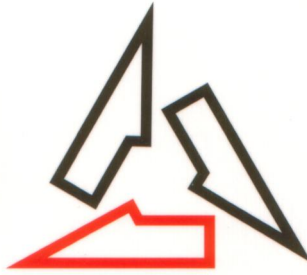


Velati

TECNOLOGIE ALIMENTARI DAL 1867



Filler DDIC10

User and Maintenance Manual

Serial number: 008108

Filler DDIC10

USER AND MAINTENANCE MANUAL

Edtion: March 2008

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Translation from the original language

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CONFORMITY DECLARATION EC

Manufacturer: **Velati s.r.l.**
Address: Via Trento 2 – 20067 Tribiano MI - Italia
Legal office: Piazza Diaz 6 - 20123 Milano – Italia

Under its own responsibility declares that:

the machine: **Filler** Type: **DDIC10-0004**

Serial number: **008108** Construction year: **2008**

it is in conformity with the regulations of the machine's directive:

- **Directive 98/37/EC and D.P.R. 459/96 related to Machines Security.**
- **Directive 2006/95/EC related to Electrical Security (*Low Tension*).**
- **Directive 97/23/EC related to Equipments in pressure (*PED*).**
- **Directive 89/336/EEC related to Electromagnetic Compatibility and further emendations introduced with Directive 92/31/EEC and 93/68/EEC.**

and for its planning and construction we have adopted concepts and principles introduced with the related paragraphs of following Harmonized Norms:

- **EN ISO 12100-1**
- **EN ISO 12100-2**
- **EN 953**
- **EN 60204-1**
- **EN 954-1**
- **EN ISO 13850**
- **EN 982**
- **EN 983**
- **EN 61000-6-4**
- **EN 61000-6-2**

Velati s.r.l. declares that is in possession of a technical manufacturing document of the devices/equipments mounted on the present machine, that are not manufactured by itself.

Verena Veronesi
General Executive Manager



Tribiano, **19/01/2009**

INTRODUCTION

This user guide contains all the safety and useful information required to ensure trouble free and long operational life of the machine.

Before starting to operate the machine, carefully read this document and note any important information, operating instructions and routine checks.

Maintenance work performed at regular intervals ensures higher output levels and less wear on the machine.

The technical information, descriptions and manufacturing information are correct at the time of printing. The manufacturer reserves the right to make future changes for reasons of product development.

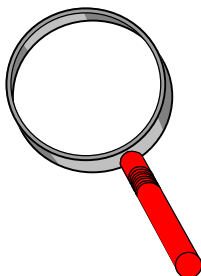
The illustrations and the drawings are complete as far as required for their understanding.

Copyright protection. Information and drawings supplied in this manual must not be reproduced, supplied to third parties or used without prior authorisation from the company.

Velati s.r.l.
Technical documentation

PUBLICATION No.: INS0004H

WARNING



This manual must be read very carefully before transporting, installing, operating or performing any maintenance operations on the machine.

This manual must be stored with care in a place known to the machine user, managers and personnel responsible for transport, installation, operation, maintenance, repairs and final dismantling of the machine.

This manual describes the intended use of the machine and gives instructions on how to transport, install, assemble, adjust and operate the machine. It gives information on how to carry out maintenance operations, how to order spares, how to identify residual risks and how personnel must be trained.

This manual is an integral part of the machine and must be retained until the machine is finally dismantled. If the manual is lost, contact the manufacturer to ask for a new copy.

Make sure that all the operators fully understand the user instructions and the meaning of any symbols present on the machine.

Accidents can be avoided by following these instructions, which are written in conformity with the machines CEE directive.

In any case, always conform to the local safety standards.

Do not remove or damage the guards, labels and the printed warnings and information, particularly those required by law.

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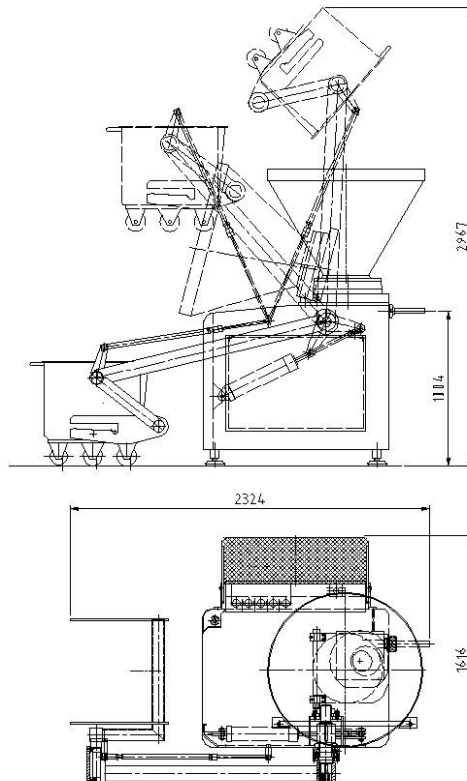
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1. DATA SHEET

1.1 Technical information

Machine name	DDIC10 Filler
Hopper capacity	LT. 300
Pumping system	Paddles
25 m ³ /h vane type vacuum pump	Theoretical vacuum 98%
Main motor power	KW 7.5
Motor power for hydraulic equipment	KW 1.8
Motor power for vacuum pump	KW 0.75
Fan motor power	KW 0.06
Total power of the machine	KW 10.11
Voltage	See the label on the machine
Machine weight	Kg. 1200

1.2 Overall dimensions



1.3 Technical description of the machine

The machine is composed of a lifter device for 200 lt. trolleys, a tilting hopper of 300 lt. capacity, a pumping group with multiple paddles.

The machine frame, and in particular all the parts in contact with the meat are completely in stainless steel.

The hopper is equipped with a feeding worm, that works in a synchronic way with the filling rotor.

The machine is equipped with a digital electronic equipment that can easily manage portions, speed, pauses and possible combined machines (Clipping machines, Tying machines and Twisters i).

Furthermore the equipment has the possibility to memorise up to 99 working programmes.

2. INSTALLATION

2.1 Transport

Personnel who carry out the machine installation must have a technical background and experience and must be qualified to carry out the operations to the required standard.

Special attention must be paid during lifting, transporting and siting of the machine.

The bagging machine is tested at the **Velati** factory and is transported fully assembled. A wooden or cardboard box containing all the machine's equipment is sent with the machine at the time of shipping.

To load or unload the bagging machine, use a crane or traspallet, positioning the ropes or forks as shown in figure 2, making sure that they are as close as possible to the centre of the machine.

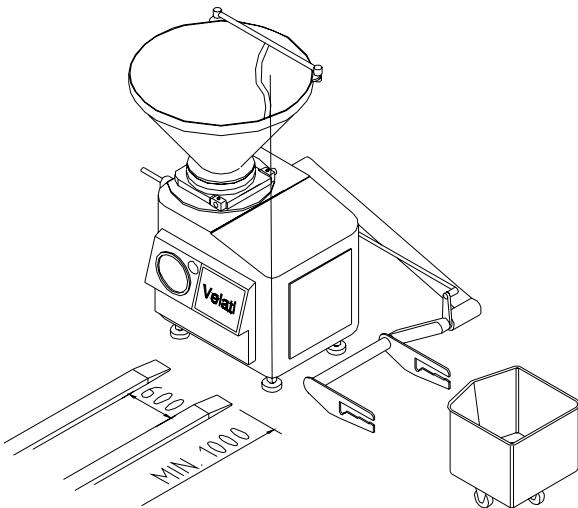


Figure 2

! Warning !

Use lifting equipment that is designed to safely lift the weight of the machine; the machine's weight is specified in chapter 1 of this manual. When lifting, take great care to avoid the machine tipping upside down when raised.

2.2 Positioning

Once the siting of the machine has been decided, carefully support it on the floor and, using the feet fitted, adjust them so that they firmly support the machine on the ground. (see fig. 3).

IMPORTANT: When adjusting the feet, check that the carriage is lodged securely in the fork of the loader.



Figure 3

It is recommended that the front side of the machine is held (discharge mouth outlet) in a lower position in comparison to the rear side by around 2-3 cm. so as to allow for the discharge of any water during the washing stage (see fig.4). To perform this operation use a level, positioning it on the upper side of the tank.

2.3 Electrical connection

Make sure that the voltage required by the machine (specified on the machine's nameplate) is compatible with the voltage of the electrical system in the place of installation and that this system conforms to current safety standards.

The equipment and the power supply cable must be suitable for the power rating.

The power supply cable must be connected directly to the power panel on the line isolator switch terminals. Connection to the machine must be performed by specialised personnel. If the motors turn in the wrong direction (make sure they rotate in the clockwise direction) reverse two of phases at the isolator switch input.

The machine is already supplied with the motors connected according to the voltage specified by the customer.

If a change of voltage is required, contact the **Velati** technical department.

3. ASSEMBLY INSTRUCTIONS

The first start-up of the machine should be made by skilled staff. We advise you to follow these points:

- Insert the worm in its seat, then make it rotate in clockwise sense up to reach the blockage. (See fig.4)



Figure 4

- Unscrew the closing ring, insert the desired filling funnel and screw it up to its blockage by means of the locking key. (See fig.5/6)



Figure 5



Figure 6

- Tilt the hopper in a vertical position, position the closing bracket and tighten them up to their blockage. (See fig.7)



Figure 7

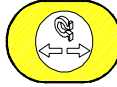
As the machine has a completely electrical-.electronic running completely it does not need heating times.

4. OPERATING INSTRUCTIONS

4.1 BUTTON DESCRIPTIONS



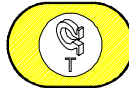
Main motor



Clipper advance/delay



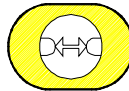
Manual mode



Clipper time



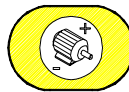
Automatic mode



Pause



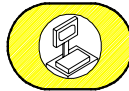
Raise loader



Motor speed adjustment



Lower loader



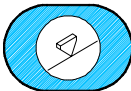
Other adjustments



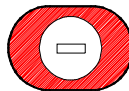
Stop loader



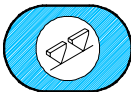
Program



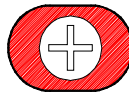
Single pulse operation



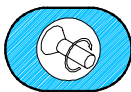
Decrease



Double pulse operation



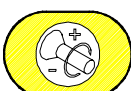
Increase



Twister ON / OFF



Confirm



Twister adjustment




Emergency

4.2 STARTING THE MACHINE



After correctly connecting and supplying power to the machine, the following message is displayed on the screen.

Velati S.r.l.
Industrial Equipment

Continuous Filler
Model IC/10


To start the machine, press the  key and wait until the following message is shown on the display:

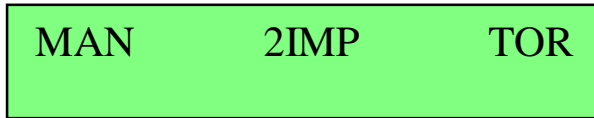
SELECT OPERATING
MODE

At this point, select the required mode of operation. Press the  key if manual mode is required or  to work using the automatic mode. The selection is displayed in the top left hand corner.


4.3 MANUAL OPERATION

4.3.1 Normal operation


Press the  button. The text MAN is displayed, the machine starts bagging only when the toggle is pressed.



4.3.2 Toggled operation


Press the  button. The text 2 IMP (2 PULSES) is displayed, the machine starts with the first press of the toggle switch and continues bagging until the switch is pressed again. To stop this function, press the toggle again. (The text 2 IMP (2 PULSES) disappears)




4.3.3 Operation with twister

When a twister is fitted, activate it by press the  key; the text TOR will be displayed. To stop this function, press the relevant key again.

The text TOR disappears.

4.4 AUTOMATIC OPERATION

Pressing the  button puts the machine into the automatic mode with the display showing the program number and weight in grams.

It is possible to change the weight parameter by pressing the  and  keys and confirming it with the key .


4.4.1 Normal operation



```
AUT
PR 01 GR. 00000
```

The bagging machine cuts the product into portions only when the toggle is pressed. If the toggle is released, the rotor is stopped without completing the positioning action.

4.4.2 Single press function


Pressing the  button displays the following:




```
AUT 1IMP
PR 01 GR. 00000
```

By pressing the toggle once, the machine completes a portion. If more portions are required, press and hold down the pedal.

4.4.3 Two press toggle operation

Pressing the  button sets the machine two press toggle mode where the first press starts the machine dividing the product into portions. To stop the machine, press the pedal again.

4.4.4 Automatic operation with twister


When the twister device is fitted, activate it by pressing the  key; the text TOR will then be displayed.

To stop this function, press the relevant key again. The text TOR disappears.




4.5 ADJUSTMENTS

4.5.1 Twister adjustment


Twister adjustment is controlled using two parameters. The SEC parameter sets the twisting time (the number of twists). The IMP parameter sets twisting to pulsed or continuous operating mode. Setting IMP to NO will operate the twister in continuous mode (always running). Setting IMP to SI (YES) will operate the twister in pulsed mode (activated only at the end of the portioning operation).

Pressing the  key displays the following:




ADJ	TWISTER
SEC. 9.99	PUL NO


Pressing buttons  and  changes the value and pressing  confirms the operation and exits the page.

4.5.2 Motor speed adjustment (both in manual and in automatic)

A parameter is provided to show the motor speed. Values between 0 and 99 can be set and are shown as a percentage. Pressing the  key displays the following:


ADJ	SPEED	AUT
SPD	21	

Buttons  and  change the value and the  button confirms the operation and exits the page.




N.B. There are two specific speeds on condition that the push-button  is pressed if you are in manual or automatic running .

4.5.3 Clipper unit advance / delay adjustment

The clipper control signal can be advanced or delayed in relation to the end of the portion. This operation is controlled by the parameter REG RIT/ANT CLIP (SET CLIP ADVANCE/DELAY). This parameter can have values between -99 and +99 (To be interpreted as conventional time taken). Positive parameter values indicate a delay, negative values indicate an advance.


Pressing the  key displays the following:

ADJ CLIP ADV/DEL
3




Pressing buttons  and  changes the value and pressing  confirms the operation and exits the page.

4.5.4 Clipper pulse adjustment

This parameter shows the clipper pulse duration in seconds.

Pressing the  key displays the following:

```
ADJ CLIP PULSE
SEC. 0.72
```




Buttons  and  change the value and the  button confirms the operation and exits the page.

4.5.5 Pause adjustment

A parameter indicates, in seconds, the pause time between one portion and the following one.

Pressing the  key displays the following:

```
ADJ PAUSE
SEC 0.64
```

Pressing buttons  and  changes the value and pressing  confirms the operation and exits the page.

4.5.6 Other adjustments

- Tare weight: This parameter keeps track of the weight of the guts;
- First cut: Generally, the first portion of every automatic cycle tends to be bigger than others. This parameter compensates for this irregularity;
- Delay: At the end of the portion cycle (not between one portion and the next!!), the rotor is pulsed in the opposite direction of rotation to normal, this parameter is provided in order to keep the meat in “tension“. The amount of rotation is increased or decreased according to the value of RIT (DELAY).
- 2nd analogue output: A second analogue output voltage (0-10 volts) is available and can be set using the AUT parameter.






Pressing the key displays the following:

ADJ OTHER	
TARE	PC

ADJ OTHER	
DEL	OUT




The cursor starts to flash under the TARE parameter value.

Buttons  and  change the value and the  button confirms the operation and goes to the next parameter.



