Group

INSTRUCTIONS FOR USE AND MAINTENANCE

ORIGINAL INSTRUCTIONS

+ **FILLING, CAPPING AND LABELLING LINE**

SERIAL NUMBER: 2298-2303

YEAR OF CONSTRUCTION: 2020

CE



Seven Fluss S.r.l. headquartered in via Fratelli Bandiera ,43 – 28040 Varallo Pombia Novara IT – tel. +39 0321 95 168 - 164 26 40
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Automatic Packaging Machinery

Sistemi di Dosaggio

Group

DECLARATION OF CONFORMITY

THE MANUFACTURER DECLARES THAT THE AUTOMATIC MACHINE FOR USE IN THE BOTTLING SECTOR, IDENTIFIABLE BY THE REFERENCES BELOW, IS IN COMPLIANCE WITH THE ESSENTIAL SAFETY AND HEALTH REQUIREMENTS REFERRED TO IN DIRECTIVE **2006/42/CE, 2014/30/UE, REG.1935/2004**

For the verification of conformity, the following standards have been consulted:
UNI EN ISO 12100:2010 – General principles for design – Risk assessment and risk reduction
EN 60204/1 2006 – Safety of machinery – Electrical equipment of machines

The person authorised to keep the technical file is:

Seven Fluss S.r.l. – Via Fratelli Bandiera, 43 – Varallo Pombia (NO)

Via Fratelli Bandiera,43
28040 Varallo Pombia (NO)
Tel. +39 0321 95168
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CE

MODELLO / MODEL	**Mod. : MR-4**				
MATRICOLA / SERIAL	**2298-2299-2300-2301-2302-2303**				
ANNO / YEAR	**2020**			PESO / WEIGHT	**2000 [Kg]**
VOLT	**400**	Hz	**50**	Kw	**10**

The Administrator

Varallo Pombia, on _____

Group

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GENERAL INFORMATION

GENERAL WARNINGS

It is advisable to read this manual carefully. If you wish to use and exploit in the best way the possibilities of the “MONOBLOC” it is fundamental that you know in depth its performance and its possibilities of use.

!!!WARNING!!!

THE MANUFACTURER will not be held responsible for inconveniences, breakages, various accidents etc. due to the non-knowledge (or in any case to the non-observance) of the indications contained in this manual. The same applies to the carrying out of variants, modifications, and/or the installation of accessories not previously authorised.

Furthermore THE MANUFACTURER declines all responsibility for damage deriving from:

- **Natural calamities**
- **Erroneous manoeuvres**
- **Lack of maintenance**

The linear filling, capping and labelling module may be used exclusively for the closing of the formats for which it has been designed and built REFER TO THE PHOTO BELOW.



PET BOTTLES

Before the use of the machine it is indispensable that the operators (supervisors and operators) are aware of the content of the “SAFETY STANDARDS” given in this manual.

Maintenance involves few and simple operations that can be carried out by the operator in charge of the machine. To obtain the maximum duration of the machine and the best economy of operation, it is advisable to adhere faithfully to the provisions contained in this manual.

Use exclusively ORIGINAL SPARE PARTS

Do not wait for the components to be worn out by use; replace them at the appropriate moment, so as to obtain a better operation of the machine, and a lower operating cost since greater damage is avoided.

RESERVE

The Manufacturer reserves the right to modify the machine, for any requirement of a constructional or commercial nature, without the obligation to promptly update the instruction and use manual as well as the spare parts catalogue.

THE MANUFACTURER makes its technical assistance service available to customers to solve any type of problem concerning the adjustment, the use and the maintenance of the machines

The requests must be made after a careful analysis of the inconveniences that have occurred and of the possible causes. Indicate in particular:

- Description of the defects found.
- The checks already carried out, if any.
- The adjustments, the modifications made and their effects.
- Any other information deemed useful for solving the problem.

Every request must be sent to:

SEVEN FLUSS S.r.l.
Via Fratelli Bandiera
28040 Varallo Pombia (NO) - ITALY

Tel.: +39 0321 95168
Fax.: +39 0321 1641834
Mail : info@sevenfluss.com

In the requests always indicate:

- *Serial number of the machine*
- *Model of the machine*
- *Year of construction*

SAFETY STANDARDS FOR USE



DANGER
VOLTAGE



DANGER
MOVING PARTS

When they involve danger, the safety standards set out in this manual are recognisable by the symbol

ATTENTION:

in addition to the standards listed below, the person responsible for the machine must comply with what is provided for by the law in force on the safety and health of personnel in the workplaces.

The person responsible for the machine must know the safety devices installed on it, as well as the method of use; moreover he must instruct the operators on the following:

- Safety and accident-prevention regulations
- Specific regulations concerning the machine
- Location of the controls

The person responsible for the machine designates the operators authorised to operate the machine, establishes the competences and the limits of intervention.
Only the aforesaid operators may work on the machine.

ATTENTION:

always adhere to the safety standards and to the instructions listed in this manual THE MANUFACTURER declines all responsibility consequent to an incorrect use of the machine.

THE TRANSPORT, THE UNLOADING AND THE ASSEMBLY OF THE MACHINE MUST BE CARRIED OUT ONLY BY SPECIALISED AND AUTHORISED PERSONNEL.
THE SUPPLY VOLTAGE MUST CORRESPOND TO THAT REQUIRED.

Take care not to invert the phases.
THE ELECTRICAL SUPPLY SYSTEM MUST BE CARRIED OUT IN ACCORDANCE WITH THE STANDARDS IN FORCE. Subsequently check, periodically, that the various power cables are in perfect condition.

ATTENTION:

DO NOT ALLOW PERSONS NOT INVOLVED IN THE WORK TO APPROACH THE MACHINE.

The use, the maintenance, the checks and the repair of the machine are permitted only to enabled operators. Said operators must be persons physically and intellectually suitable, not under the effect of alcohol or drugs.

ATTENTION:

When it is not working, the machine must be protected from involuntary movements. Therefore cut off the power and press the emergency stop button

CHECK, before starting work, for any visible defects on the safety devices and that the emergency stop button operates regularly.

MAKE SURE THAT:

- there are no persons not involved near the machine
- there are no foreign objects on the machine (tools, rags, etc.)
- the machine, after having been started, does not emit anomalous noises; should this happen, stop it immediately and identify the cause.
- all the doors and protections are regularly closed

DO NOT USE:

- garments that may get caught in the moving parts (scarves, foulards, wristwatches, bracelets, rings etc.)

