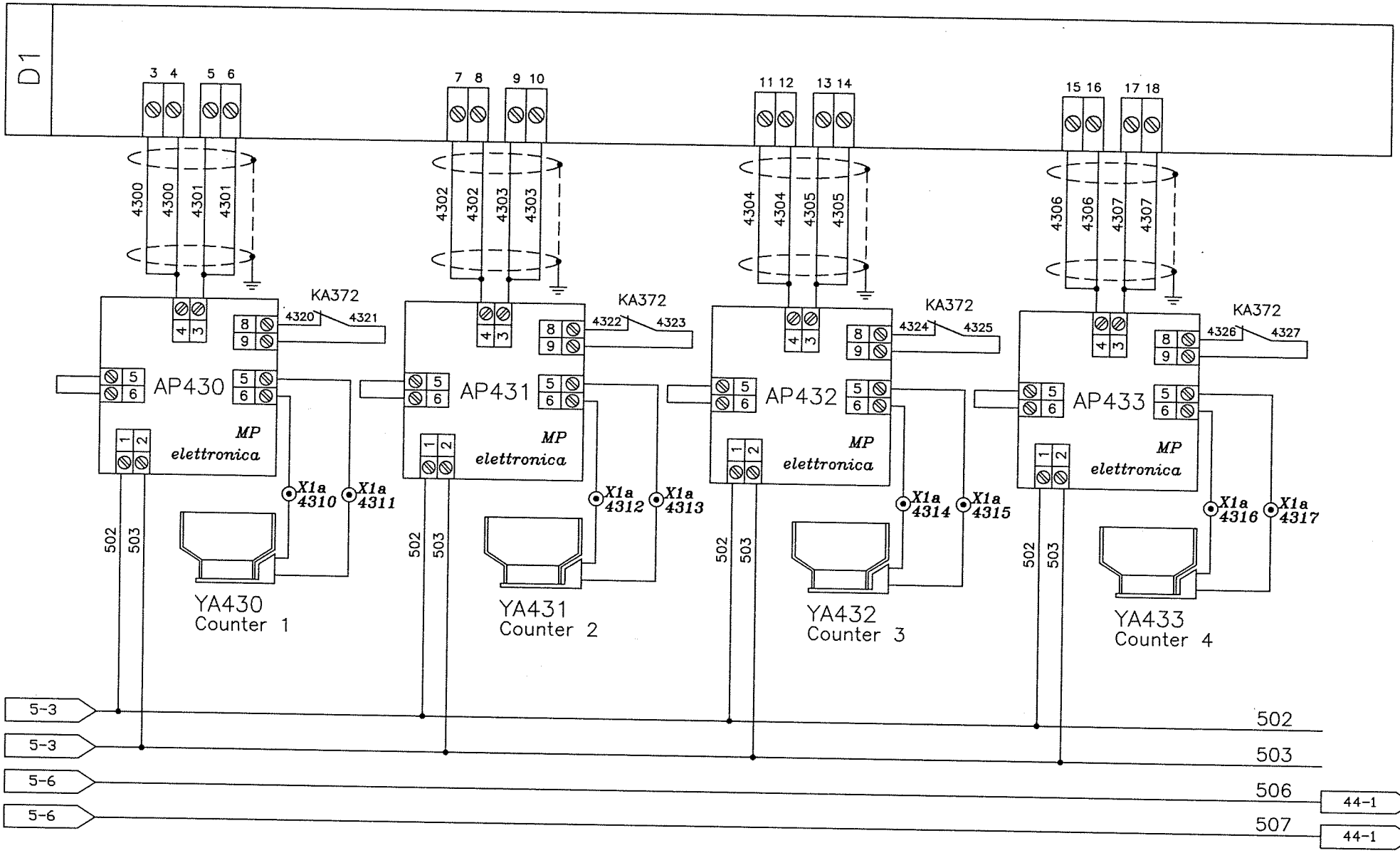
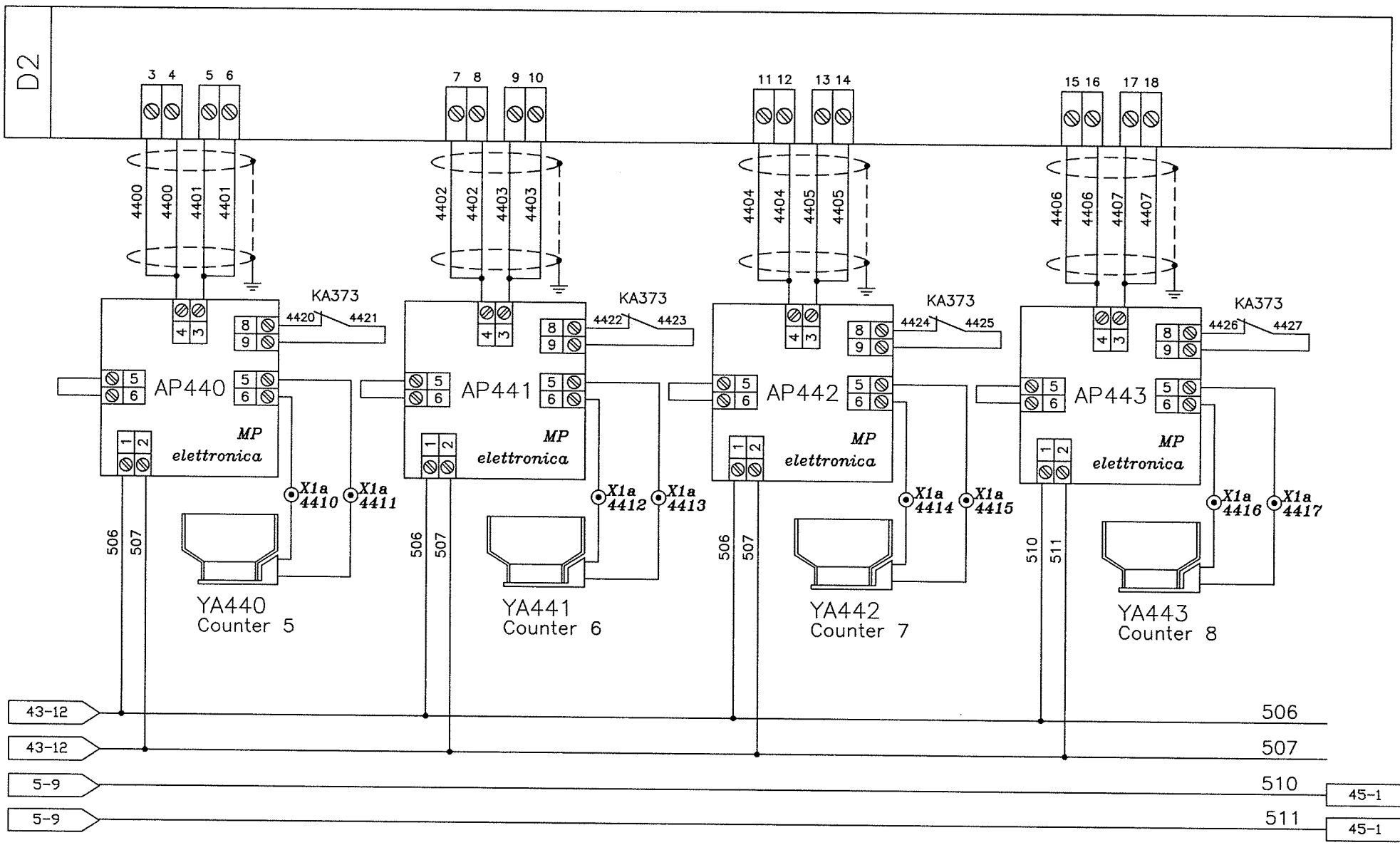
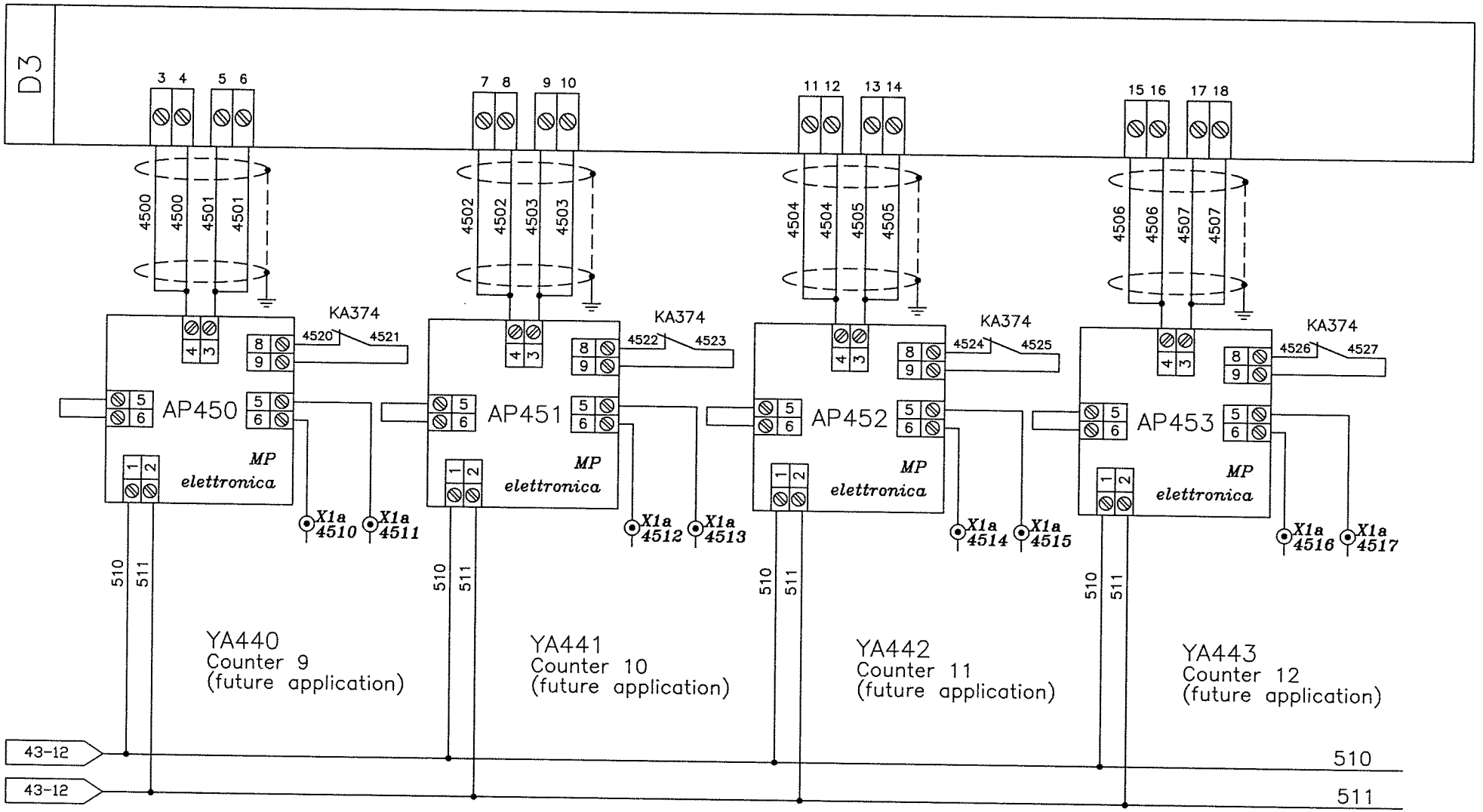
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*42 / 43*
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	*C.f.*	*23/05/2005*	910



Packaging Machinery Specialists Via Val D'Aosta 7/b – 36015 Schio (VI) Italy Tel: +39 0445 575534 – Fax +39 0445 575489 Web: www.newmapackaging.com	Macchina: *Vert.560*	Mat.: *910*	Cliente: *Canmade Inc.*	Foglio / Segue: *43 / 44*
	Gruppo: *USCITE ANALOGICHE*	Esec.: *C.J.*	Data: *23/05/2005*	Dis. N°: 910



Packaging Machinery Specialists Via Val D'Aosta 7/b – 36015 Schio (VI) Italy Tel: +39 0445 575534 – Fax +39 0445 575489 Web: www.newmapackaging.com	Macchina: Vert.560	Mat.: 910	Cliente: Canmade Inc.	Foglio: 44 / Segue: 45	
	Gruppo: USCITE ANALOGICHE	Esec.: C.J.	Data: 23/05/2005	Dis. N°: 910	



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Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*45 / 46*
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE ANALOGICHE	*C.f.*	*23/05/2005*	910