4.6 PROGRAMMING

From the automatic page, press the  key; the following is displayed:

```
PROGRAMS
NUM  1
```

Select the program No. required by pressing the  and  keys, then press  to confirm. The following message is shown on the display:

```
SAVE PR X - > ENTER
RETRIEVE PR X - > P
```

Pressing  saves all the current work parameters inside program No. X whilst, if the  button is pressed, all the parameters stored with work program No. X are retrieved.

NB: X can vary from 1 to 99.

4.7 PART AND HOUR COUNTER DISPLAY






At startup, when SELEZIONARE MODO DI FUNZIONAMENTO (Select Mode Of Operation) is displayed, press the following combination of keys in sequence:

     , the following will be displayed:

No. PARTS
No. HRS






Press 

RESET PARTCOUNTER
PASSWORD XXXX

To reset the part counter, sequentially press the button   
 , otherwise, if resetting is not required, press the  button four times.


The following will be displayed:


RESET HOURCOUNTER
PASSWORD XXXX

To reset the hour counter press     , otherwise to exit from the page, press the  button four times.

4.8 HOPPER LOADING CAPACITY

To load the meat into the hopper, put the tub into the correct position on the loader's fork and make sure that the balancer locks it into position.

To raise the fork, press the  button once and wait until the tub completes its tipping operation.

If problems are encountered when raising the fork, the loader can be stopped by pressing the  button; the loader will be stopped immediately.

To return it, press and hold down the  button until the tub reaches its end of travel position.

4.9 OPERATING SPECIFICATIONS

The paddle pump of the filler is operated by a synchronic with permanent magnets (Brushless) fed by its operation. The motor is supplied by the company Vickers while the operation is supplied by the company Selema and have the following characteristics:

- Operation: Digital Brushless feeding 400V complete with armour-plated regeneration resistor, ventilation, inside soft start encoder 5 V simulation, separated feeding for the auxiliaries at 24 V, 25 A. nominal current, top current 50 A rms
- Motor: Brushless 23 Nm nominal, 73 Nm of top, 3000 rpm
Nominal current 15 A (FAS T2 V8 030).

In order to make a verification of good motor running and operation you can see the leds (at the ignition) placed on the front of the operation. If, after having given tension and after approx 10 seconds, you see four green leds on, you have the confirmation that the operation and the motor run correctly.

If not, contact the Technical department of Velati.

5. PROCESSING METHODS

5.1 Filling and portioning problems

<u>Problem</u>					<u>Possible cause</u>		<u>Solution</u>
Greasing problems	Weight accuracy	Porous cutting panel	Air leak problems	Sedimentation problems		Notes at end of table	
*	*	*			The counter-support curve is not fitted	1	Fit the curved counter-support
				*	The curved support is fitted		Remove the curved counter-support
*	*	*	*		Insufficient vacuum	1.2	Increase the vacuum
*	*	*	*	*	Filling rhythm is excessive	1.3	Reduce the filling time
*	*	*	*	*	Filling pipe is too long	1.3	Use a shorter filling pipe
*	*	*	*	*	Filling pipe is too narrow	1.3	Use a wider filling pipe
*	*	*	*		Level of material in the hopper too low		Add first
		*	*		Filling material with a high percentage of air		Fit the feeder fitting
*	*	*	*		Vacuum channel blocked with filling material	1	Clean
*					Conveyor mechanism too hot		Fill the conveyor mechanism with ice to cool it
*				*	Filling material too hot		Cool the filling material

<u>Problem</u>					<u>Possible cause</u>		<u>Solution</u>
Greasing problems	Weight accuracy	Porous cutting panel	Air leak problems	Sedimentation problems		Notes at end of table	
	*				Specific weight is outside range	4	
*	*	*	*		Pause time between grinding and filling the raw sausage is too long	5	Reduce the pause time
				*	Filling material is ground too much		Grind the meat for the sausage to the specifications
*	*	*	*		Excessive percentage of air due to blunt grinder blades		Use sharp grinder blades

Instructions

1. Irregular material expulsion, high fat content and inaccurate weights are all caused by insufficient material being fed.
2. With a vacuum lower than -0.9 bar, if new, the transport mechanism with a high number of revolutions can produce a higher vacuum than the vacuum produced by the vacuum pump. Using this method, air can enter the transport mechanism.
3. High filling pressure causes: a high mass loss, vacuum system blockage, bad de-aeration, weight inaccuracies and high fat content.
4. A different composition of filling material or different process carried out using other grinders of different design can cause large fluctuations in the specific weight.
5. Long stoppage times can cause the filling material to thicken, especially if accelerated curing methods are used.

5.2 Gut processing instructions

Storage and processing operations must strictly comply with the regulations set by the producer supplying the gut product.

Quality of gut			
Ovine		Pig gut	
Wet and salty	Dry and salty	Wet and salty	Dry and salty

Pre-treatment

	•		•	The day before: rinse the gut well with cold water, lightly squeeze and hang in cool conditions overnight.
•	•			On the day of use: respectively, wet and rinse the guts in warm water for a short time (+37 °C)
		•	•	Soften the guts for between 30 to 60 minutes in warm water
•	•	•	•	To improve material flow: for example, with sodium carbonate (baking powder) Add 2-3 soup spoons in 5 l. of water at +37 °C
•	•	•	•	Unused guts: Rinse well, salt and place in a cool location.

6. CLEANING

- Before starting the cleaning, the machine should be switched off and the emergency push-button placed on the control panel should be pressed down. (See fig.8)



Figure 8

- After having released the locking levers and tilted the hopper, you have to disassemble the spiral make it rotate in counter-clockwise sense. (See fig.9)



Figure 9

- If additional equipment is fitted, it must be removed and cleaned. After unplugging the additional equipment connections from the sockets, protective caps must be fitted. (See fig.10)



Figure 10

- Unscrew the locking ring and remove all the parts. (See fig.11)



Figure 11

- Open the vacuum bull's eye and insert the cap and if there is some material inside, remove it . (See fig.12/13)



Figure 12



Figure 13

IMPORTANT

Thoroughly clean with hot water or high pressure or steam cleaning equipment and do not use strong alkaline detergents. Hot water is recommended up to 60 °C.

When using high pressure or steam cleaning equipment, the jet must not be allowed to spray directly onto electrical equipment, bearings and gaskets.

Dry the machine with care and apply food grade grease or oil to all brightwork on the machine.

7. MAINTENANCE

The maintenance works should be only made by duly trained technical personnel. The works to be done during the maintenance are listed in the attached list. If you don't want to lose the guaranty rights, all the maintenance should be done by skilled personnel.

- Before starting to clean the machine, the machine should be switched off and the emergency push-button placed on the control panel should be pressed down..(See fig. 14)



Figure 14

7.1 Every 8 working hours

- Grease the pinion and the crown of the mixer. (See fig.15). Act on the vent-hole valve (screw it) to make the surplus grease coming (See fig.16).



Figure 15

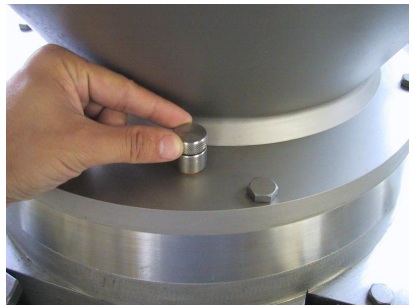


Figure 16

7.2 Every 200 working hours

- Grease the tilting of the hopper (See fig.17) and the toggle's bush (See fig.18).



Figure 17



Figure 18

- Grease the bearing of the lifter device (See fig. 19)



Figure 19

7.3 Every 1000 working hours

VACUUM PUMP

- Check (See fig.20) and if necessary add oil in the vacuum pump (See fig.21). To empty it, remove the discharging cap. (See fig.22).



Figure 20



Figure 21



Figure 22

HYDRAULIC EQUIPMENT

- Check (See fig.23) and if necessary add oil in the hydraulic equipment (See fig.24). To empty it, remove the discharging cap. (See fig.25).



Figure 23

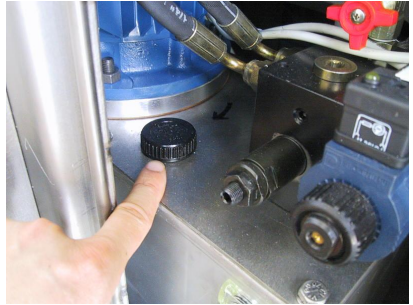


Figure 24

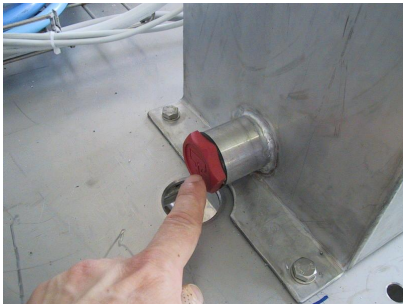


Figure 25

REDUCER

- Open the door on the control side (See picture 26) Check (See picture 27) and eventually add some oil in the reducer (See picture 28). To empty it, remove the discharging cap (See picture 29).



Figure 26



Figure 27



Figure 28



Figure 29

7.4 Lubricating table

Type	Intervention	Frequency	Lubrificant
Pinion and crown	Greasing	Every 8 hours	Zep MW food grease
Mechanic	Greasing	Every 200 hours	Shell Supergrease AM
Vacuum pump	Addition Oil change	Every 1000 hours	Shell Vitrea 68
Hydraulic equipment	Addition Oil change	Every 1000 hours	Shell Tellus 46
Reducer	Addition Oil change	Every 1000 hours	Shell Vitrea 68

You can even use different grease and oil unless it is of good mark and with the same characteristics.

8. GENERAL WARNINGS

8.1 Intended use

The machine is intended to be used by one operator only.

All the materials that come into contact with the product must be for food use and conform to the CEE directive.

The machine must not be operated in conditions or for uses different from those specified in this manual. **Velati** does not accept any responsibility for faults, problems or injuries due to use of the machine for purposes other than intended.

8.2 General safety regulations

The safety officer in charge of the department in which the machine is installed, must clearly inform all operators on the risk of injuries, the personal safety equipment to be used and on the general safety regulations specified by international and national laws and standards in force in the country where the machine is used.

To avoid possible accidents, all operators must comply with international and local safety standards in force in the country where the machine is used.

*Before starting any operation on the **Velati** machine, every operator must fully understand the operation of the machine and the use of the controls and must have read and understood all the information contained in this manual.*

No safety related parts of the machine must be tampered with or replaced without the written consent of **Velati**.

The use of accessories, tools, consumables or spare parts different from those recommended by the manufacturer and/or specified in this manual can cause injuries to the operator and/or damage to the machine.

Any modifications of the machine made without the consent of **Velati** releases **Velati** from any civil or criminal responsibility.

Removal or tampering with any safety device is strictly prohibited.

Any installation, routine maintenance or breakdown maintenance operation must be carried out with the machine switched off and with the electrical power and pneumatic supply (if present) disconnected.

Do not place hands or introduce screwdrivers, keys or other tools into moving parts.

The operators work area must be kept clean, tidy and free from any object that could restrict free movement. Operators must avoid unsafe operations and awkward positions that may affect their balance.

Operators must be aware of clothes, necklaces, bracelets and rings getting caught and trapped and of their dangerous consequences.

All operators must use the personal safety equipment required and must wear suitable clothing for the health regulations that apply in the food industry.

The work area must be adequately lit for the required operations. Insufficient or excessive lighting can be dangerous.

Operators must use the machine strictly following all instructions given in this manual. The person in charge must make sure that the machine is used correctly.

Every day, before starting the machine, the operator must check that all the safety devices are in good working order. The operator must immediately report to the person in charge any faults found with the safety devices. The person in charge must then make sure that the faulty safety devices are immediately replaced or repaired. The machine must be prevented from being started before the repair/maintenance work has been completed.

The cleaning instructions contained in this manual must be followed.

The instructions, safety regulations and warnings contained in this manual must always be fully complied with.

8.3 Noise

Velati machines are designed and built to minimise noise pollution.

8.4 Further definitions

The maintenance engineer is the person given the duties of transporting, installing, starting, adjusting, cleaning, repairing and maintaining the machine. This person must be qualified and have the required experience in transporting, installing, setting up and maintaining machines and mechanical, electrical, pneumatic and oil-hydraulic systems. It is also recommended that the maintenance engineer studies the electrical, hydraulic, pneumatic diagrams and the exploded views of the machine before starting the machine.

The operator, is the person who uses the machine. This operator must fully understand all the warnings and operating instructions given in this manual.

8.5 Zones with safety devices

The machine is equipped with some protection devices, to guaranty the safety of the operator during the machine's running. In the following list there are some safety devices that are present on the machine.

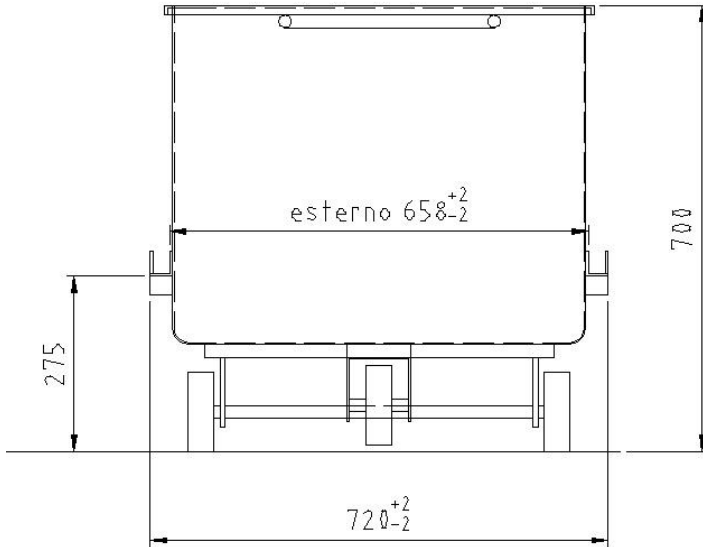
Rif.	Denomination
1	Under the hopper there is a magnetic sensor that totally blocks the machine when the hopper is open.
2	On the push-button control board there is an emergency push-button, which if it is pressed, it blocks the machine running; to re-start the machine you have to release the same emergency push-button.
3	If you want to tilt the hopper during the processing, first you have to press the emergency push-button placed on the push-button control board and than make the vacuum leak acting on the valve that is placed under the push-button control board . (See fig.30)



Figure 30

CAUTION:

the loader fork is suitable to lift standard trolleys of 200 litres having an overall weight not higher than 200 kg.



Different trolleys or smaller width may slip off and fall.

9. GUARANTEE and CUSTOMER SERVICE

9.1 Guarantee

Velati srl, a leader in the field of meat processing machinery, only uses the highest quality materials and components in the construction of its machines.

If some parts are found to be defective or non conforming, the conditions of the guarantee specified in the contract apply.

Damages to the machine and its accessories caused by misuse or uses other than those specified are not covered by the guarantee. The guarantee will be honoured only if the machine has been correctly used by following the instructions given in this manual, including the routine maintenance operations.

The guarantee starts from the shipment date of the machine

All consumables, routine maintenance materials and parts damaged by improper use of the machine are not covered by the guarantee.

Repairs and/or replacements made during the guarantee period do not extend its duration.

The guarantee does not cover any claims for compensation for any loss of production.

9.2 Customer service

Velati srl engineers are available to perform any routine or breakdown maintenance operations.