USE:

- caps that contain the hair, for those who have long hair.
- shoes with non-slip soles.

ATTENTION:

When the equipment is replaced, to change the format of the product to be processed, the main switch must be switched off and the emergency stop button pressed.

ATTENTION:

When the machine is running, it is strictly forbidden to deactivate the protection and safety devices.

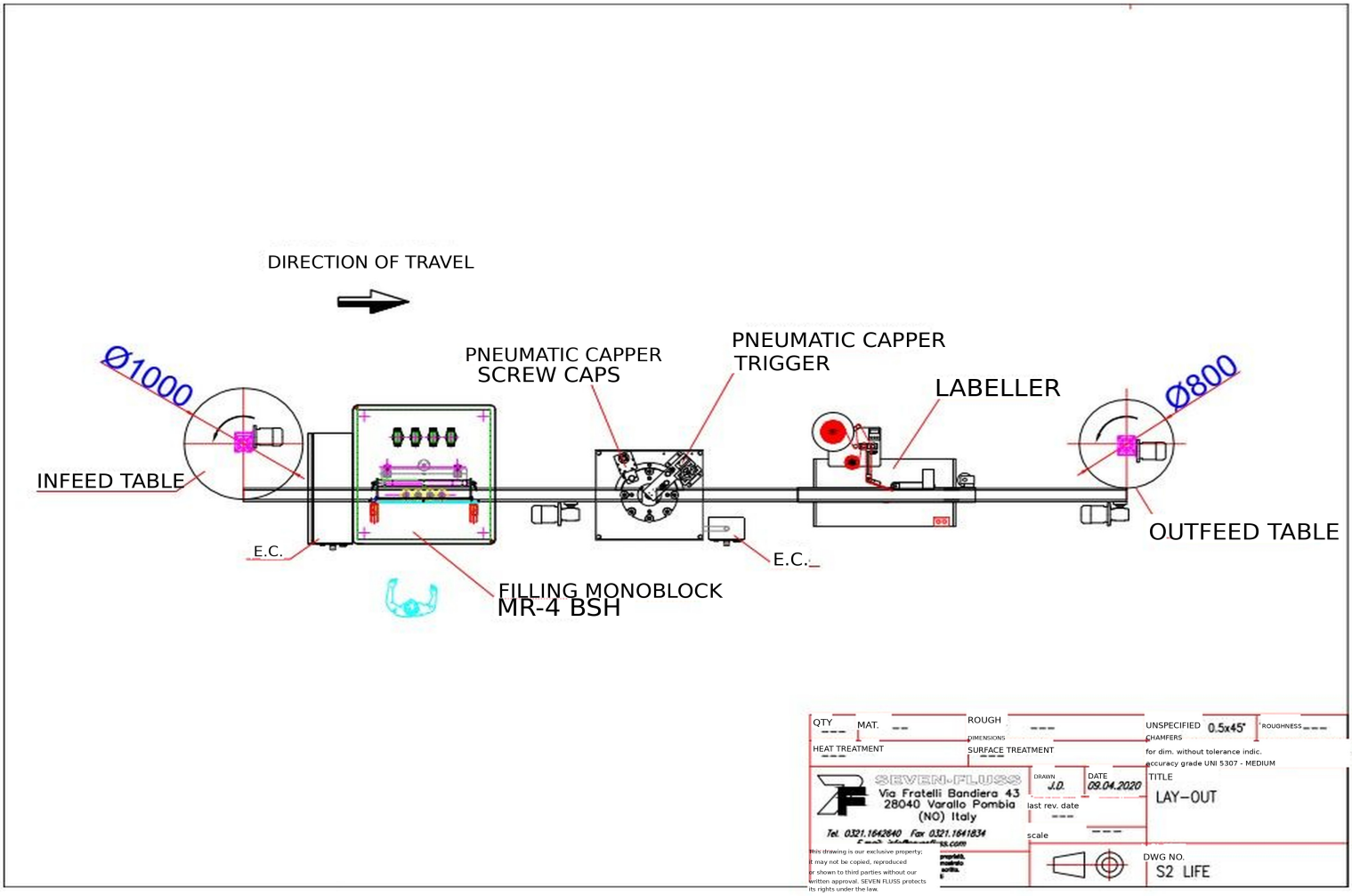
At the change of shift the operator must inform the person succeeding him and his superior of any operating and/or safety defects found, even if they have not caused the stopping or a malfunctioning of the machine.

ATTENTION:

Do not intervene on the machine when it is running, keep a proper distance from the moving parts.
Do not handle tools, various objects, detergents, etc. near the machine when it is running.
Do not start the machine should anomalies be noticed on the equipment, instruments, indicator lights etc. present on the control panel.
During operation, the machine must always be supervised by an operator.

THE LINE CANNOT OPERATE IN AN EXPLOSIVE ATMOSPHERE

THE LINE MUST BE USED BY ONE OPERATOR AT A TIME (unless there is a need to supply the machinery, increase production, carry out ordinary or extraordinary maintenance), in that case DIFFERENT ROLES WITH SPECIFIC AND DIFFERENT TASKS MAY BE INVOLVED


DIRECTION OF TRAVEL
Ø1000
PNEUMATIC CAPPER
SCREW CAPS
PNEUMATIC CAPPER
TRIGGER
LABELLER
Ø800
INFEED TABLE
E.C.
E.C.
OUTFEED TABLE
FILLING MONOBLOCK
MR-4 BSH
QTY
MAT.
ROUGH
UNSPECIFIED 0.5x45°
ROUGHNESS
DIMENSIONS
CHAMFERS
HEAT TREATMENT
SURFACE TREATMENT
for dim. without tolerance indic.
accuracy grade UNI 5307 - MEDIUM
SEVEN-FLUSS
Via Fratelli Bandiera 43
28040 Varallo Pombia
(NO) Italy
Tel. 0321.1642640 Fax 0321.1641834
DRAWN
J.D.
DATE
09.04.2020
TITLE
LAY-OUT
last rev. date
scale
DWG NO.
S2 LIFE
This drawing is our exclusive property;
it may not be copied, reproduced
or shown to third parties without our
written approval. SEVEN FLUSS protects
its rights under the law.

