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MACCHINE PER PNEUMATICI E PER I PROCESSI DI RICOSTRUZIONE
EQUIPMENT FOR THE TYRE AND RETREADING INDUSTRIES

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OPERATION AND MAINTENANCE MANUAL

RAS 201 - Builder

PRECURED TREAD BUILDING AND STITCHING MACHINE FOR TRUCK TYRES

First printed on March 20, 2001 Revision: *05* / 17.06.2020

machine type	**RAS 201** *Precured tread building and stitching machine* *for truck tyres*
year of manufacture	2022
serial no.	MAT-21191
manufacturer	MATTEUZZI SRL Via Serra, 1/E – 3 40012 CALDERARA DI RENO BOLOGNA - Italy
importer	

Questo manuale è parte integrante della macchina e deve essere disponibile durante l'uso della macchina stessa e per la cessione ad eventuali altri utilizzatori.

This manual is an integral part of the machine. It must be kept close to hand when using the machine and must be available for transfer to other users if necessary.

Cette brochure fait partie intégrante de la machine; elle doit être disponible pendant le fonctionnement de la machine et accompagner la machine en cas de cession à d'autres utilisateurs.

Diese Betriebsanleitung ist ein ergänzender Bestandteil der Maschine. Alle Bediener müssen während des Betriebs direkten Zugang zur Anleitung haben .

CONTENTS

1. INTRODUCTION

1.1. GENERAL SAFETY INSTRUCTIONS

1. This manual provides the user with the instructions needed to ensure safe and correct use of the machine and to perform running maintenance operations on it. All personnel involved in the transportation, installation, commissioning, operation, maintenance and repair of the machine and its accessories must have read and properly understood:
   - the operating instructions,
   - the safety rules,
   - the warnings contained in the individual chapters and paragraphs.

2. It is forbidden for two or more persons to use the machine simultaneously, whether for operating or to carry out maintenance. The operator must be properly trained to use the machine, to evaluate the characteristics and condition of the casing to be processed and to perform, when necessary, the adjustments and settings as dictated by the type of job to be done. Persons under the influence of drugs, alcohol or medicines that impair the speed of their reflex reactions must not be allowed to engage in the installation, operation, retooling and maintenance of the machine.

3. Failure to observe the warnings contained in this manual might cause personal injury and even death. The manual must be accompanied by the company's specific rules, including supervisory and reporting duties, regarding work organization, work cycles, personnel appointed to the various tasks and other matters.

4. The user must check that the personnel perform their tasks with full knowledge and awareness of the safety rules and hazards, and that they follow the instructions contained in this manual. The user must also make sure that the machine is always in perfect working order.

5. The machine may only be used in perfect working order and it must be used by a single trained operative, in compliance with the prevailing safety and accident-prevention regulations. This provision includes observance of the operating and maintenance instructions contained in this manual.

6. Warnings and danger signs in the form of plates, stickers and marks fitted to the machine must be scrupulously observed. These plates, stickers and marks must not be removed and must be legible at all times.

7. Do not cover the cooling grilles on the electrical cabinet.

8. It is forbidden to disconnect or modify the safety devices.

9. Cut off the electrical and pneumatic power supply connections and discharge any remaining air before carrying out any cleaning, retooling or maintenance operations.

10. Power up the machine to the voltage specified on the plate and set up an appropriate connection board in accordance with prevailing standards.

11. Cut off the electrical and pneumatic connections and call up the customer service when:
- The electrical and electronic parts of the machine have been exposed to rain or water.
- The machine does not function properly, even though the instructions are followed.
- The machine has been damaged during transportation or handling.
- The machine exhibits a marked deterioration with respect to its normal level of performance.

	**WORK SAFETY WARNING SIGN. In the following instructions this symbol appears next to warnings describing situations which, when the machine is in operation, pose a serious risk of injury. You must always observe these warnings and work with particular care and attention. Same warnings must be notified to all the persons assigned to do work on the machine.** **In addition to the specific warnings, you must also take account of the general safety rules.**

1.2. LIMITED LIABILITY

The information, data and instructions contained in this manual are current at the time of printing and are based on our most up-to-date technical knowledge.

We shall make good any defects and omissions under the warranty obligations undertaken at the time of the order, but shall not satisfy any further claim. Demands for compensation, on whatever legal grounds they are made, shall not be considered.

The translations from the Italian are made with due care and diligence, but with the usual provisos. The only text forming the basis for interpretation is the original version in Italian which can be obtained on demand.

The manufacturer disclaims all liability for malfunctions or inefficiencies caused by:

improper use, negligence, non-maintenance or incorrect maintenance, incorrect manoeuvres, incorrect electrical or pneumatic power supply, omission of required adjustments, tampering or modifications not authorized in writing to mechanical, pneumatic, electrical, electronic parts or software programs.

Furthermore, the manufacturer accepts no responsibility in the event that wire or electrode welding jobs are carried out on any part of the machine or even on other machines connected to the same mains power supply, unless the manufacturer has been contacted in advance and the appropriate precautions agreed and implemented.

1.3. DEFINITIONS

User. Denotes the party (business/firm) which uses and employs the machine and assigns suitably trained personnel to operate it.

Operator. Denotes the person instructed by the user to perform specific operations connected with the use of the machine, including the necessary cleaning, checks and visual inspections.

Trained personnel. This term denotes an individual who has received instruction and training both on the tasks assigned to him/her and on any dangers occasioned by improper use. The said individual is also well informed and has demonstrated his or her knowledge regarding the necessary safety devices, protective measures, relevant regulations, health and safety rules and work conditions.

Mechanical maintenance technician. This term denotes an individual who is in charge of mechanical adjustments, maintenance and repairing.

Electrical maintenance technician. This term denotes an individual who is in charge of electrical adjustments, maintenance and repairing.

Dangerous area. Any area inside or close to the machine, where the presence of a person implies a risk to the health and safety of that person.

Exposed person. Any person totally or partially inside a dangerous area.

Danger. Any cause of possible health and safety damage.

Risk. The product between the probability that an event could happen and the seriousness of injures or damages to health and safety it can cause.

Protections. Safety measures that protect operators from dangers that cannot be eliminated or mitigated through design only.

Shelter. A protection that consists of a physical barrier.

Tyre casings and tyres may generically be described as *tyres* in the descriptions provided in this manual, when no more specific mention is required.

1.4. WARRANTY

This manual contains all the information, rules and standards to be observed. Therefore, it must be read carefully before starting up the machine.

MATTEUZZI SRL may not be held liable for any damage or operating abnormalities resulting from failure to observe the service instructions.

The machine's wear parts are not covered by the warranty. Any claims under warranty must be reported immediately, as soon as the defect is identified, and the machine's serial number must also be specified.

The warranty lapses in the following cases:

- improper use,
- use of work equipment that is not allowed,
- installation and connection of electrical cables performed incorrectly and not in conformity with prevailing regulations,
- use of non-original spare parts or accessories.
- modifications made without the permission of MATTEUZZI SRL and, in particular, modifications which include electrode or wire welding.

1.5. PERSONNEL SELECTION AND REQUIREMENTS

With respect to the operation or maintenance of the machine to be performed independently, the user may only assign operators who:

- are over 18 years of age;
- have suitable physical and mental abilities;
- have been trained in the use or maintenance of the machine and have then demonstrated their competence. The training must include teaching of the necessary theoretical concepts regarding the machine and the characteristics of tyre casings, and it must also provide sufficient opportunity for the trainees to carry out practical trials and acquire the ability to identify abnormalities that might threaten work safety;
- can be relied upon to perform competently the operations assigned to them.

The user must clearly define the tasks and duties of the personnel with regard to operation, maintenance and repairs.

2. PRELIMINARY MACHINE INFORMATION

2.1. GENERAL DESCRIPTION

The machine is designed to build and stitch the precured tread and cushion gum on buffed or buffed and cemented casings of bus, truck and light transport vehicle tyres.

These operations may only be performed on tyre casings that have already been inspected, cleaned to remove foreign objects, repaired and buffed.

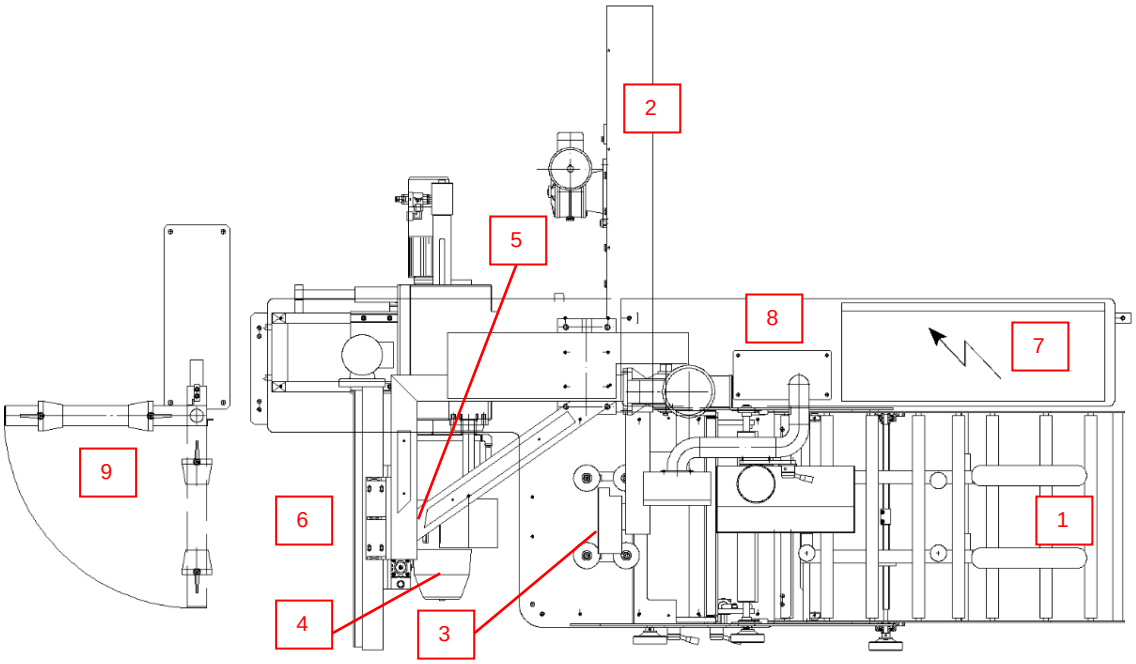


Figure 1: general description

1. Tread lift
2. Precured tread cutter
3. Tread positioner
4. Expandable hub
5. Tread presser
6. Building and stitching zone
7. Electrical cabinet
8. Control panel
9. Poly support

2.2. USE

The machine is designed to build and stitch the precured tread and cushion gum on buffed or buffed and cemented casings of bus, truck and light transport vehicle tyres.

These operations may only be performed on tyre casings that have already been inspected, cleaned to remove foreign objects, repaired and buffed.

2.2.1. PROHIBITED USE

It is forbidden to use the machine for any purpose other than the ones described at par.2.2.

It is also forbidden to use the machine to process:

- tyre casings filled with dirt, earth or other substances,
- tyre casings containing water,
- tyre casings showing marked mechanical damage (cuts, raised belts, deformed beads, etc.),
- solid (non-inflatable) tyre casings,
- tyre casings exceeding the permitted weight,
- unbuffed tyre casings that could cause intermittent impact and vibrations dangerous for the operator and for machine mechanisms.

2.2.2. TYRE CASING AND TREAD SIZES

The standard machine is designed to process tyre casings of the following sizes:

	MINIMUM	*MAXIMUM*
External diameter	711 mm (28”)	1193 mm (47”)
Bead diameter	14”	24.5”
weight	---	110 kg (243 lbs)

The standard machine is designed to process tread rolls or pre-cut tread strips of the following sizes:

	MINIMUM	*MAXIMUM*
Tread width	140 mm (5 1/2”)	395 mm (15.5”) (*)
Tread thickness	---	32 mm (1 1/4”)
Tread length	---	11 m (433”)

(*) for treads having thickness up to 20 mm, the machine can process strips having maximum width = 416 mm. Different machine capacity limits can be considered when requested by the user at the time of the purchase order.

2.2.3. INSTRUCTIONS ON THE TYRE

Any instructions stamped on the sidewall of the casing by the tyre manufacturer must be followed.

2.2.4. TYRE INFLATION PRESSURE

MAXIMUM PRESSURE: 2 bar (30 PSI)

2.3. IDENTIFICATION PLATE

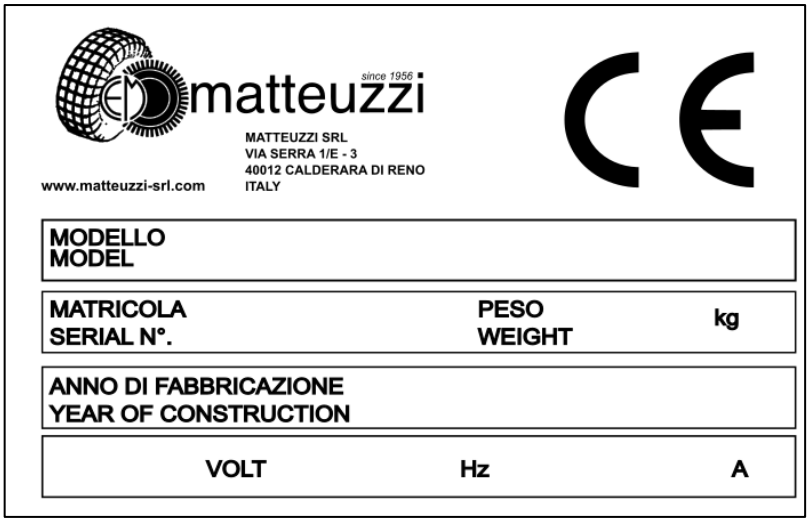


Figure 2: CE identification plate

The identification plate is fitted on the machine frame.

The following data are reported on the identification plate:

- CE marking (when applicable)
- Manufacturer name and address
- Machine model
- Serial number
- Weight
- Year of manufacture
- Electrical data

When contacting the machine manufacturer, in order to request information or ordering spare parts, the following data must always be specified:

- Machine model
- Serial number
- Year of manufacture

2.4. RESIDUAL RISKS

	**Warning and danger notices in the form of plates, adhesives and marks applied to the machine must be strictly observed. They must not be removed and must be legible and easy to read at all times.**

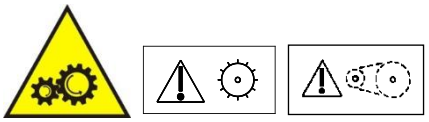
2.4.1. MACHINE HANDLING

Risks:	
During machine handling, the operator may crush his hands, feet or other body parts.	