Any call-out request must be made to **Velati srl** by calling or sending a fax to the numbers shown on the back of this document.

10. WASTE MATERIAL DISPOSAL

When tin use, the machine can produce special waste.

Special waste is produced by industrial processes, agricultural business, small manufacturers, commercial and service industries that, because of quality or quantity, is not considered suitable for mixing with household waste.

Disposal of used oils, special and toxic/harmful waste must be carried out in compliance with current regulations. .

11. TAKING THE MACHINE OUT OF SERVICE

The dismantling operations must be performed by qualified personnel .

Dismantling of the machine must comply with the regulations in the country of use.

Disconnect the machine from the electrical system.

Remove any machine connections to other machines by carefully checking that any connections with machines that are still working are not disabled.

Drain reservoirs and reduction units containing lubricating oil and store it in compliance with current regulations.

Proceed to remove single components of the machine and sort them according to their composition. The machine is mainly constructed from steel and plastic materials.

Finally, proceed to recycle the machine parts according to the current regulations in the country of use.

When dismantling the machine, carefully follow the safety instructions given in this manual.

12. SPARE PARTS TABLES

ITALIANO

Per richiedere i pezzi di ricambio fare riferimento alle seguenti tavole. Per ordinare il materiale contattare la Velati spedendo un fax o telefonando e riferire il tipo della macchina di cui si è in possesso, il gruppo, e il codice del particolare.

ENGLISH

To ask for spare parts, please refer to the following tables. To order the material, please contact Velati by sending a fax or phoning and tell the type of machine in your possession, the group, the particular's.

FRANÇAIS

Pour demander les pièces détachées se référer aus tables suivantes. Pour commander le matériel contacter la Velati en envoyant un fax ou en téléphonant et référer le type de machine dont on est en possession, le groupe, et le code du particulier.

ESPAÑOL

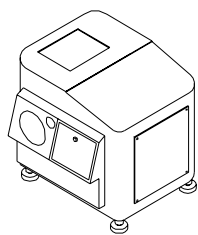
Para pedir las piezas de cambio mirar las tablas que siguen. Para pedir el material contactar Velati enviando un fax o llamando y explicar el tipo de maquina que se utiliya, el grupo y el codigo del particular.

DEUTSCH

Bitte, beziehen Sie sich auf die folgende Tabelle un die Ersatzteile zu bekommen. Bitte, senden Sie uns einen Fax oder telefonieren Sie um das Material zu bestellen. Teilen Sie uns mit, Maschinen-Model, Ersatzteile und Kode der Teil die Sie brauchen.

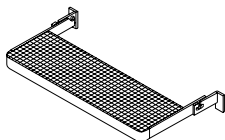
РУССКИЙ

При заказе запчастей необходимо делать ссылки на последующие иллюстрации. Чтобы заказать материал необходимо связаться с Velati посредством факса или телефона и сообщить тип машины, группу (А, В, С и т.п.), и код детали.



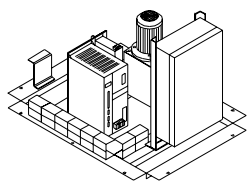
Tav. A Base

Pag. 45



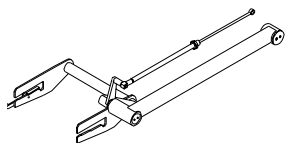
Tav. B Service platform

Pag. 46



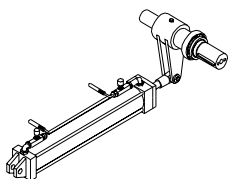
Tav. C Base plate

Pag. 47



Tav. D Lifter device

Pag. 48



Tav. E Lifter device transmission

Pag.50

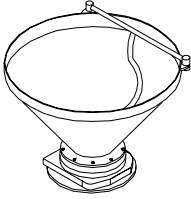


Table F Hopper

Page 52

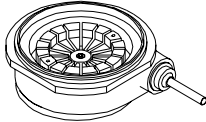


Table G Filling chamber

Page 54

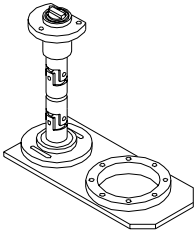


Table H Feeding 1

Page 56

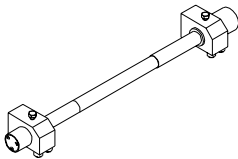


Table I Hopper tilting

Page 58

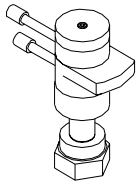


Table L Head closing

Page.60

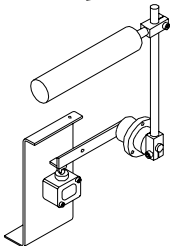


Table M Toggle

Page 61

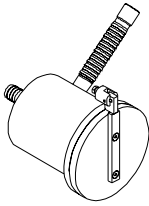


Table N Bull's eye

Page 63

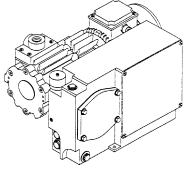


Table O Vacuum pump

Page 65

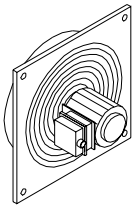


Table P Ventilation

Page 68

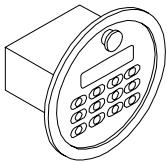


Table Q Control board

Page 69

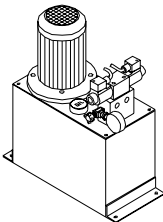


Table R Hydraulic equipment

Page 70

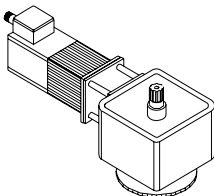
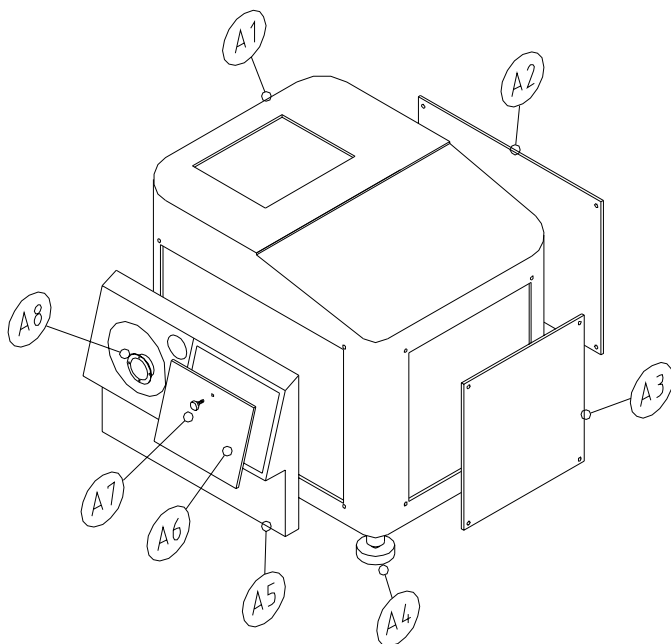


Table S Gear box

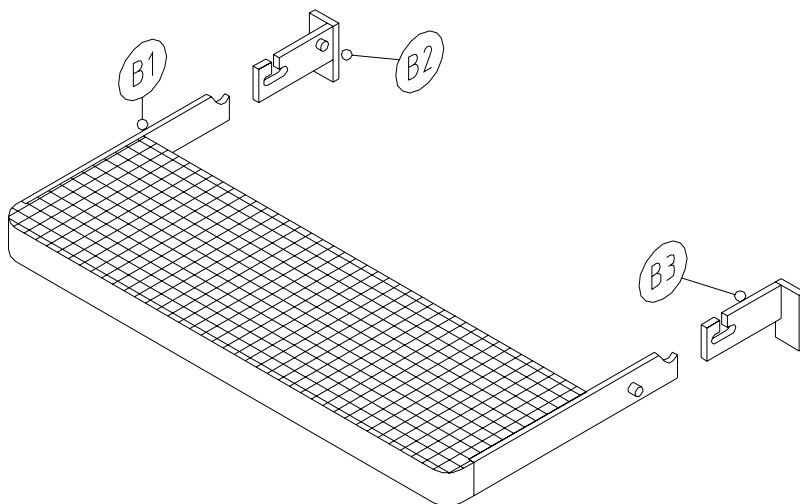
Page 71

Gruppo	Tavola	Disegno
Basamento	A	01



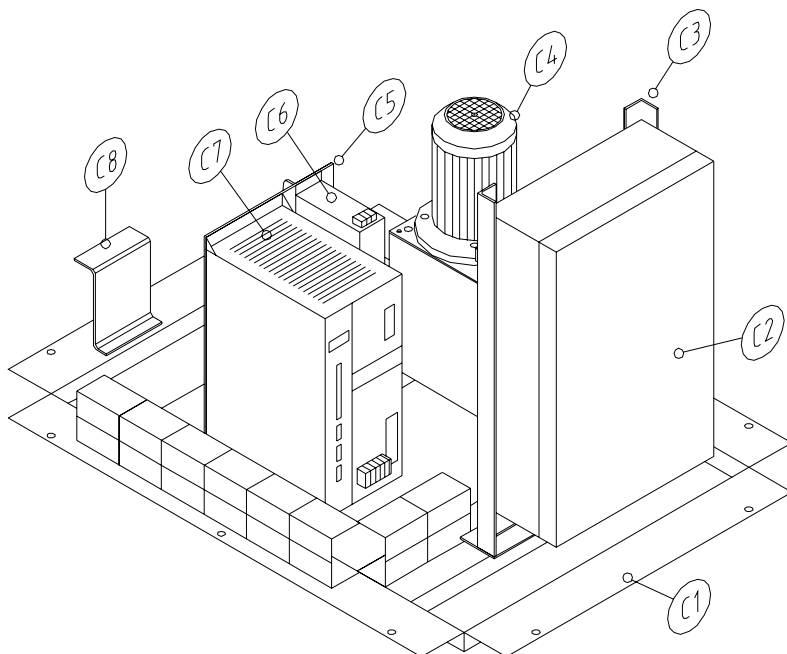
POS.	DENOMINAZIONE	CODICE	Q.tà
A1	Basamento	Z1DD0201001-B	1
A2	Portina laterale	Z1DD0203002-B	1
A3	Portina anteriore	Z1DD0203003--	1
A4	Piede inox M30	MIPI15030100	4
A5	Portina porta comandi e imbuti	Z1DD0203001--	1
A6	Portina accesso imbuti	Z1DD0203015--	1
A7	Pomello M6 femmina	MIACPOM6P	1
A8	Vuotometro Ø63 att. 1/4" flangiato inox	LEACVU63-1/4PA	1

Gruppo	Tavola	Disegno
Pedana di servizio	B	01



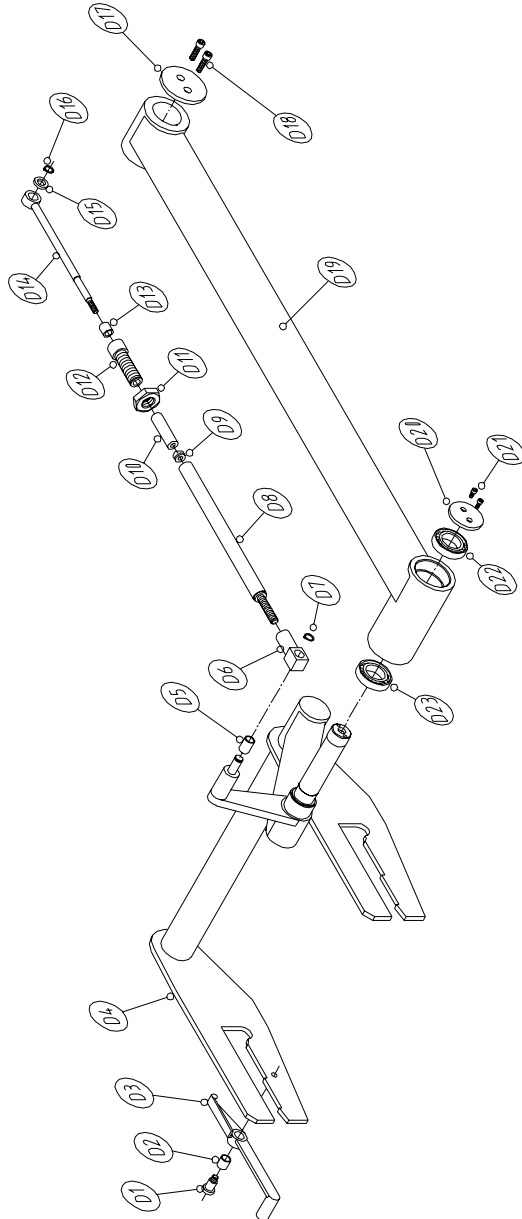
POS.	DENOMINAZIONE	CODICE	Q.tà
B1	Pedana	Z1DD0225001--	1
B2	Staffa sinistra per pedana	Z1DD0217010--	1
B3	Staffa destra per pedana	Z1DD0217002-A	1

Gruppo	Tavola	Disegno
Piastra di base	C	01



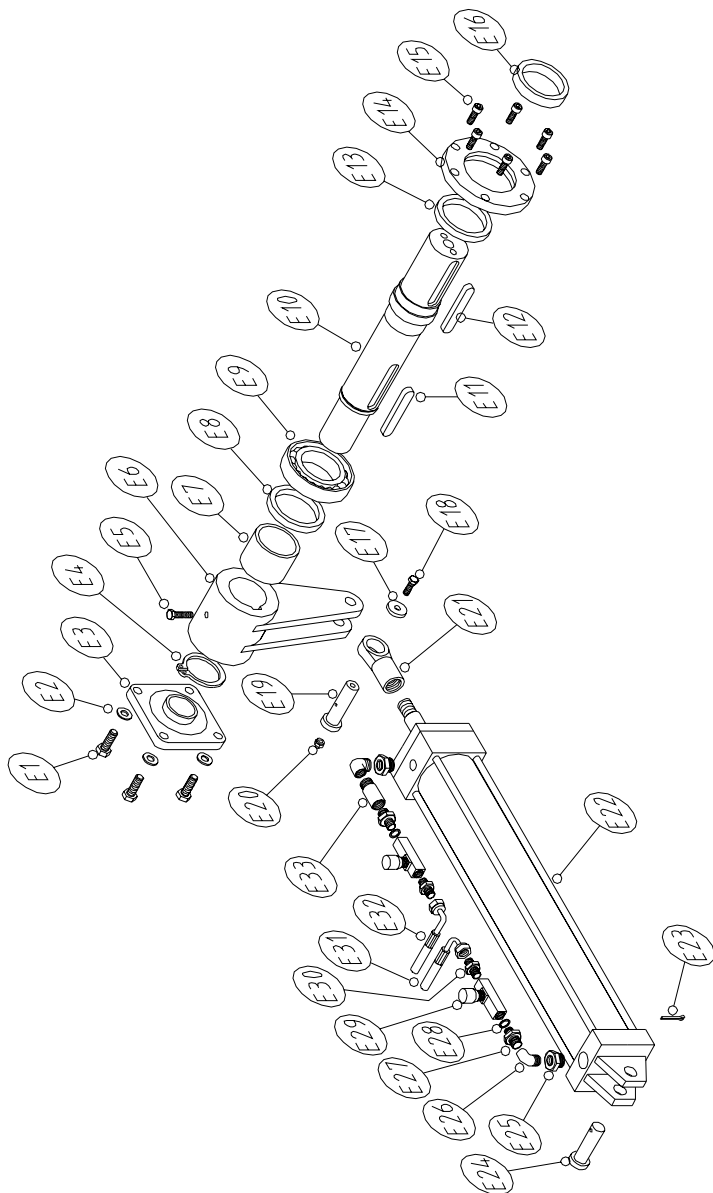
POS.	DENOMINAZIONE	CODICE	Q.tà
C1	Base del basamento	Z1DD0201002--	1
C2	Quadro elettrico	TLQEI4001	1
C3	Staffa porta quadro elettrico	Z1DD0217003-B	1
C4	Centralina olio	IDCEIC10	1
C5	Staffa porta azionamento	Z1DD0217004-B	1
C6	Filtro Shaffner	HWINFILTRFN258-30-07	1
C7	Azionamento	HWINAZIONAMENSELEMA	1
C8	Staffa per finecorsa ginocchiera	Z1DD0217008--	1