PARTS OF THE CONTROL SYSTEMS RELATED TO SAFETY

Safety function (mechanical risk): line stop with guards open

The interlock microswitches ensure that the line cannot be started except after the front guards have been closed, and its immediate stop in the event of opening. They are managed by means of a category 3 safety control unit equipped with double control, managed by the PLC on board the machine. The restoration of functionality can take place exclusively from the panel located on the front of the machine. Therefore there is no exposure to risk, not even for short moments.

The level of risk related to the aforesaid function has been assessed as category A (low)

Safety function (electrical risk): emergency stop

The emergency stop buttons present on the line, in the event of intervention, determine the isolation of the electrical supply and the cutting off of the pneumatic actuators. The functions considered are implemented by means of a category 3 double-break contactor and by a category 3 safety control unit equipped with double control, managed by the PLC on board the machine. The stop determined by the intervention of the emergency buttons is immediate. The buttons are immediately identifiable and easily reachable. The total enclosure of the line protects the operator from the risks that could be generated in the event of an emergency during the execution of the work cycle. The restoration of the functionalities of the line, after the removal of the cause of the emergency and the restoration of the functionality of the buttons, can take place exclusively from the panel located on the front of the machine.

The level of risk related to the aforesaid function has been assessed as category A (low)

SAFETY STANDARDS FOR MAINTENANCE

ATTENTION:

All the control, lubrication, adjustment and maintenance operations must be strictly carried out with the machine stopped, the power disconnected and the emergency stop button pressed.

When it becomes necessary to switch on the power to carry out certain operations, check that the appropriate safeties have been inserted or insert them.

The power must be switched on only for the time strictly necessary for the execution of the operation, paying the utmost attention to persons and to the machine.

ATTENTION:

During repair work, the safeties may be deactivated exclusively by specialised personnel, who must pay particular attention in order to avoid damage to persons or to the machine.

WARNINGS THAT MUST BE OBSERVED WHEN CARRYING OUT INTERVENTIONS ON THE MACHINE:

- ➢ Apply a sign on the control panel indicating its “out of service” status.
- ➢ All the repair operations must be carried out by specialised personnel guided by a supervisor.
- ➢ After having disconnected the power, take measures to prevent it from being switched on accidentally.
- ➢ In interventions on the electrical system, after having made sure that the voltage has been removed, provide for an earth connection and for barring any nearby parts under
  - Do not allow persons not involved in the work to approach the machine.
- ➢ D o not clean the electrical components with water or other fluids.

ATTENTION:

In the washing and cleaning operations of the machine, use aggressive detergents, lyes, acids etc. with caution. Strictly adhere to the instructions of the detergent manufacturer. Use protective clothing, such as goggles, overalls, gloves etc.

ATTENTION:

When several persons are engaged in the repair work, before starting the machine it is compulsory to warn them.

ATTENTION:

To carry out certain checks it is possible to operate the machine manually with the protection carter open. Before carrying out such operations, it is mandatory to keep uninvolved persons away.

CHECKS FOR SAFETY

AT THE END OF THE MAINTENANCE OR REPAIR WORK, BEFORE STARTING THE MACHINE.

The person responsible for the machine will check that all the works have been completed, that all the safeties are regularly operating and that the persons not involved in the operation of the plant have been kept away.

CHECK AFTER 1000 WORKING HOURS

Check all the safety devices.

CHECK AFTER 2000 WORKING HOURS

The machine must be subjected by the specialised operator to an annual check to verify that all the safeties are regularly operating and that the various parts of the machine are in good condition. Once the check has been carried out, apply a label on the machine certifying that the check has been performed.

NOTE

For any maintenance, repair work etc. use exclusively

SPECIALISED PERSONNEL or contact the “TECHNICAL ASSISTANCE SERVICE OF THE MANUFACTURER.”

ATTENTION:

THE MANUFACTURER does not guarantee the repair work and is not responsible for the damage that may derive from it when said work has not been carried out by its personnel.

TRANSPORT

UNPACKING AND LIFTING

UNPACKING

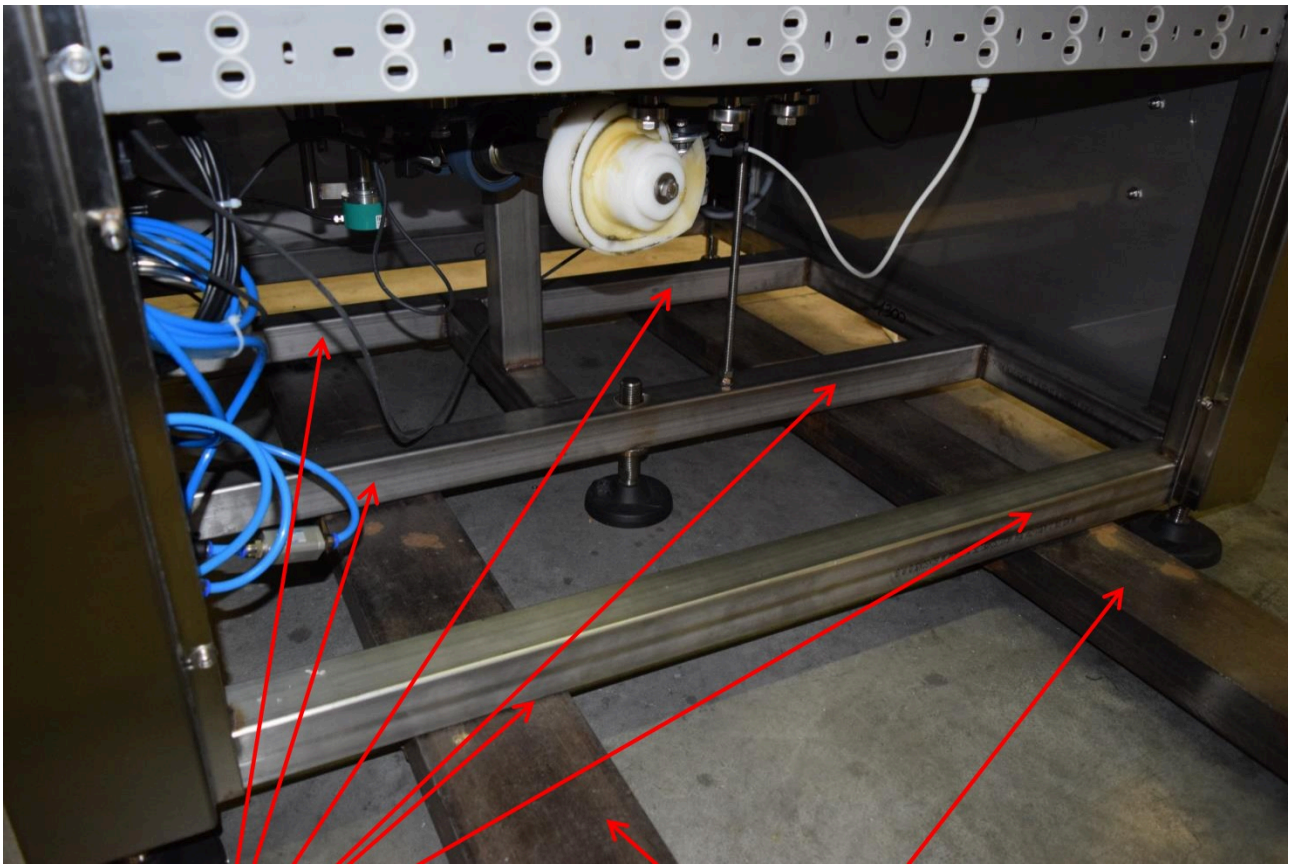
The machine is delivered using packaging systems or other types of protection, depending on the type of transport used; it is strongly recommended to pay the utmost attention during the removal of the packaging, in order to prevent damage to the machines and injuries to persons, as well as to dispose of the packaging materials in accordance with the laws in force in the country in which the machine will be installed