Personal protective equipment:	
Gloves	
Protective footwear	
Hard hat	
Work apparel	

Safety procedures:	
Use handling devices with adequate lifting capacity.	--
Operate on flat surfaces.	--
Always check the proper fastening of the parts to be lifted.	--
Strictly follow the instructions reported in the Operation and Maintenance Manual.	--

2.4.2. MACHINE IN OPERATION

Risks:	
Cutting risk due to the rotary cutter.	
MECHANICAL PARTS IN MOVEMENT These plates are present on the protections covering dangerous moving parts (gears, belts, tools, etc.) The protections can be removed for maintenance reasons by trained personnel only after cutting off the electrical power and compressed air supplies.	
MIND YOUR HANDS! The operator must pay attention to machine parts that may pose a risk of crushing, such as: o roller guides, o sectors of expanding hub, o building and stitching groups.	
Electrocution due to contact with electrical parts.	
Entanglement due to parts in movement.	

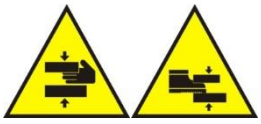
	**Crushing, cutting and entanglement risks are present also when the machine is not performing a cycle, due to compressed air in the pneumatic circuit.**

Personal protective equipment:	
Work apparel without loose or frayed elements that may be caught in rotating or moving parts	
The operator must wear gloves to protect his hands from mechanical injury when handling the casing, since it might have exposed steel belts or there may be nails or other sharp objects embedded in it that were not removed during inspection.	

Personal protective equipment:	
The operator must wear protective footwear.	
In particular conditions it may be necessary to wear other personal protective equipment suitable for the operation performed.	--

Safety procedures:	
Keep the area surrounding the machine clean, free from obstacles and objects that may make it slippery.	--
Make sure that only authorized personnel is in the working area.	
Do not remove safety devices.	
Strictly follow the instructions reported in the Operation and Maintenance Manual.	--
Do not wear loose long hair.	--
Do not wear jewellery.	--
Do not weld (It is forbidden to carry out electrode or wire welding on any part of the machine, on other machines in the vicinity or on machines connected to the same mains power supply. Permanent damage may be done to the computer and equipment connected to it and your warranty voided. If necessary, contact Matteuzzi srl to establish the required precautions.).	
Do not use water to extinguish fire.	

2.4.3. MACHINE MAINTENANCE

Risks:	
Hands and feet crushing due to sudden falling of machine parts or tools during retooling.	
Electrocution due to contact with electrical parts.	
Cutting during blade retooling.	

Personal protective equipment:	
The operator must wear gloves.	
The operator must wear protective footwear.	
Personal protective equipment that may be necessary for the specific maintenance operations.	--

Safety procedures:	
Maintenance operations can be performed only by qualified personnel.	
To perform maintenance operations, follow this general procedure: cut off all machine power supplies, perform the necessary maintenance, reconnect the machine to the power supplies, check the safety conditions of the machine.	
Strictly follow only the maintenance interventions reported in the Operation and Maintenance Manual.	--
Do not grease parts in motion.	

Safety procedures:	
Do not weld (It is forbidden to carry out electrode or wire welding on any part of the machine, on other machines in the vicinity or on machines connected to the same mains power supply. Permanent damage may be done to the computer and equipment connected to it and your warranty voided. If necessary, contact Matteuzzi srl to establish the required precautions.).	
Do not use water to extinguish fire.	

WARNING!

High voltage is available inside the electrical box even after supply cut off. Wait at least 5 minutes before opening the electrical cabinet or touching any other electrical device.

2.4.4. NOTICES ON THE MACHINE

Warning and danger notices in the form of plates, adhesives and marks applied to the machine must be strictly observed. They must not be removed and must be legible and easy to read at all times.

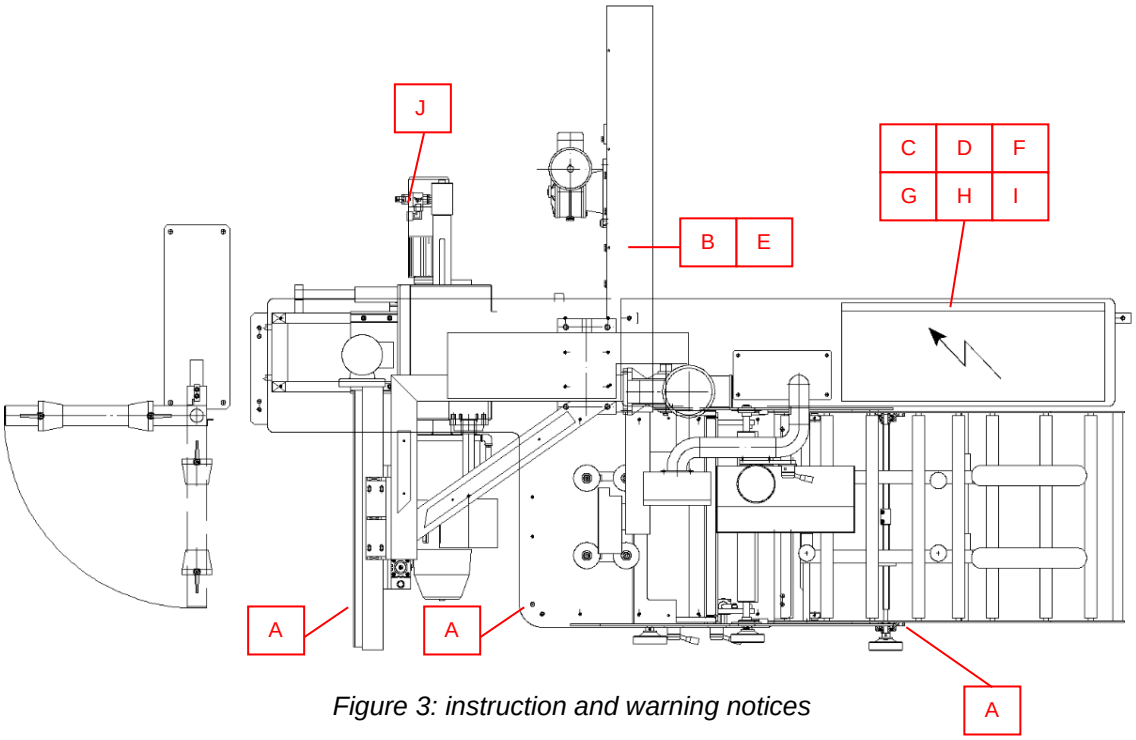
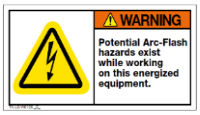
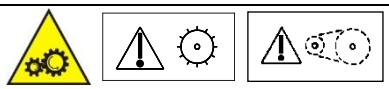


Figure 3: instruction and warning notices

REF.	NOTICES ON THE MACHINE	INSTRUCTIONS FOR OPERATOR
A		HAND CRUSHING RISK
B		CUTTING RISK DUE TO THE ROTARY CUTTER.
C		DANGER RISK OF ELECTRIC SHOCK Orange wires inside the panel remain energized when the main switch is in the off position. To service these circuits, shut off the equipment at the main service disconnect.
D		WARNING Potential arc – flash hazards exist while working on this energized equipment.
E		MECHANICAL PARTS IN MOVEMENT
F		DANGER Hazardous voltage. Disconnect power before servicing or cleaning.
G		CAUTION Risk of electric shock. More than one disconnect switch may be required to de-energize the equipment before servicing.
H		WARNING Read and understand the operator's manual before using this machine. Failure to follow operating instructions could result in death or serious injuries.
I		HAZARDOUS VOLTAGE All doors must be closed before energizing the panel.
J		CAUTION! LOCKOUT AIR SUPPLY AND DISCHARGE RESIDUAL AIR BEFORE REMOVING THIS BRACKET.

2.5. TECHNICAL DATA

2.5.1. WEIGHT AND DIMENSIONS OF THE MACHINE IN SERVICE

DIMENSIONS OF THE MACHINE IN SERVICE	3228 x 1960 x 2000 (h) mm 127” x 77” x 47” (h)
WEIGHT	960 kg 2116 lbs
MACHINE BASE	1,5 m^2 1.79 sq. yd

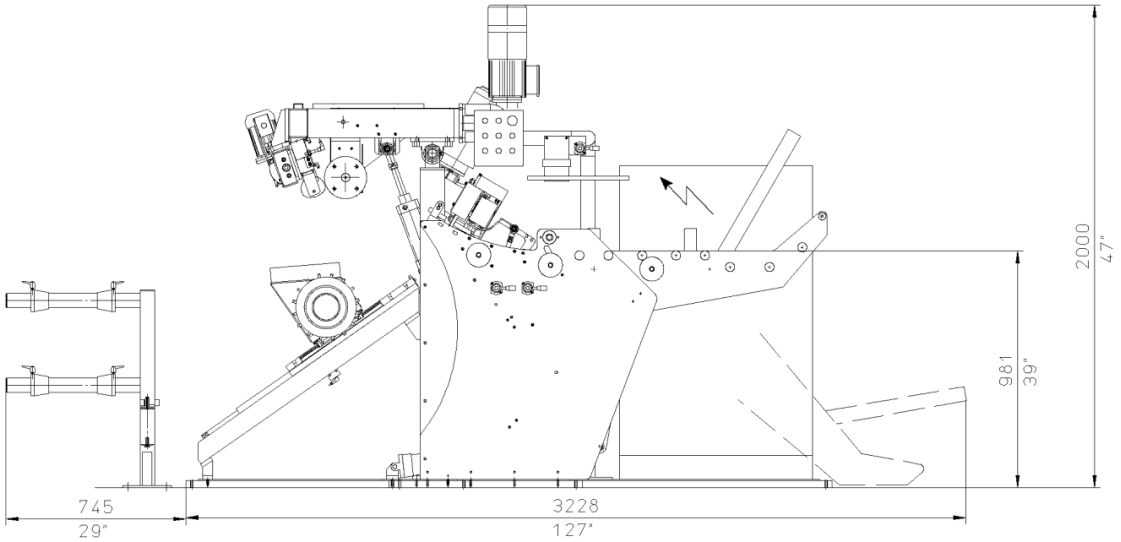


Figure 4: dimensions of the machine in service

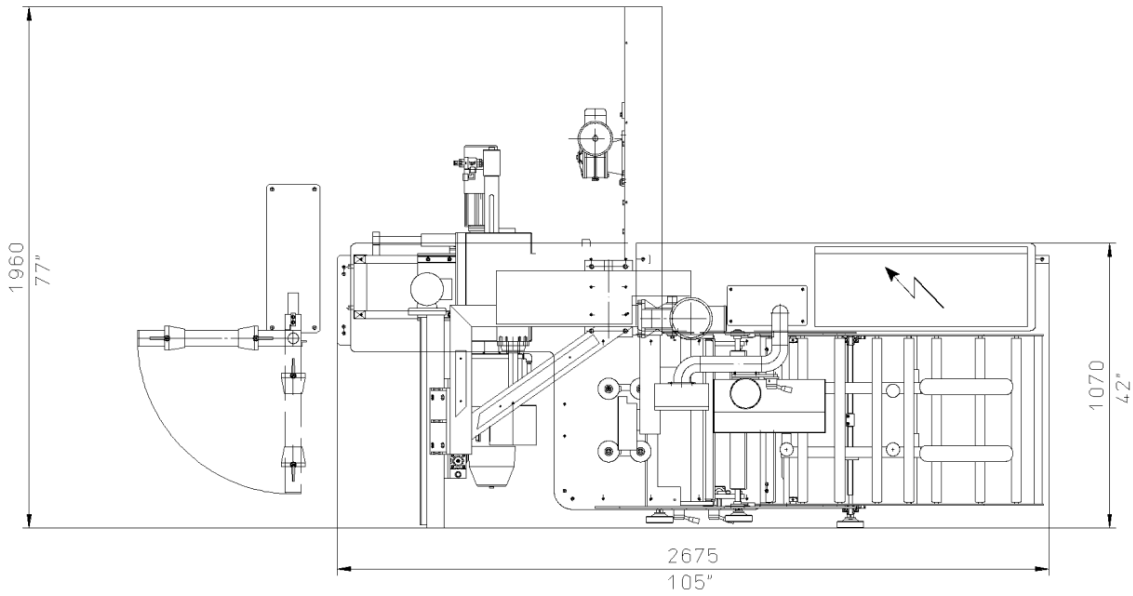


Figure 5: dimensions of the machine in service

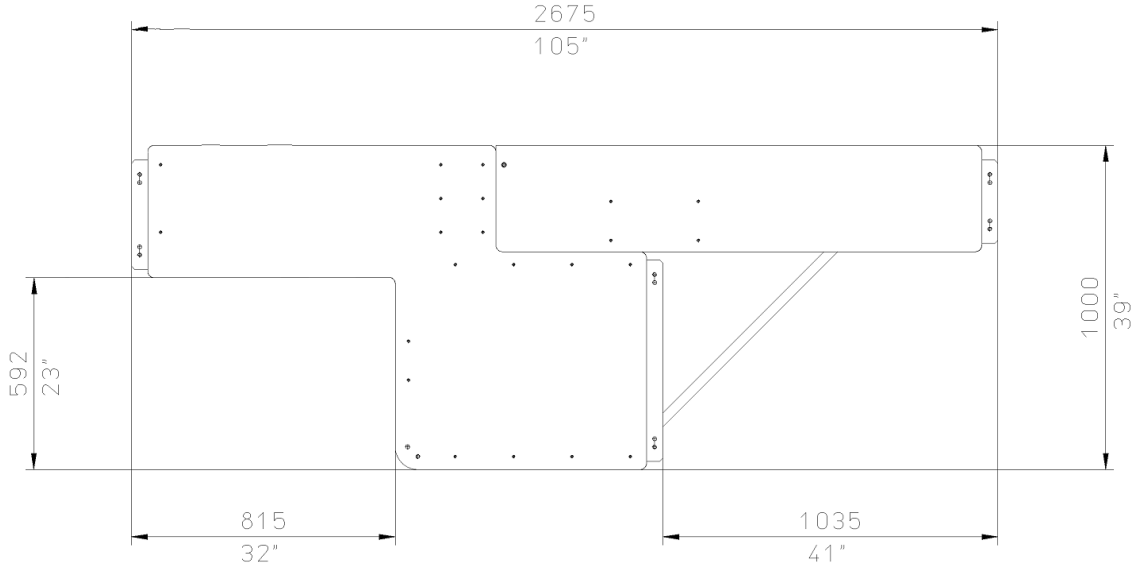


Figure 6: machine base

2.5.2. ELECTRICAL POWER SUPPLY

Total installed power	5,2 kW
Rated output	6,5 Ampere
Voltage	**The machine is designed for connection to the following type of power supply:** **480 Volt, 3-phases, 60 Hz**
The power supply line must be stable and foolproof. The configuration of the system upstream of the machine must contain protection devices suitable to the data reported above.	