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

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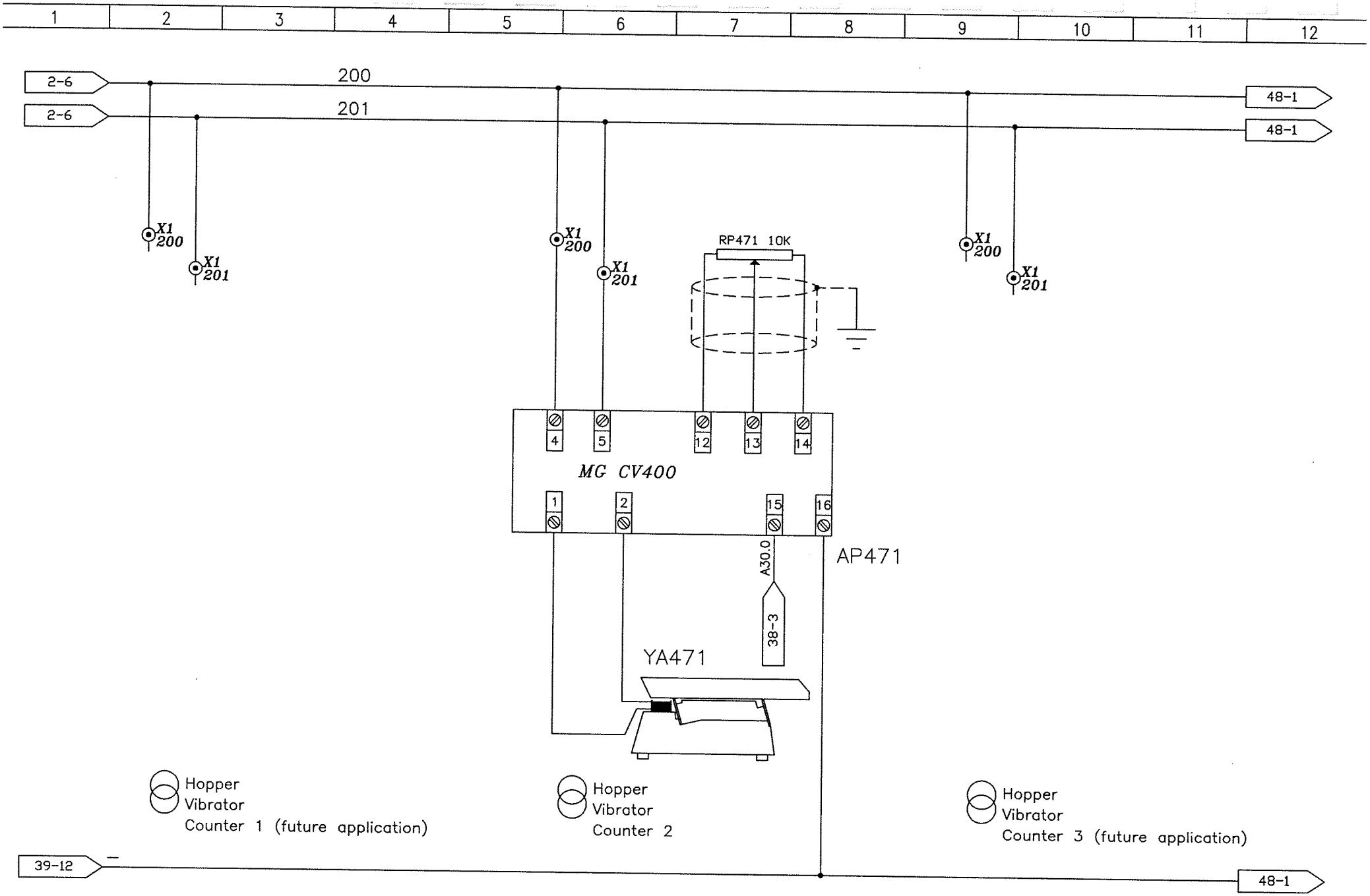
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*46 / 47*
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	*C.f.*	*23/05/2005*	910



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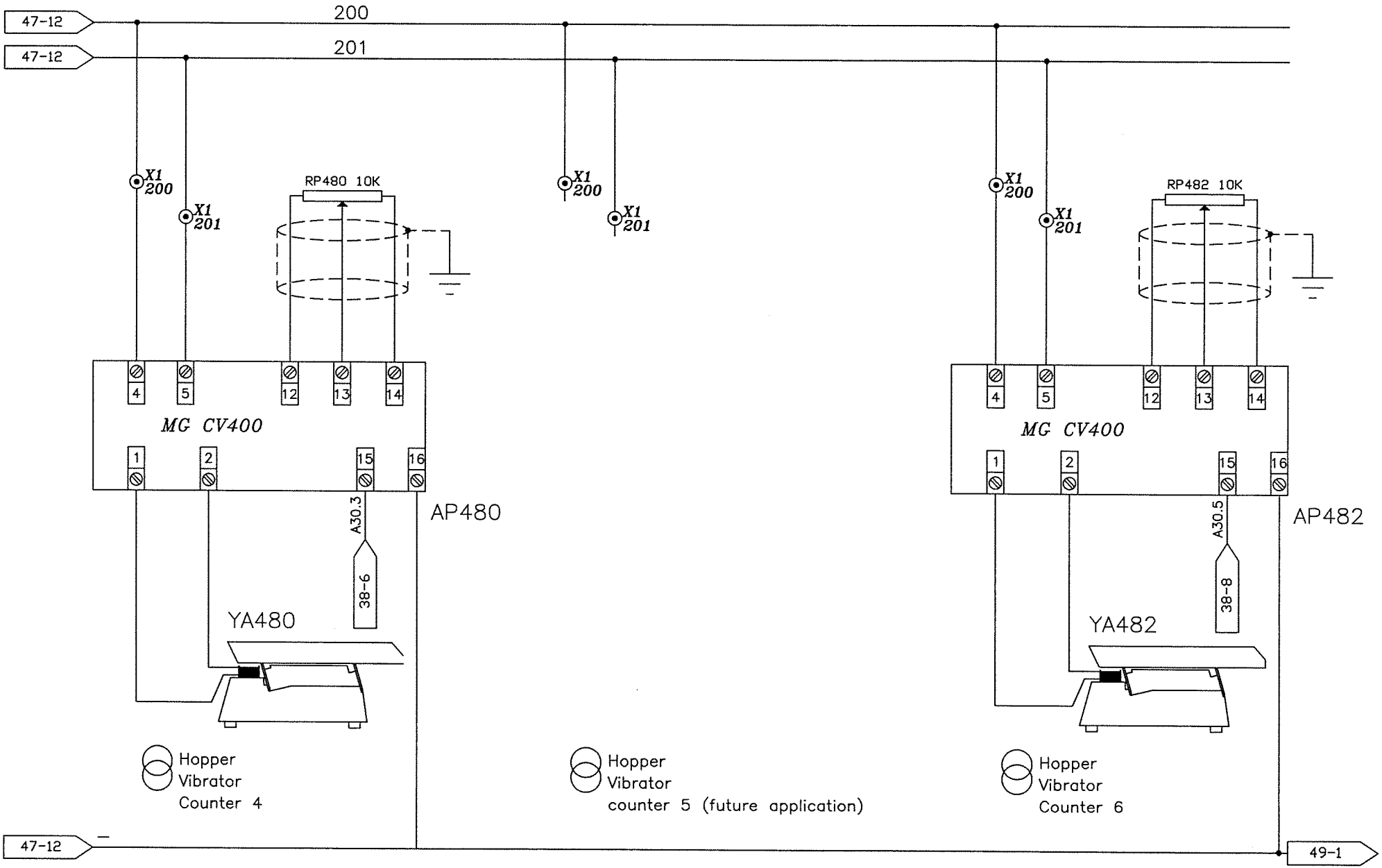
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*47 / 48*
Gruppo	**Esec.**	**Data**	**Dis. N°**
ALIMENTAZIONE TRAMOGGE	*C.J.*	*23/05/2005*	910



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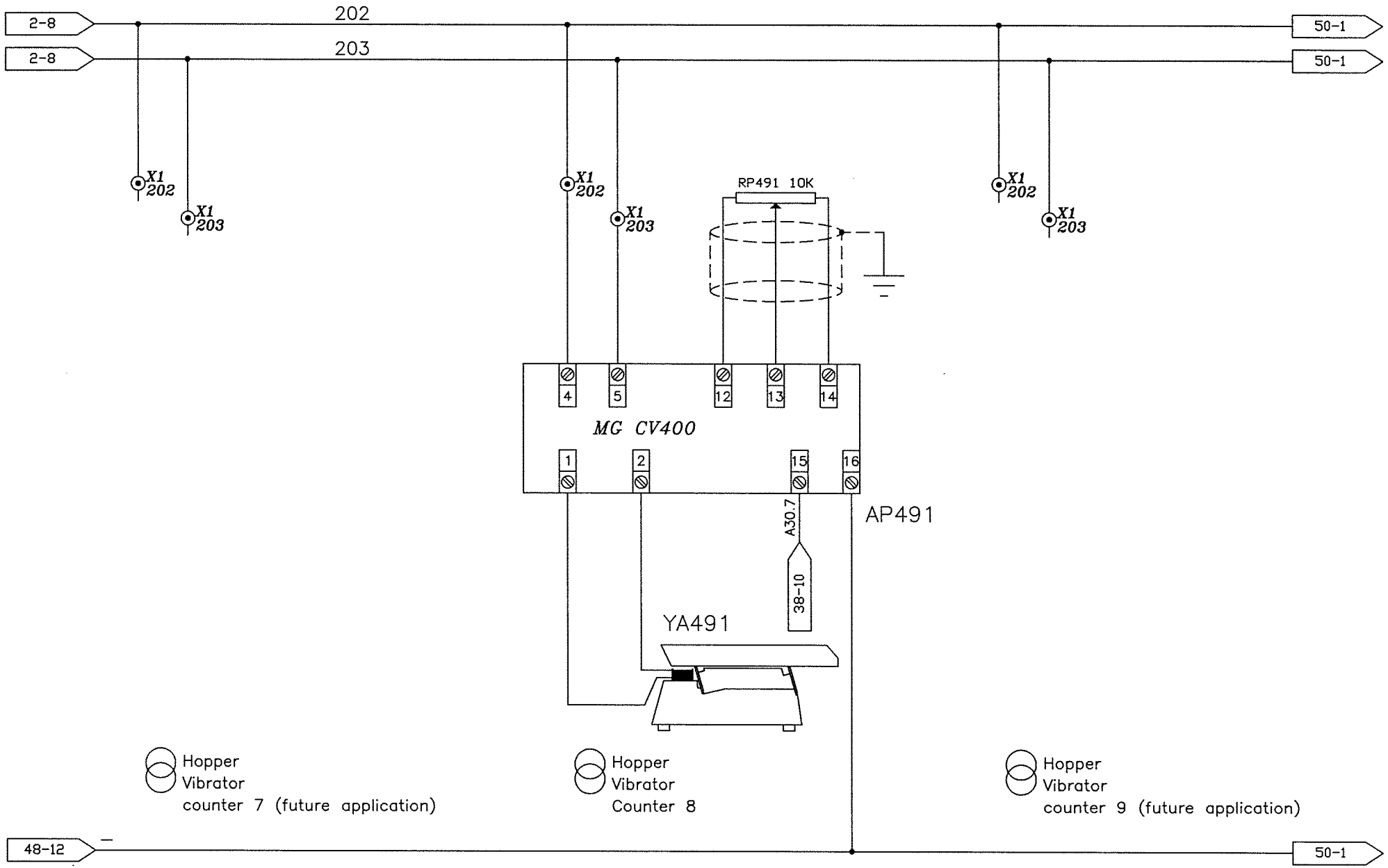
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*48 / 49*
Gruppo	**Esec.**	**Data**	**Dis. N°**
ALIMENTAZIONE TRAMOGGE	*C.f.*	*23/05/2005*	910



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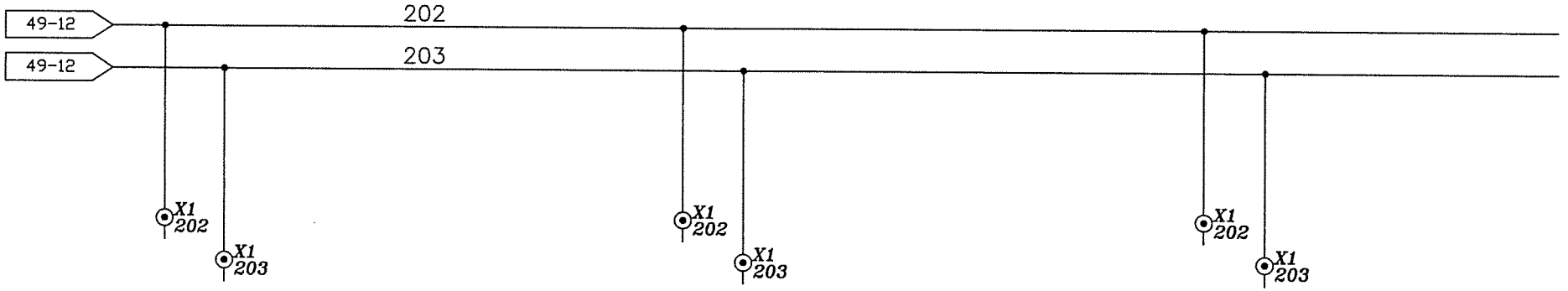
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*49 / 50*
Gruppo	**Esec.**	**Data**	**Dis. N°**
ALIMENTAZIONE TRAMOGGE	*C.f.*	*23/05/2005*	910



Hopper vibrator counter 10 (future application)

Hopper Vibrator counter 11 (future application)

Hopper Vibrator counter 12 (future application)

49-12

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Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	50 / 51
Gruppo	**Esec.**	**Data**	**Dis. N°**
ALIMENTAZIONE TRAMOGGE	C.J.	23/05/2005	910