LIFTING

The lifting of the “CAPPING MACHINE” must be carried out by personnel specialised in such operations (forklift truck drivers, crane operators, etc.) with assistance on the ground from a person appointed to signal the overall dimensions in the event that the dimensions of the crate do not allow sufficient visibility; the personnel must be equipped with clothing and personal safety devices.

- Make sure that access to the area in which the lifting operations are carried out is forbidden to persons not directly involved in the work, using adequate means (barriers, warning signs, etc.).
- The capacity of the lifting means used must be adequate for the mass to be lifted; the movement must be slow, with appropriate lighting and sufficient free space to work in safety conditions.
- Under no circumstances must the personnel appointed to carry out the handling operations pass under the load or in its immediate vicinity. This also applies to the person in charge of giving the signals to the driver.
- Pay the utmost attention while moving the units: keep hands and other parts of the body away while the loads are being lowered.

Carry out the lifting operations as indicated: in the case of use of inadequate means or of hazardous actions there is the danger of serious injuries to the operators or of damage to the machinery, damage for which the company SEVEN FLUSS S.r.l. will not be held responsible in any case.



LIFTING ATTACHMENTS

FORKLIFT FORKS

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- - Email info@sevenfluss.com website www.sevenfluss.com

DEMOLITION OF THE MACHINE

The demolition of the machine must be carried out by personnel specialised in the mechanical and electrical field. The regulations relating to these operations vary according to the States and may differ considerably, therefore it is recommended to analyse and apply all the legal provisions at the moment in which the machine is to be decommissioned. The machine has been built using non-hazardous materials (steel, plastics, rubber) which do not give recycling or disposal problems at the end of their service; in any case, it is necessary to have a good knowledge of the constructional characteristics of the machine and a good technical ability to dismantle it, as well as specific tools. It is recommended to contact the technical service of SEVEN FLUSS s.r.l. in order to obtain the maximum safety conditions while this work is carried out.
Before any In particular it is suggested to:

- **Oils and lubricants:** Drain all the gearboxes and any other components of the used oils and dispose of them in accordance with the regulations in force in the country of use
- **Electrical components:** Remove and separate every electrical component (cables, motor protectors, computers, panels etc.) and dispose of them in accordance with the regulations in force in the country of use
- **Plastic parts:** Remove and separate every plastic component (bottle equipment, guides, selections for the feeder etc.) and dispose of them in accordance with the regulations in force in the country of use
- **Ferrous parts:** Remove and separate every ferrous electrical component (cables, motor protectors, computers, panels etc.) and dispose of them in accordance with the regulations in force in the country of use.

Group

TECHNICAL CHARACTERISTICS

DIMENSIONS

The linear filling, capping and labelling module has been designed and built to close PET containers with cap, trigger and pump closures. The machine consists of a filling station with 4 dosers, a monobloc with a motorised central star wheel having inside it two capping stations for screw cap and spray, a labelling station, a motorised loading table + a likewise motorised unloading table and two conveyor belts.

All the setting and control operations of the machine are programmed by a PLC and can be controlled and modified through two Touch screen panels positioned on the electrical cabinet located on the side of the machine. As regards the labelling machine there are only the start and stop keys and the emergency mushroom button.

VOLTAGE	400 V / 3 phases
ELECTRICAL CONSUMPTION	9 kw
CURRENT FREQUENCY	50 Hz
COMPRESSED AIR OPERATING PRESSURE	6 BAR
COMPRESSED AIR CONSUMPTION	500 Nlt/min
NOISE LEVEL - MAXIMUM LEVEL DURING WORK - MAXIMUM TEMPORARY LEVEL	 < 70 DB (A) < 80 DB (A)
AMBIENT VOLUME (minimum recommended)	>200 m3

POSITIONING AND CONNECTIONS

POSITIONING OF THE MACHINERY

ATTENTION: 

The machine is normally supplied assembled in every part. Should it become necessary, for transport or shipment in wooden crates, to dismantle some parts, during the positioning phase, before connection to the other supplies of the plant, provision must be made for their reassembly.
During positioning, in addition to compliance with the safety standards, the safety devices of the machine must under no circumstances be removed or tampered with (carters, electrical and/or electronic protection barriers, mechanical barriers, etc.).

POSITIONING

The machine must be positioned on a floor capable of bearing its weight distributed over the various feet, without its load-bearing capacity being lost over time; the floor must be carefully levelled, of the non-slip type and without surface defects.
The installation site must allow the operator to move around the machine without hindrance and to carry out easily and in safety his ordinary work and the extraordinary operations (maintenance and intervention on the machine).