The voltage, frequency, system and rated current of the machine are also indicated on the notice applied to the door of the electrical cabinet.

	**ONLY A QUALIFIED ELECTRICAL MAINTENANCE ENGINEER MAY ACCESS THE ELECTRICAL CABINET AND LIVE CIRCUIT.** **CONNECTION TO THE ELECTRICAL MAINS MUST BE MADE BY A QUALIFIED ELECTRICAL MAINTENANCE TECHNICIAN IN ACCORDANCE WITH CURRENT ACCIDENT-PREVENTION REGULATIONS.**

2.5.3. COMPRESSED AIR SUPPLY

Compressed air supply	8 bar (120 psi)
Compressed air absorption	600 Nl/cycle (21 cu ft/cycle)

Compressed air is supplied to the machine's circuit through a lockable inlet valve connected to a filter-reducer unit. The inlet valve provides a quick coupling.

To cut off compressed air supply to the machine, during operations requiring this precaution, the maintenance technician shall close and lock the actuator of the lockable inlet valve. The locking key must be kept by the maintenance technician in a safe place.

2.6. AMBIENT AND OPERATING CONDITIONS

2.6.1. OPERATING ENVIRONMENT

	MIN	MAX
Temperature	5° C	40° C
Relative humidity	30%	90%

Lighting	>300 lux required in the operator area. The machine operates in a closed industrial environment in the presence of people at work and the lighting provided in the workplace under prevailing local regulations is deemed sufficient.

2.6.2. AERIAL NOISE EMISSION

The following parameters were measured at the operator workstation during a working cycle of a new and properly serviced machine:

- LA(eq) [dB], equivalent continuous A-weighted sound pressure level.

Measurements were made according to method UNI EN ISO 3746:2011 – determination of occupational noise exposure.

MEASUREMENT RESULTS

LA(eq) = 78,5 dB (A) (average value).

2.7. OPERATING TOOLS

2.7.1. TREAD CUTTER BLADE

Installed on the tread cutter there is a circular blade with the following characteristics:

OPTION A: 6” BLADE

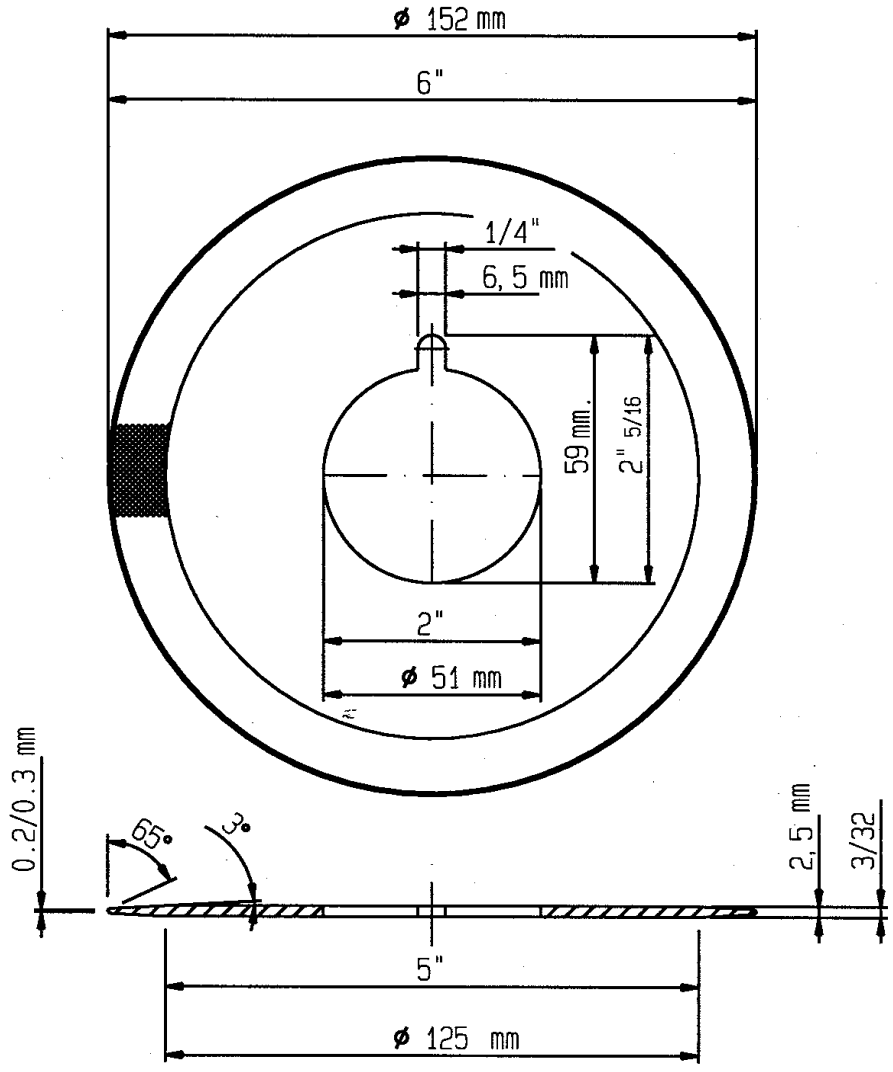


Figure 7: circular blade

OPTION B: 7” BLADE

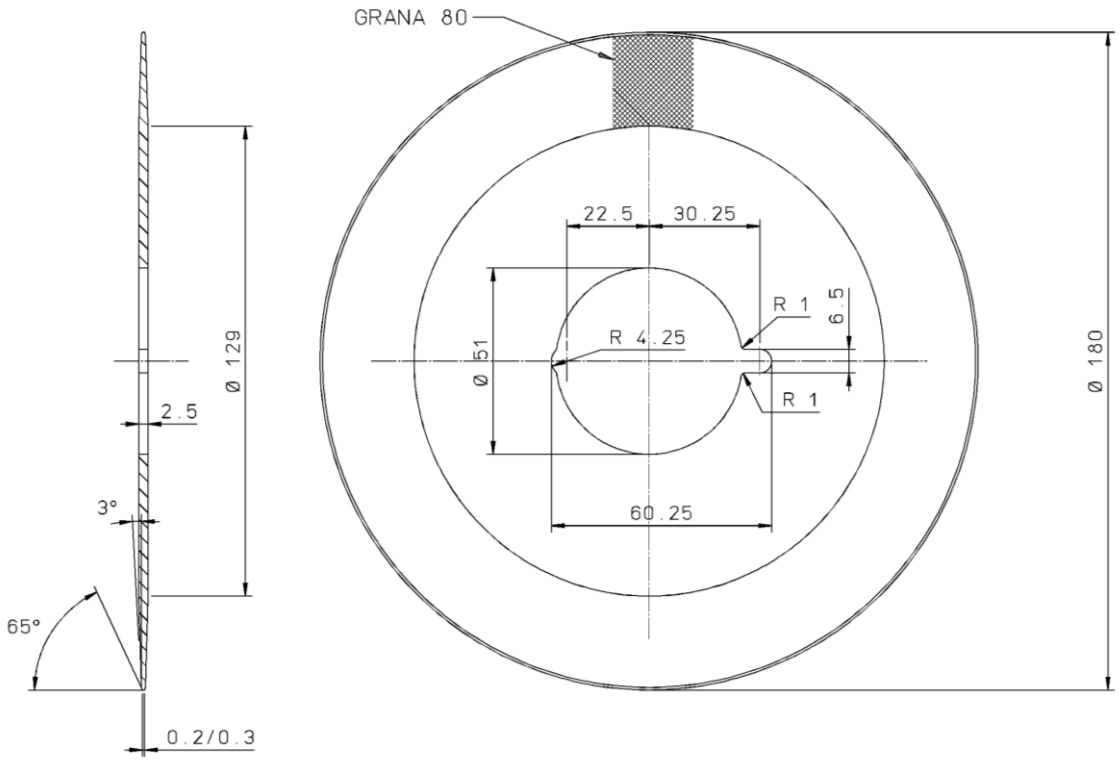


Figure 8: circular blade

Use a tool with the same characteristics when replacing the blade.

The type and characteristics of the precured tread being used may consume the circular blade more or less rapidly. Bear in mind that worn blades diminish the quality of the cut.

It is forbidden to fit any other type of tool in place of the circular blade.

The *Retooling* chapter contains instructions on how to replace the circular blade.

3. MACHINE HANDLING, POSITIONING AND INSTALLATION

3.1. PACKED MACHINE HANDLING

The machine and accessories are packed and secured to the pallets with bolts and nails in order to obtain a single rigid body, that is covered by a protective film.

Inspect each package upon receipt, and carefully make sure it has not been damaged or tampered.

ANY DAMAGE NOTICED ON THE MACHINE UPON RECEIPT MUST BE COMMUNICATED TO THE MACHINE MANUFACTURER.

The below reported operations may only be performed by trained personnel and with the use of a forklift truck with sufficient lifting capacity and fork length commensurate with the weight and dimensions of the package. Any other equipment must be considered unsuitable and dangerous.

Standard machine packing:

NET WEIGHT			
Pallet or crate	1 / 1	Machine and accessories	960 kg (2116 lbs)

Detailed information regarding actual packing are reported at shipment time in the specific packing list.

Use a forklift truck to load/unload the packed machine and accessories, and to transport them to the installation site.

- **The user has to choose an adequate installation site taking into consideration the space needed for tyre feeding and discharging.**
- **If necessary, the user has to install further safety devices, other than the ones supplied with the machine.**
- **The machine is designed to be used by a single operator. No other person must be able to gain access to the moving parts, which must be isolated and protected from the rest of the workplace by the user.**

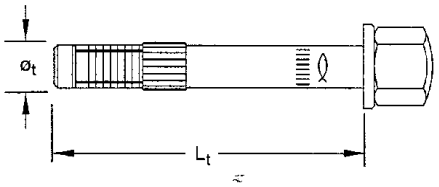
Pallet or crate	1 / 1	Machine and accessories

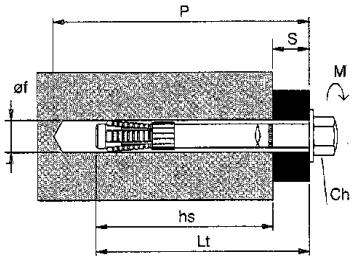
Figure 9: packed machine handling

3.2. MACHINE POSITIONING

1. Check that the floor is level and able to bear the weight of the machine.
2. Lift the machine 100 mm (4”) off the floor so as to remove the pallet after the fastening devices have been removed. For this purpose use ropes hooked to the parts of the machine with facility for their connection.
3. The pallet to which the machine is secured is protected by a waterproof polyethylene sheet which, if thrown away, must be disposed of properly and in accordance with local anti-pollution regulations.
4. Place in a position convenient to the operator the stand provided to support the rolls of cushion gum and protective polyethylene film. Fix it to the floor means of the relevant screws.
5. Secure the machine units to the floor using the holes provided in the base.

We suggest to use steel anchors suitable for fixing into solid materials. The following data refer to fixings in concrete:





anchor ext. dia. - ∅t	12 mm
anchor length - L_t	100/135 mm
anchor placing depth - hs	≥ 70 mm
drilling nominal dia. - ∅f	12 mm
drill hole depth - P	100/135 mm

4. CONNECTION TO POWER SUPPLIES

4.1. WARNINGS

Installation of the machine must be carried out by skilled personnel. The said personnel may only proceed with the installation after having studied the contents of the specification charts, figures and the information contained in the *introduction* and in this chapter of the manual.

The machine leaves the factory after undergoing repeated testing and inspection and it will be ready for use when the installation operations described below have been correctly carried out. If any further information is required, please contact the supplier, giving extensive details on the stage of machine installation and any abnormalities encountered.

The machine installation site will be determined by the customer according to the means by which the tyres and tread strips are fed to the machine, the means by which the tyres are removed and according to workplace, production and safety-related requirements.

The installation area must be protected so that only personnel authorized by the user can gain access to it.

4.2. COMPRESSED AIR

⚠	**The operations described below must be carried out by trained personnel.**

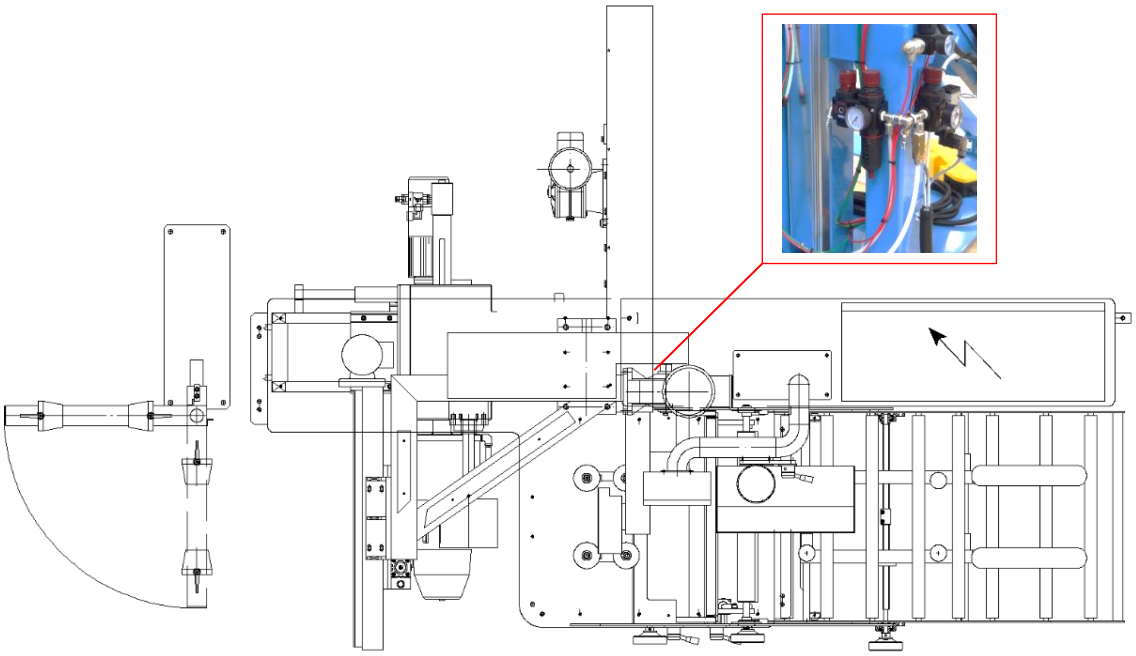


Figure 10: connection to power supplies

Supply the fitting of the lockable inlet valve connected to the filter-reducer unit with compressed air at approx. 8 bar (120 PSI). The pressure reducer is factory set to 8 bar (120 PSI) and this value must not be exceeded. The feed pressure to the machine circuit is shown on the LINE pressure gauge installed on the filter-reducer unit.