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

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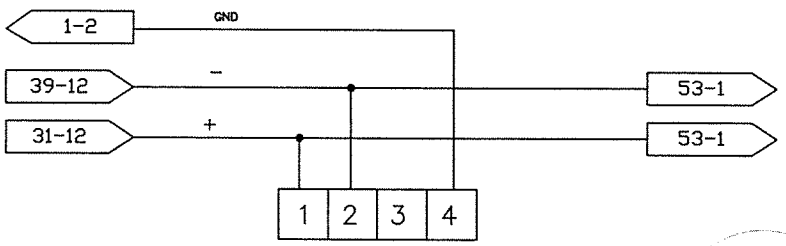
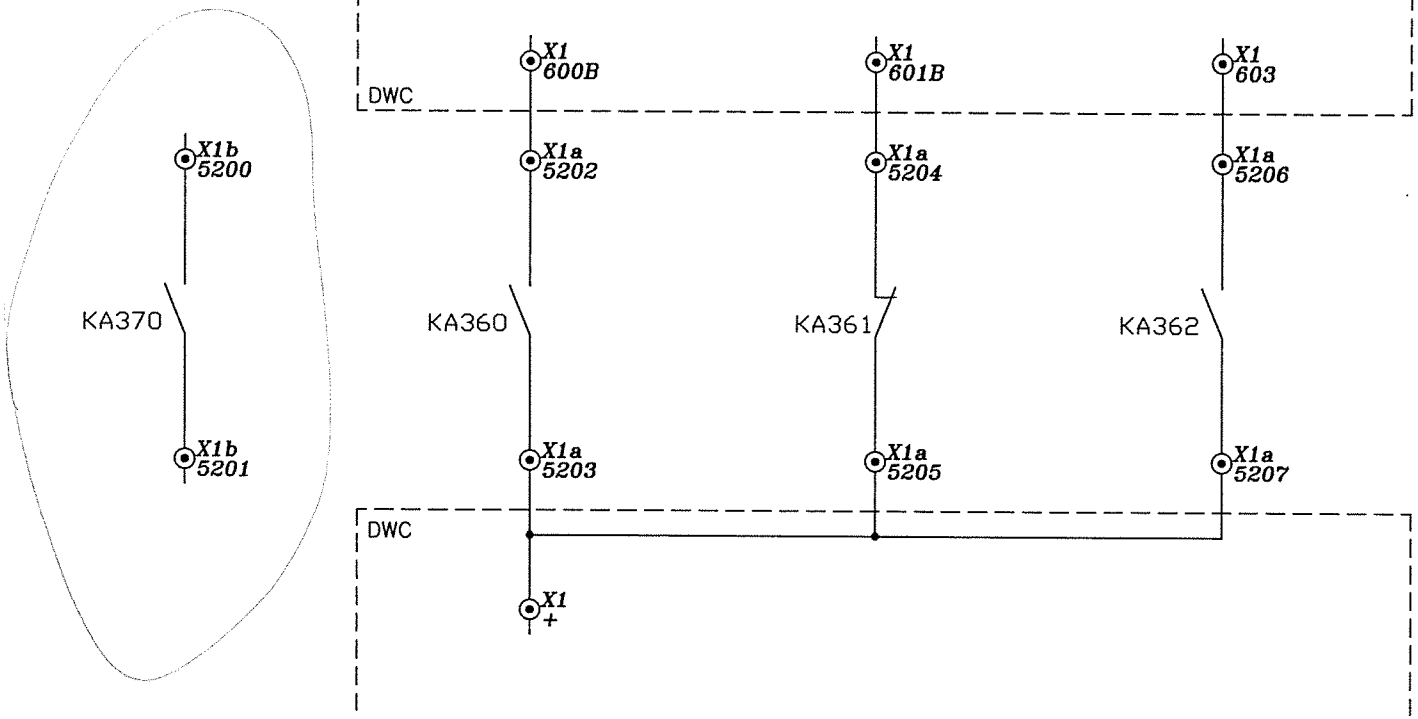
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*51 / 52*
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	*C.f.*	*23/05/2005*	910



OP17 SIEMENS KEYPAD



Signal to printer (orange wire 1,5 mmq)

Start DWC Counter (orange wire 1,5 mmq)

Stop DWC Counter (Orange wire 1,5 mmq)

Signal to discharge to DWC (orange wire 1,5 mmq)

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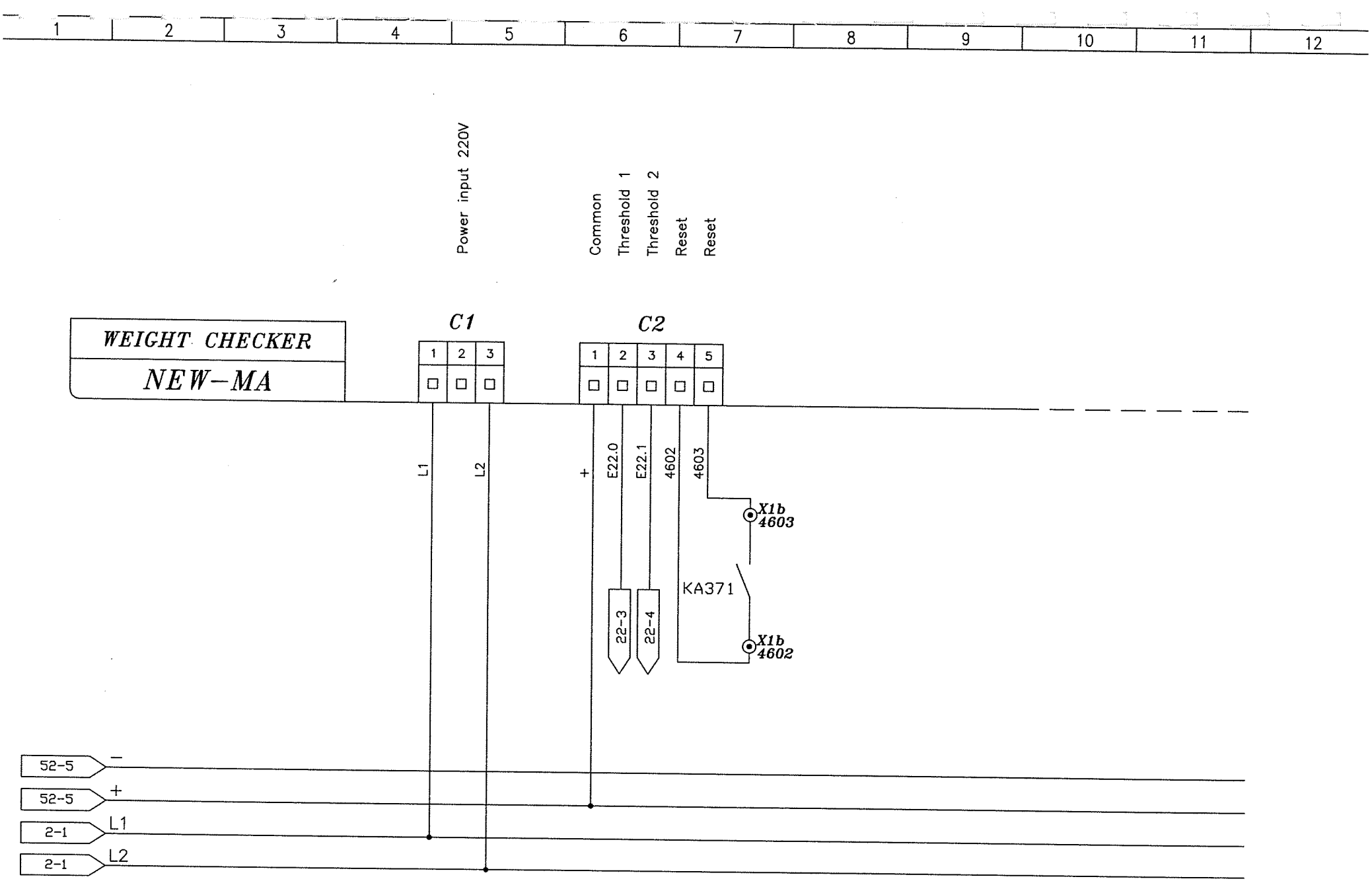
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*52 / 53*
Gruppo	**Esec.**	**Data**	**Dis. N°**
SINCRONISMI	*C.f.*	*23/05/2005*	910



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Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	53 / 54
Gruppo	**Esec.**	**Data**	**Dis. N°**
CONTROLLO PESO	C.f.	23/05/2005	910

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

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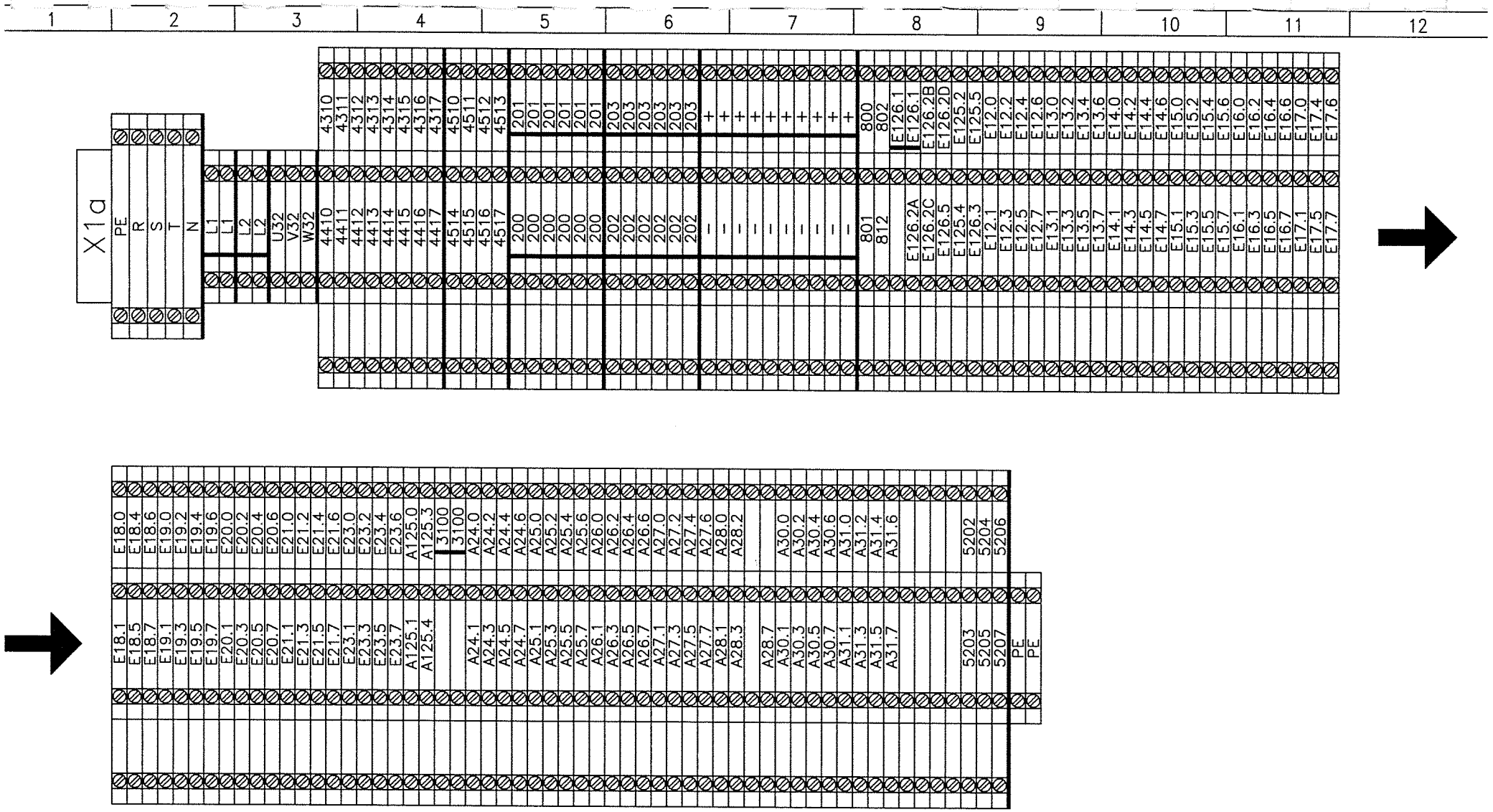
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*54 / 55*
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	*C.f.*	*23/05/2005*	910



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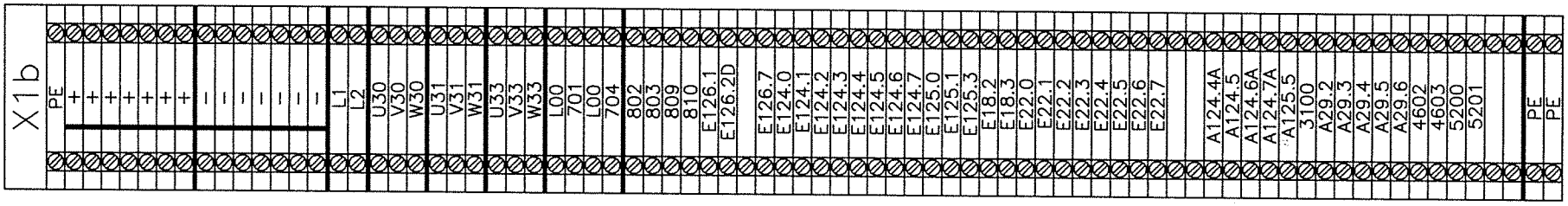
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*55 / 56*
Gruppo	**Esec.**	**Data**	**Dis. N°**
MORSETTIERA	*C.f.*	*23/05/2005*	910