ATTENTION: 

The levelling of the machine must be carried out with precision in order to prevent twisting, imperfect parallelism between the planes and irregular loads on the supports.
The manufacturer declines all responsibility for damage or malfunctioning of the machines due to incorrect levelling or to non-observance of maintenance at the designated intervals.

➢ Open the protection doors.

- Level the machine by positioning a spirit level on a horizontal plane of the machine and operating on the adjustable feet (PHOTO 2). Make sure that all the support feet are loaded uniformly.



- After having verified that the machine is actually levelled, lock the feet by tightening the relevant lock nuts.

NOTE: After having finished the levelling procedure, check the position of all the conveyor belts and of the connection transmissions with any other machines and, if necessary, operate on the supports to adjust height and parallelism.

Group

CONNECTION AND INSTALLATION OF THE CONVEYOR BELT

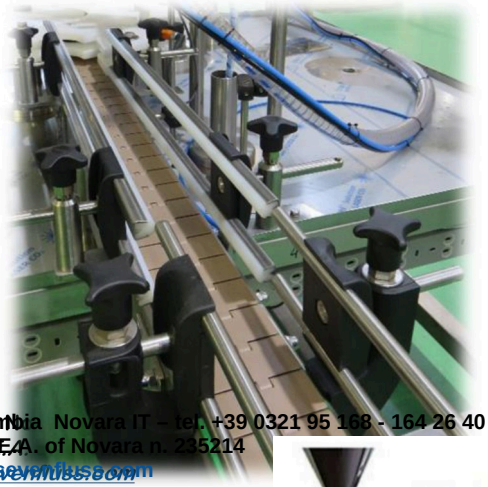
ALL THE HANDLING OPERATIONS OF THE MACHINE MUST BE CARRIED OUT BY QUALIFIED PERSONNEL AND WITH THE UTMOST CARE IN ORDER TO AVOID DAMAGING THE MACHINE

Install the belt observing the following procedure:

- Bring the conveyor belt close to the machine by inserting the assembly bolts in the through holes present on the box frame of the conveyor belt and in the holes on the body of the machine.
- Check that the belt is perfectly aligned with the axis of the machine (the belt must pass without lateral forcing from the box frame to the machine plane).
- Make sure that the conveyor belt is perfectly levelled with the machine plane: if necessary operate on the three-foot adjustable supports.
- Tighten the bolts that fix the conveyor belt to the machine.
- After having positioned the box frame, fit and close the chain by inserting the connecting pin between the first and the last link.
- Adjust the tension of the chain by moving the return roller along the mounting slots present in the box frame.

WARNING:

If the chain is excessively tight it may cause forcing of the return roller and excessive wear of all the parts in contact through sliding. The chain is supplied with the suitable length, do not add or remove links from the chain.
If necessary act on the return roller provided by making it slide in the adjustment slots. Tighten the fixing lock nuts so that the pin of the roller has no play or displacement.



- Connect the motor cable of the conveyor belt and check the direction of rotation.
- Check that any emergency stop button is connected and operates correctly

ELECTRICAL CONNECTION

!!!WARNING!!!

The connection between the machine and the electrical mains must be carried out only by specialised personnel observing the safety standards in force in the country in which the machine is to be installed.

WARNING:

Make sure that the characteristics of the main cables and of the earth cable correspond to the specifications indicated in paragraph 1.2.2. Connect the other end of the electrical cable to an automatic switch, thermal or magnetic, respecting the connection order of the machine.

ATTENTION:

Before carrying out the first electrical connection with the machine, disconnect the power supply from the main line. It is furthermore necessary to:

- Make sure that the electrical supply characteristics correspond to what is declared on the identification plate of the machine.
- Insert the power cable in the cable gland and connect the wires to the terminal board of the main switch referring to the electrical diagrams supplied at the end of this manual.



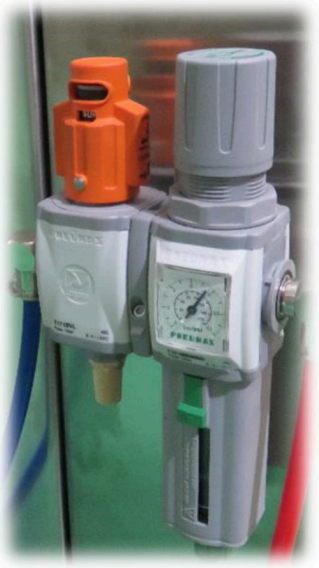
EARTH CONNECTION

The machine must be provided with an earth connection to be connected to the earth of the plant of the installation site. The connection between earth and external line is made inside the electrical cabinet.
The earth cable must have a cross-section equal to at least 50% of the cross-section of the electrical supply cable of the machine.



PNEUMATIC CONNECTION

Before carrying out the connection check that the characteristics of the pneumatic supply comply with what is indicated in the section “TECHNICAL CHARACTERISTICS”.



The connection of the pneumatic system of the machine is carried out by connecting the compressed air hose to the special fitting on the filter/regulator unit on the side of the machine (PHOTO 5).

Make sure that the filter/regulator unit is set for a maximum operating pressure of 6 bar (87 psi); if necessary adjust the pressure value by acting on the special knob.

USE and ADJUSTMENTS

GENERAL NOTICES

The filling, capping and labelling line is a machine with multiple capabilities, several of which are automatic. It is possible to cap bottles of different format and shape with plastic caps, after changing the capping head and the specific accessories.

THE MACHINE IN QUESTION IS PREPARED FOR CAPPING WITH PRE-THREADED PLASTIC CAPS (GENERAL WARNINGS / PAGE 7)

THE MACHINE OPERATOR

The machine "OPERATOR" is responsible for the daily maintenance of the "FILLING, CAPPING AND LABELLING LINE".
His task is, in addition to that of making sure that the necessary materials (caps, bottles) are always available, to verify that the correct settings of the machine have been made. In particular it is necessary that the following be checked:

- **That the machine is correctly prepared to be able to work the caps and bottles whose equipment is mounted.**
- **That all the safety devices have not been tampered with or damaged**
- **That there is no foreign body inside the machine.**

BOTTLE FORMAT

Check that the star wheel pockets and any other accessories are the corresponding ones; maximum play of the bottle in the star wheel pocket = -0, +2 mm.
It is advisable to check the outer diameter of the bottle and to verify that the value detected corresponds to the one stamped on the star wheels, on the rear rails and on any other equipment.