4.3. ELECTRICAL POWER

⚠	**The operations described below must be carried out by trained personnel.**

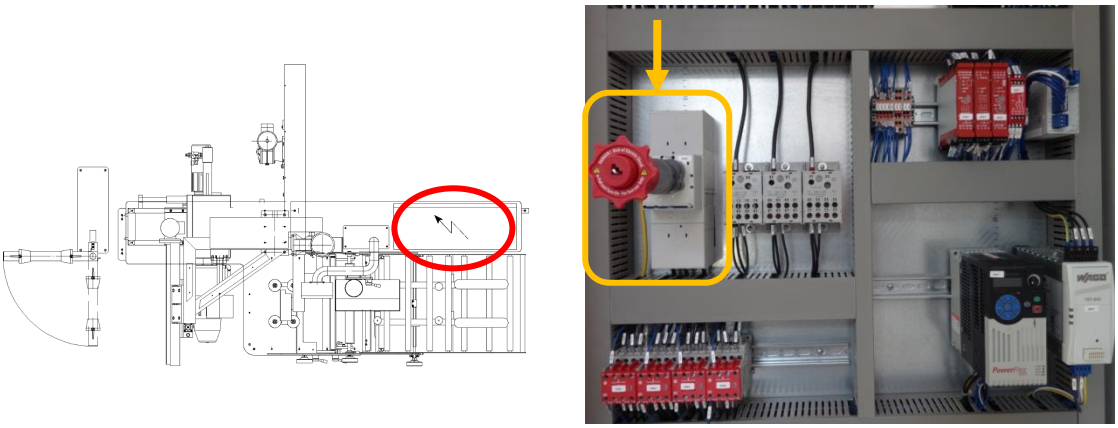


Figure 11: connection to power supplies

The electrical maintenance engineer responsible for making the electrical connection must first check that the voltage indicated on the plate applied to the machine matches the mains supply voltage.

In order to connect the machine to the electrical power supply, proceed as follows.

1. Make sure the machine is correctly connected to compressed air and its pneumatic circuit has been powered up.
2. Open the doors to the electrical cabinet and power up the terminal strip L1 – L2 – L3 + earth with a three-phase electrical current.
3. Close the doors of the electrical cabinet and set the MAINS SWITCH to I/ON. The LINE pilot lamp on the stitching unit control panel switches ON.
4. Before proceeding with any other operation, check that the connection has been made in phase as follows.
    a. Release, if necessary, the EMERGENCY STOP push-buttons on the control panels.
    b. Turn the RESET selector switch located on the main control panel
    c. Press the RESTART push-button located on the main control panel to access to the machine functions. The push-button is illuminated.

    IF THE SAW BEGINS TO MOVE, PRESS THE E-STOP AND RETURN TO STEP 4 (PHASE SEQUENCE).

d. Move the CARRIAGE BWD/FWD selector to BWD and check that the expandable hub carriage descends towards the machine base. If this is not the case, switch off the electrical power, reverse one phase (wire) in the connection and repeat the check.

5. When the connection has been correctly made press shortly the CUT push-buttons to position the blade to its rest position, away from the operator

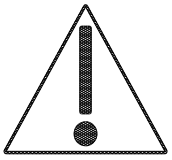
<u>Important notice for users supplying machine with 60 Hz voltage</u>.

The machine has been factory tested and set using electrical current at the same voltage as the user, but at 50 Hz. A number of settings may have to be changed when the units are powered at 60 Hz. Please take great care when performing the first few cycles and notify the manufacturer of any machine that does not conform to the information contained in this manual.

One of the units that may be most affected by the change in the electrical frequency is the stitching unit, and in particular the rotation speed of the tyre loaded on the expandable hub and rim assembly which will increase by approximately 20%.

5. MACHINE USE

5.1. WARNINGS



The machine is built with top quality materials and with electronic, electrical, mechanical and pneumatic devices to ensure safe use.

The tyres to be processed must have been previously inspected, dried, cleaned, repaired and buffed and any objects that might have become embedded in the sidewalls or the tread during use, posing a threat to operator safety, must have been removed.

The operator must be trained to evaluate the characteristics and condition of the tyres to be processed, to carry out the adjustments and preliminary operations required by the machine and the tyre, and to perform the various process operations.

5.2. SAFETY DEVICES AND FUNCTIONS

	**It is forbidden to use the emergency controls for operational reasons. Their activation is independent of the consequences they might have on the process being performed.**

5.2.1. EMERGENCY STOPS PUSH-BUTTONS

Located on the machine control panel and on the front side of the stitching group there are two block – EMERGENCY STOP – push-buttons that the operator or an engineer assigned to specific operations must activate immediately should he recognise an impending risk of personal injury or damage to the machine:

When one of these push button is pressed, all the machine devices are blocked and any tyre being processed is deflated.

After an emergency block, the operator can restart the machine only when an engineer has checked that the cause of the emergency has been eliminated.

In order to restart the machine, proceed as follows.

- Release the EMERGENCY STOP push-button that has been pressed.
- Press the RESTART push-button located on the control panel to gain access to the machine functions and controls.
- The next manoeuvres depend on the operator choice.
    a. If the cycle can be resumed from the point at which it was interrupted:
        i. press the INFLATION push button
        ii. press the APPLICATION – RUN push button.
    b. If the cycle must be definitively interrupted:
        i. set the STITCHING GROUP selector to UP to create the conditions needed to unload the tyre,
        ii. turn the RESET selector switch to set the machine in its start position.

5.3. ELECTRICAL CONTROLS

5.3.1. MAIN CONTROL PANEL

Figure 12: electrical cabinet door

electrical system diagram - ref.	control label	description
70P1 indicator lamp	LINE *LINEA*	On when the auxiliaries circuit is powered up. If the mains switch is set to ON and this lamp is off, an authorised electrical maintenance engineer must check the lamp and/or the electrical circuit for failures.
90S2 mushroom push-button	EMERGENCY STOP *PARADA EMERGENCIA*	The operator or a technician assigned to specific operations must activate immediately the EMERGENCY-STOP push-button should he recognise an impending risk of personal injury or damage to the machine.
110S1 two-function push-button	INFLATION INFLAMIENTO *DEFLATION* *DESINFLAMIENTO*	Starts inflation or deflation of the tyre loaded on the expandable hub.

electrical system diagram - ref.	**control label**	**description**
90S1 70P2 illuminated push-button	RESTART *RESTABLECIMIENTO*	Press this push-button after releasing any EMERGENCY STOP push-button. The push-button pilot lamp turns ON.
110S3 selector	RESET *INICIACION CICLOS*	Use the RESET selector to set the machine in its start position after an emergency stop.
111S5 3-position selector with return to centre	STITCHING GROUP *GRUPO ROLADO* DOWN UP *ABAJO ARRIBA*	Position the selector lever to UP to move the entire stitching group away from the tyre surface. When the lever is positioned to DOWN the group descends to work position.
111S1 two-function push-button	STITCHING *ROLADO* RUN DWELL *ARRANQUE PAUSA*	A single touch of the push button starts the stitching operation of the twin rollers on the tread already applied and stapled. Press and hold down so that the twin stitching rollers dwell on one part of the tread. The stitching cycle is completed when the button is released. This push-button is located both on the control panel and on the front side of the stitching group.
111S3 two-function push-button	STITCHING STOP *PARADA ROLADO*	A single touch interrupts the stitching rollers cycle. If pressed for more than 2 seconds, the push button interrupts the cycle and the stitching unit returns to the rest position.
111S7 3-position selector with return to centre	TREAD JOG *MOVIMIENTO BANDA* FWD BWD *ADELANTE ATRAS*	Precured tread application in manual mode. With the selector lever positioned to FWD, the tread feed is activated. When the lever is positioned to BWD the tread movement is reversed.

electrical system diagram - ref.	**control label**	**description**
112S2 130P1 three-function luminous push-button	APPLICATION *APLICACION* RUN STOP *ARRANQUE PARADA*	The first touch of the push button moves the tyre to work position until when it touches the endstroke microswitch. The second touch of the push button moves the stitching group to touch the tread strip positioned on the tyre. After a PLC controlled time the tyre starts rotating and the tread is applied. These operations are stopped automatically by the proximity switch that feels the tread edge. The third touch of the push button stops tyre rotation if needed during the cycle.
110S4 three-position selector	CARRIAGE *CARRO* BWD FWD *ATRAS ADELANTE*	With the selector lever positioned to BWD the tyre is removed away from application position and/or tread feeding bench. When the selector lever is positioned to FWD the tyre reaches the tread application position.
95S1 push-button 95S2 push-button	CUT *CORTE*	When pressed simultaneously (maximum delay 0.5 seconds) these push-buttons activate the cutting operation which is interrupted only when they are released. When the push-buttons are released, the cutter reverses its stroke to rest position.

5.3.2. STITCHING CONTROLS

Figure 13: stitching controls

electrical system diagram - ref.	control label	description
110S2 two-function push-button	INFLATION *INFLAMIENTO* DEFLATION *DESINFLAMIENTO*	Starts inflation or deflation of the tyre loaded on the expandable hub.
111S6 push-button	STITCHING CUSHION *ROLADO GOMA DE UNION*	The first touch of the push button starts the stitching operation of the twin rollers on the cushion gum. The second touch of the push button starts a PLC controlled automatic sequence of stitching strokes and stitching dwells of the twin rollers.
90S3 mushroom push-button	EMERGENCY STOP *PARADA EMERGENCIA*	The operator or a technician assigned to specific operations must activate immediately the EMERGENCY-STOP push-button should he recognise an impending risk of personal injury or damage to the machine.
111S2 two-function push-button	STITCHING TIRE *ROLADO*	A single touch of the push button starts the stitching operation of the twin rollers on the tread already applied and stapled. Press and hold down so that the twin stitching rollers dwell on one part of the tread. The stitching cycle is completed when the button is released. This push-button is located both on the control panel and on the front side of the stitching group.
111S4 push button	STITCHING STOP *PARADA ROLADO*	A single touch interrupts the stitching rollers cycle. If pressed for more than 2 seconds, the push button interrupts the cycle and the stitching unit returns to the rest position.

5.3.3. ELECTRICAL CABINET

electrical system diagram - ref.	**control label**	**description**
10Q1 Mains switch	MAINS SWITCH	MAINS SWITCH. When set to O/OFF also acts as a lockable block to cut off the power supply

5.3.4. PEDAL CONTROLS

electrical system diagram - ref.	**control label**	**description**
112S2 foot pedal	ROTATION *ROTACION*	Press and keep depressed this pedal control to activate clockwise tyre rotation to facilitate manual operations such as the cushion gum application. Release the pedal to stop tyre rotation.

More information about the electrical system and control lay-out are contained in the *ANNEX 2* to this manual - see *ELECTRICAL SYSTEM DIAGRAM.*

5.4. PNEUMATIC CONTROLS

pn. control	control label	description
three position lever with fixed central position	POLY PINCH ROLLER *PRESOR POLY* UP DOWN *ARRIBA* *ABAJO*	Separates/brings together the two rollers which remove the poly from the tread.
three position lever with fixed central position	TREAD LIFT *ELEVADOR BANDA* UP DOWN *ARRIBA* *ABAJO*	Lowering and raising of the mobile roller bench to facilitate tread roll loading.
three position lever with fixed central position	TREAD PRESSER *PRESOR BANDA* UP DOWN *ARRIBA* *ABAJO*	Lowering and raising of the tread presser to facilitate cutting operations.

More information about the pneumatic system are contained in the "*ANNEX 3"* to this manual - see *PNEUMATIC CIRCUIT DIAGRAM.*

5.5. COMPRESSED AIR CONTROL DEVICES

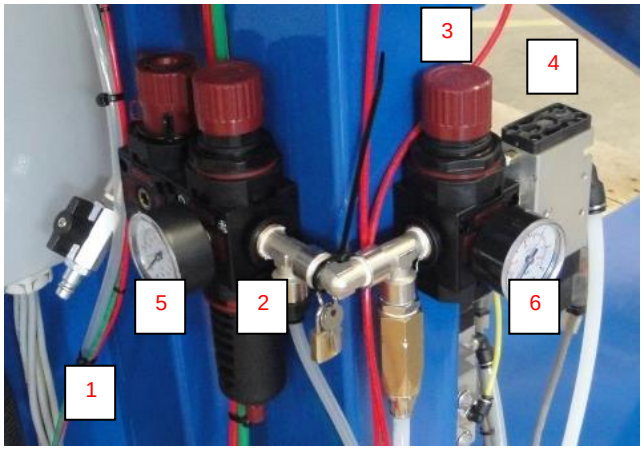


Figure 14: compressed air controls

Ref.	*Pneumatic diagram-ref.*	*Description*
1	-	Lockable inlet valve for compressed air feeding to the machine pneumatic circuit.
2	FRL1	Filter-regulator. The regulator is factory set to 8 bar and this value must not be modified.
3	R12	Pressure regulator set to 2 bar, that controls tyre inflation.
4	EV12	Solenoid valve controlling tyre inflation.
5	-	Pressure gauge that visualizes the compressed air line value.
6	G12	Pressure gauge that visualizes tyre inflation pressure.