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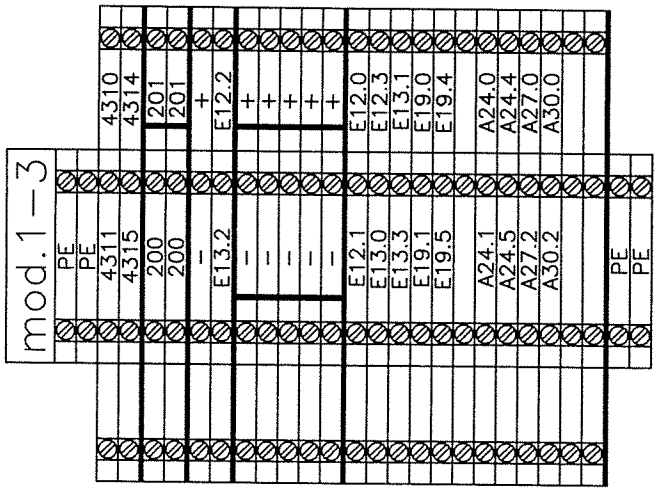
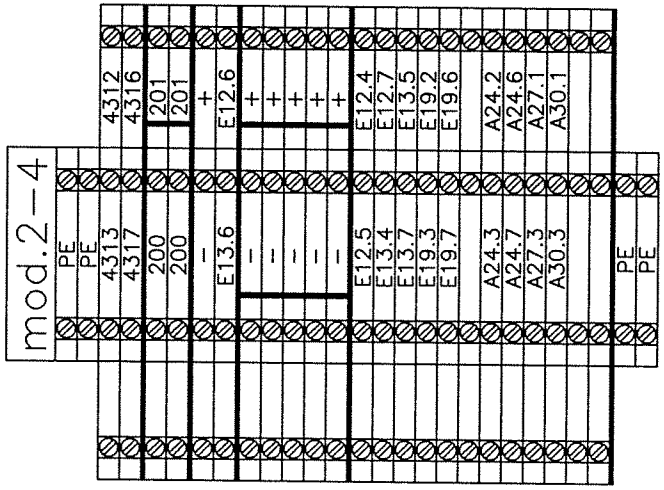
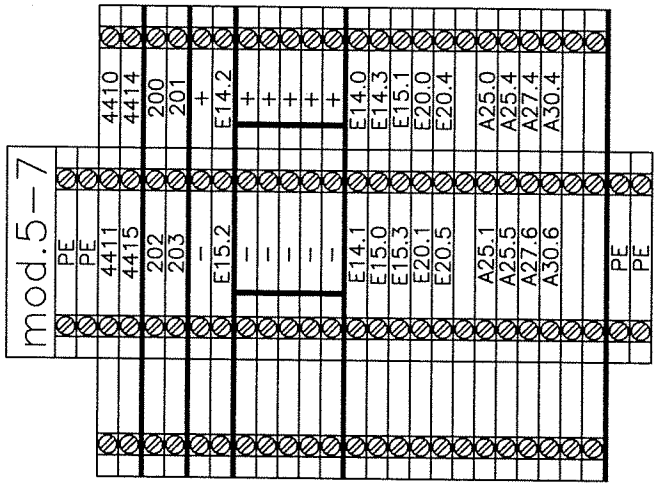
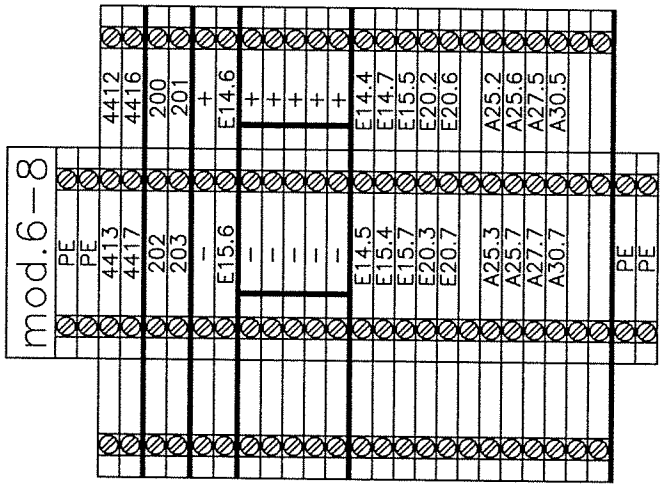
Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	910	Canmade Inc.	56 / 57
Gruppo	**Esec.**	**Data**	**Dis. N°**
MORSETTIERA	C.f.	23/05/2005	910









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Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*57 / 58*
Gruppo	**Esec.**	**Data**	**Dis. N°**
MORSETTIERA	*C.f.*	*23/05/2005*	910

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

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Macchina	Mat.	Cliente	Foglio / Segue
Vert.560	*910*	*Canmade Inc.*	*58 / 59*
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	*C.f.*	*23/05/2005*	910

PLC inputs

E124.0 Encoder CHA
E124.1 Encoder CHB
E124.2 Free
E124.3 Free
E124.4 Photocell eye mark detection (future applic)
E124.5 Free
E124.6 Free
E124.7 Free

E125.0 Start film reel
E125.1 Stop film reel
E125.2 Micro switch belt step
E125.3 Jaws closed
E125.4 Pedal for discharge from manual table
E125.5 Bucket on manual table closed
E125.6 Vertical sealing wire broken alarm
E125.7 Horizontal sealing wire broken alarm

E126.0 Emergencies check
E126.1 Start
E126.2 Stop
E126.3 Pressure swicth
E126.4 Overload switches failure
E126.5 Free
E126.6 Film unwind button
E126.7 Film reel is over

E12.0 Lower bucket closed counter 1
E12.1 Upper bucket closed counter 1
E12.2 Photocell: product is through counter 1
E12.3 No product on counter 1 (future appl.)
E12.4 Lower bucket closed counter 2
E12.5 Upper bucket closed counter 2
E12.6 Photocell: product is through counter 2
E12.7 No product on counter 2 (future appl.)

E13.0 Lower bucket closed counter 3
E13.1 Upper bucket closed counter 3
E13.2 Photocell: product is through counter 3
E13.3 No product on counter 3 (future appl.)
E13.4 Lower bucket closed counter 4
E13.5 Upper bucket closed counter 4
E13.6 Photocell: product is through counter 4
E13.7 No product on counter 4 (future appl.)

E14.0 Lower bucket closed counter 5
E14.1 Upper bucket closed counter 5
E14.2 Photocell: product is through counter 5
E14.3 No product on counter 5 (future appl.)
E14.4 Lower bucket closed counter 6
E14.5 Upper bucket closed counter 6
E14.6 Photocell: product is through counter 6
E14.7 No product on counter 6 (future appl.)

E15.0 Lower bucket closed counter 7
E15.1 Upper bucket closed counter 7
E15.2 Photocell: product is through counter 7
E15.3 No product on counter 7 (future appl.)
E15.4 Lower bucket closed counter 8
E15.5 Upper bucket closed counter 8
E15.6 Photocell: product is through counter 8
E15.7 No product on counter 8 (future appl.)

E16.0 Lower bucket closed counter 9 (future appl.)
E16.1 Upper bucket closed counter 9 (future appl.)
E16.2 Photocell: product is through counter 9 (future appl.)
E16.3 No product on counter 9 (future appl.)
E16.4 Lower bucket closed counter 10 (future appl.)
E16.5 Upper bucket closed counter 10 (future appl.)
E16.6 Photocell: product is through counter 10 (future appl.)
E16.7 No product on counter 10 (future appl.)

PLC Inputs

E17.0 Lower bucket closed counter 11
E17.1 Upper bucket closed counter 11
E17.2 Photocell: product is through counter 11
E17.3 No product on counter 11 (future appl.)
E17.4 Lower bucket closed counter 12
E17.5 Upper bucket closed counter 12
E17.6 Photocell: product is through counter 12
E17.7 No product on counter 12 (future appl.)

E18.0 Exclude signal for maual loading
E18.1 Free
E18.2 Free
E18.3 Printer failure
E18.4 Weight is ready on DWC
E18.5 Discharge is over from DWC
E18.6 Alarms present on DWC
E18.7 Free

E19.0 Increase vibrations on counter 1
E19.1 Decrease vibrations on counter 1
E19.2 Increase vibrations on counter 2
E19.3 Decrease vibrations on counter 2
E19.4 Increase vibrations on counter 3
E19.5 Decrease vibrations on counter 3
E19.6 Increase vibrations on counter 4
E19.7 Decrease vibrations on counter 4

E20.0 Increase vibrations on counter 5
E20.1 Decrease vibrations on counter 5
E20.2 Increase vibrations on counter 6
E20.3 Decrease vibrations on counter 6
E20.4 Increase vibrations on counter 7
E20.5 Decrease vibrations on counter 7
E20.6 Increase vibrations on counter 8
E20.7 Decrease vibrations on counter 8

E21.0 Increase vibrations on counter 9
E21.1 Decrease vibrations on counter 9
E21.2 Increase vibrations on counter 10
E21.3 Decrease vibrations on counter 10
E21.4 Increase vibrations on counter 11
E21.5 Decrease vibrations on counter 11
E21.6 Increase vibrations on counter 12
E21.7 Decrease vibrations on counter 12

E22.0 Threshold 1 (weight OK)
E22.1 Threshold 2 (weight to be rejected)
E22.2 Photocell: boxes present on infeed belt (future appl.)
E22.3 Photocell: boxes present on outfeed belt (future appl.)
E22.4 Photocell: too many boxes on outfeed belt (future appl.)
E22.5 Cylinder to load boxes is completely backward (future appl.)
E22.6 Cylinder to unload boxes is completely backward (future appl.)
E22.7 Free

E23.0 Free
E23.1 Free
E23.2 Free
E23.3 Free
E23.4 Free
E23.5 Free
E23.6 Free
E23.7 Free

PLC outputs

A124.0 Film reel unwind
A124.1 Film pulling
A124.2 Infeed belt
A124.3 Outfeed belt
A124.4 EV vertical jaws
A124.5 EV horizontal sealing jaws
A124.6 EV Knife
A124.7 EV Horizontal Jaws

A125.0 Pilot light: alarms
A125.1 Pilot light: no product present
A125.2 Automatic cycle
A125.3 Pilot light: signal to discharge
A125.4 EV bucket on manual loading
A125.5 EV air blow
A125.6 Vertical sealing
A125.7 Horizontal sealing

A24.0 EV upper bucket counter 1
A24.1 EV lower bucket counter 1
A24.2 EV upper bucket counter 2
A24.3 EV lower bucket counter 2
A24.4 EV upper bucket counter 3
A24.5 EV lower bucket counter 3
A24.6 EV upper bucket counter 4
A24.7 EV lower bucket counter 4

A25.0 EV upper bucket counter 5
A25.1 EV lower bucket counter 5
A25.2 EV upper bucket counter 6
A25.3 EV lower bucket counter 6
A25.4 EV upper bucket counter 7
A25.5 EV lower bucket counter 7
A25.6 EV upper bucket counter 8
A25.7 EV lower bucket counter 8

A26.0 EV upper bucket counter 9 (future appl.)
A26.1 EV lower bucket counter 9 (future appl.)
A26.2 EV upper bucket counter 10 (future appl.)
A26.3 EV lower bucket counter 9 (future appl.)
A26.4 EV upper bucket counter 11 (future appl.)
A26.5 EV lower bucket counter 11 (future appl.)
A26.6 EV upper bucket counter 12 (future appl.)
A26.7 EV lower bucket counter 12 (future appl.)

A27.0 EV Air blow on counter 1
A27.1 EV Air blow on counter 2
A27.2 EV Air blow on counter 3
A27.3 EV Air blow on counter 4
A27.4 EV Air blow on counter 5
A27.5 EV Air blow on counter 6
A27.6 EV Air blow on counter 7
A27.7 EV Air blow on counter 8

A28.0 EV Air blow on counter 9
A28.1 EV Air blow on counter 10
A28.2 EV Air blow on counter 11
A28.3 EV Air blow on counter 12
A28.4 Start DWC counter
A28.5 Stop DWC counter
A28.6 Signal to discharge from DWC
A28.7 Free

A29.0 Printer failure
A29.1 Self reset weight checker (future appl.)
A29.2 Boxes infeed belt (future appl.)
A29.3 Boxes outfeed belt (future appl.)
A29.4 EV box loading (future appl.)
A29.5 Ev unload box (future appl.)
A29.6 EV block box (future appl.)
A29.7 Power to vibrators' cards

PLC outputs

A30.0 Hopper on counter 1 (future appl.)
A30.1 Hopper on counter 2
A30.2 Hopper on counter 3 (future appl.)
A30.3 Hopper on counter 4
A30.4 Hopper on counter 5 (future appl.)
A30.5 Hopper on counter 6
A30.6 Hopper on counter 7 (future appl.)
A30.7 Hopper on counter 8

A31.0 Hopper on counter 9
A31.1 Hopper on counter 10
A31.2 Hopper on counter 11
A31.3 Hopper on counter 12
A31.4 Free
A31.5 Free
A31.6 Free
A31.7 Free

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

WIRING DIAGRAMS

DWC COUNTER

230 Vac 60 Hz
1PH+N

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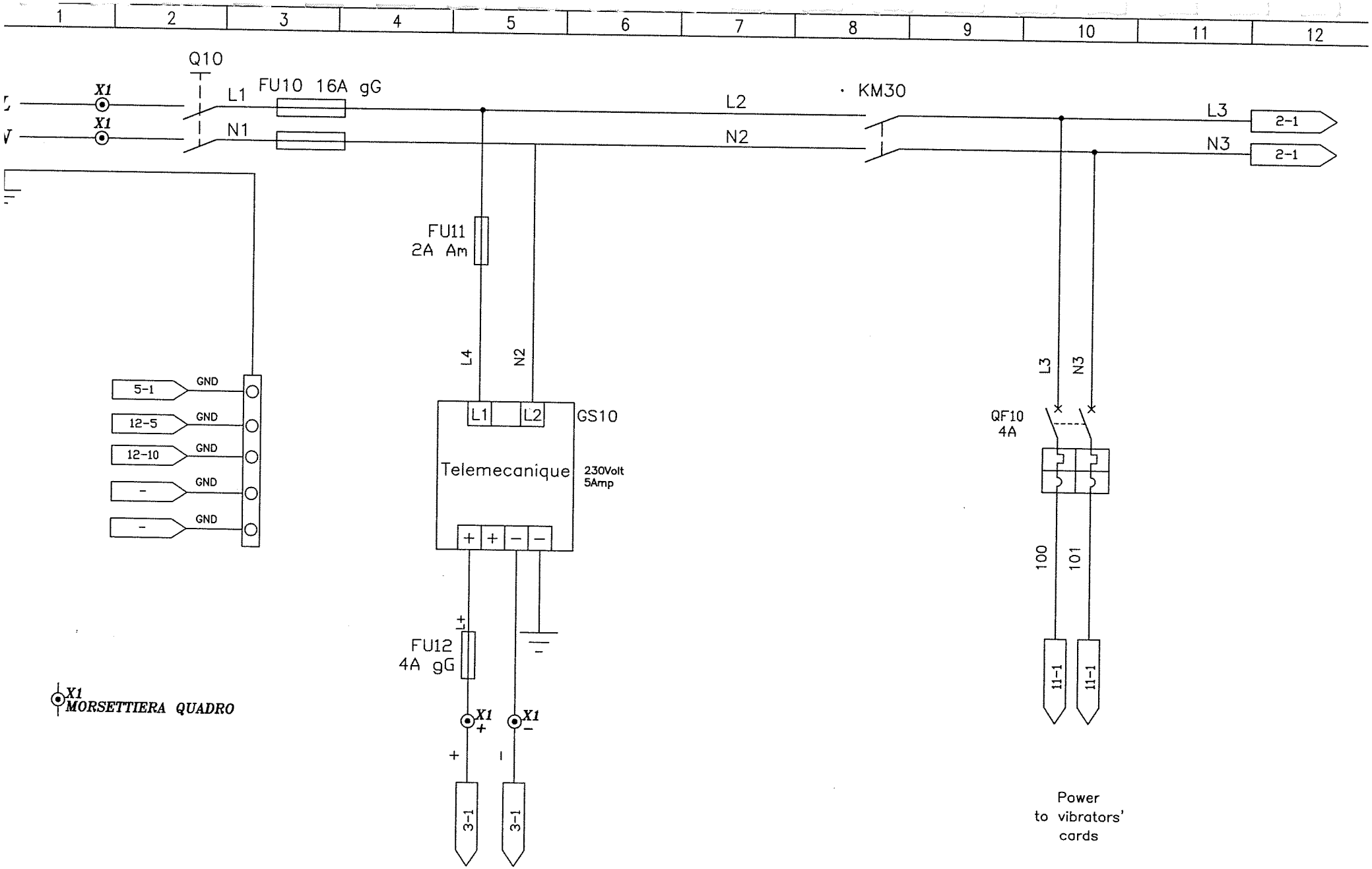
Macchina	Mat.	Cliente	Foglio / Segue
DWC	910	Canmade Inc.	0 / 1
Gruppo	**Esec.**	**Data**	**Dis. N°**
	C.J.	23/05/2005	910