SPEED SYNCHRONISATION

To use the capping machine in a bottling line it is necessary to synchronise the speed of the machine with the rest of the line.

It is possible to modify the speed by acting on the potentiometer with numbered scale located on the electrical cabinet (PHOTO 6); turning clockwise the speed is INCREASED; turning ANTI-CLOCKWISE it is decreased.



TOUCH SCREEN OPERATION

See the description document attached (Att.1-T) to this manual

MANUAL RUNNING AND AUTOMATIC CYCLE

MANUAL RUNNING →

For the management of the machine in manual cycle refer to the OPERATOR PANEL MANUAL attached to this manual

In manual running condition the utmost attention is required on the part of the operators. Its use must be limited solely to operations for restoring the standardised cycle

Group

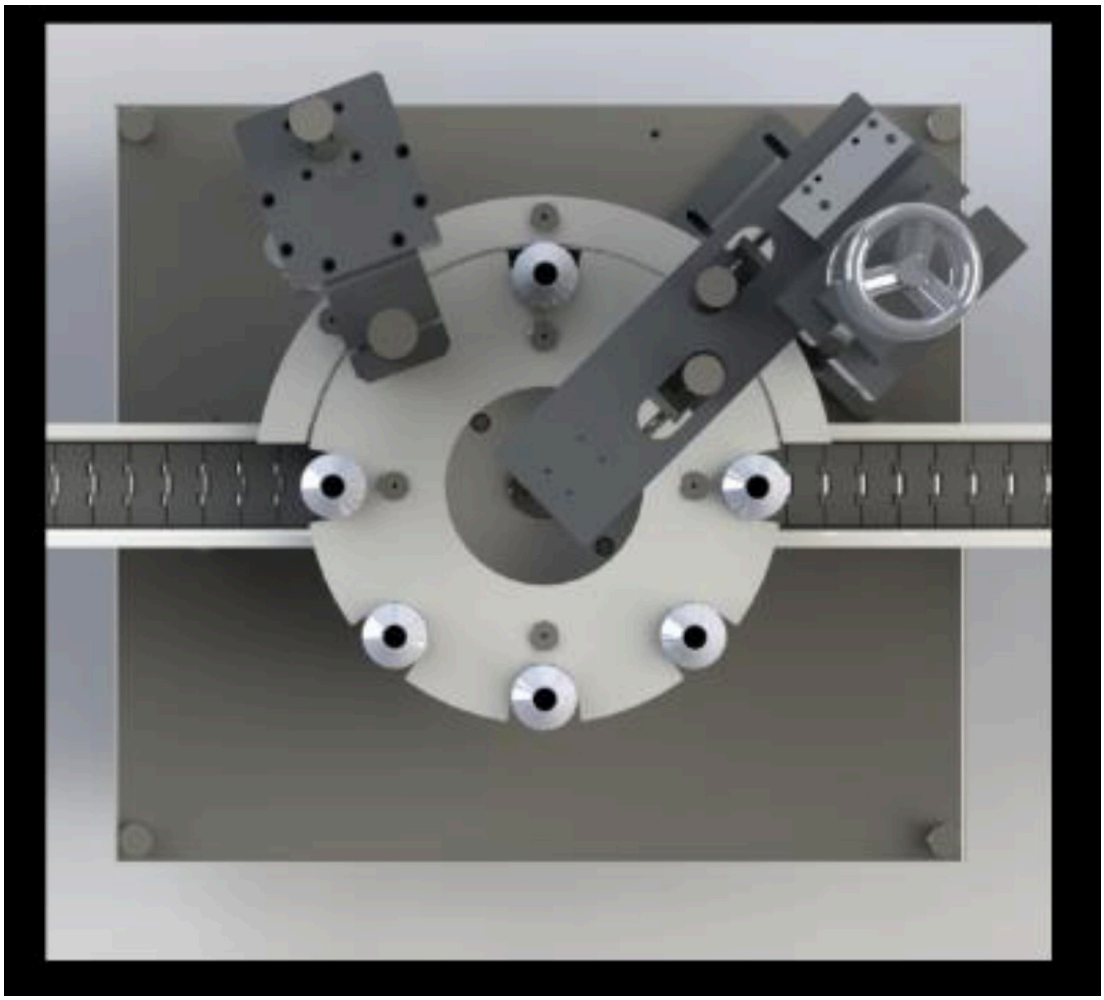
AUTOMATIC CYCLE →

For the management of the machine in automatic cycle refer to the OPERATOR PANEL MANUAL attached to this manual