	**THE CONTROL DEVICES LISTED ABOVE ARE CONNECTED IN SEQUENCE AND SET SO AS TO GUARANTEE THE INFLATION REQUIRED BY THE MACHINE OPERATION AND TO KEEP THE PRESSURE WITHIN THE SAFETY LIMITS.** **THESE SETTINGS MUST NOT BE CHANGED AND THE DEVICES MUST BE MAINTAINED IN PERFECT WORKING ORDER.** **DO NOT PUSH THE INFLATION push button to turn on inflation if the tyre is not loaded on the expandable hub.** **If the rubber rim on the hub is worn, it may not support inflation. As a result, it may tear and harm the operator or other persons in the vicinity.**

More information about the pneumatic system are contained in the "*ANNEX 3*" to this manual - see *PNEUMATIC CIRCUIT DIAGRAM.*

5.6. MECHANICAL ADJUSTMENTS

5.6.1. CHANGING THE RIM OF THE EXPANDING HUB

Before starting a stitching cycle, the operator has to check that the size of the expandable rubber rim on the hub is suitable for the size of the tyre to be processed.

	**Qualified personnel may work on the machine only after the electrical and pneumatic feeds have been disconnected.**

How to fit the rubber rim on the expandable hub

1. Fit the rim by sliding the seats of its sections on the hub wings. The rapid air coupling on the rim must be correctly positioned with respect to the length of the two compressed air feed tubes coming from the expandable hub. Push the rim carefully.
2. Turn the four rim fastening pins counter clockwise.
3. Connect the fittings of the two compressed air feed tubes coming from the expandable hub to the rim.

	**The frequency of expandable rim changing can be reduced by working in series.**

	**DO NOT press the INFLATION push-button to turn on inflation if there is no tyre on the hub. If the rubber rim on the hub is worn, it may not support inflation. As a result, it may tear and harm the operator or other people in the vicinity.**

5.7. OPERATOR WORK STATION

When tyre loading has been carried out, the operator must stand close to the control panel and perform the manual adjustments and operations required by the cycle.

	**The area surrounding the work stations must be kept clean and, in particular, it must be kept free of slippery substances, tools or objects that might impede safe operator movement.**

5.8. OPERATION

	**Before beginning a production cycle the operator must check that the size of the rim mounted on the expandable hub and the tread width/pattern are correct for the size of tyre to be machined.**

5.8.1. MACHINE EMPTY RESTART

At the start of every day or workshift, or when the electrical power supply is cut off for maintenance work, it is recommended to perform a MACHINE EMPTY RESTART to set up the machine control devices to operate correctly. In order to do so, proceed as follows.

1. Position the mains switch of the electrical cabinet to I/ON.
2. Activate the machine pneumatic circuit.
3. The rotary cutter is to its rest position.
4. The LINE lamp on the stitching unit control panel is switched ON.
5. Release the EMERGENCY STOP push-button on the control.
6. Turn the RESET selector switch located on the control panel.
7. Press the RESTART push-button located on the control panel to gain access to the machine functions.

When these operations have been completed the machine is ready for a cycle.

5.8.2. INFLATING AND DEFLATING THE TYRE

Load the tyre on the expandable hub rim and press the INFLATION / DEFLATION push-button.

When the INFLATION / DEFLATION push button is pressed, tyre casing inflation is activated and performed in **two successive stages**:

- During the first stage the solenoid valve YV1 activates the expansion of the rim for the short period of time controlled by the PLC.
- Next, the solenoid valve YV2 comes into operation, starts the tyre casing inflation up to 2 bar (30 PSI) and maintains this pressure during the process. The pressure regulator that controls the inflation is factory set to 2 bar (30 PSI) during machine testing and inspection.

Two spring-operated safety valves, installed on the joint of the expandable hub, release the compressed air if the pressure to which they have been set is exceeded during the above mentioned inflation stages.

Press again the INFLATION / DEFLATION push button to deflate the tyre casing.

	**Do not press the INFLATION push button to start inflation when the tyre is not loaded on the expandable hub. A rubber rim in poor condition might not withstand the inflation and may cause injury to the operator or other persons in the vicinity.**

5.8.3. APPLYING THE CUSHION GUM ON THE BUFFED TYRE

To facilitate this operation the machine provides:

- the foot pedal that rotates the tyre,
- the CUSHION GUM STITCHING push-button:

The first touch of the push button starts the stitching operation of the twin rollers on the cushion gum.

The second touch of the push button starts a PLC controlled automatic sequence of stitching strokes and stitching dwells of the twin rollers.

5.8.4. PRECURED TREAD ROLL LOADING AND FEEDING

1. Set the lever of the TREAD LIFT pneumatic control to DOWN to set the movable roller bench in the loading position.
2. Place the precured tread roll on the bench with the tread pattern uppermost and with the edge in the direction of the machine stitching group.

	**Remove any dangling piece of protective poly and/or precured tread that might threaten operator safety and the mechanical components during loading.**

3. Set the TREAD LIFT pneumatic control to UP. The movable roller bench rises and stops automatically at the height of the machine fixed roller bench.
4. Set the lever of the POLY PINCH ROLLER pneumatic control to UP to separate the two rollers. Separate the poly from the tread and fix the poly end on the lower roller.
5. Set the lever of the POLY PINCH ROLLER pneumatic control to DOWN to bring together the two rollers
6. Operate the handwheel that detaches the poly from the tread and causes the tread to advance until when its leading edge reaches the cutter lower guide which indicates where the cut will be made.
7. Use the handwheels provided to adjust the distance between the guiding pins that hold the tread in the centre.

5.8.5. TREAD APPLICATION AND STITCHING CYCLE

1. Press the APPLICATION push-button that starts flashing.
2. Press for the second time the APPLICATION push-button. The tyre loaded on the expandable hub moves towards the roller bench which carries the tread ready for application start. The tyre stroke is stopped by a microswitch.
3. Feed the tread until its leading edge is between 13-25 mm. (1/2" – 1") beyond the stitching group central roller.
4. Press for the third time the APPLICATION push-button to lower the stitching group on the tread edge applied to the tyre. After a few seconds, a PLC controlled delay, the tyre rotation starts and stops when the tread leading edge is detected by a proximity switch.
5. Set the lever of the TREAD PRESSER pneumatic control to DOWN in order to block the tread in the current position.
6. Press the two CUT push-buttons together so that the operator hands are well away from the pinch and cut points. The blade moves to cut the tread transversely. Hold down the two CUT push-buttons until the cut has been completed. The blade halts when the two CUT push-buttons are released. The blade returns to home position when the two CUT push-buttons are pressed once more.
7. Set the lever of the TREAD PRESSER pneumatic control to UP in order to unlock the tread strip. The tyre moves away from the roller bench.
8. Position the STITCHING GROUP selector to UP and rotate the tyre manually to bring the tread joint to a convenient position for the operator when he is standing in front of the stitching unit.
9. Position the STITCHING GROUP selector to DOWN to lower the stitching group on the tread.
10. Arrange the joint (splice) between the two ends of the tread and staple them together.
11. Control the stitching operation by means of the STITCHING - RUN/DWELL push-button.

    A **single touch of the push button** starts the tyre rotation and operates the twin stitching rollers: they start pressing on the tread and move from the centre towards the tyre shoulders where they stop due to the intervention of a proximity switch.

    Press and hold down the push button so that the twin stitching rollers insist on a certain area of the tread. Release the push button to allow the twin rollers to complete their stroke towards the tyre shoulders.
12. The stitching cycle can be interrupted moving the selector STITCHING GROUP to UP: the tyre stops rotating and the twin rollers return to their rest central position ready to start a new cycle.
13. Stitching operation can also be interrupted by the STITCHING STOP push-button that pressed one time interrupts the cycle and kept depressed for more than 2 seconds ends the cycle.

5.8.6. HOW TO LEAVE THE MACHINE AT THE END OF THE WORKSHIFT

1. Unload the tyre from the expandable hub and rim assembly.
2. Move the *tread lift* selector to “down”.
3. Set the main electrical cabinet mains switch to “off”.

6. MAINTENANCE

6.1. SAFETY RULES FOR MAINTENANCE AND REPAIRS

- Maintenance denotes all servicing, inspection and repair work.
- Mechanical and electrical repairs and adjustments may only be performed by qualified personnel. It is forbidden for unauthorized persons to perform any work on the machine.
- The required adjustments, maintenance work and inspections must be performed at the specified intervals and in compliance with the instructions regarding the replacement of components/subassemblies.
- You must not carry out any maintenance operations, apart from visual checks, until you have first cut off the electrical current and the compressed air supplies and discharged any residual air in the machine by operating the pneumatic controls under load less conditions.
- You must comply with environmental protection regulations with regard to the disposal of waste and parts replaced.
- To prevent personal injury during maintenance, adjustments or repairs, you must only use appropriate and correctly calibrated tools and instruments.

6.2. RULES REGARDING WORK ON ELECTRICAL COMPONENTS

- Work on the electronics and the electrical components may only be carried out by qualified electricians.
- Mark off the work area with a chain or red/white tape and appropriate danger signs.
- Use only original fuses with the required amperage. Defective fuses must not be repaired but replaced with fuses of the same kind.
- The electrical equipment and electrical system on board the machine must be inspected and checked at regular intervals. Defects, such as loose connections, damaged power cables and worn protection device contacts, must be eliminated immediately.
- Use only insulated tools.
- Should it be necessary to work on live parts, the electrician must be accompanied by a second person who, in the event of an emergency, should press the BLOCK/EMERGENCY STOP button.
- Cut off the power supply before disconnecting or connecting up plug/socket electrical connectors.

IT IS STRICTLY FORBIDDEN TO CARRY OUT ELECTRODE OR WIRE WELDING ON ANY PART OF THE MACHINE, ON OTHER MACHINES IN THE VICINITY OR ON MACHINES CONNECTED TO THE SAME MAINS POWER SUPPLY. If necessary, contact Matteuzzi srl to establish the required precautions. Permanent damage may be done to the computer and equipment connected to it and your warranty voided.

⚠	**Any work required on the machine must be performed by qualified personnel and only after the electrical and pneumatic power supplies have been cut off.**

6.3. MAINTENANCE OPERATIONS

6.3.1. DAILY MAINTENANCE

description	**personnel**
At the start of every day or work shift check that the block - emergency stop buttons are in perfect working order.	operator
Keep the operator floor area clean, removing rubber dust and any objects that might make it slippery. **Do not use an air hose to blow off dust. Instead, please use a vacuum system. Permanent damage may be done to different parts and your warranty voided.**	
Remove the polyethylene film detached from the tread from the poly pinch roller and dispose of it in accordance with prevailing regulations.	
Clean thoroughly the parts exposed to process dust. **Do not use an air hose to blow off dust. Instead, please use a vacuum system. Permanent damage may be done to different parts and your warranty voided.**	
Visually check the wear of the rubber rim of the expandable hub and ask for its replacement, if necessary.	
Check the efficiency of the rubber rim mounted on the expandable hub. Ask for replacement, if necessary.	

6.3.2. MONTHLY MAINTENANCE

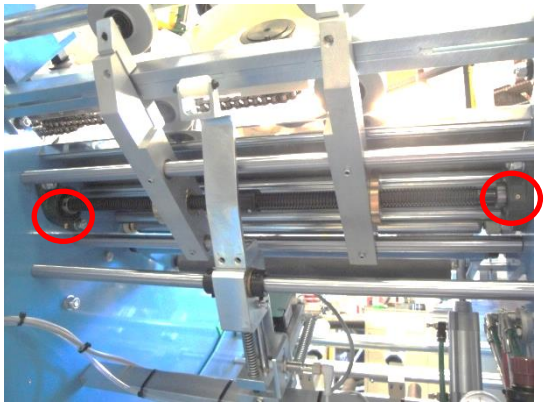
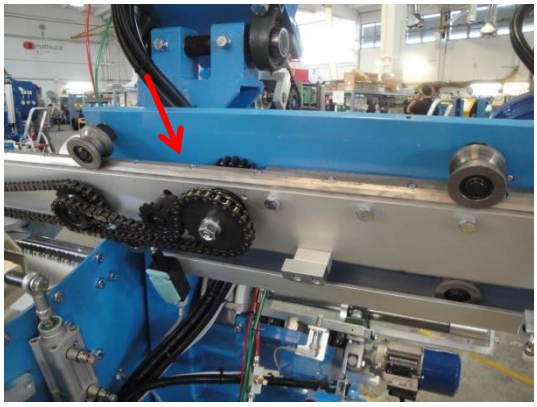
description	**personnel**
Check the efficiency of the silencers installed on the compressed air outlets. Keep them clean and ask for them to be replaced when necessary.	operator
Cut off compressed air supply to discharge the condensate from the compressed air filter bowl.	mechanical maintenance engineer
The electrical equipment and electrical system on board the machine must be inspected and checked at regular intervals. Defects, such as loose connections, damaged power cables and worn protection device contacts, must be eliminated immediately.	electrical maintenance engineer

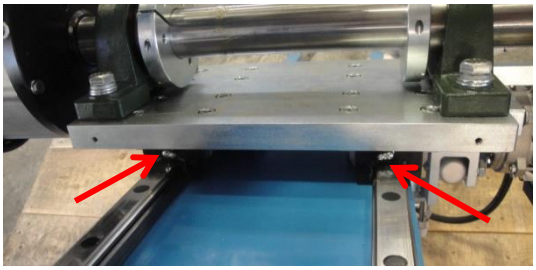
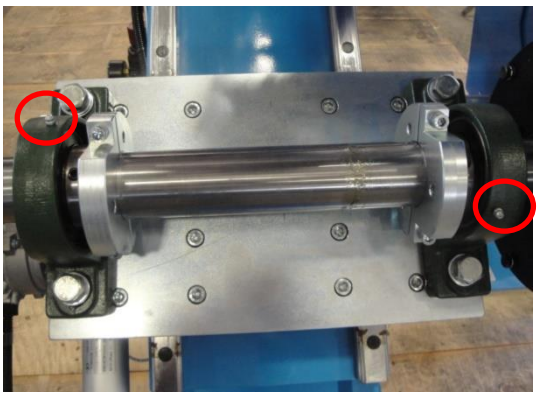
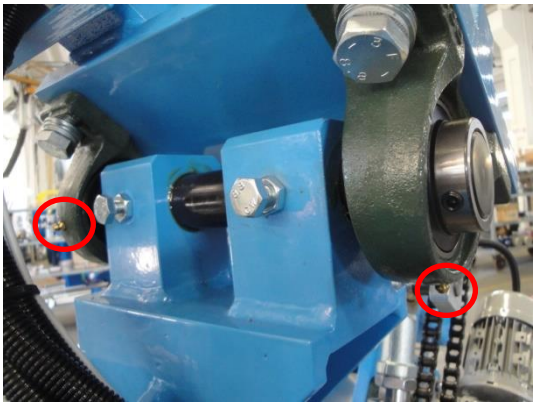
6.3.3. QUARTERLY MAINTENANCE

description	**personnel**
Perform lubrication of the critical machine parts. See paragraph 6.3.3.1 at following pages.	mechanical maintenance engineer

6.3.3.1. Lubrication

⚠	**The following operations must be performed by a qualified mechanical maintenance engineer and only after the electrical and pneumatic power supplies have been cut off.** **Use a grease gun filled with a commercially available product that is made specifically for mechanical lubrication.**

Feed with grease the pillow block of the screw on which the twin rollers move horizontally.	
In the rotary cutter assembly, remove the fixing screws of the guards containing the gear, the rack and the linear guide and clean and grease them.	