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Macchina	Mat.	Cliente	Foglio / Segue
DWC	*910*	*Canmade Inc.*	*1 / 2*
Gruppo	**Esec.**	**Data**	**Dis. N°**
ALIMENTAZIONI	*C.J.*	*23/05/2005*	910

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

1-12 L3

1-12 N3

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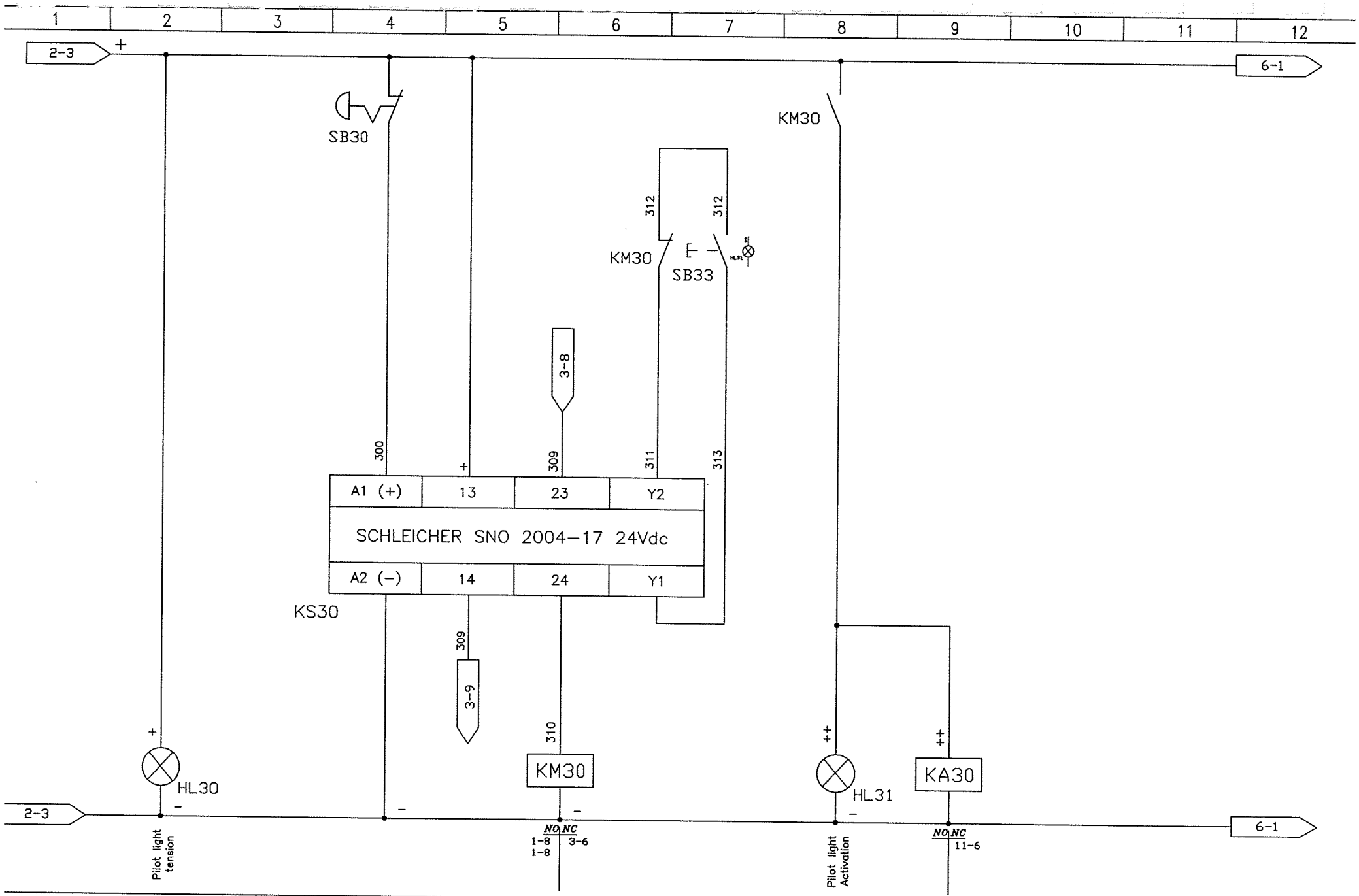
Macchina	Mat.	Cliente	Foglio / Segue
DWC	910	Canmade Inc.	2 / 3
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	C.f.	23/05/2005	910



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Macchina	Mat.	Cliente	Foglio / Segue
DWC	910	Canmade Inc.	3 / 4
Gruppo	**Esec.**	**Data**	**Dis. N°**
EMERGENZA	C.f.	23/05/2005	910

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

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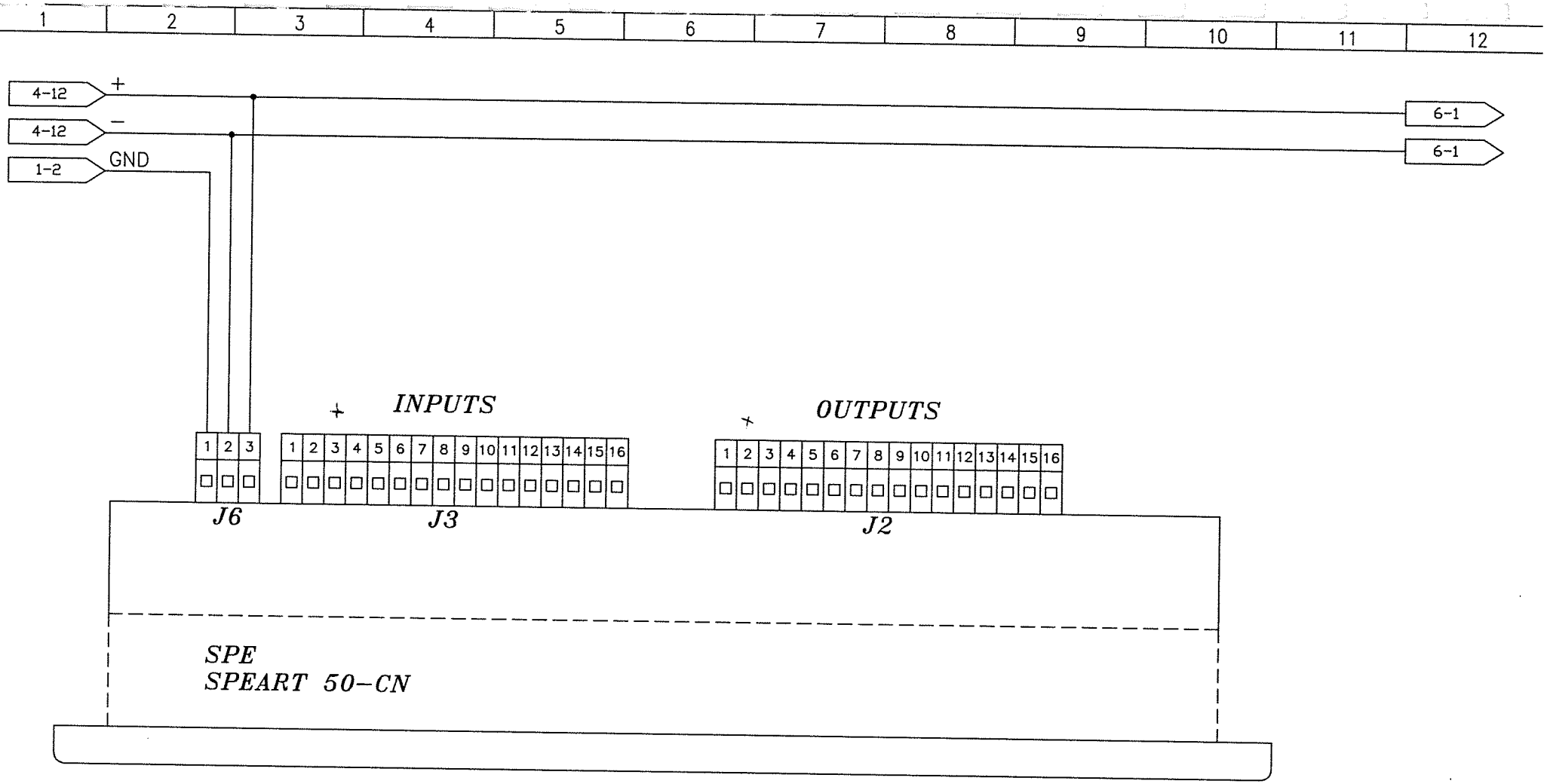
Macchina	Mat.	Cliente	Foglio / Segue
DWC	*910*	*Canmade Inc.*	*4 / 5*
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	*C. f.*	*23/05/2005*	*910*



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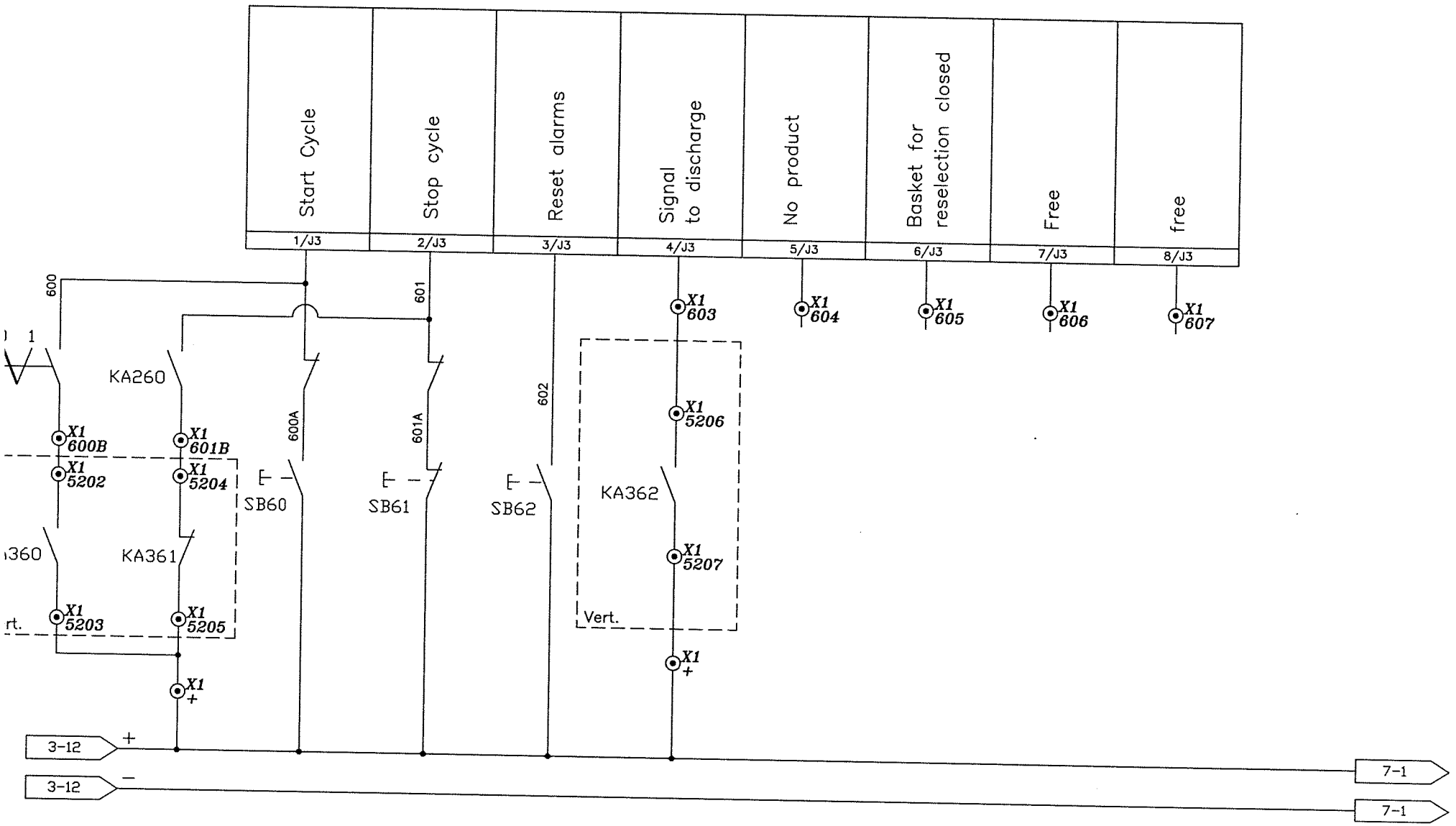
Macchina	Mat.	Cliente	Foglio / Segue
DWC	910	Canmade Inc.	5 / 6
Gruppo	**Esec.**	**Data**	**Dis. N°**
ALIMENTAZIONE CONTROLLO	C.f.	23/05/2005	910