BOTTLE FORMAT CHANGE

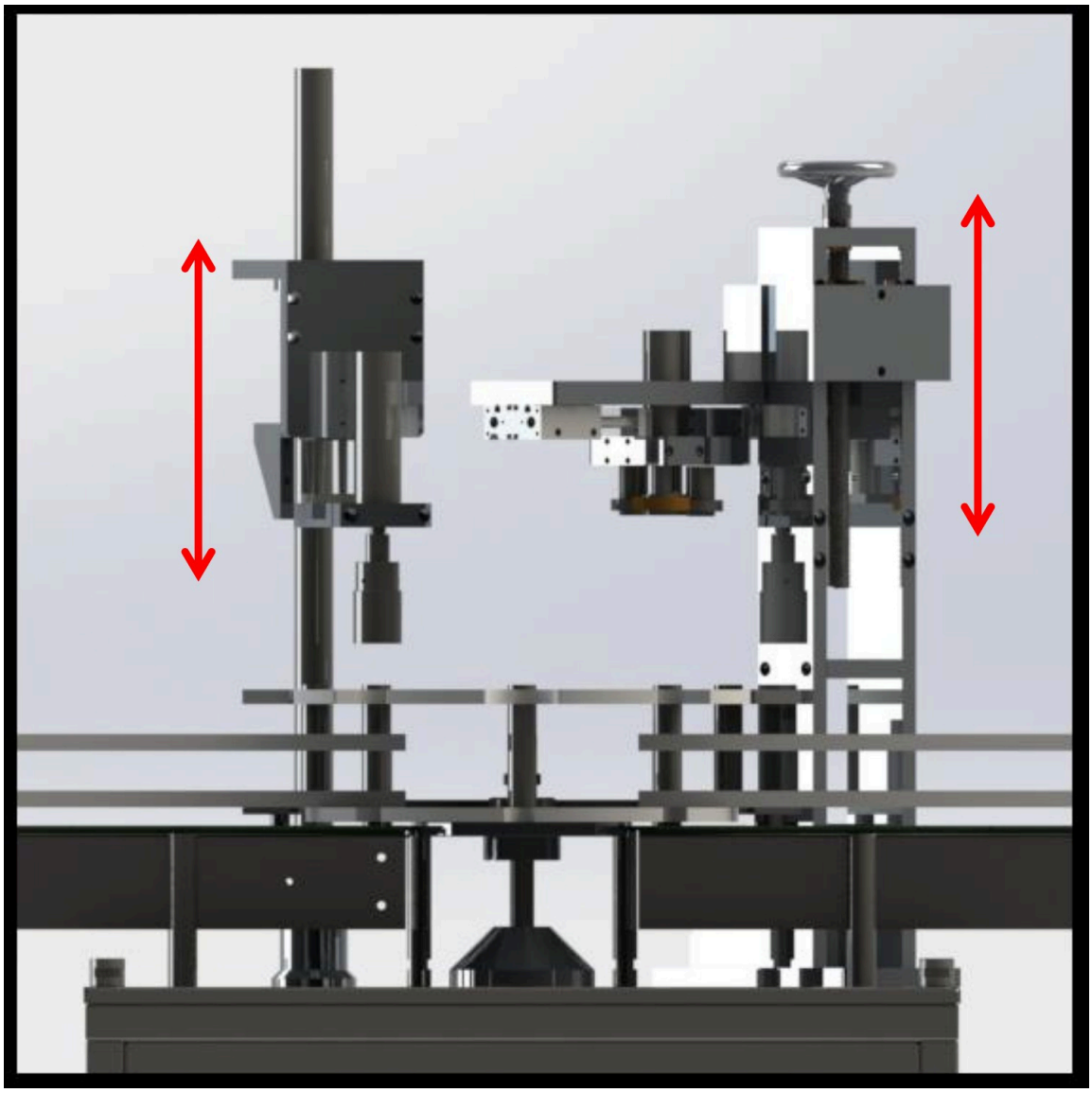
CAPPER :

- **Wanting to use bottle formats of different diameter it is necessary to interchange the transport star wheel, the external counter-shoulder and the capping head.**



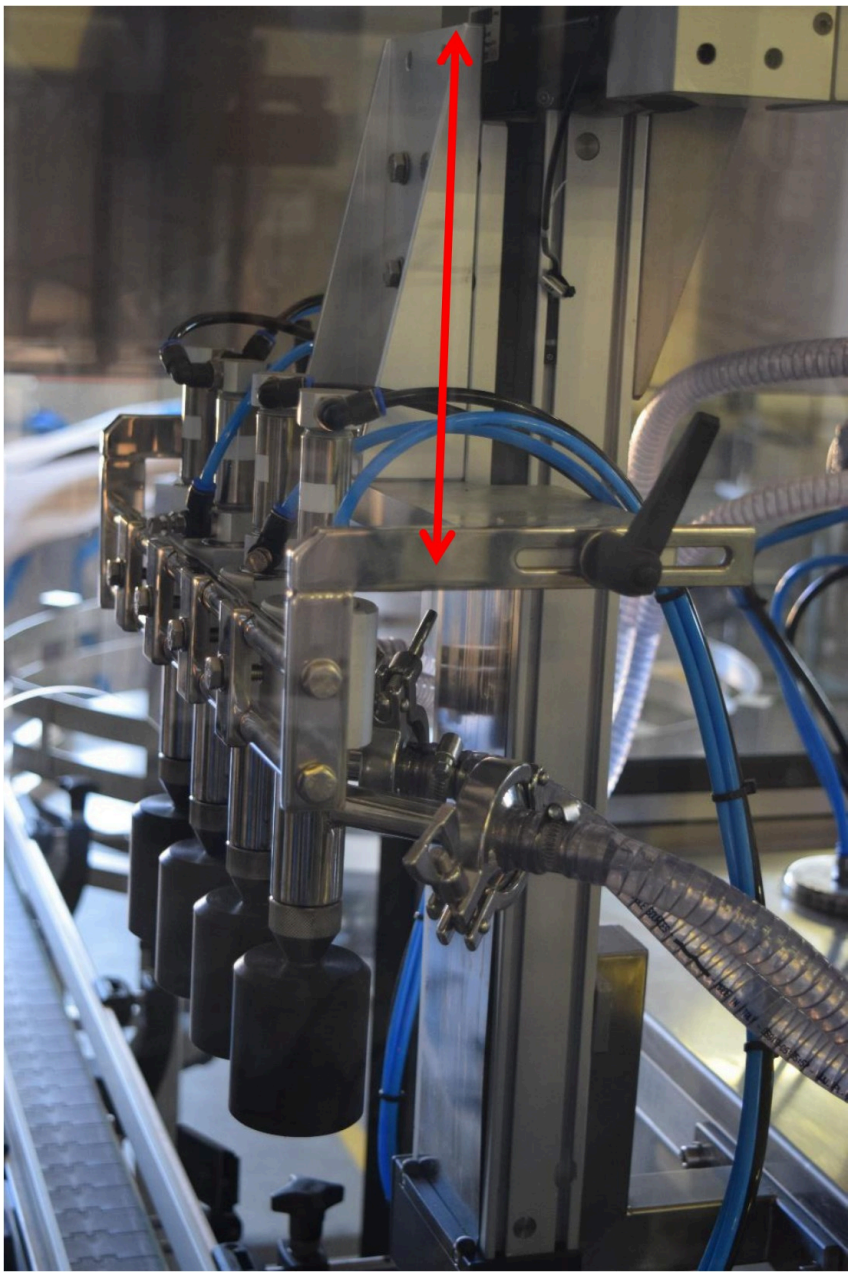
- In the case of formats with different heights the format change operation involves the height adjustment of the screw/trigger capper