Gruppo	Tavola	Disegno
Elevatore	D	01



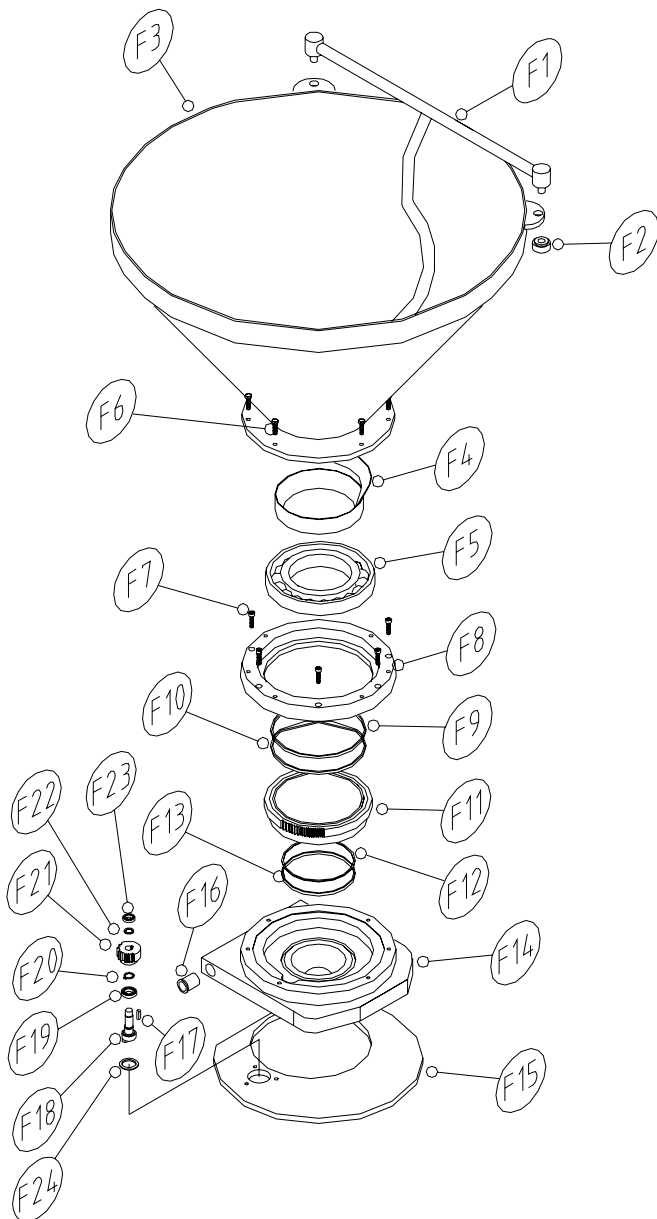
POS.	DENOMINAZIONE	CODICE	Q.tà
D1	Perno bussola bilanciare	EPER20Q0006--	1
D2	Bussola bilanciare	EBUS20Q0004--	1
D3	Bilanciere	EBIL20Q0002--	1
D4	Forca caricatore	EFOR20I0001--	1
D5	Bussola occhiolo tubo	EBUS20Q0002--	1
D6	Testina regolabile	ETES20Q0001--	1
D7	Seeger Ø19	MISE7435U19A	1
D8	Tubo con occhiolo	ETUB20Q0001--	1
D9	Ghiera di bloccaggio	EGHI20Q0001--	1
D10	Cursore	ECUR20Q0001--	1
D11	Dado di fermo	EDAD20Q0001--	1
D12	Canotto filettato	ECAN20Q0001--	1
D13	Bussola canotto	EBUS20Q0003--	1
D14	Asta scorrevole	EAST20Q0007--	1
D15	Bussola occhiolo asta	EBUS20Q0001--	1
D16	Seeger Ø20	MISE7435U20A	1
D17	Piattello caricatore braccio	EPIA20Q0001--	1
D18	Vite testa cilindrica M12x45	MIVI5931U1245A1	2
D19	Braccio caricatore	EBRA20F0001--	1
D20	Rondella caricatore	ERON20Q0004--	1
D21	Vite testa cilindrica M8x20	MIVI5931U820A1	2
D22	Cuscinetto K6210 2RS	CMCURS62102RS	1
D23	Cuscinetto K6210 2RS	CMCURS62102RS	1

Gruppo	Tavola	Disegno
Trasmissione elevatore	E	01



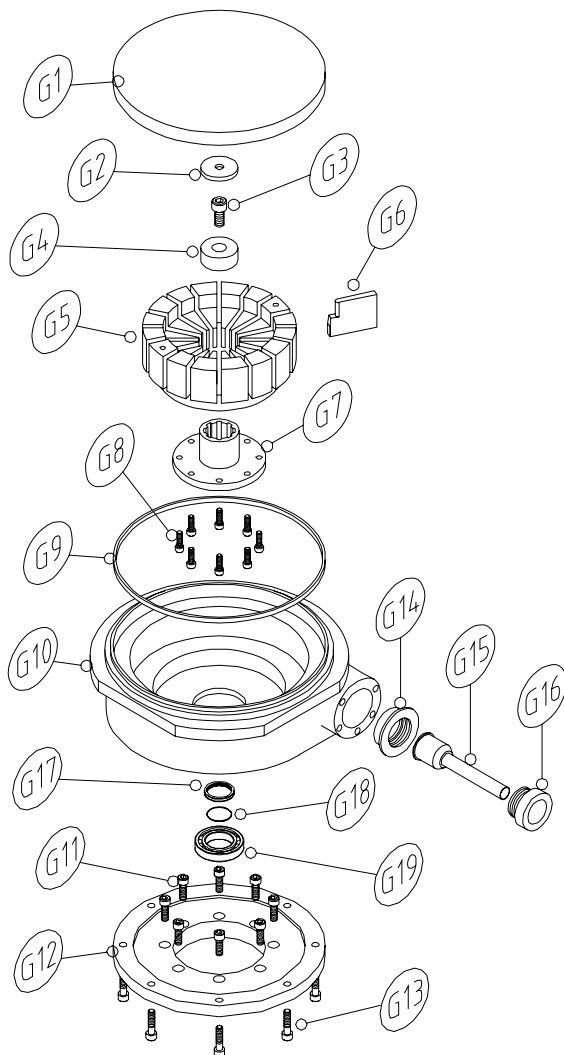
POS.	DENOMINAZIONE	CODICE	Q.tà
E1	Vite T.E. M16x40	MIVI5739U1640A1	4
E2	Rondella perno 18x30	MIRO6592U1934A	4
E3	Supporto UCF 212	CMSUOSUCF212	1
E4	Seeger per albero Ø70	MISE7435U70A	1
E5	Vite T.E. M10x25	MIVI5739U1025A1	1
E6	Leva caricatore	ELEV20F0001--	1
E7	Distanziale per leva caricatore	EDIS20Q0001--	1
E8	MIM 85-105-13	CMGNMIM8510513AB	1
E9	Cuscinetto SKF 22215CC	CMCUOR22215CC	1
E10	Albero caricatore	EALB20F0001--	1
E11	Linguetta 18x11x110	MILI6604U1811110	1
E12	Linguetta 18x11x110	MILI6604U1811110	1
E13	MIM 85-105-13	CMGNMIM8510513AB	1
E14	Piattello caricatore	EPIA20Q0005--	1
E15	Vite T.C. M8x35	MIVI5931U835A1	6
E16	Anello	EANL20Q0001--	1
E17	Rondella bloccaggio leva	ERON20Q0001--	1
E18	Vite T.E. M8x15	MIVI5739U815A1	6
E19	Perno forcella caricatore	EPER20Q0008--	1
E20	Ingrassatore inox diritto ¼"	MIIN1/4DA1	2
E21	Testina unibal Ø20M20-1.5 alta resis. FEZN	IDTEU20M20-1.5AZ	1
E22	Cilindro idraulico 80x25x370 composto da:	IDCI8025370B	1
	Tubo R1T ¼" 90°-90° or. 0° L=450 ferro	IDTUB1/4CC450B	1
	Tubo R1T ¼" D-90° L=600 ferro	IDTUB1/4DC600B	1
	Raccordo diritto	MIRAC61/48DA1	6
	Riduzione idraulica G1/2-G1/4	MIRAIB11/2C1/4Z1	2
	Gomito a 90° maschio - femmina G1/2	MIRAIB4MF1/2CZ1	2
	Nipplo idraulico G1/4 inox	MIRAIA61/4A1	4
	Nipplo ¾ inox	MIRAA63/4A1	1
	Rondella piana in rame ¼"x20	IDRO1/4X20CU	6
	Nipplo rid. Idr. G3/8-G1/4 conici nich.	MIRAIA73/8C-1/4CZ1	2
	Portagomma G3/4 Ø30	MIRAB23/4DN30A1	1
	Raccordo femmina inox a T da G1/4	MIRAB31/4A1	1
	Silenziatore pneum. G1/4 plastica	LEACSI1/4P	1
	Regolatore di flusso G1/4	MIVARF1/4FF	1

Gruppo	Tavola	Disegno
Catino	F	01



POS.	DENOMINAZIONE	CODICE	Q.tà
F1	Controspirale	Z1DD0227001-A	1
F2	Pomello di fissaggio	EPOM02Q0001--	2
F3	Catino	Z1DD0222001--	1
F4	Spiarle	Z1DD0226001-A	1
F5	Cuscinetto SKF 61856	CMCURS61856	1
F6	Vite T.E. M10x45	MIVI5739U1045A1	6
F7	Vite T.C. M10x40	MIVI5931U1040A1	5
F8	Piastra superiore	EPST18Q0003--	1
F9	Piattina caric. a vetro 275.5x256.5x5	EPIA18Q0002--	1
F10	Or 81000	CMGNOR81000AB	1
F11	Ruota Z=94	ERUO18F0001--	1
F12	Piattina caric. a vetro 213.5x195.5x5	EPIA18Q0001--	1
F13	Or 8775	CMGNOR8775AB	1
F14	Piastra inferiore	EPST18Q0003--	1
F15	Piastra base	EPST19I0001--	1
F16	Bussola guida per rotazione piastra inferiore	EBUS18G0004--	2
F17	Linguetta 8x7x32	MILI6604U8732	1
F18	Albero innesto superiore	EALB18F0001--	1
F19	Cuscinetto SKF 22205E	CMCUOR22205CC	1
F20	Seeger Ø25	MISE7435U25A	1
F21	Pignone Z=19	EPIG18F0004--	1
F22	Distanziale	EDIS18Q0003--	1
F23	Cuscinetto SKF 6204 2RS	CMCURS62042RS	1
F24	Merkel M17-40	CMGSM409011M17AB	1

Gruppo	Tavola	Disegno
Camera d'insacco	G	01



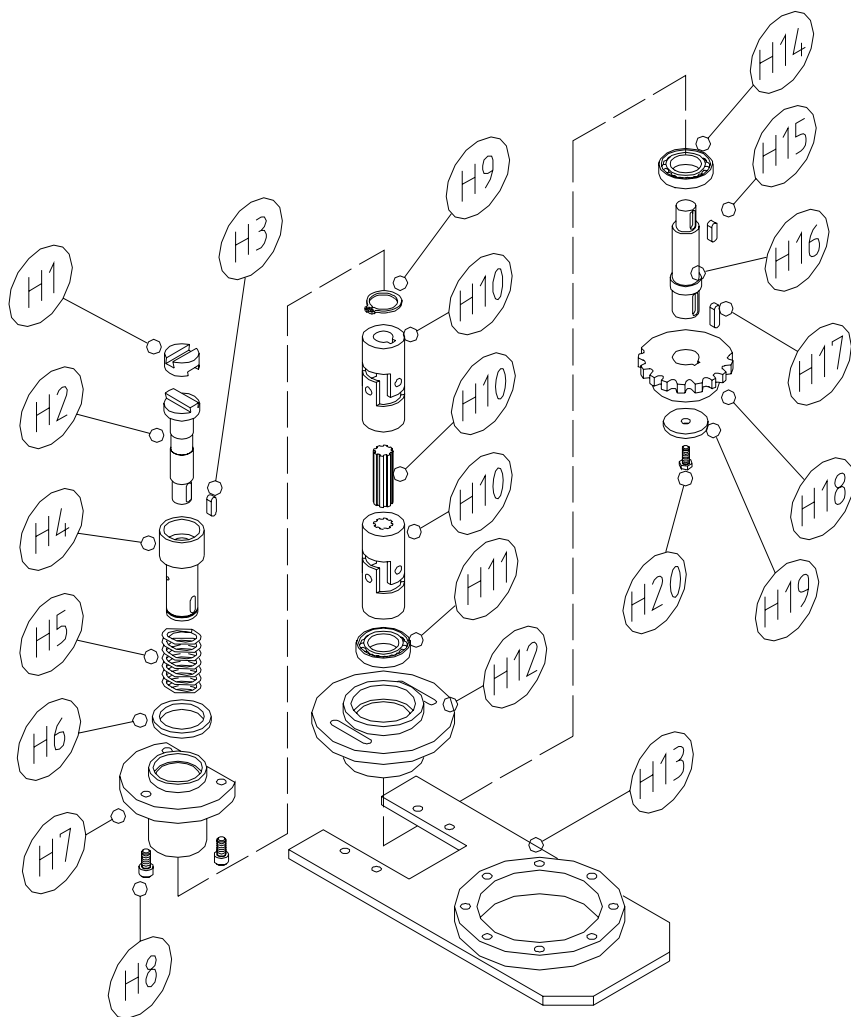
POS.	DENOMINAZIONE	CODICE	Q.tà
G1	Coperchio camma	ECOP19Q0001--	1
G2	Distanziale di fermo	EDIS19Q0001--	1
G3	Vite T.C. M16x30 sinistra	MIVI5931U1630A5	1
G4	Anello di bloccaggio	EANL19Q0001--	1

G5	Rotore a 20 tagli Rotore a 10 tagli	EROR19F0003-- EROR19F0004--	1 1
G6	Paletta	EPAL19D0001--	10 / 20
G7	Flangia scanalata	EFLA19F0001--	1
G8	Vite T.C. M8x20	MIVI5931U820A1	8
G9	Or 81300	CMGNOR81300AN	1
G10	Camera d'insacco	ECAE19S0001-B	1
G11	Vite T.C. M10x30	MIVI591U1030A1	8
G12	Piastra fissaggio riduttore	EPST03I0002--	1
G13	Vite T.E. M16x35	MIVI5739U1635A1	8
G14	Bussola filettata	EBUS19Q0001--	1
G15	Imbuto	VEDI DOTAZIONE	V.D.
G16	Ghiera chiusura	EGHI21Q0001--	1
G17	Merkel M17-75	CMGSM759011M17AB	1
G18	Piattello	EPIA19Q005--	1
G19	Cuscinetto SKF 6215 2RS	CMCURS62152RS	1