Clean and slightly grease the linear guides for up/down movement of the expanding hub and rim assembly.	
Feed with grease the pillow block nipples of the hub rotation shaft.	
Feed with grease the pillow block nipples of the tread cutter oscillating support.	
Feed with grease the pillow block nipple on the tread lift handwheel.	

Feed with grease the pillow block nipples of the presser roller shaft.	

6.3.3.2. Gearboxes

The gearboxes fitted on the machine are life-lubricated.

6.3.4. SEMIANNUAL MAINTENANCE

description	**personnel**
Check the state of the air operated machine components and equipment.	mechanical maintenance engineer
Check and; if necessary; tighten the bolts and nuts of the operating parts.	

6.4. RETOOLING

6.4.1. CHANGING THE BLADE IN THE TREAD CUTTER

Worn blades diminish the quality of the cut. The operator must visually check the condition of the cutter blade and, if necessary, request replacement.

	• **This operation may only be performed by a mechanical maintenance engineer or trained personnel.** • **To prevent damaging the fastening screw, use only the spanner provided with the machine and no others.** • **Proceed with the blade replacement only after cutting off the electrical and pneumatic power supplies, as described below**
	**During blade replacement the mechanical maintenance technician or trained personnel must wear protective gloves.**

How to change the blade in the cutter:

- Press CUTTER UP push-button to return the cutter to its raised position.
- Cut off the electrical and pneumatic power supplies.
- Using the 90° spanner 13 mm, loosen the screw locking the cutter blade and replace the blade.
- Replace every component, exactly reproducing the original configuration.
- Carry out a machine empty restart procedure - see par. 5.8.1.

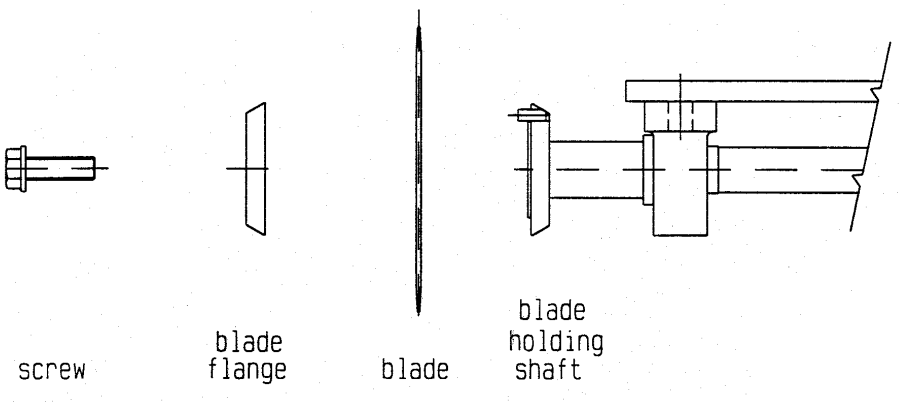


Figure 15: blade retooling

6.5. ACCESSORIES PROVIDED

Q.ty	**description**	**use**
1	spanner - 10 mm./13 mm.	Various maintenance operations
1	Allen wrench - 4 mm. Allen wrench - 5 mm. Allen wrench - 6mm.	

6.6. ORDERING SPARE PARTS

When ordering spare parts, please specify the following:

- the serial number and year of manufacture of your machine, as indicated on the plate fitted to the machine,
- the reference number of the part as indicated on the drawings illustrating the machine assemblies - see annex 1,
- the part description as given on the parts lists - see annex 1,
- any other details you think may be useful to identify exactly the replacement part you require.

7. DECOMMISSIONING

7.1. STOPPING THE MACHINE

When stopping the machine definitively, before disassembling, proceed with the following:

- Disconnect the machine from the electrical power supplies;
- Disconnect the machine from the compressed air supplies (if present);
- Disconnect the machine from the hydraulic power supplies (if present).

7.2. DISASSEMBLY AND DISPOSING

Once the operations have been carried out, all machine parts can be removed for scrapping.

When disassembling the machine comply meticulously with the handling indications set out in this manual.

In particular:

- Do not use non-compliant or worn ropes or cables with a lifting capacity lower than the machine weight;
- Move the machine carefully and make sure that people are not standing in the operating area of the lifting equipment;
- Do no stand under suspended loads;
- Pay particular attention to suspended parts and relative risks.

7.3. DISPOSING AND SCRAPPING

There are no hazardous components or materials in the machine that could cause problems during decommissioning.

Once the single components have been disassembled, start dividing them by material as follows.

- Ferrous material: frame, guard, fittings, etc.
- Aluminium: flanges, etc.
- Plastic material: gaskets, cables, etc.
- Electric material: motors, panel, equipment.

During scrapping, retrieve any components that can be retrieved and reused.

ALL THE MACHINE COMPONENTS, AFTER HAVING BEEN SEPARATED BY MATERIAL, MUST BE SCRAPPED BY SPECIALISED COMPANIES THAT OPERATE IN COMPLIANCE WITH THE LEGAL REQUIREMENTS IN FORCE IN THE USER'S COUNTRY.

8. LIST OF ANNEXES

Annex No.	**Description of the folder contents**
1	DRAWINGS ILLUSTRATING THE COMPONENT PARTS OF THE MACHINE TOGETHER WITH PART LISTS
2	ELECTRICAL SYSTEM DIAGRAM
3	PNEUMATIC CIRCUIT DIAGRAM

RAS 201 BUILDER

OPERATION AND MAINTENANCE MANUAL

since 1956 matteuzzi

MACCHINE PER PNEUMATICI E PER I PROCESSI DI RICOSTRUZIONE
EQUIPMENT FOR THE TYRE AND RETREADING INDUSTRIES

matteuzzi srl
Via Serra 1/E - 3
40012 Calderara di Reno - Bologna - ITALY
Tel. +39 - 051726351
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matteuzzi@matteuzzi-srl.com

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ANNEXES 1, 2, 3

to OPERATION AND MAINTENANCE MANUAL

RAS 201 - Builder

Year of manufacture	2022
Serial no.	MAT – 21191
Manufacturer	MATTEUZZI SRL Via Serra, 1/E – 3 40012 CALDERARA DI RENO BOLOGNA - Italy
Importer	

1 DRAWINGS ILLUSTRATING THE COMPONENT PARTS OF THE MACHINE TOGETHER WITH PART LISTS

2 ELECTRICAL SYSTEM DIAGRAM

3 PNEUMATIC CIRCUIT DIAGRAM

This manual is an integral part of the machine. It must be kept close to hand when using the machine and must be available for transfer to other users if necessary

ALLEGATO – ANNEX – ANNEXE – ANHANG – ANEXO 1

disegni e lista dei componenti meccanici

mechanical part list and drawings

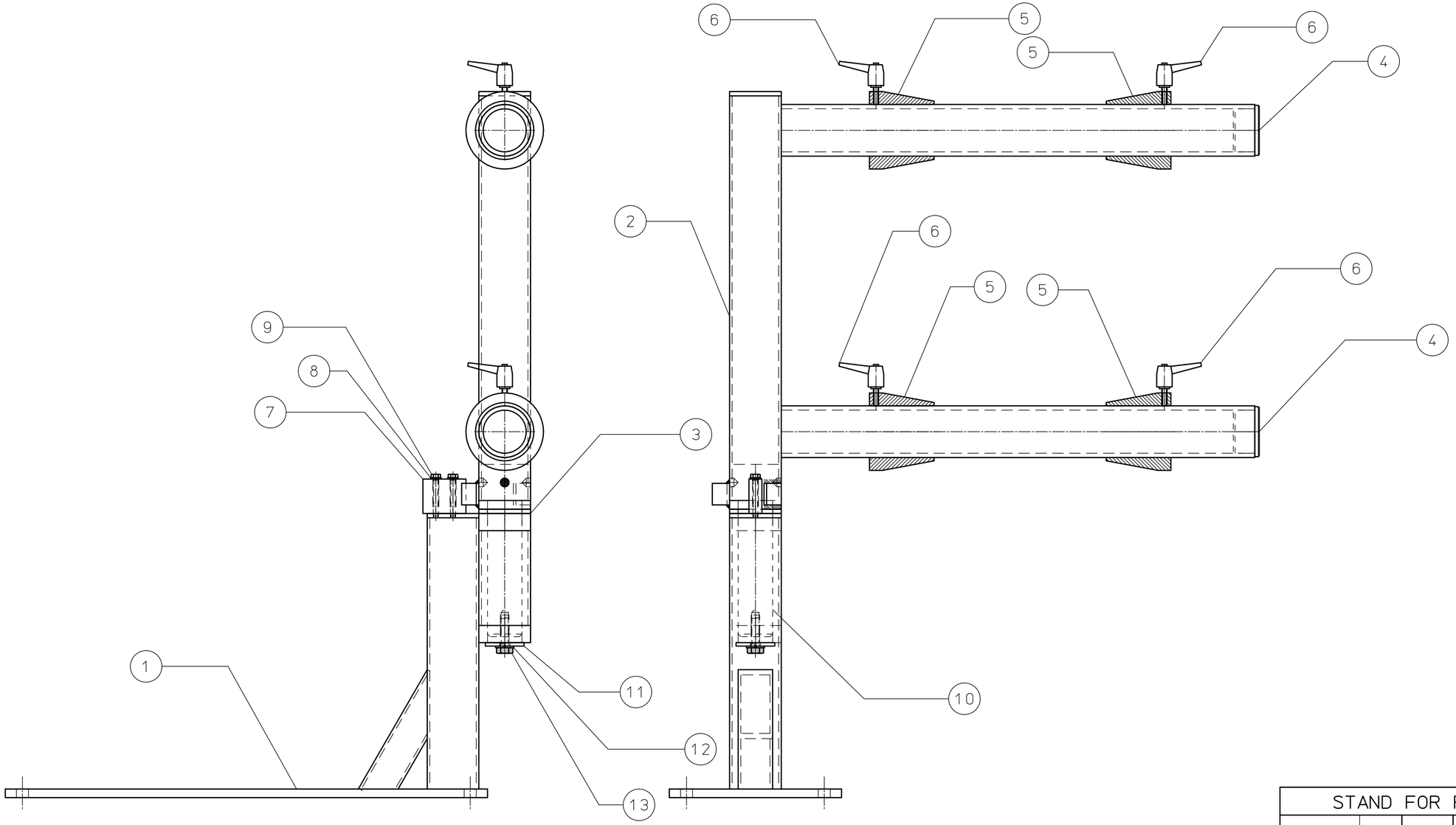
description et plans des composants mécaniques

Zeichnungen und Mechanikteile-Liste

dibujos y lista de los componentes mecánicos

contents

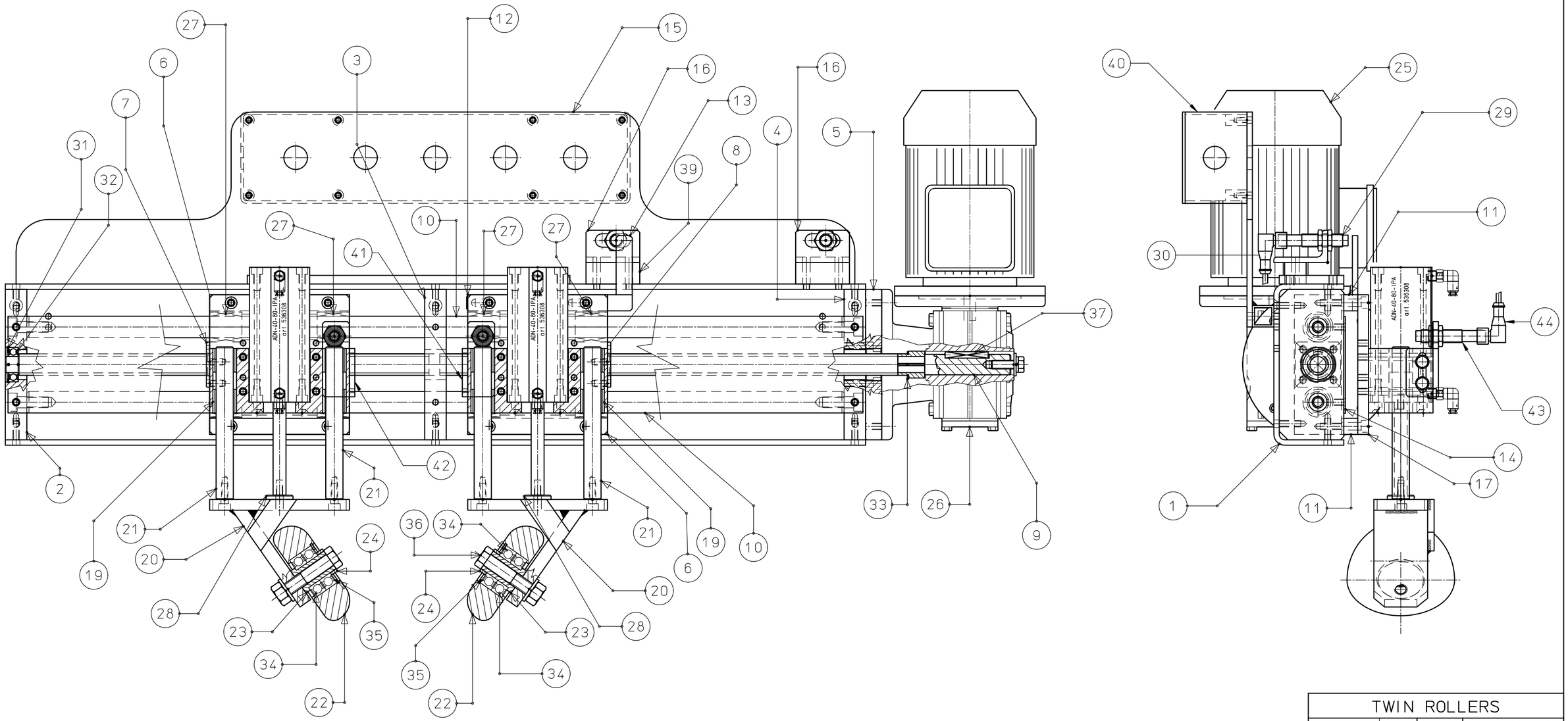
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
1	11321.0	STAND FOR POLY – FIXED FRAME	1
2	11322.0	STAND FOR POLY – MOBILE COLUMN	1
3	11323.0	SPACER RING	1
4	11324.0	COVER	2
5	10106.0	TAPERED ROLLER	4
6	20180.0	RAPID CLAMP, M63P-M6X20	4
7	11327.0	STOPPER	1
8	23836.0	WASHER, I.D. 6 UNI6592	2
9	23898.0	SCREW, HEXAGONAL HEAD DIA.6 L=45 MM.	2
10	11328.0	SHAFT	1
11	23899.0	WASHER, D.12X45X4 ZINC-PLATED	1
12	23843.0	WASHER, D.10 UNI6592 ZINC-PLATED	1
13	23690.0	SCREW, HEXAGONAL HEAD M10X35 ZINC-PLATED	1