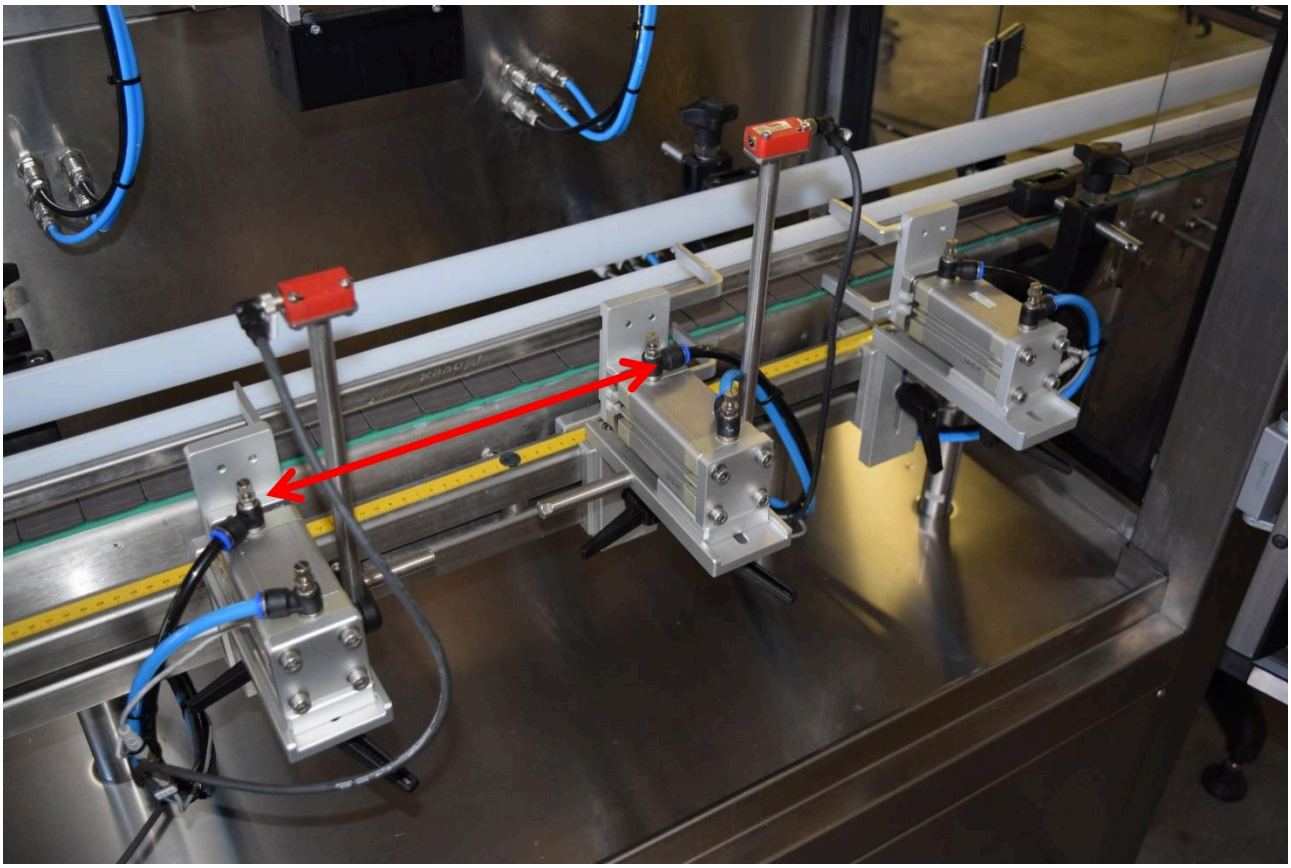
  N.B.: In the case in which one of your cappers is not used it is advisable to bring it to the upper end of stroke so as to leave as much space as possible for the translation of the bottles in the star wheel.



DOSER : Wanting to use bottle formats of different diameter and height it is necessary to modulate the distance between the stoppers so as to make 4 bottles of the desired size fit, adjust the dosing height through the touch-screen panel and the quantity of dose to be dispensed.

N.B. The third stop gate is to be used ONLY when the diameter of the container is smaller than the minimum distance that can be kept between the nozzles.





BEFORE CARRYING OUT ANY MANUAL OPERATION, IT IS NECESSARY TO VERIFY THAT THE MACHINE IS SWITCHED OFF WITH THE MAIN SWITCH IN THE “OFF” POSITION.

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- - Email info@sevenfluss.com website www.sevenfluss.com

PERIODIC CHECKS AND LUBRICATION

PERIODIC CHECKS AND MAINTENANCE



ATTENTION:

All the control and lubrication operations must be carried out with the machine switched off and disconnected from the electrical and pneumatic plant.

➢ *DAILY OPERATIONS*

The operations described below must be carried out by the operator every day or at most after 15/20 hours of work of the machine:

- ➢ Clean the screwing heads with compressed air to remove any residue left.
- ➢ Check and if necessary clean the cap chute and the feeder
- ➢ Check that all the movements and the parts of the machine operate correctly.

➢ *WEEKLY OPERATIONS*

The operations described below must be carried out by the operator every week or at most after 80 hours of work.

- ➢ Grease all the mechanical mechanisms present below the machine.
- ➢ Check the oil level of the gearbox and if necessary top up.

INTERNAL CLEANING OF THE ELECTRICAL CABINET

Authorised personnel : ELECTRICAL MAINTENANCE TECHNICIAN

a) Switch off the machine by moving the main switch located on the electrical cabinet to the “O” position.

b) Open the door of the electrical cabinet using the special key supplied.

c) Clean the interior of the electrical cabinet without using liquid components.

d) Check the connections to the terminals of the equipment.

e) Tighten any loose connections.

f) Close the door of the electrical cabinet with the special key and check its perfect closure.

g) Reconnect the line power supply to the electrical cabinet.

h) Restart the machine according to the switch-on procedure, taking care to check any anomalous situations that might occur due to involuntary errors or tampering carried out during the intervention performed.

CLEANING OF THE EXTERNAL PARTS AND WORKING PARTS OF THE MACHINE

Authorised personnel: no particular qualification, provided that they are authorised by the user of the machine.

Attention: the electrical switch must be locked with a padlock in the “O” position. The air valve must be locked in the “O” position.

All the external parts – excluding the gears – in steel must be cleaned with a damp cloth (it is advisable to use exclusively spray detergents suitable for stainless steel)

The polyethylene star wheel must be cleaned with a cloth soaked in a non-aggressive detergent, without solvents.