INPUTS SPEART 50–CN



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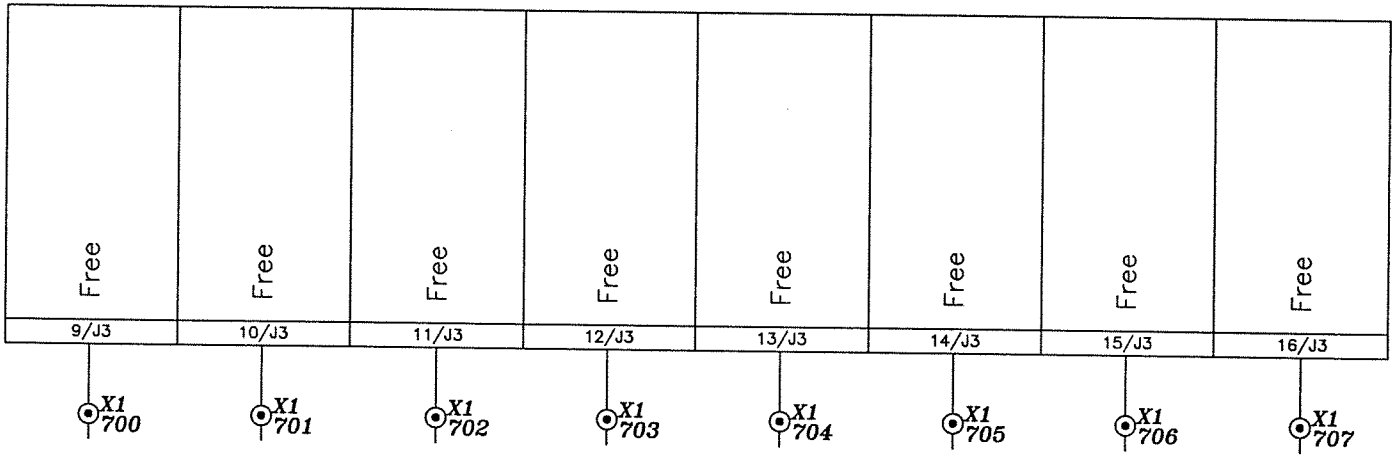
Macchina: DWC	Mat.: 910	Cliente: Canmade Inc.	Foglio: 6 / 7	Segue
Gruppo: INGRESSI	Esec.: C.J.	Data: 23/05/2005	Dis. N°: 910	

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

INPUTS SPEART 50-CN



6-12 +

6-12 −

15-1

8-1

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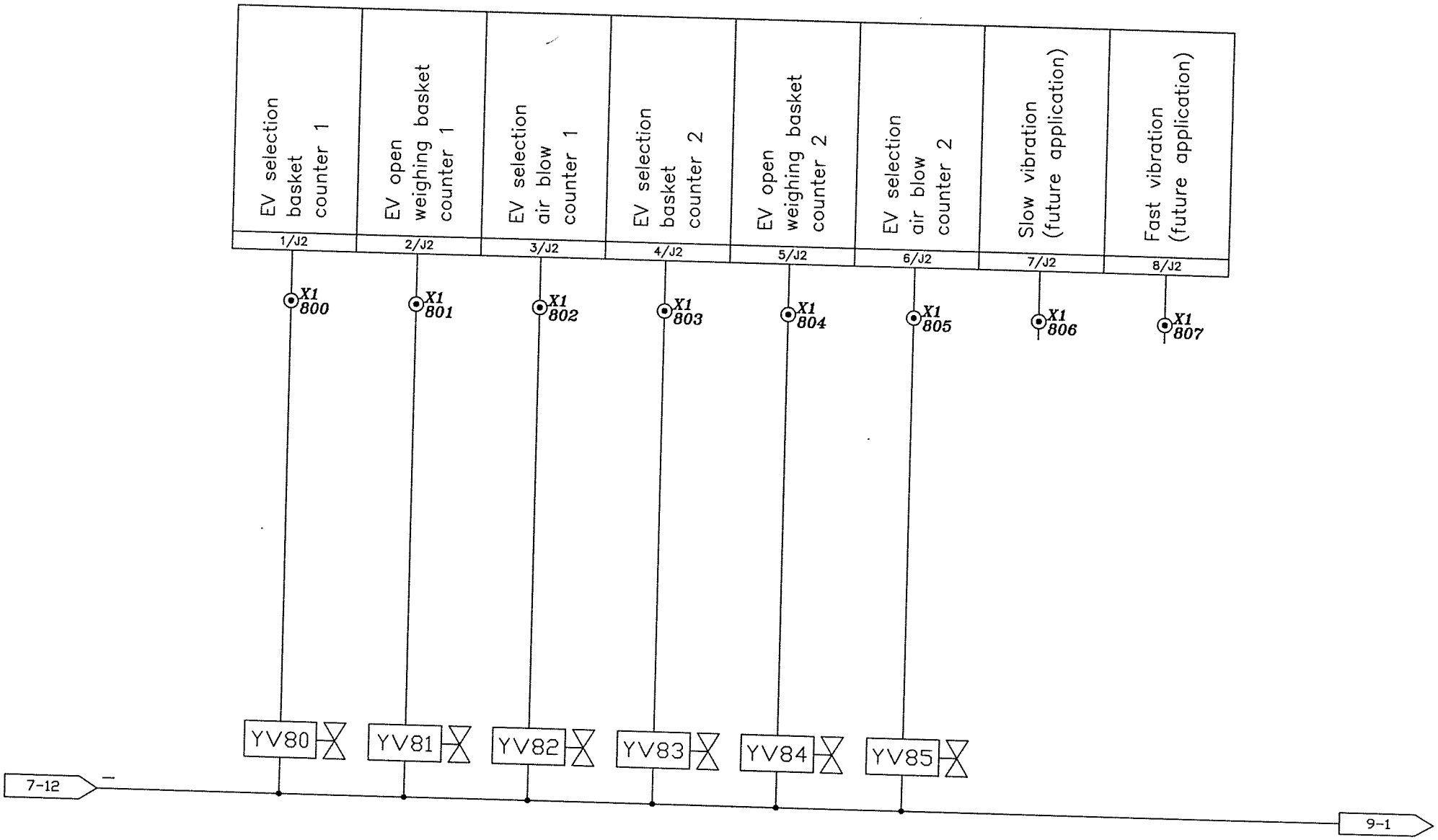
Macchina	Mat.	Cliente	Foglio / Segue
DWC	910	Canmade Inc.	7 / 8
Gruppo	**Esec.**	**Data**	**Dis. N°**
INGRESSI	C.f.	23/05/2005	910

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

OUTPUTS SPEART 50–CN



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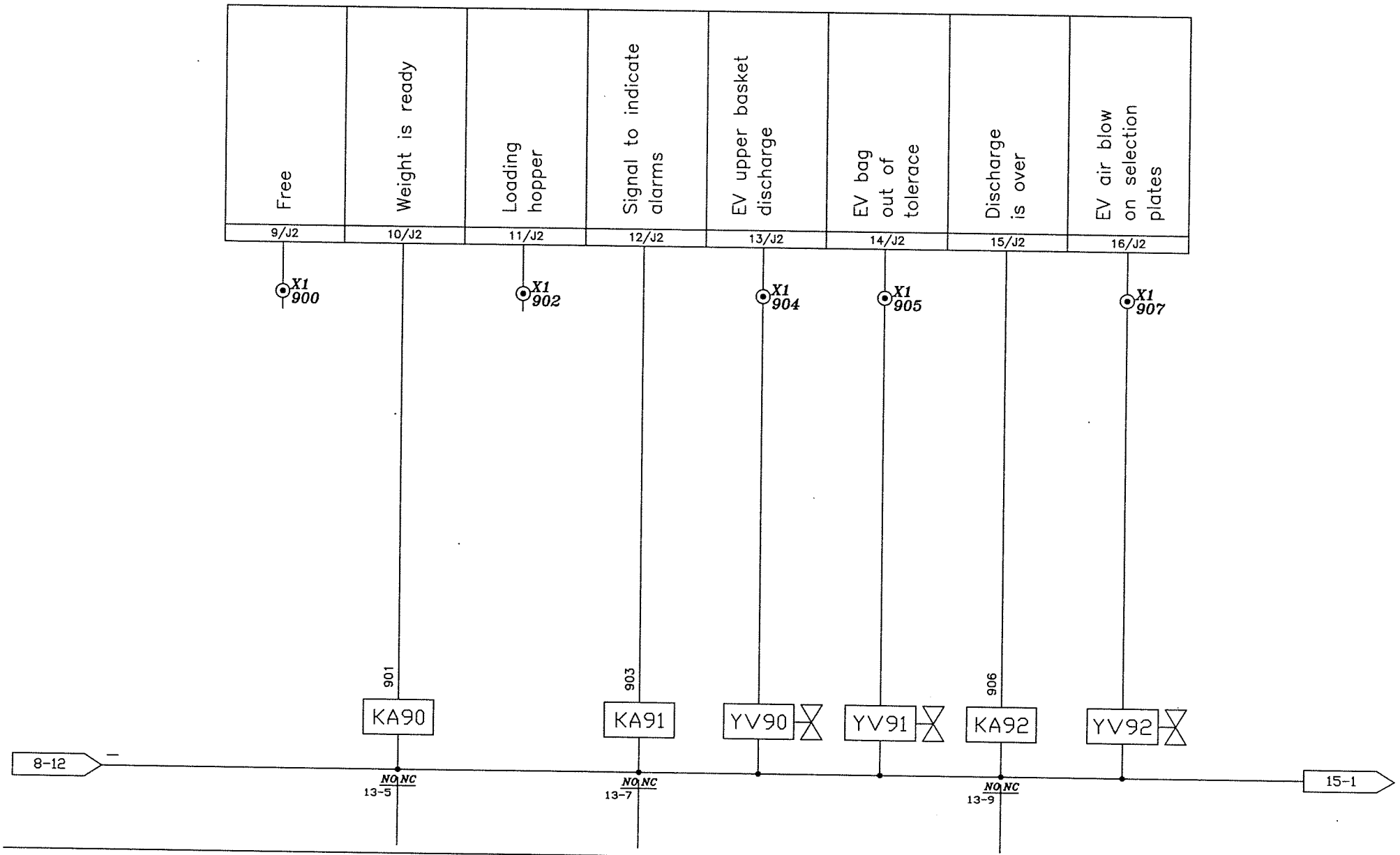
Macchina	Mat.	Cliente	Foglio / Segue
DWC	910	Canmade Inc.	8 / 9
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE	C.J.	23/05/2005	910

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

USCITE SPEART 50-CN



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Macchina	Mat.	Cliente	Foglio / Segue
DWC	910	Canmade Inc.	9 / 10
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE	C.J.	23/05/2005	910

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

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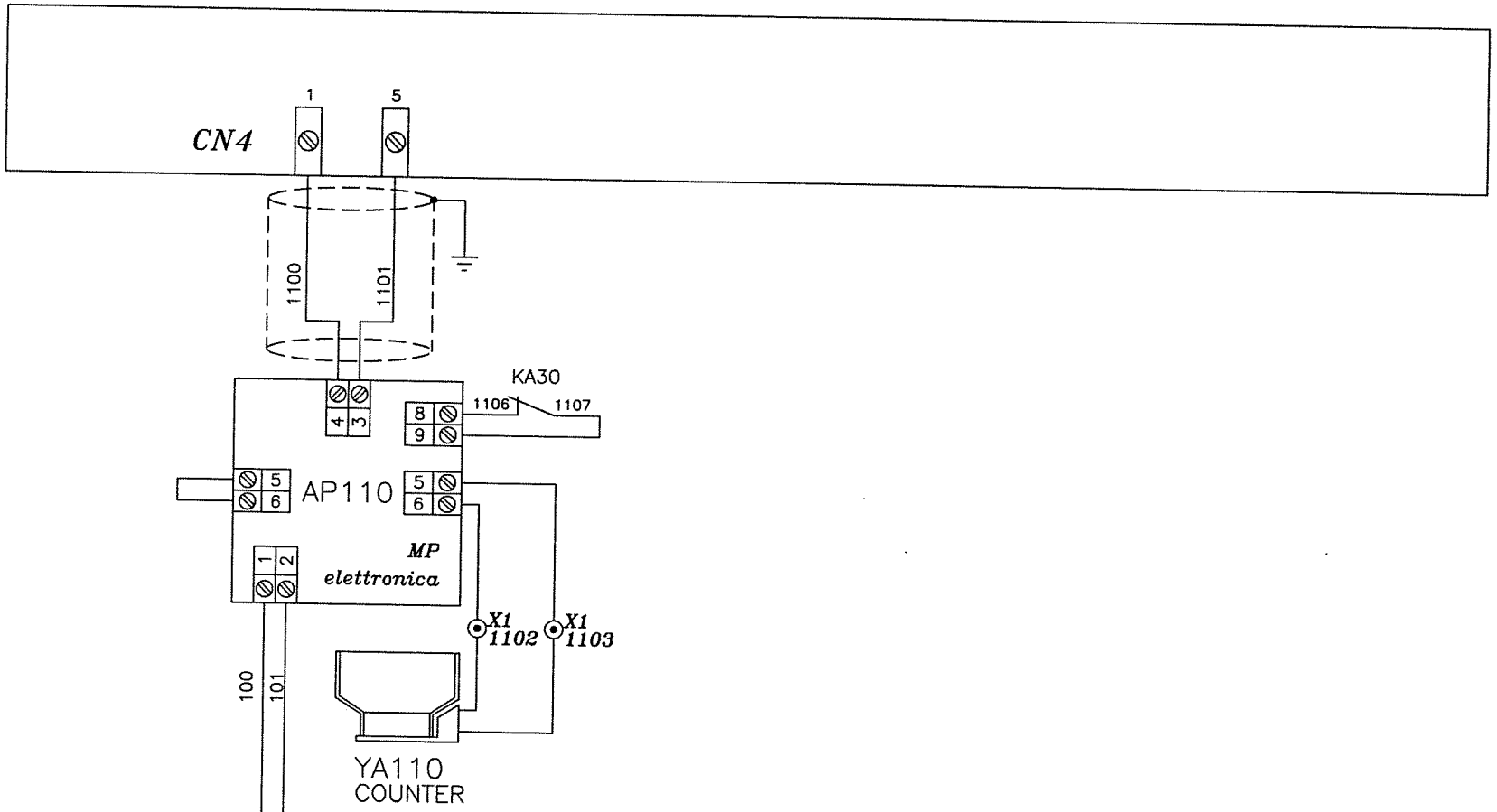
Macchina	Mat.	Cliente	Foglio / Segue
DWC	910	Canmade Inc.	10 / 11
Gruppo	**Esec.**	**Data**	**Dis. N°**
RISERVA	C.f.	23/05/2005	910