PEZZI A CONTATTO CON IL PRODOTTO

POS.	DENOMINAZIONE	CODICE	MATERIALE
G20	Coperchio camma	ECOP19Q0001--	AISI 420 da fusione tempra totale 52-53 HRC
G21	Distanziale di fermo	EDIS19Q0001--	RESINA ACET.
G22	Vite T.C. M16x30 sinistra	MIVI5931U1630A5	AISI 304
G23	Anello di bloccaggio	EANL19Q0001--	AISI 304
G24	Rotore a 20 tagli / a 10 tagli	EROR19F0003-- / EROR19F0004--	AISI 420 da fusione AISI 420 da fusione tempra totale 52-53 HRC
G25	Paletta	EPAL19D0001--	AISI 420 Tempra totale 52-53 HRC
G26	Flangia scanalata	EFLA19F0001--	AISI 420 BONIF.
G27	Vite T.C. M8x20	MIVI5931U820A1	AISI 304
G28	Camera d'insacco	ECAE19S0001-B	AISI 420 da fusione Tempra totale 54-55 HRC
G29	Bussola filettata	EBUS19Q0001--	AISI 304
G30	Imbuto	-	AISI 304 + Resina acetica
G31	Ghiera chiusura	EGHI21Q0001--	AISI 304
G32	Anello di strisciamento rotore	EANL19Q0003-B	PET
G33	Vite T.C. con intaglio M6x20	MIVI5931U620A1	AISI 304

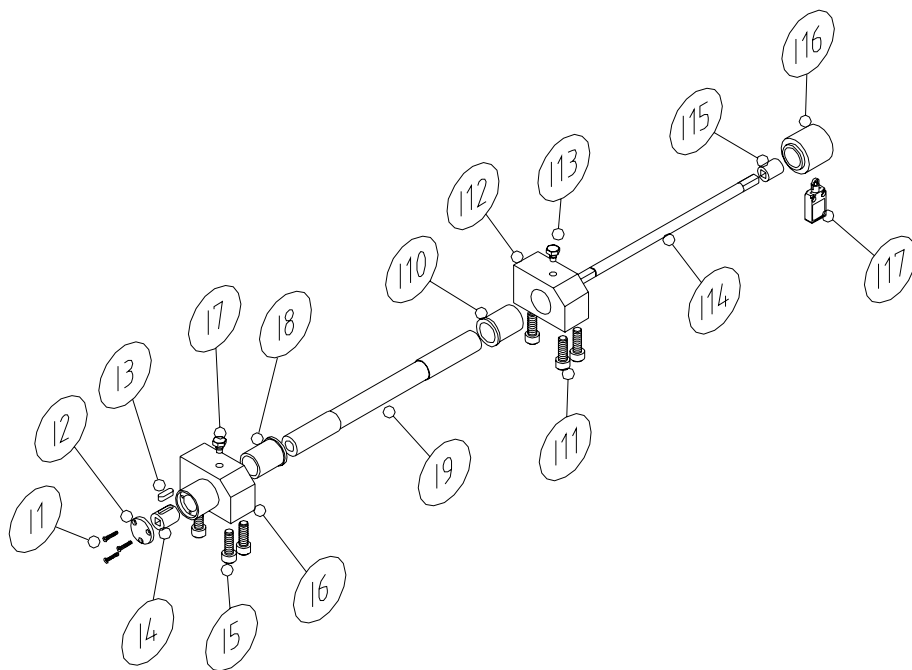
Gruppo	Tavola	Disegno
Alimentazione	H	01



POS.	DENOMINAZIONE	CODICE	Q.tà
H1	Dischetto	EDIC18F0001--	1
H2	Albero inferiore con innesto	EALB18F0007--	1
H3	Linguetta 8x7x22	MILI6604U8722	1

H4	Bussola scorrevole Vite di bloccaggio perno	EBUS18F0010— EVIT18Q0002--	1 1
H5	Molla per innesto	EMOL18Q0001--	1
H6	Bussola	EBUS18Q0011--	1
H7	Supporto bussola scorrevole	ESUP18Q0007--	1
H8	Vite T.C. M10x15	MIVI5931U1015A1	3
H9	Seeger per albero Ø35	MISE7435U35A	1
H10	Giunto cardanico	CMGI29447	1
H11	Cuscinetto SKF 6306 2RS	CMCURS63062RS	1
H12	Supporto rinvio mescolatore	ESUP18Q0006-A	1
H13	Piastra fissaggio pignoni per catena	EPST18I0001-A	1
H14	Cuscinetto SKF 6306 2RS	CMCURS63062RS	1
H15	Linguetta 8x7x30	MILI6604U8730	1
H16	Albero rinvio mescolatore	EALB18F0001--	1
H17	Linguetta 8x7x25	MILI6604U8725	1
H18	Pignone Z=12 per catena semplice	EPIG18F0003--	1
H19	Rondella per albero rinvio	ERON18Q0002--	1
H20	Vite T.E. M10x25	MIVI5739U1025A1	1

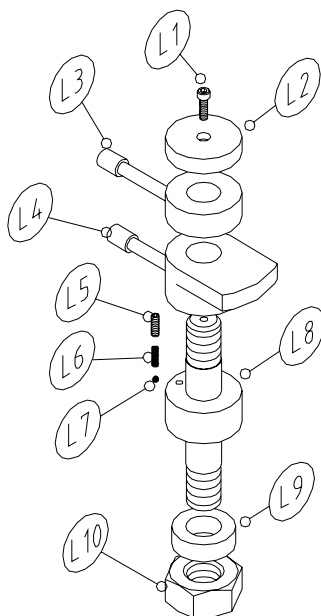
Gruppo	Tavola	Disegno
Ribaltamento catino	I	01



POS.	DENOMINAZIONE	CODICE	Q.tà
I1	Vite T. S. M4x10	MIVI5933U410A1	3
I2	Coperchietto per supporto sinistro	ECOP18Q0001--	1
I3	Linguetta 8x7x25	MILI6604U8725	1
I4	Bussola con quadro per supporti	EBUS18G0002--	2
I5	Vite T.C. M12x50	MIVI5931U1250A1	1
I6	Supporto rotazione testata sinistro	ESUP18G0001--	1
I7	Vite bloccaggio dado testata	EVIT18Q0001--	1
I8	Bussola supporto	EBUS18G0003--	1
I9	Albero per rotazione testata	EALB18F0002--	1
I10	Bussola supporto	EBUS18G0003--	1
I11	Vite T.C. M12x50	MIVI5931U1250A1	2
I12	Supporto rotazione testata destro	ESUP18G0002--	1

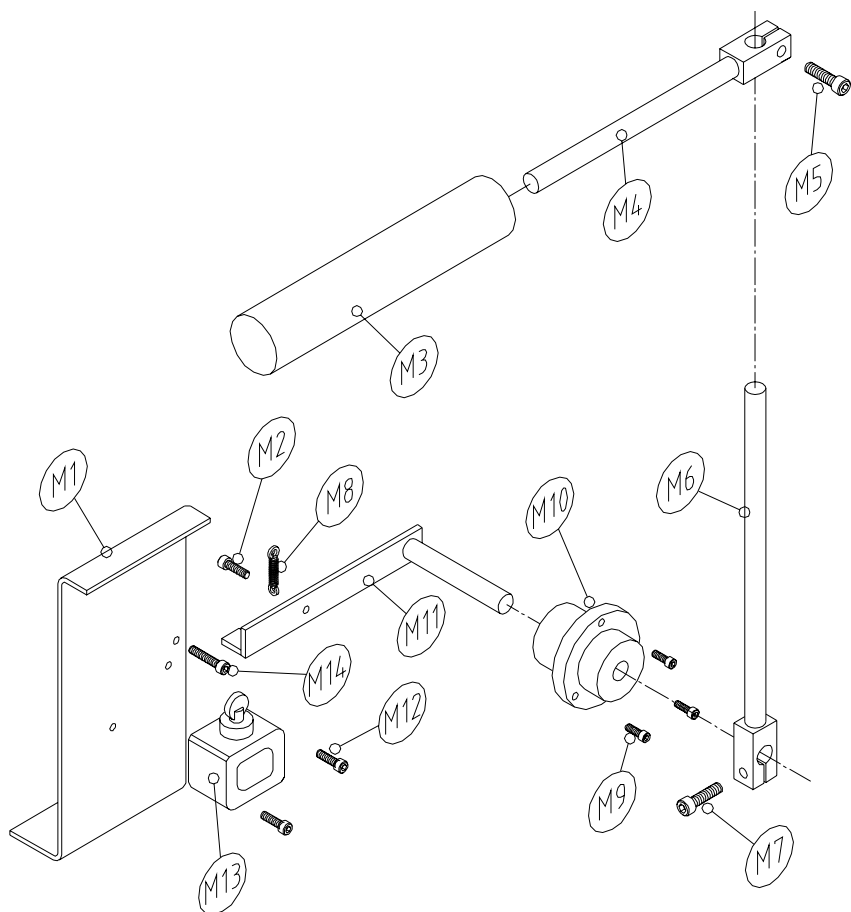
I13	Vite bloccaggio albero testata	EVIT18Q0001--	1
I14	Astina di torsione Ø13	EAST18G0001--	1
I15	Bussola con quadro	EBUS18G00001--	1
I16	Tappo copri raccordo	ETAP21Q0001--	1
I17	Sensore di sicurezza 120 272/3M elobau	TLSSSENSOREELOBAUM18	1

Gruppo	Tavola	Disegno
Chiusura testata	L	01



POS.	DENOMINAZIONE	CODICE	Q.tà
L1	Vite T.C. M6x15	MIVI5931U615A1	2
L2	Piattello per finecorsa leva chiusa testata	EPIA18Q0003--	2
L3	Maniglia sinistra	EMAN18Q0001A	1
	Maniglia destra	EMAN18Q0002-A	1
L4	Blocchetto sinistro	EBLO18Q0001-B	1
	Blocchetto destro	EBLO18Q0002-B	1
L5	Grano M10	MIGR	2
L6	Molla inox compr.1-Øm6.3-14.5-5.5	MIML17224DD12910	2
L7	Sfera inox Ø8	MIACSF8A	2
L8	Tirante destro	ETIR18Q0001--	1
	Tirante sinistro	ETIR18Q0002--	1
L9	Distanziale per tiranti	EDIS18Q0002--	2
L10	Dado esagonale M27	MIDA5588U27A1	2

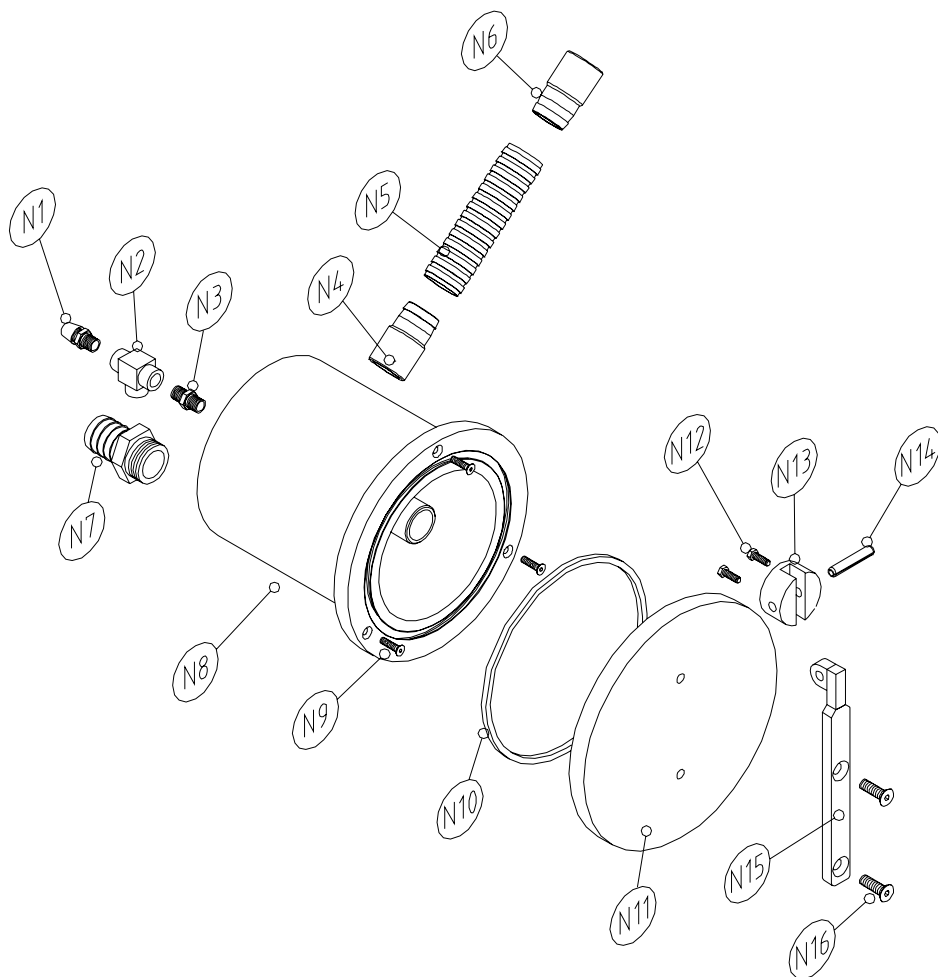
Gruppo	Tavola	Disegno
Ginocchiera	M	01



POS.	DENOMINAZIONE	CODICE	Q.tà
M1	Staffa per finecorsa ginocchiera	Z1DD0217008--	1
M2	Vite T.E. M6x25 Dado M6 Rondella Ø6	MIVI5739U625A1	1
		MIDA5588U6A1	1
		MIRO6592U6.412.5A	1
M3	Ginocchiera	EGIN21V0001--	1
M4	Leva corta ginocchiera	ELEV21V0002--	1
M5	Leva lunga ginocchiera	ELEV21V0003--	1
M6	Vite T.C. M8x30	MIVI5931U830A1	1

M7	Vite T.C. M8x30	MIVI5931U830A1	1
M8	Molla traz. Inox 1.6-15.4-63.7	MIML17224DT42140	1
M9	Vite T.C. M5x15	MIVI5931U515A1	1
M10	Bussola giocchiera	EBUS21V0001--	1
M11	Leva ginocchiera	ELEV21V0001--	1
M12	Vite T.C. M5x15 Rondella Ø5	MIVI5931U515A1	2
		MIRO6592U5.310A	2
M13	Finecorsa	TLFCBERNSTEINRO	1
M14	Vite T.E. M8x50 tutta filettata Dado M8 Rondella Ø8	MIVI5739U850A1	1
		MIDA5588U8A1	1
		MIRO6592U8.417A	1