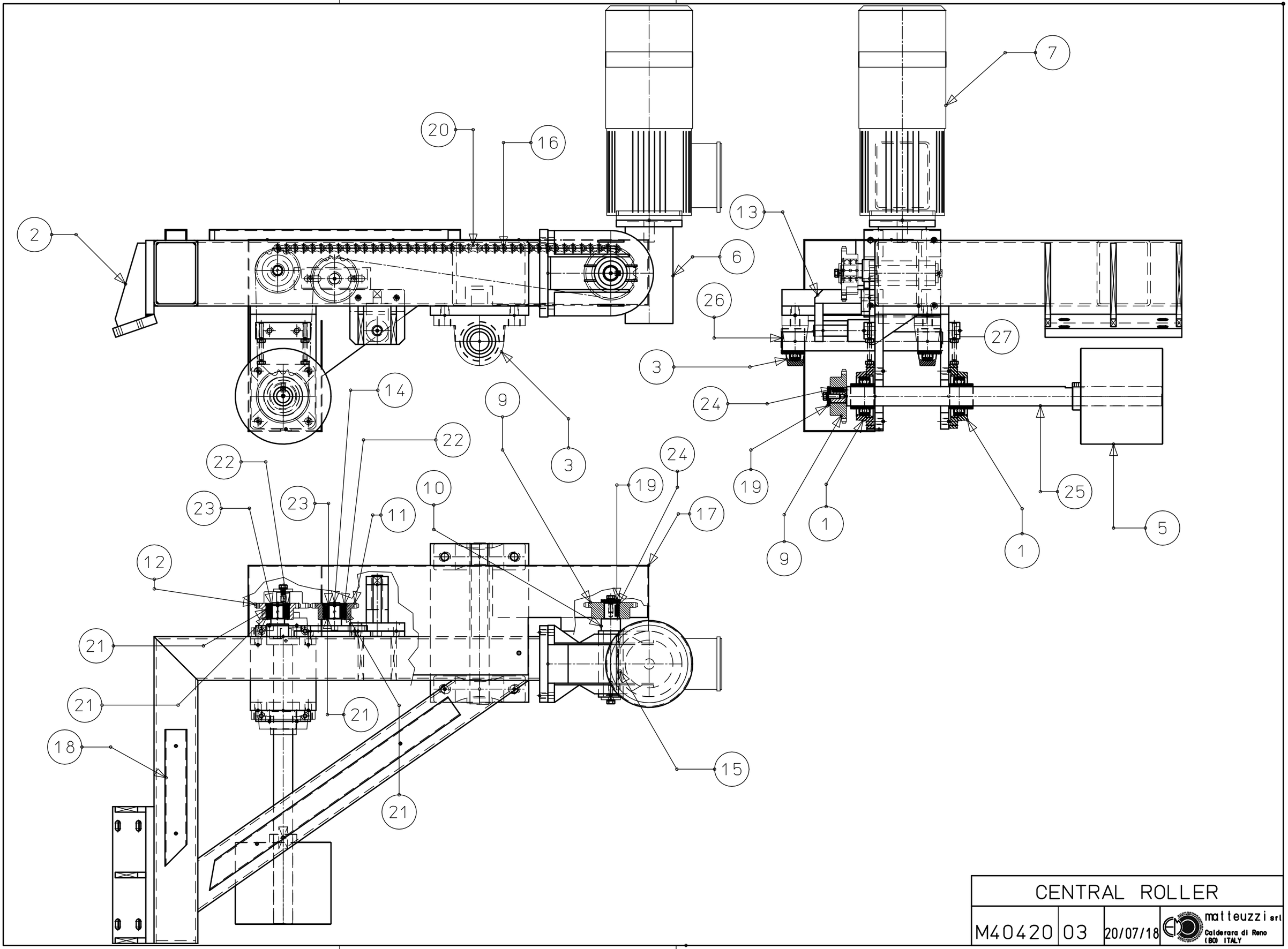
STAND FOR ROLLS			
M40277	00	17/08/00	matteuzzi srl Calderara di Reno (BO) ITALY

rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
1	11223.2	FRAME	1
2	11216.0	SUPPORT	1
3	11217.0	SUPPORT	1
4	11218.0	SUPPORT	1
5	11219.0	FLANGE FOR GEARBOX	1
6	11220.0	SLEDGE	2
7	11214.0	BUSHING, L.H. FITMENT	1
8	11215.0	BUSHING, R.H. FITMENT	1
9	11213.0	SCREW	1
10	11212.0	SHAFT	2
11	11221.0	SPACER	3
12	14524.00	SPACER	1
13	12276.0	FEELER	1
14	11222.0	PROTECTION	1
15	14525.00	PROTECTION	1
16	14530.00	SUPPORT	2
17	14528.01	PLATE	2
18	29051.0	CYLINDER, COMPACT FESTO D.40X80 ADN-40-80-IPA	2
19	14529.2	SUPPORT	2
20	14523.1	SUPPORT	2
21	14513.0	SHAFT	4
22	11224.0	ROLLER	2
23	11225.0	PIN	2
24	11226.0	SPACER	2
25	20705.0	MOTOR, M63 4 POLES 0,25HP B5	1
26	20476.4	GEARBOX, RMI40FL 1/20 PAM63 B5	1
27	23060.0	BALL BUSHING, KH 2030 PP	8
28	10611.0	WASHER	2
29	22708.0	PROXIMITY SWITCH, AM1/AP-2H D=12N.0	2
30	22711.0	CONNECTOR, C/WITH 10 M. CABLE	2

rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
31	21934.0	SNAP RING, I.D.32	1
32	20069.0	BALL BEARING, SKF 6002-2RS1	1
33	20012.0	SNAP RING, I.D. 20	1
34	20067.0	BALL BEARING, 6004 2RS	4
35	22517.0	SNAP RING, I.D. 42	2
36	24691.0	SCREW, HEXAGONAL HEAD - DIA.12 - L=60 MM.	2
37	21193.0	KEY, 6X6X40	1
38	20441.0	ELBOW, "L" 1/4"-T4	4
39	14536.0	SPACER FOR PROXIMITY SWITCH SUPPORT	2
40	14429.0	FRONT PANEL	1
41	78416.0	SUPPORT FOR PROXIMITY SWITCH, R.H. FITMENT	1
42	78417.0	SUPPORT FOR PROXIMITY SWITCH, L.H. FITMENT	1
43	31087.00	PROXIMITY SWITCH, IS-12-C2-S2 M12	2
44	31088.00	CONNECTOR, TEM 1204 100 FRD-6 10 MT.	2


ADN-40-80-1PA
art 536306
TWIN ROLLERS
M40419 04 15/07/20
matteuzzi srl
Calderara di Reno
(BO) ITALY

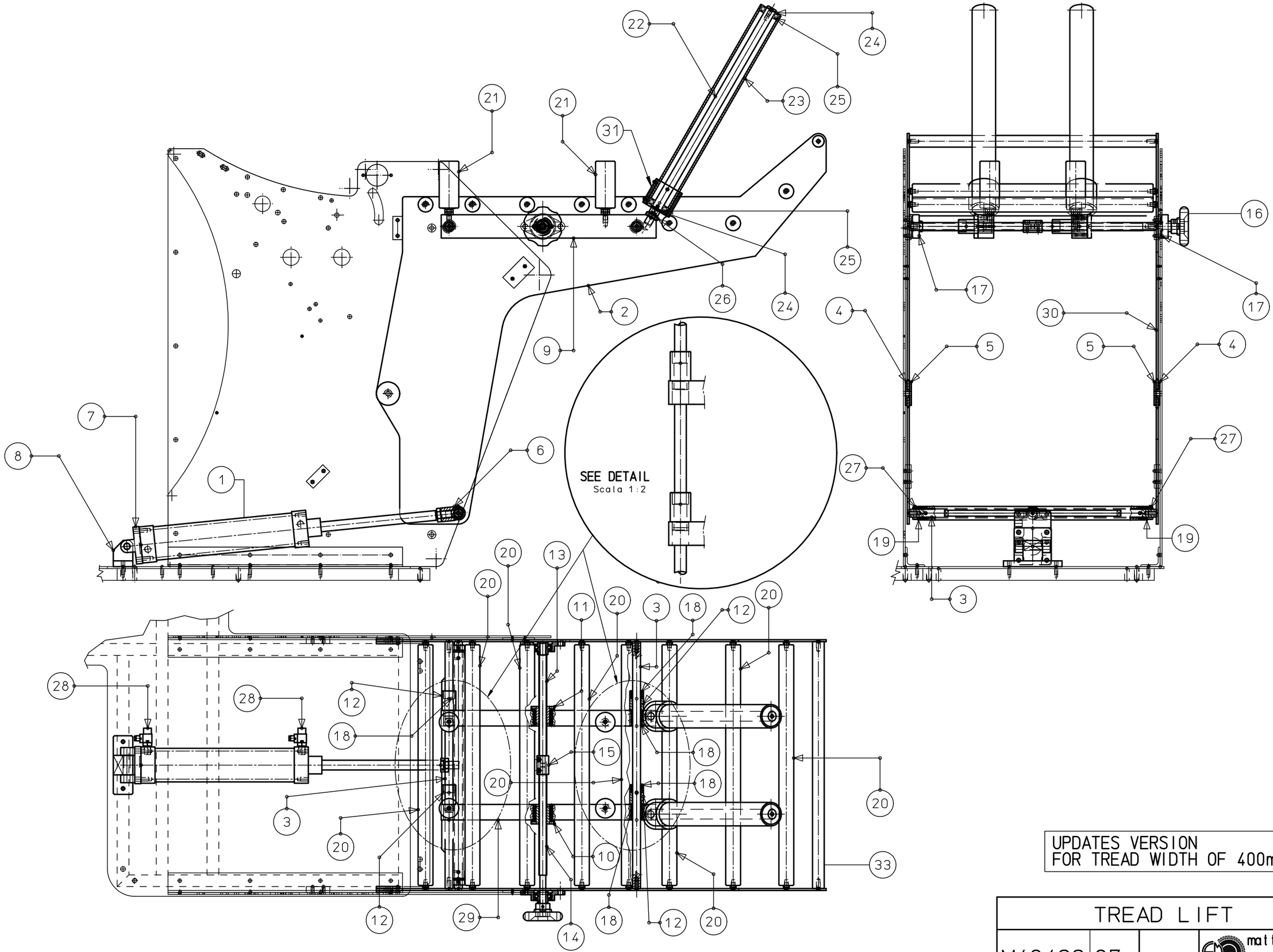
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
1	23565.0	PILLOW BLOCK, UCF207	2
2	14484.1	MOVABLE ARM	1
3	21108.0	PILLOW BLOCK, UCP 207	2
5	14521.0	CENTRAL ROLLER	1
6	26190.0	GEARBOX, RMI70F3 1/40 PAM80 B14	1
7	20759.0	MOTOR, R80 2/6P 0,75/0,14HP B14 WITH BRAKE	1
9	14461.0	PINION	2
10	14454.0	SHAFT	1
11	14556.0	CHAIN TENSIONING PINION	1
12	14462.0	CHAIN TENSIONING PINION	1
13	14476.0	SUPPORT	1
14	14445.0	PIN	1
15	22516.0	KEY, 8X7X100	1
16	14557.0	CHAIN, 5/8 L=1968.5	1
17	14500.0	PROTECTION	1
18	14532.1	CHANNEL FOR CABLES	1
19	21012.0	WASHER, I.D.8.5X35X4	3
20	22318.0	CONNECTING LINK, 5/8"S	1
21	20067.0	BALL BEARING, 6004 2RS	4
22	22517.0	SNAP RING, I.D.42	2
23	20012.0	SNAP RING, I.D.20	2
24	21049.0	KEY, 8X7X20	2
25	72093.1	SHAFT FOR ROLLER	1
26	72092.0	SHAFT FOR ARM	1
27	84570.00	SUPPORT	2
	24454-0	HEXAGONAL HEAD SCREW M8x70	4



CENTRAL ROLLER			
M40420	03	20/07/18	matteuzzi srl Calderara di Reno (BO) ITALY

rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
1	29048.0	CYLINDER, ISO FESTO D.80X300 DSBC-80-300-PPSA-N3 ART.2126641	1
2	14486.00	SIDE PLATE, R.H.FITMENT	1
3	14491.00	BAR	3
4	14493.00	BUSHING	2
5	14494.00	WASHER	2
6	14507.00	PLATE	1
7	23175.0	HINGE, D.80 FEMALE W/PIN KF19080	1
8	14489.00	SUPPORT FOR CYLINDER	1
9	14564.00	ARM	1
10	14560.00	THREADED BUSHING, TPN20 L.H.	1
11	14510.00	THREADED BUSHING, TPN20 R.H.	1
12	14490.00	SPACER	4
13	14509.00	SCREW, TPN 20 R.H.	1
14	14508.00	SCREW, TPN 20 L.H.	1
15	10166-0.00	JOINT FOR BARS	1
16	84539.00	HAND WHEEL	1
17	21400.0	PILLOW BLOCK, UCFL 202	2
18	23034.0	BUSHING, 20-38-20	8
19	28956.0	BUSH, BRONZE 20-28-35-20	2
20	14559.01	ROLLER, DELTA 38/15 B2 X=616 Z=632 STAINLESS STEEL 304	8
21	14558.01	ROLLER, GAMMA 50/12C X=120 STAINLESS STEEL 304	4
22	14527.00	SHAFT	2
23	14526.00	ROLLER FOR TREAD ROLL	2
24	21995.0	SNAP RING, I.D.25	4
25	20212.0	BALL BEARING 6205 2RS	4
26	24039.0	NUT, I.D. 20 MM ZINC PLATED	2
27	20274.0	COLLAR, ABU20 DIN705	2
28	22146.0	FLOW REGULATOR, 3/8" DIA. 8 HOSE (453080)	2
29	14531.00	ARM	1