ANALOGIC OUTPUTS SPEART 50-CN



1-10 100

1-10 101

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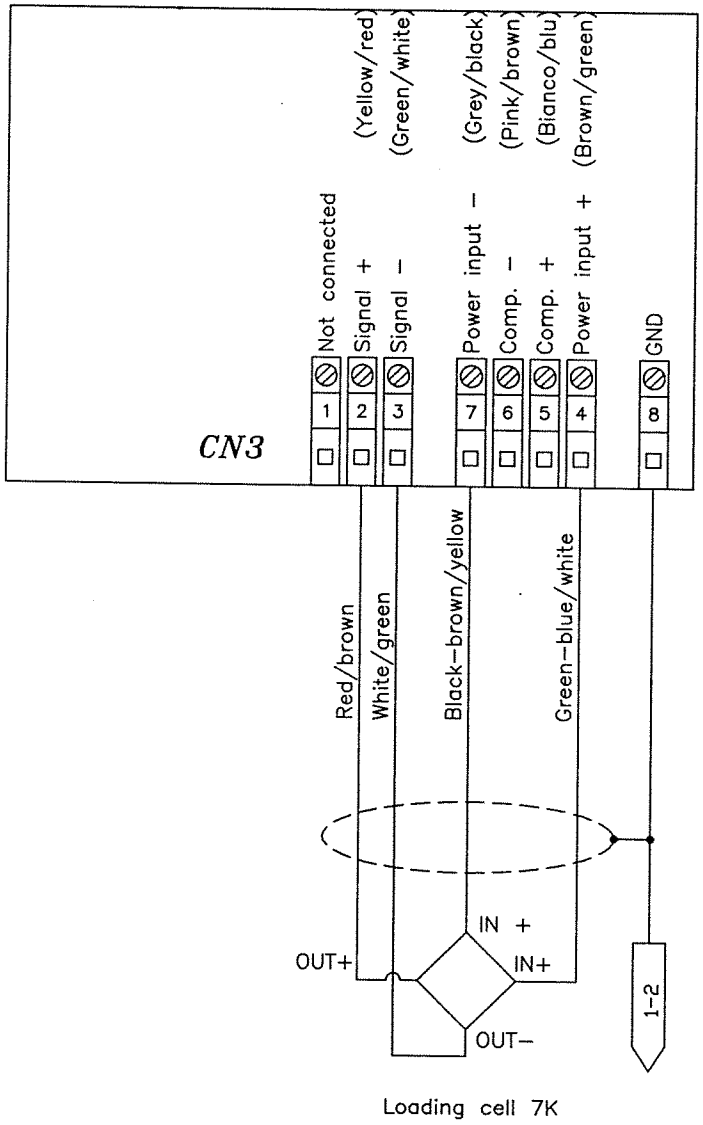
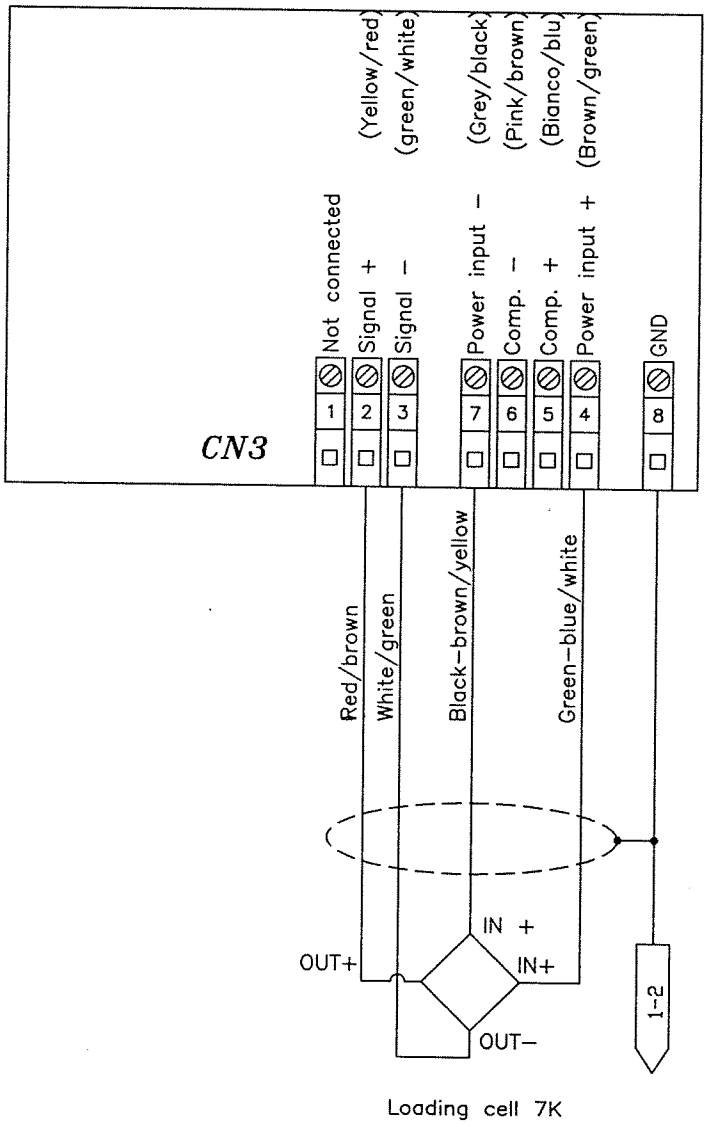
Macchina	Mat.	Cliente	Foglio / Segue
DWC	910	Canmade Inc.	11 / 12
Gruppo	**Esec.**	**Data**	**Dis. N°**
USCITE ANALOGICHE	C.f.	23/05/2005	910

SCALES1



Loading cell 7K

SCALES 2



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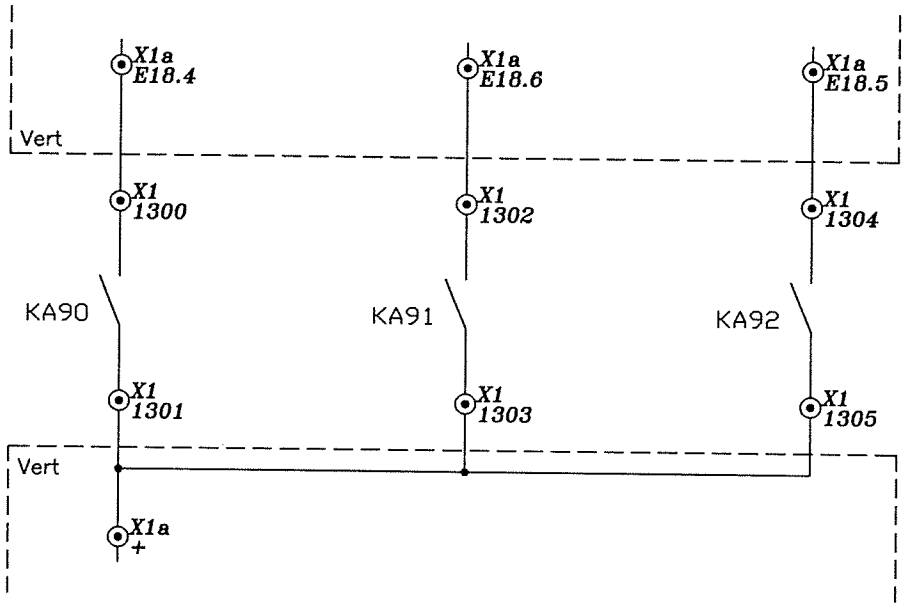
Macchina	Mat.	Cliente	Foglio / Segue
DWC	910	Canmade Inc.	12 / 13
Gruppo	**Esec.**	**Data**	**Dis. N°**
CELLE Di CARICO	C.f.	23/05/2005	910



Weight
is ready
(orange wire 1,5 mmq)

Signal indicating
alarms
(orange wire1,5 mmq)

Discharge is
over
(orange wire 1,5 mmq)

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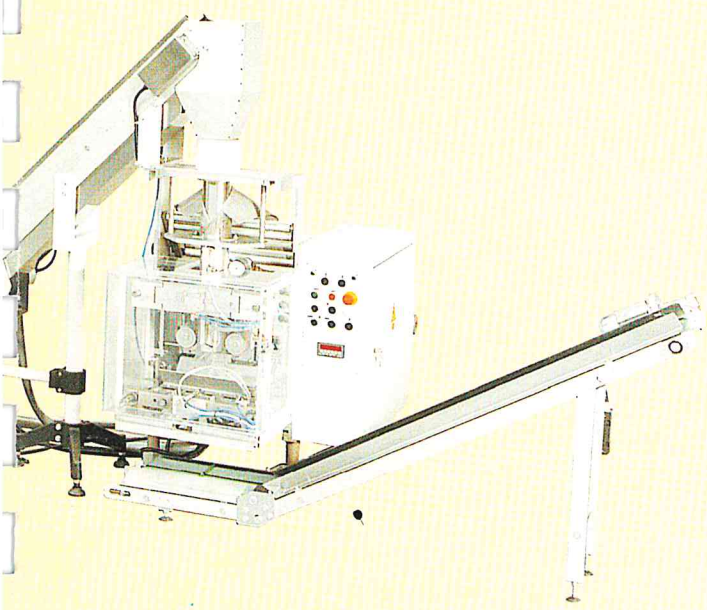
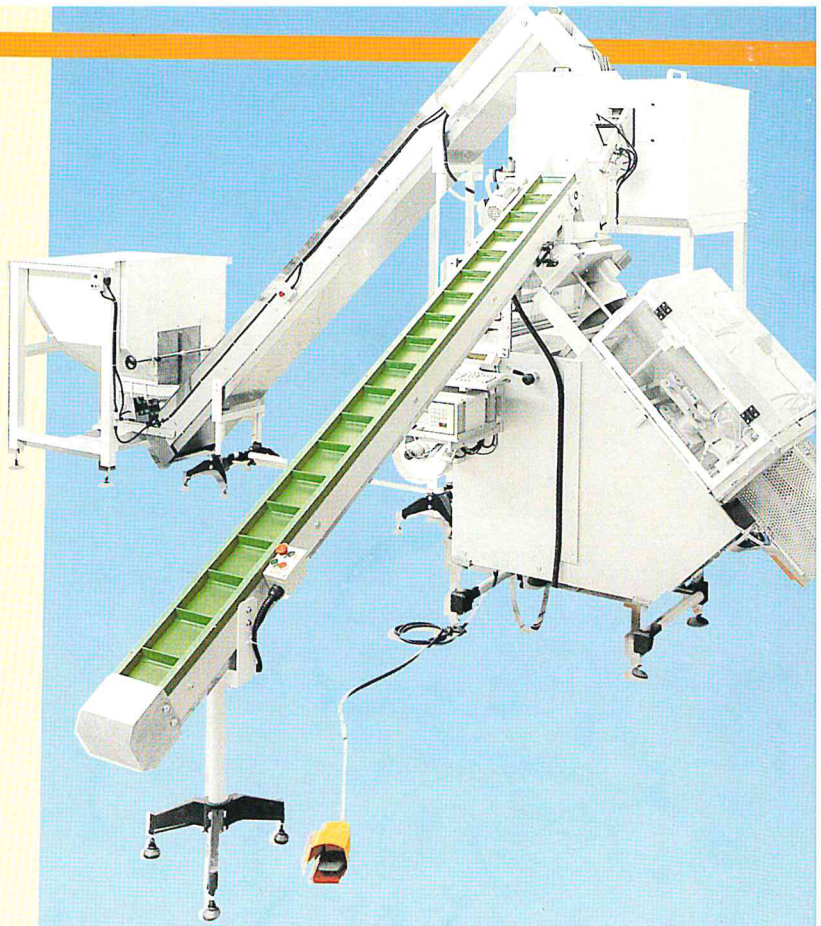
Macchina	Mat.	Cliente	Foglio / Segue
DWC	*910*	*Canmade Inc.*	*13 / 14*
Gruppo	**Esec.**	**Data**	**Dis. N°**
SINCRONISMI	*C. J.*	*23/05/2005*	910

Unsere Verpackungslinie ist dank unserer 20-jaehrigen Erfahrungen in diesem Bereich entstanden.
Das modulare Aufbausystem unserer Anlage ermoeglicht kundenspezifische Loesungen: von einfachen Maschinen mit manueller Beladung bis hin zu komplett automatisierten und unabhaengigen Linien.
Dank der einfachen Handhabung und der extrem hohen Zuverlaessigkeit, finden unsere Maschinen Anwendung in den unterschiedlichsten Industriebereichen: von Kleinarmaturen bis zu Befestigungselementen, von Dichtungen bis zu elektrischen Komponenten, von Metallkleinteilen bis zu Kunststoffteilen usw.

Notre gamme d'ensacheuses est le résultat d'une expérience dans ce secteur qui dure depuis vingt ans.
La modularité de nos lignes permet d'aboutir a la création de lignes personnalisées, a partir de simples machines a chargement manuel jusqu'a des lignes complètement automatiques et autonomes.
Grâce a leur semplicité d'utilisation et a leur extrème fiabilité, nos machines sont largement employées dans divers secteurs industriels comme par exemple: - les industries des raccords, - les élements de fixation, - les pièces metalliques, plastiques etc...