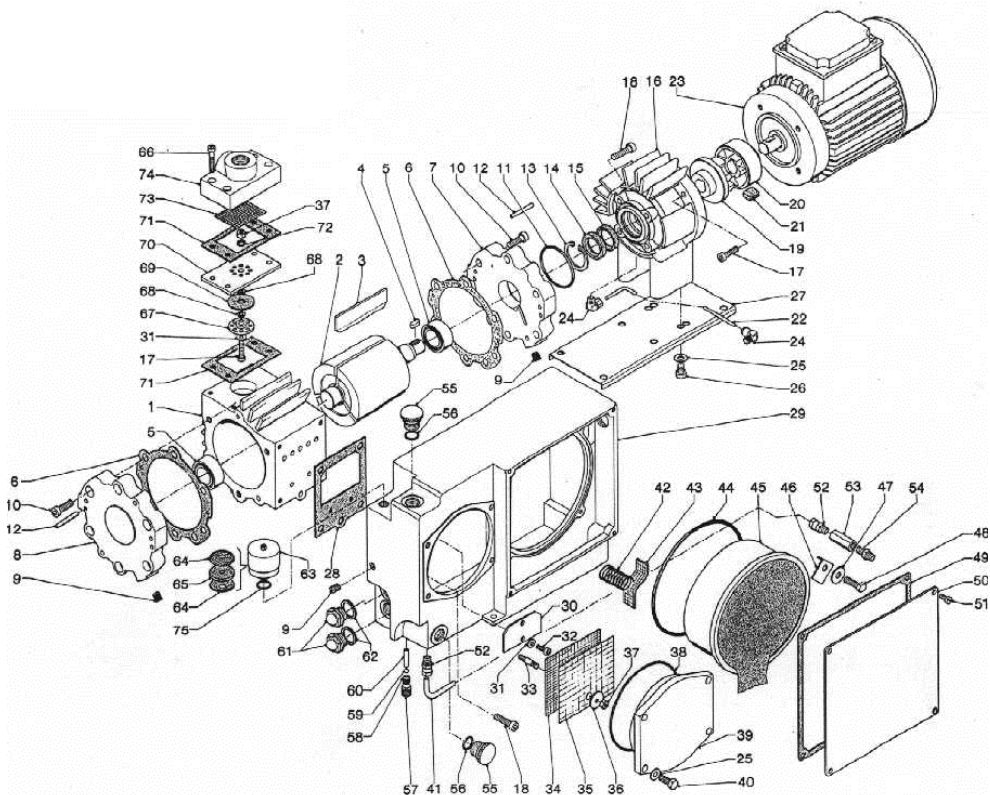
Gruppo	Tavola	Disegno
Oblò	N	01



POS.	DENOMINAZIONE	CODICE	Q.tà
N1	Raccordo diretto con ogiva Ø8	MIRAC61/48DA1	1
N2	Raccordo femmina a "T" da ¼"	MIRAB31/4A1	1
N3	Nipplo ¼" inox	MIRAA61/4A1	1

N4	Portagomma Ø30	MIRAB23/4DN30A1	1
N5	Tube per vuoto	ASTUSPI30	1
N6	Portagomma Ø30	MIRAB23/4DN30A1	1
N7	Portagomma 1''	MIRAB21''A1	1
N8	Oblò	EOBL21T0001-B	1
N9	VTS M5x15	MIVI5933U515A1	4
N10	OR 228	CMGNOR288AB	1
N11	Coperchio oblò	ECOP21Q0002--	1
N12	VTE M5x15	MIVI5739U515A1	2
N13	Piastrina fissaggio oblò	EPST21I0001-A	1
N14	Spina parallela	MISP2338I645A	1
N15	Astina chiusura coperchio	EAST21Q0001--	1
N16	VTS M8x20	MIVI5933U820A1	2

Gruppo	Tavola	Disegno
Pompa Rotant PVL 25 - 35	O	01



POS.	DENOMINAZIONE	CODICE	Q.tà
O1	Statore	-	1
O2	Rotore	-	1
O3	Paletta	-	3
O4	Chiavetta 6x15	-	1
O5	Cuscinetto NA4905	-	2
O6	Guarnizione carta	-	2
O7	Coperchio lato motore	-	1
O8	Coperchio lato esterno	-	1
O9	Tappo conico 1/8" G	-	4
O10	Vite T.C.E.I. M8x25	-	12
O11	O.R. 158	-	1

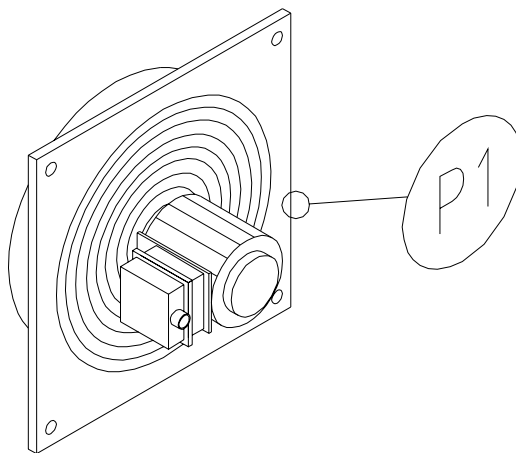
O12	Spina elastica d. 5x36	-	4
O13	Anello seeger d.40	-	1
O14	Anello tenuta 25-38-7	-	1
O15	Anello tenuta 25-35-7	-	1
O16	Manicotto pompa - motore	-	1
O17	Vite T.C.E.I. M6x25	-	5
O18	Vite T.C.E.I. M8x30	-	4
O19	Semigiunto maschio	-	1
O20	Semigiunto femmina	-	1
O21	Gommino per giunto	-	6
O22	Tubo d.4/2 sfogo anelli	-	1
O23	Motore elettrico	-	1
O24	Raccordo L 1/8" x tubo d.4/2	-	2
O25	Rosetta d.8	-	8
O26	Vite T.E. M8x12	-	4
O27	Basamento	-	1
O28	Guarnizione pompa – serbatoio	-	1
O29	Serbatoio	-	1
O30	Deflettore	-	1
O31	Rosetta d.6	-	3
O32	Vite T.C.E.I. M6x16	-	2
O33	Prigioniero M6	-	2
O34	Lamiera microstirata	-	1
O35	Lamiera stirata	-	1
O36	Rosetta d.6x24	-	2
O37	Dado M6	-	3
O38	O.R. 4500	-	1
O39	Coperchio sx per serbatoio	-	1
O40	Vite T.E. M8x20	-	4
O41	Tubo d.4/2 recupero olio	-	1
O42	Molla	-	1
O43	Filtro recupero olio	-	1
O44	O.R. 4650	-	1
O45	Separatore olio	-	1
O46	Squadretta premi separatore	-	4
O47	Rosetta d.8x24	-	4
O48	Vite T.E. M8x24	-	4
O49	Guarnizione coperchio dx	-	1
O50	Coperchio dx per serbatoio	-	1
O51	Vite T.C. M6x12	-	4
O52	Raccordo 1/8" per tubo d.4/2	-	2

O53	Valvola ritegno 1/8''G	-0*	1
O54	Nipplo conico 1/8''G	-0*	1
O55	Tappo 1/2''G	-	2
O56	O.R. 3075	-	2
O57	Tappo conico 1/4''G	-	1
O58	Tappo forato 1/8''G	-	1
O59	Sfera d. 6,4	-	1
O60	Tubetto Al a. 6/4x25	-	1
O61	Spia olio 1/2''G	-	2
O62	Rosetta spia olio	-	2
O63	Zavorratore 3/8''G	-	1
O64	Disco lamiera	-	2
O65	Disco feltro d. 34/7,5x4	-	1
O66	Vite T.C.E.I. M6x35	-	4
O67	Disco supporto valvola aspirazione	-	1
O68	Rosetta ottone d. 6/10x1,5	-	2
O69	Disco gomma d. 10/36x2	-	1
O70	Piastra valvola aspirazione	-	1
O71	Guarnizione aspirazione	-	2
O72	Rosetta grover d.6	-	1
O73	Filtro aspirazione	-	1
O74	Bocca aspirazione	-	1
O75	O.R. 119	-	1

* PVL 25/B - PVL 35/B

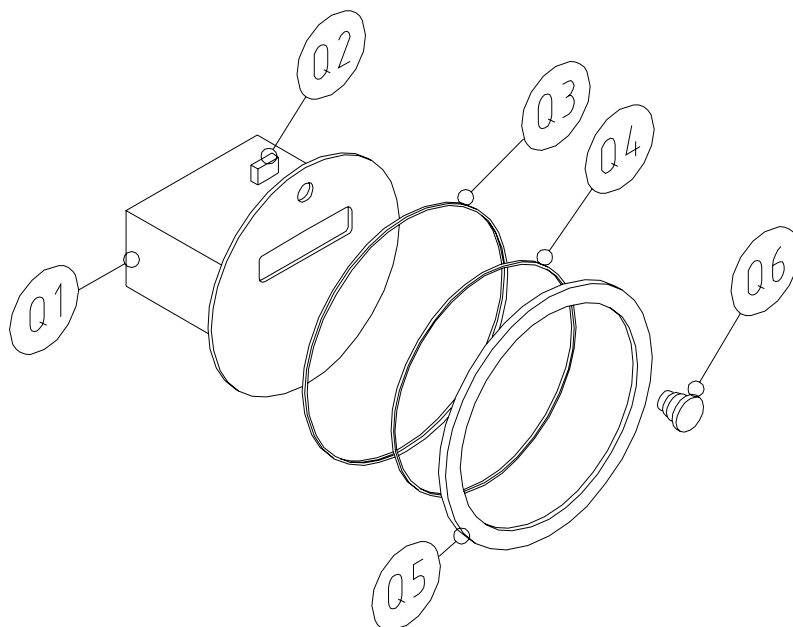
Pompa vuoto completa (Rotant PVL 25 25mc/h 0,75 kw)
Cod. TLPVPVL25

Gruppo	Tavola	Disegno
Ventilazione	P	01



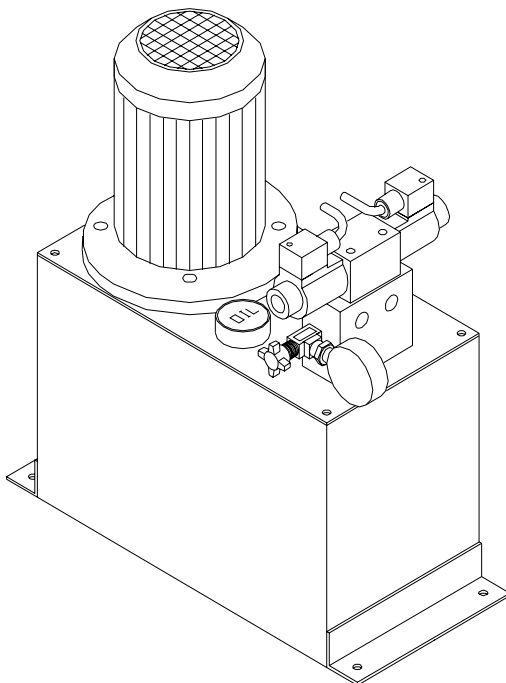
POS.	DENOMINAZIONE	CODICE	Q.tà
P1	Ventilatore	TLVEE254M	1

Gruppo	Tavola	Disegno
Pannello di comando	Q	01



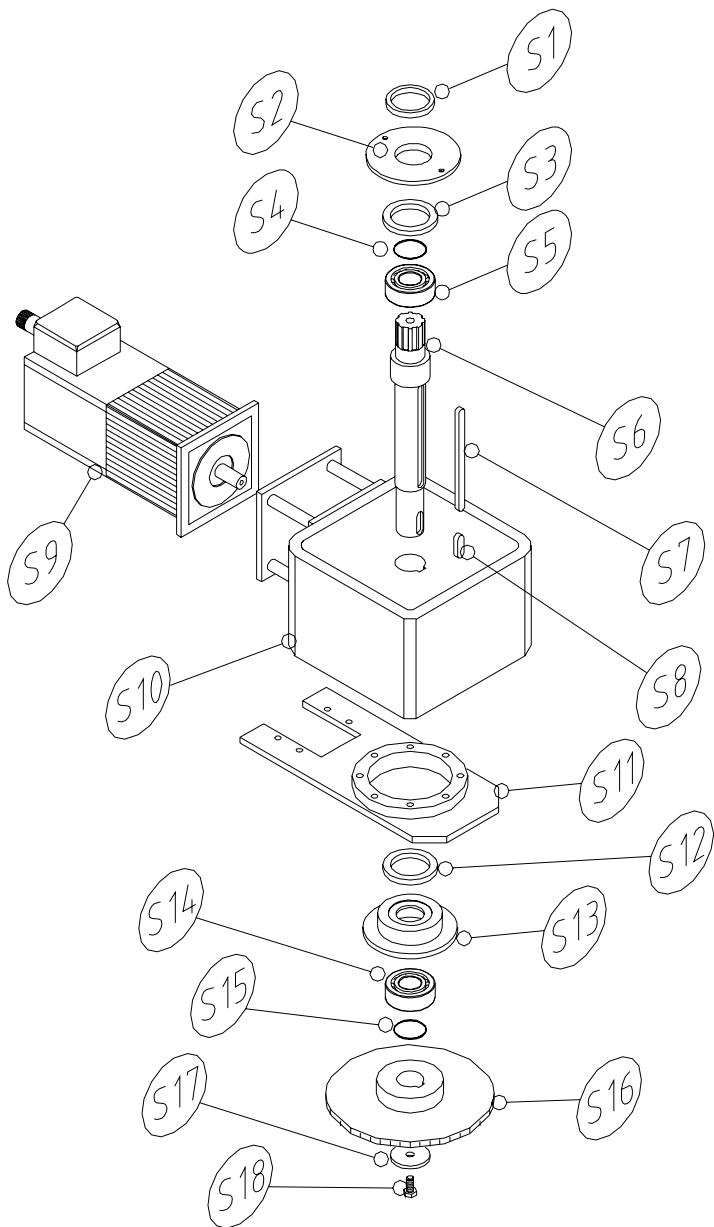
POS.	DENOMINAZIONE	CODICE	Q.tà
Q1	Pannello IC/10 Elap	HWPAPANNXIC10-CM140	1
Q2	Contatto chiuso	TLPUESNC	1
Q3	Guarnizione Ø3.5 esterna per pannello	CMGST3,5ESTPAN	1
Q4	Guarnizione Ø3.5 interna per pannello	CMGST3,5INTPAN	1
Q5	Flangia tastiera	EFLA21I0001--	1
Q6	Pulsante emergenza	TLPUESROEM	1

Gruppo	Tavola	Disegno
Centralina idraulica	R	01



POS.	DENOMINAZIONE	CODICE	Q.tà
R1	Centralina idraulica	IDCEIC10	1

Gruppo	Tavola	Disegno
Riduttore	S	01

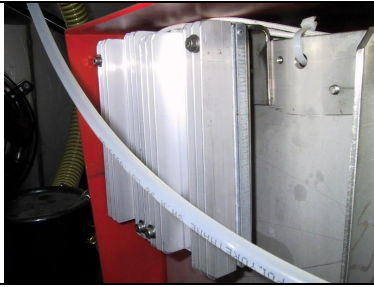
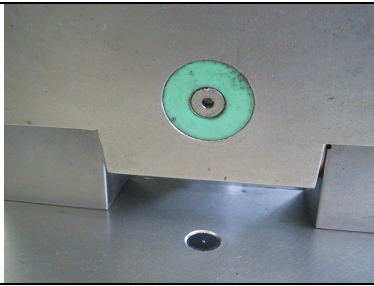




POS.	DENOMINAZIONE	CODICE	Q.tà
S1	Distanziale di spallamento	EDIS19Q0002--	1
S2	Anello di strisciamento rotore	EANL19Q0003-B	1
S3	Merkel M17-75	CMGSM759011M17AB	1
S4	Piattello	EPIA19Q0005--	1
S5	Cuscinetto SKF 6215 2RS	CMCURS62152RS	1
S6	Albero riduttore	EALB03F0004--	1
S7	Linguetta 14x9x200	MILI6604U149200	1
S8	Linguetta 14x9x45	MILI6604U14945	1
S9	Mot Brushless Vickers Fast T2 V8 030	TLMSFAST2V8030	1
S10	Riduttore K603 AG 0430 Stober	CMR2603AG43MQ20EL3	1
S11	Piastra fissaggio	EPST18I0001-A	1
S12	Distanziale grande per cuscinetto 2309	EDIS03Q0003--	1
S13	Flangia di supporto	EFLA03G0002--	1
S14	Cuscinetto SKF 2309E-2RS	CMCUOS2309E2RS	1
S15	Distanziale piccolo per cuscinetto 2309	EDIS03Q0004--	1
S16	Pignone Z=42	EPIG18F0002--	1
S17	Rondella per albero riduttore	ERON18Q0003--	1
S18	VTE M12X25	MIVI5739U1225A1	1




Gruppo	Tavola	Disegno
Materiale vario	T	01



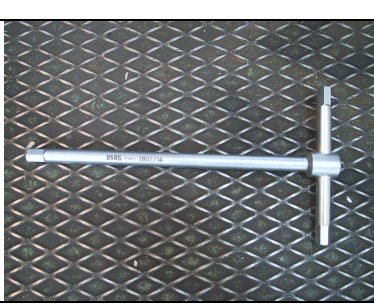

ALTRO MATERIALE



POS.	PARTICOLARE	DESCRIZIONE E CODICE
T1		<p>N°1 Spirale Cod. Z1DD0226001-A</p> <p>N°1 Controspirale Cod. Z1DD0227001-A</p> <p>N°2 Pomelli per controspirale Cod. EPOM02Q0001--</p> <p>N°1 Spogliatore corto per spirale Cod. ESPO02C0003—</p>
T2		<p>N°1 Tappo chiusura manicotto lavaggio Cod. ETAP19Q0001--</p>
T3		<p>N°1 Tassello appoggio catino Cod. ETAS02Q0001-A</p>
T4		<p>N°1 Tappo copri raccordo Cod. ETAP21Q0001--</p>

T5		<p>N° 1 Dissipatore di calore Cod. EDSS01A0001--</p>
T6		<p>N° 1 Sensore di sicurezza Cod. TLSSSENSOREELOBAUM18</p> <p>N°1 Magnete Cod. TLSSMAGNETEELBAUD30</p>
T7		<p>N°1 Maschio Cod. TLCONNETTORECNM10</p> <p>N°1 Custodia maschio Cod. TLCOCUSTODIACHO10L</p> <p>N°1 Femmina Cod. TLCONNETTORECNF10</p> <p>N°1 Custodia femmina Cod. TLCOCUSTODIACHP10LS</p>
T8		<p>N°4 Piede inox Ø150 M30-100 Cod. MIPI15030100</p>

ACCESSORI PER MANUTENZIONE

POS.	PARTICOLARE	DESCRIZIONE E CODICE
T9		<p>N°2 Pomolo maschio M8 per estrattore rotore Cod. MIACPOM8P</p>
T10		<p>N°1 Tappo lavaggio Cod. ETAP19Q0002—</p>
T11		<p>N°1 Estrattore rotore Cod. EEST19Q0001—</p>
T12		<p>N°1 Maniglia estrattore coperchio Cod. EMAN22Q0001—</p>

T13		<p>N°1 Chiave chiusura ghiera Ø95/100 Cod. UTCHGH95/100</p>
T14		<p>N°1 Chiave chiusura controspirale Ø68/75 Cod. UTCHGH45/50</p>
T15		<p>N°1 Chiave a "T" Cod. UTCHBR280T/14</p>
T16		<p>N°1 Cartuccia grasso Cod. UTLUCA400ZEP N°1 Pompa per grasso Cod. UTOFPMABC400</p>

T17		N°1 Mazza teflon Cod. UTOFMATEFLON
T18		N°1 Riduzioni Policlip Cod. ERID21D0001— (fil. metrica) Cod. ERID21D0002— (fil. Alim.)

Gruppo	Tavola	Disegno
Imbuti	U	01

CATALOGO IMBUTI INSACCATRICE



POS.	DENOMINAZIONE	CODICE
T1	Imbuto Ø12, lunghezza tubo L= 380	EIMB21D0023--
T2	Imbuto Ø15, lunghezza tubo L= 380	EIMB21D0024--
T3	Imbuto Ø18, lunghezza tubo L= 380	EIMB21D0025--
T4	Imbuto Ø20, lunghezza tubo L= 380	EIMB21D0029--
T5	Imbuto Ø25, lunghezza tubo L= 380	EIMB21D0026--
T6	Imbuto Ø30, lunghezza tubo L= 380	EIMB21D0027--
T7	Imbuto Ø32, lunghezza tubo L= 380	EIMB21D0032--
T8	Imbuto Ø38, lunghezza tubo L= 380	EIMB21D0028--
T9	Imbuto Ø45, lunghezza tubo L= 380	EIMB21D0030--
T10	Imbuto Ø50, lunghezza tubo L= 380	EIMB21D0031--

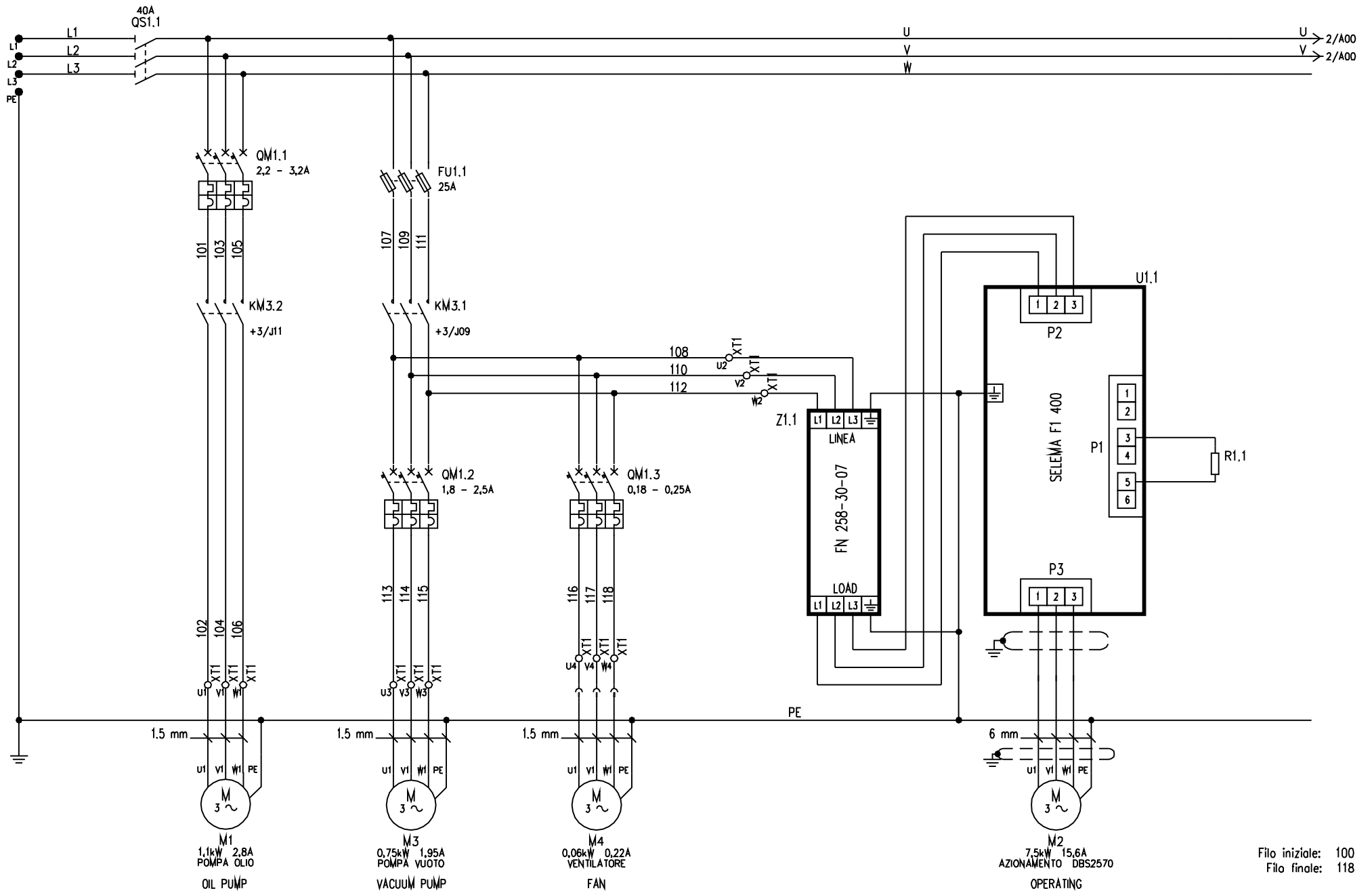
Velati s.r.l.

TECNOLOGIE ALIMENTARI DAL 1867



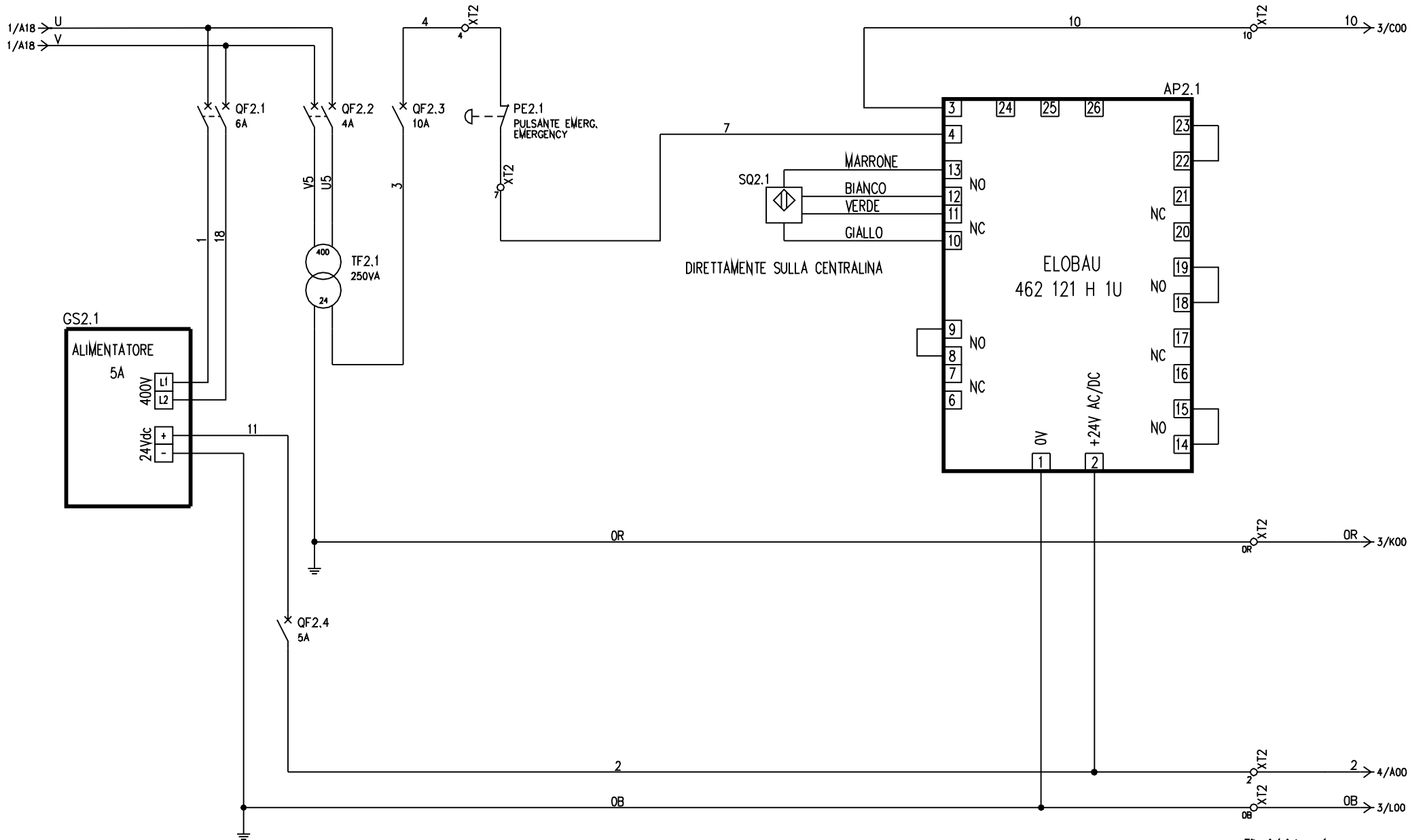
Via TRENTO , 2 20067 TRIBIANO (MILANO) Tel. 02/9064717 Fax 02/90630808

Cliente
Tipo macchina INSACCATRICE IC10
Nr. disegno TLQEI4003
Nr. programma pannello operatore
Nr. programma PLC
Potenza installata kW = 12
Tensione nominale V = 400
Frequenza Hz = 50
Linea alimentazione mm ² 10
Grado di protezione minima IP65