Linea automatica di conteggio e confezionamento raccordi composta da: **TRAMOGGIA DA 500 LT., NASTRO ELEVATORE, MODULO DI CONTEGGIO, CONFEZIONATRICE VERT. 560 PE INCLINATA, NASTRO INCLINATO PER CARICO MANUALE RACCORDI GROSSI.**

Automatische Zaehl-und Verpackungslinie fuer Verbindungsstuecke, bestehend aus: **Trichter von 500 Lt, Senkrechtfoerderband, Zaehluorrichtung schraege senkrechte Verpackungsmaschine 560 PE, schraeges Foerderband zur manuellen Ladung von grossen Verbindungsstuecken.**

Automatic counting and bagging line for pipe fittings, consisting of: **HOPPER OF 500 LT., ELEVATOR CONVEYOR, COUNTING UNIT, VERT. 560 MACHINE PE INCLINED, INCLINED CONVEYOR FOR MANUAL FEEDING FOR BIGGER ITEMS.**

Ligne automatique de comptage et d'emballage de raccords composée de: **TREMIE DE 500 LITRES, TAPIS ELEVATEUR, MODULE DE COMPTAGE, ENSACHEUSE VERT. 560 PE INCLINEE, TAPIS INCLINE POUR LE CHARGEMENT DES GROSSES PIECES.**

Zaehl-und Kitverpackungslinie fuer Siphon bestehend aus: **4 Zaehlvorrichtungen, Versorgungsband, senkrechte Verpackungsmaschine 400 PE.**

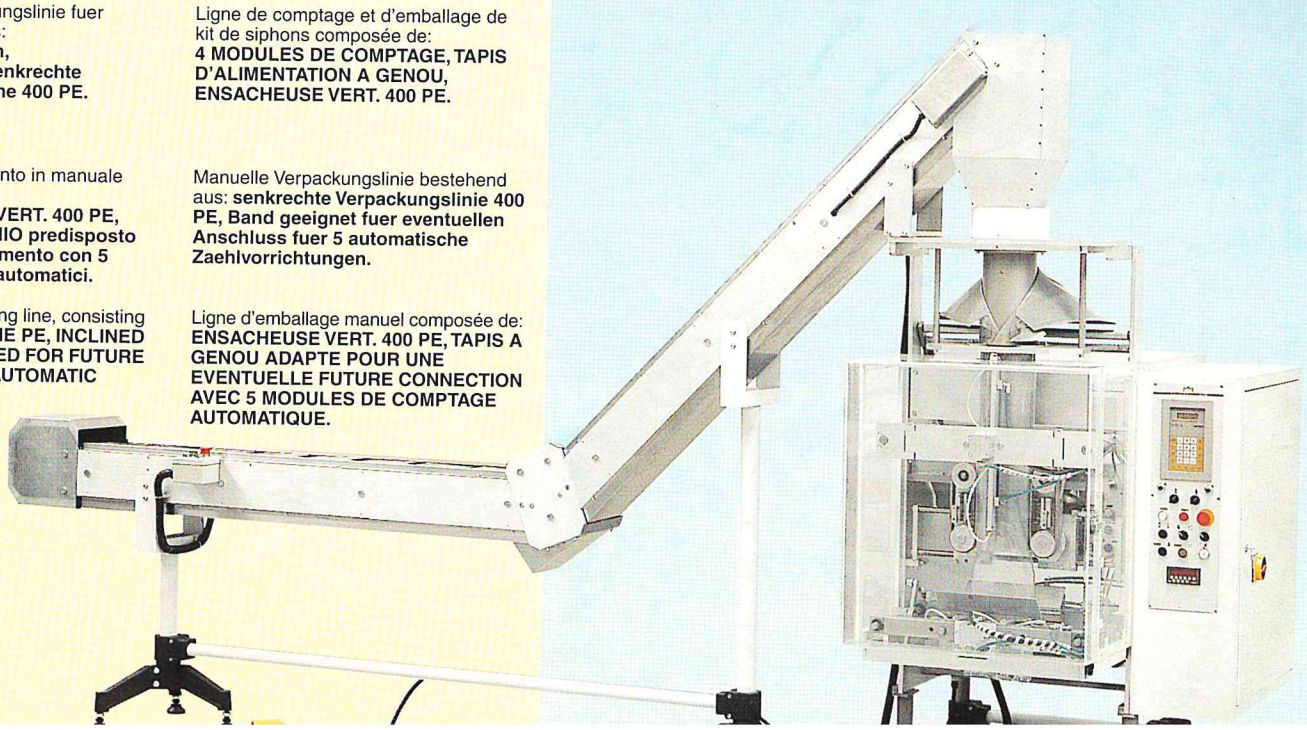
Ligne de comptage et d'emballage de kit de siphons composée de: **4 MODULES DE COMPTAGE, TAPIS D'ALIMENTATION A GENOU, ENSACHEUSE VERT. 400 PE.**

Linea di confezionamento in manuale composta da: **CONFEZIONATRICE VERT. 400 PE, NASTRO A GINOCCHIO predisposto per un futuro collegamento con 5 moduli di conteggio automatici.**

Manuelle Verpackungslinie bestehend aus: **senkrechte Verpackungslinie 400 PE, Band geeignet fuer eventuellen Anschluss fuer 5 automatische Zaehlvorrichtungen.**

Manual counting bagging line, consisting of: **VERT. 400 MACHINE PE, INCLINED CONVEYOR PREPARED FOR FUTURE CONNECTION OF 5 AUTOMATIC COUNTING UNITS.**

Ligne d'emballage manuel composée de: **ENSACHEUSE VERT. 400 PE, TAPIS A GENOU ADAPTE POUR UNE EVENTUELLE FUTURE CONNECTION AVEC 5 MODULES DE COMPTAGE AUTOMATIQUE.**

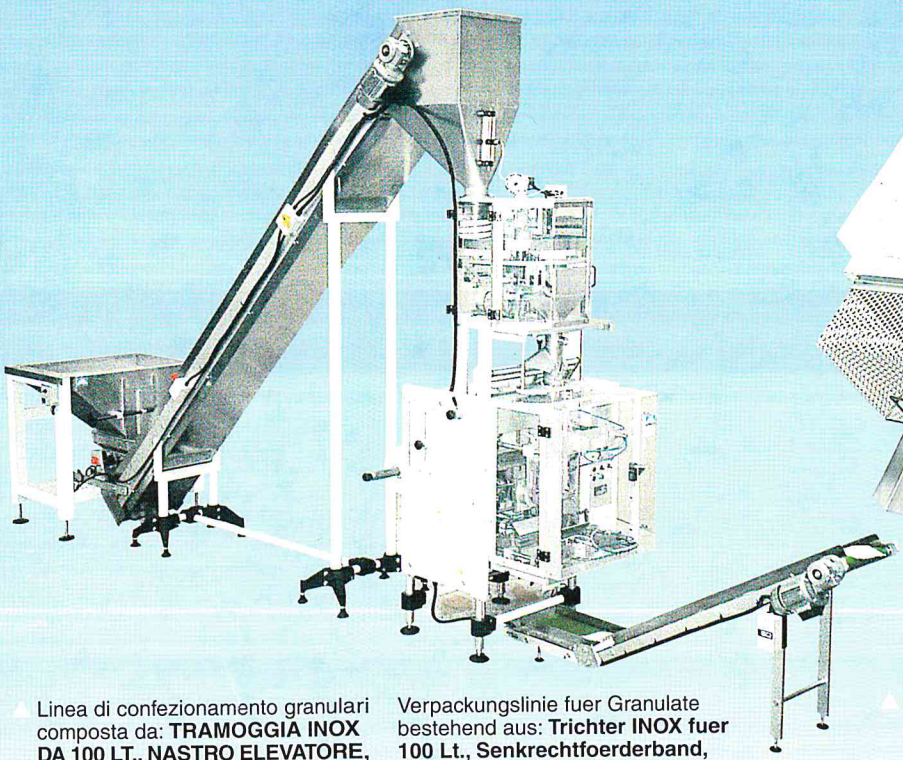


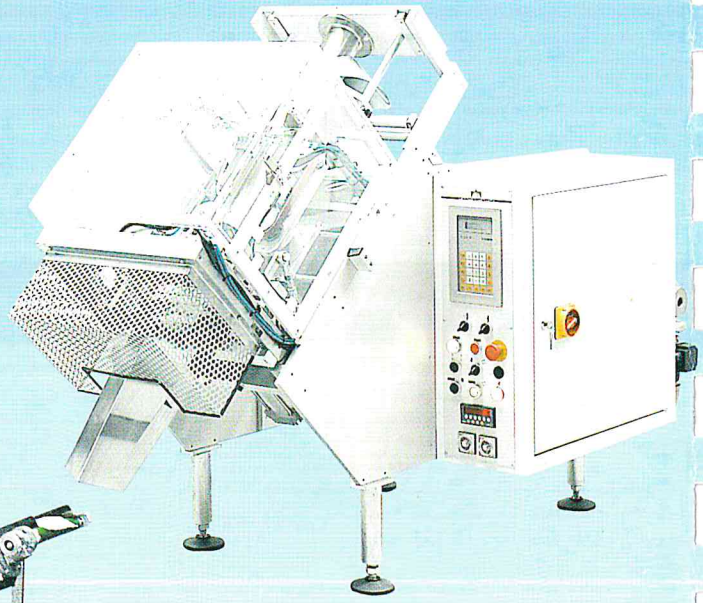
Proponiamo infine le confezionatrici verticali per prodotti alimentari con i relativi sistemi di carico automatico studiati e dimenzionati in funzione del prodotto da confezionare.

Finally, we propose our vertical machines for food products with special automatic feeding system designed for each product to be packed.

Desweiteren bieten wir senkrechte Verpackungslinien an fuer Lebensmittel mit entsprechender automatischer Ladung spezifisch abgestimmt auf das zu verpackende Produckt.

Entre autres nous proposons nos ensacheuses verticales pour produits alimentaires avec des systèmes de chargement automatique etudiés et dimensionés en fonction du produit a emballer.





Linea di confezionamento granulari composta da: **TRAMOGGIA INOX DA 100 LT., NASTRO ELEVATORE, DOSATORE VOLUMETRICO, CONFEZIONATRICE VERT. 560.**

Packing line for granulated products, consisting of: **INOX HOPPER OF 100 LT., ELEVATOR CONVEYOR, CUP'S VOLUMETRIC FEEDER, VERT. 560 MACHINE.**

Verpackungslinie fuer Granulate bestehend aus: **Trichter INOX fuer 100 Lt., Senkrechtfoerderband, volumetrische Dosieranlage, senkrechte Verpackungslinie 560.**

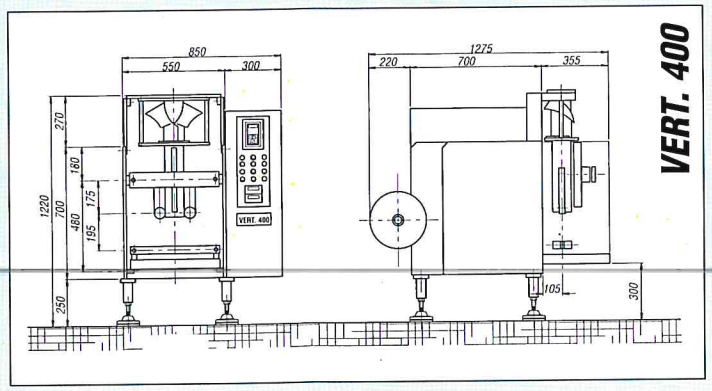
Ligne d'emballage de granulés composée de: **TREMIE INOX DE 100 litres, TAPIS ELEVATEUR, DOSEUR VOLUMETRIQUE, ENSACHEUSE VERT. 560.**

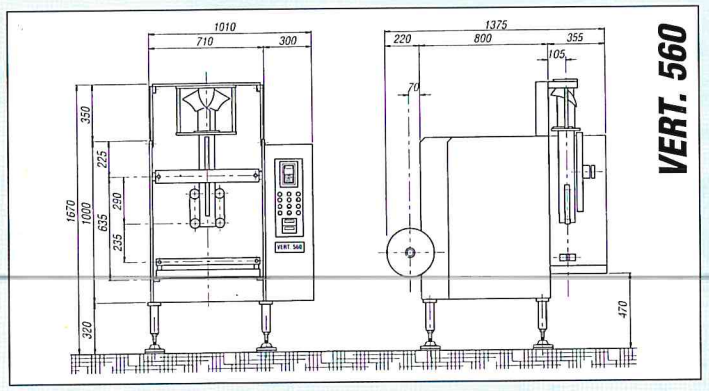
Confezionatrice vert. 400 inclinata per biscotti.

Vert. 400 machine inclined for biscuits.

Schraege, senkrechte Verpackungslinie 400 fuer Gebaeck.

Ensacheuse vert. 400 inclinee pour emballer les biscuits.





CARATTERISTICHE TECNICHE	TECHNICAL CHARACTERISTICS	TECHNISCHE DATEN	CARACTÉRISTIQUES TECHNIQUES	VERT. 400	VERT. 560
Pot. install. vers. cellophane	Power consump. for heat seal vers.	Stromverbrauch für heißsiegelfähige Version	Puissance installée sur la version thermique	2,5 KW	2,5 KW
Pot. install. vers. polietilene	Power consump. for poly vers.	Stromverbrauch für PE-Version	Puissance installée sur la version polyéthylène	2 KW	2 KW
Peso	Weight	Gewicht	Poids	200Kg	270Kg
Lungh. conf. m/m max-min.	Maximum bag length m/m max-min.	Max. Beutellänge m/m max-min.	Longueur maxi sachet m/m max-min.	300/50	450/50
Larghezza confezione	Maximum bag width	Max. Beutelbreite	Largeur maxi sachet	170/60	270/60
Diametro bobina	Film reel dia.	Folienrollendurchmesser	Diamètre maxi bobine de film	350	400
Larghezza fascia	Film reel width	Breite der Folienrolle	Largeur maxi bobine de film	400 max	560 max
Pressione d'esercizio	Air pressure	Druckluft	Consommation air comprimé	6 BAR	6 BAR
ø max tubo conformatore est.	Forming tube with max. external ø	Fülltube mit einem max. Außbendurchmesser	Tube conformateur avec ø maxi extérieur	110 mm	170 mm

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