Filo iniziale: 100
Filo finale: 118

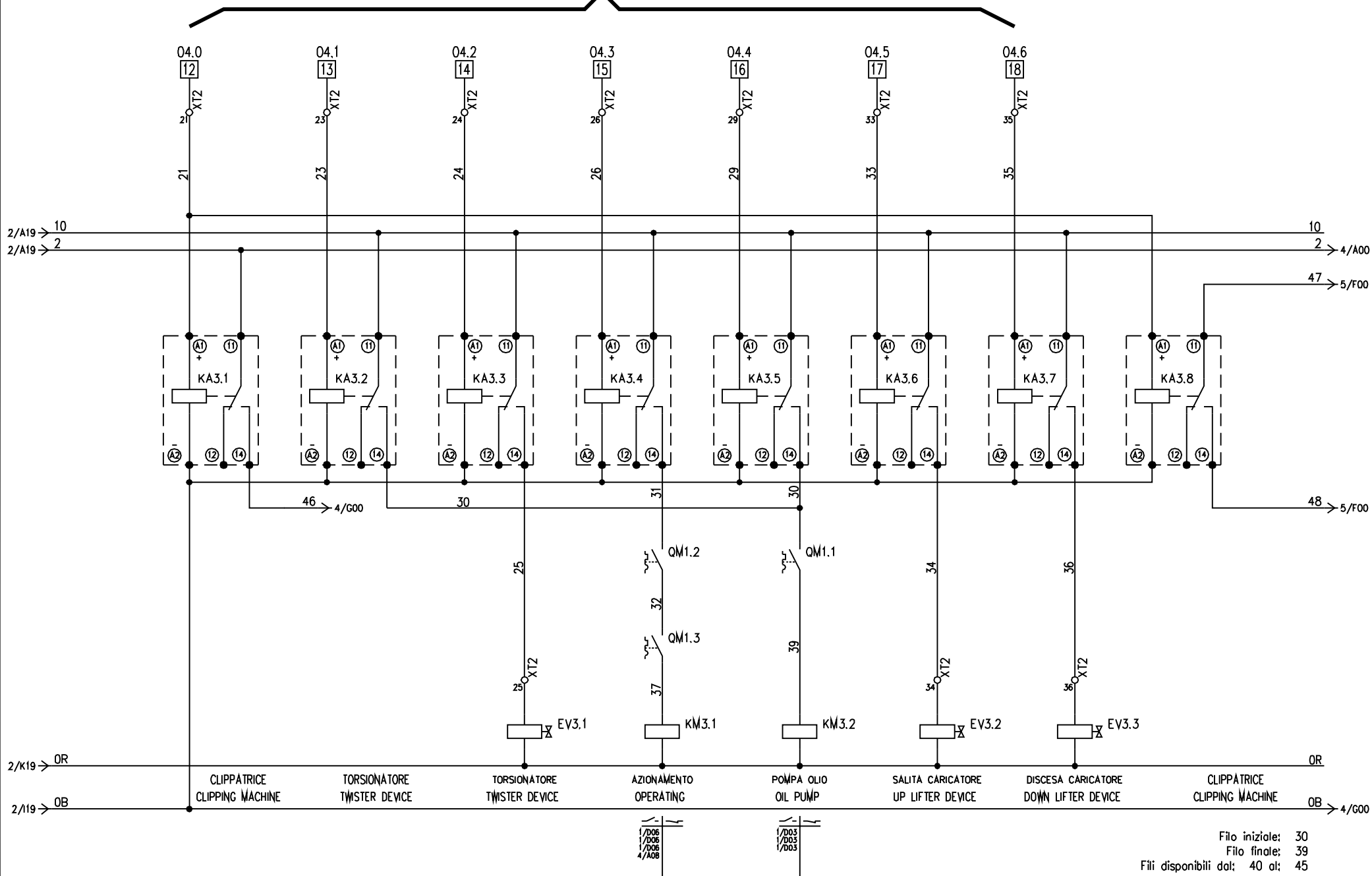


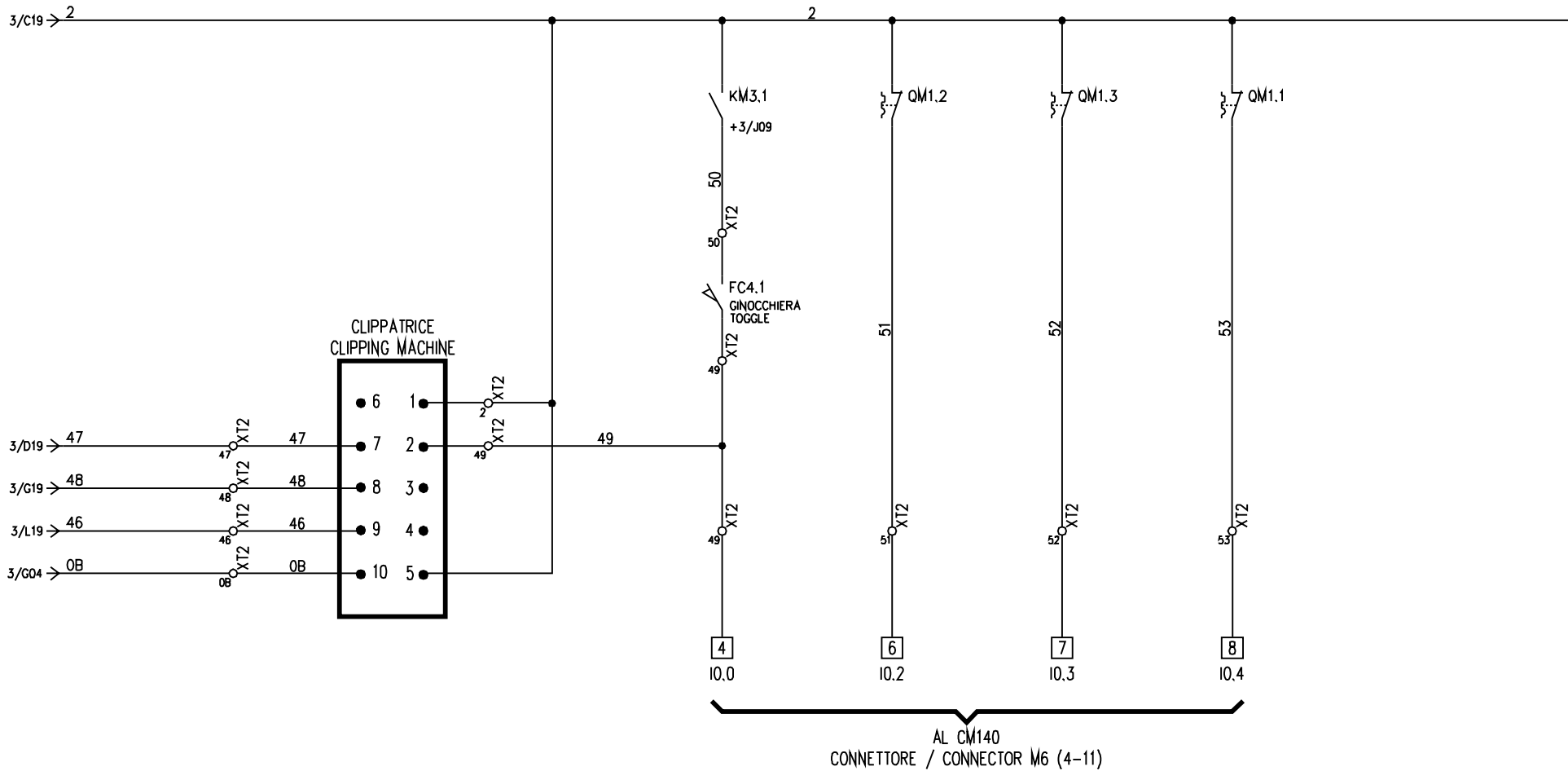


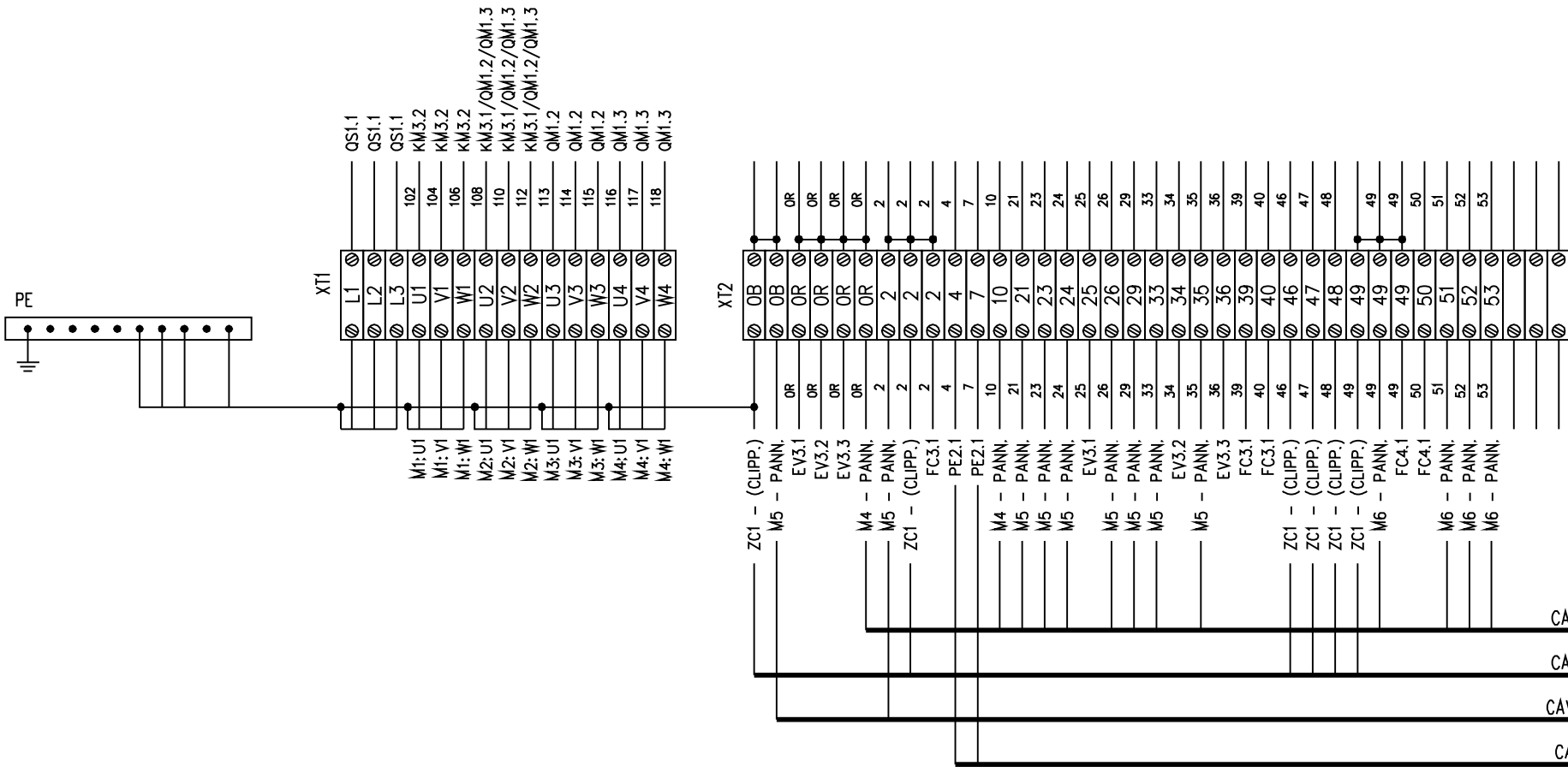
Filo iniziale: 1
Filo finale: 20



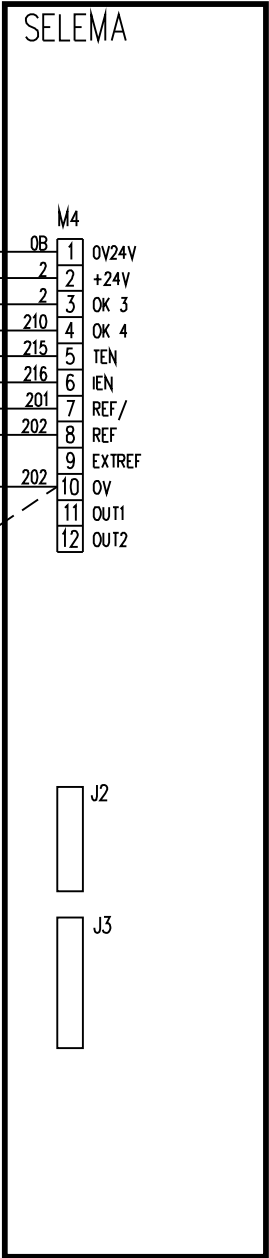
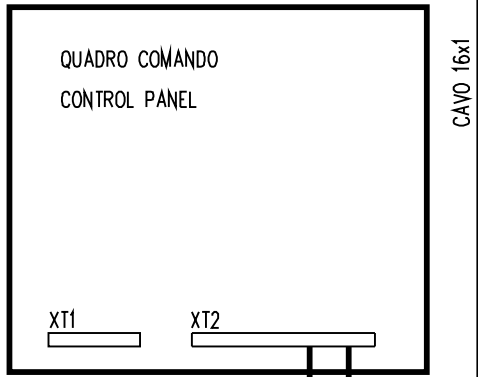
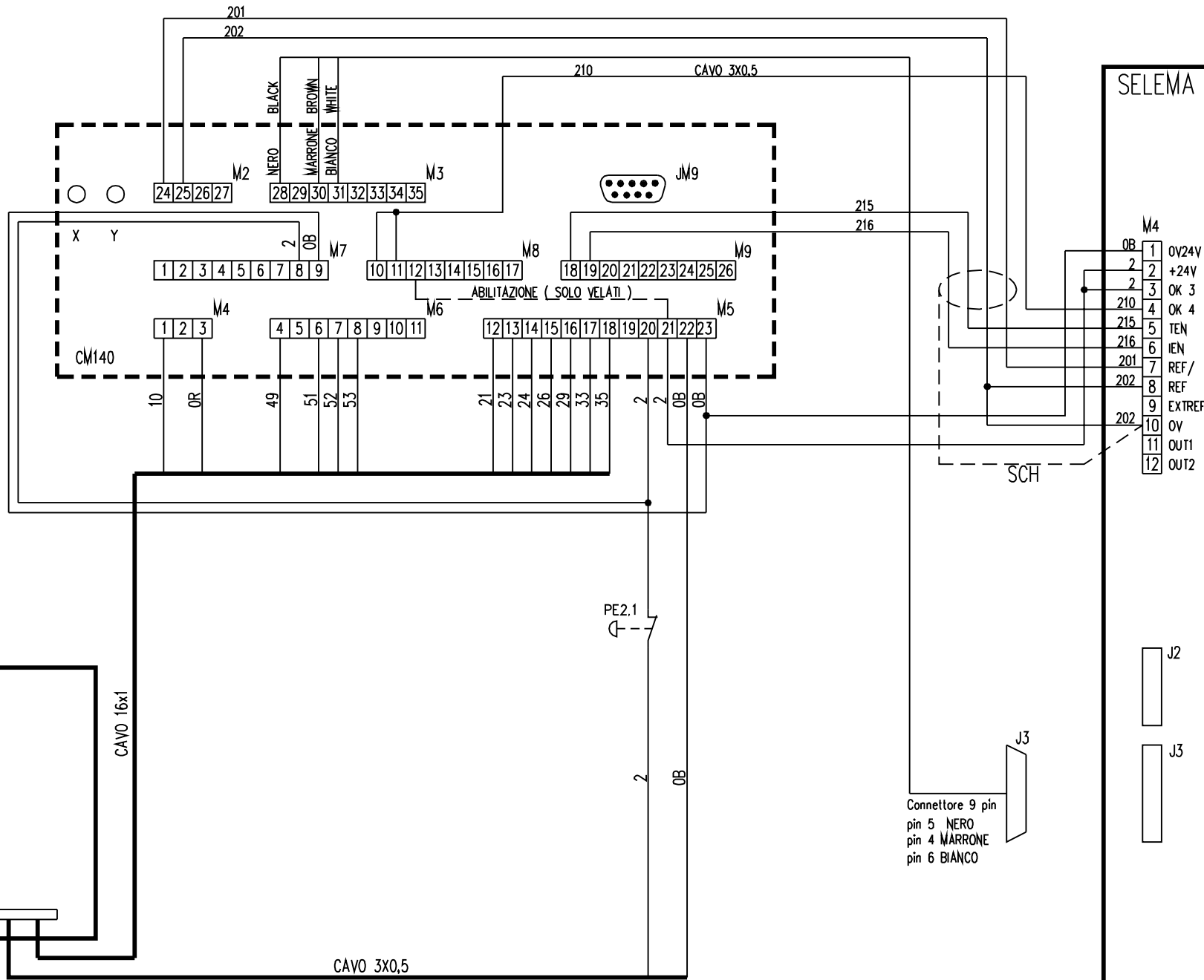
DAL CM140 CONNETTORE / CONNECTOR M5 (12-23)







Data	27/05/2002
Disegnato	GRASSI FABIO
Controllato	



Connettore 9 pin
 pin 5 NERO
 pin 4 MARRONE
 pin 6 BIANCO