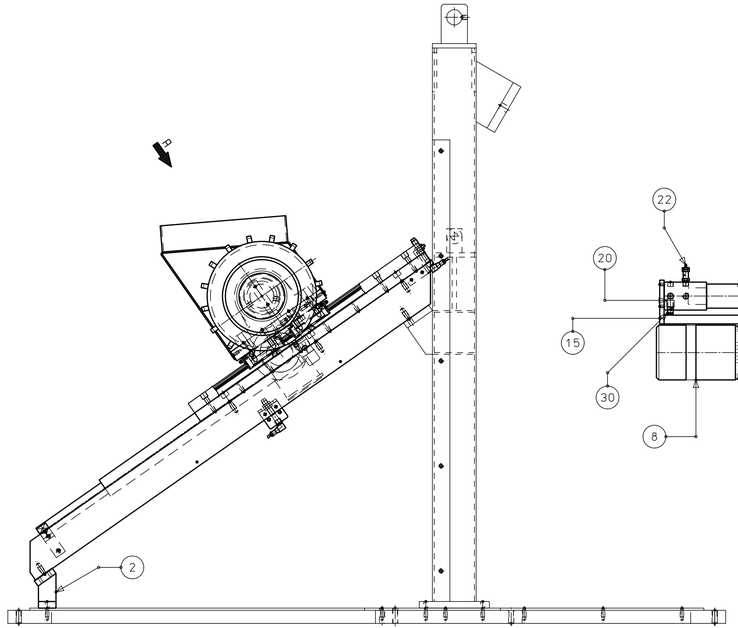
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
30	14485.00	SIDE PLATE, L.H. FITMENT	1
31	79004.00	REAR ROLLERS SPACER (OPTIONAL)	2
33	71896.00	BAR	1

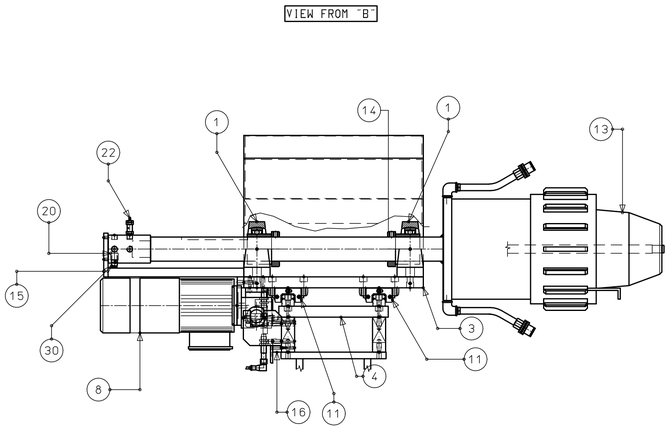


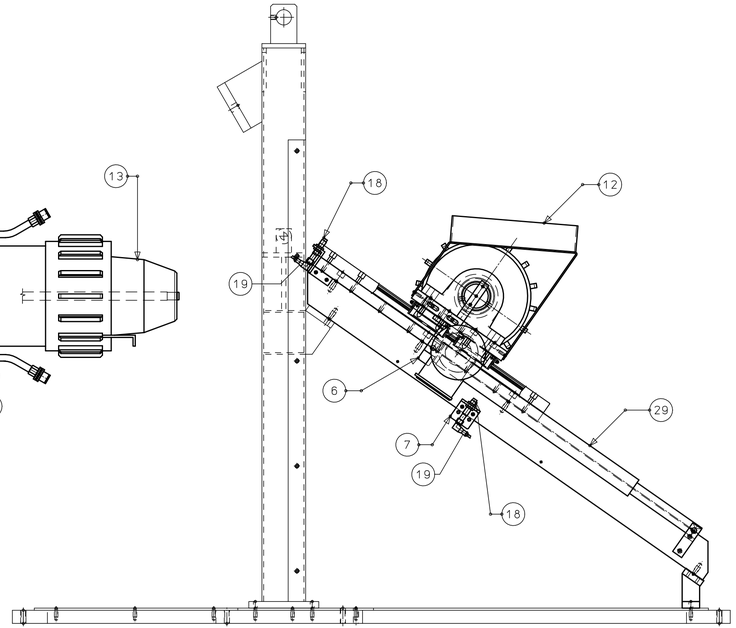
UPDATES VERSION
FOR TREAD WIDTH OF 400mm

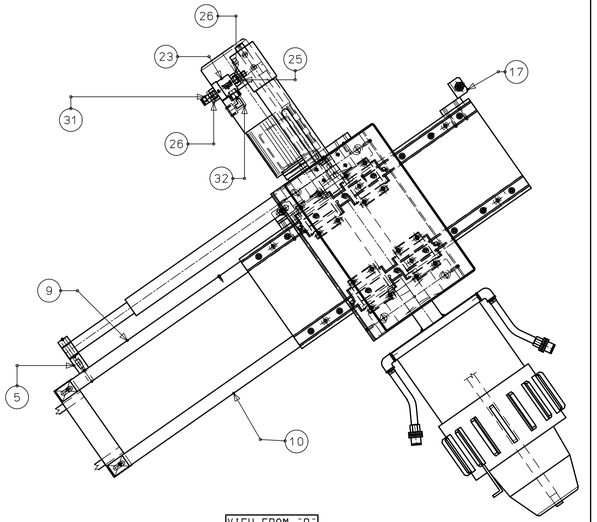
TREAD LIFT			
M40422	07	18/02/22	matteuzzi srl Calderara di Reno (BO) ITALY

rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
1	23803.0	PILLOW BLOCK, UCP 211	2
2	14487.0	SUPPORT	1
3	14488.0	PLATE	1
4	14496.1	PLATE	1
5	14498.0	REAR CONNECTION FOR LINEAR ACTUATOR	1
6	14499.0	FRONT CONNECTION FOR LINEAR ACTUATOR	1
7	14530.0	SUPPORT FOR PROXIMITY SWITCH	1
8	20711.0	MOTOR, GR.63 2P 0,35HP B14	1
9	14471.0	PLATE	1
10	14472.0	PLATE	1
11	14535.0	LINEAR GUIDE, LH30 L=640	2
12	14505.0	TRAY	1
13	13100.01	EXPANDABLE HUB	1
14	30376.0	STOP RING ABU 55 DIN 705	2
15	72091.0	SUPPORT	1
16	14536.0	SPACER	1
17	14537.0	SUPPORT	1
18	22708.0	PROXIMITY SWITCH, AM1/AP-2H-3W D.12	2
19	22711.0	CONNECTOR C/WITH 10 M. CABLE	2
20	21812.0	FITTING, ELBOW CONNECTOR ¼”GS	1
22	20646.2	SAFETY VALVE, ¼” 2,5 BAR	1
23	22255.0	QUICK EXHAUSTER, VSR ½”	1
25	20580.0	FITTING, 3/8” MALE TO ¼” MALE ADAPTER	1
26	20510.0	NIPPLE, M1/2”-F3/8”	1
29	14534.0	LINEAR ACTUATOR,ECV1 VRS C=400 R1/10	1
30	20426.0	FITTING, STRAIGHT CONNECTOR ¼”T8	1
31	21931.0	FITTING, STRAIGHT CONNECTOR M 3/8"	1





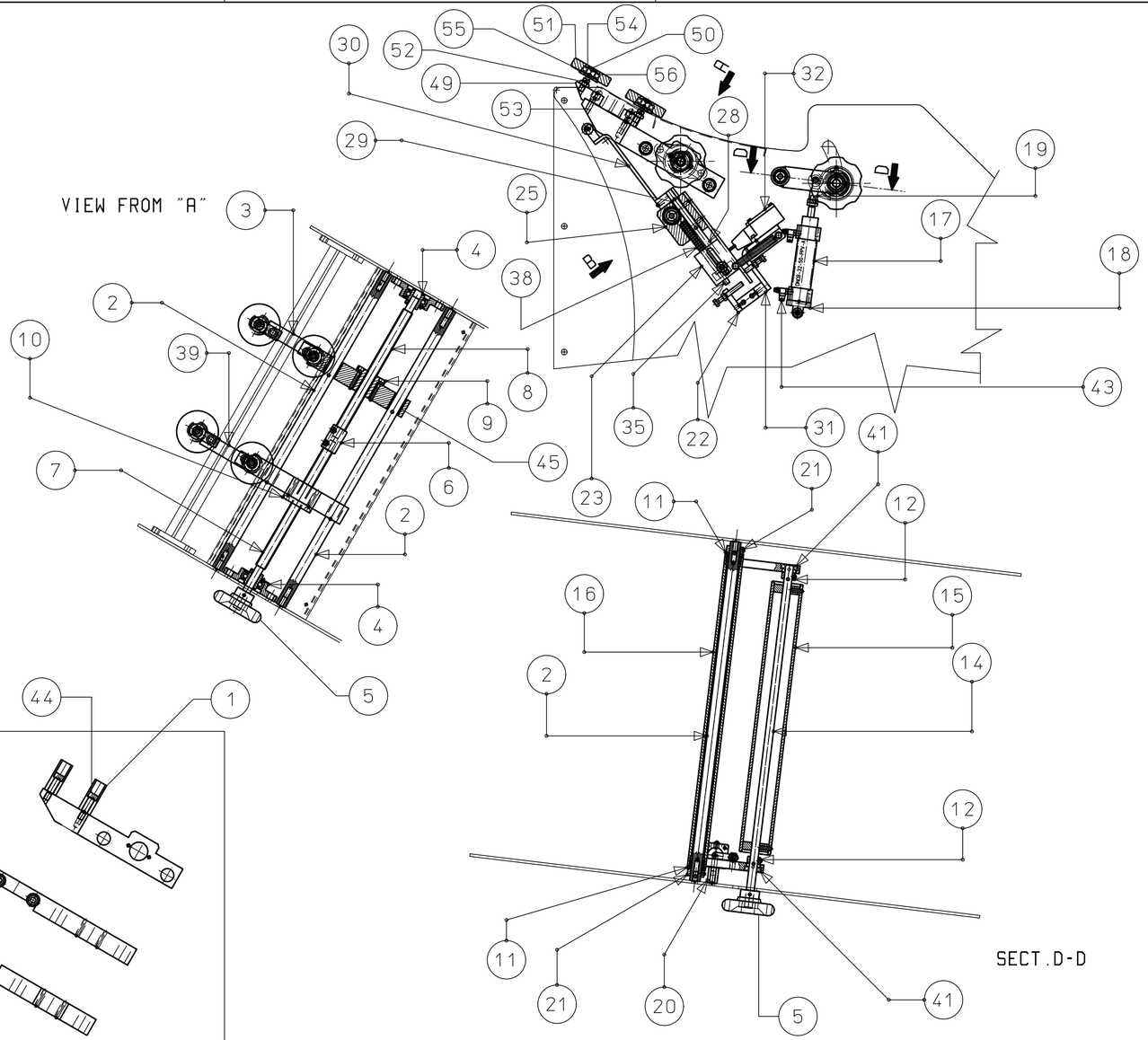


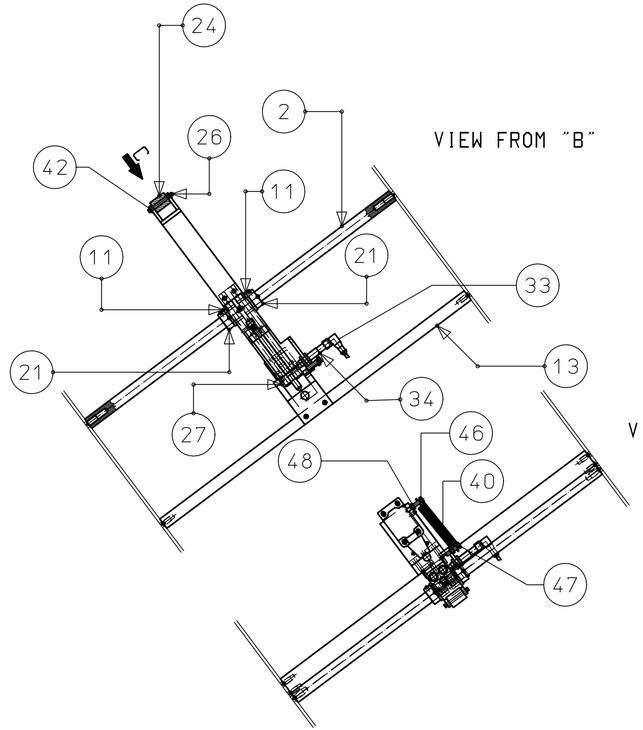


EXPANDABLE HUB			
M40423	03	15/07/20	matteuzzi srl Calderara di Reno (BO) ITALY

rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
1	14520.00	CENTRING ROLLER	4
2	14481.00	BAR	4
3	14514.00	MOBILE SIDE PLATE	1
4	21400-0	PILLOW BLOCK, UCFL 202	2
5	84539.00	HAND WHEEL	2
6	10166-0.00	JOINT FOR BARS	1
7	14508.00	SCREW, TPN 20 L.H.	1
8	14509.00	SCREW, TPN 20 R.H.	1
9	14510.00	THREADED BUSHING, R.H.TPN 20	1
10	14560.00	THREADED BUSHING, L.H.TPN 20	1
11	28956-0	BUSH, BRONZE 20-28-35-20	4
12	24444-0	COLLAR, ABU 15 DIN 705	2
13	14430.00	TOOTH	1
14	14515.00	SHAFT FOR ROLLER	1
15	14516.00	ROLLER	1
16	14551.00	SHAFT	1
17	29050-0	CYLINDER, ISO FESTO D.32X50 DNCB-32-50-PPV-A	1
18	23183-0	HINGE, FEMALE ISO D.32 W/PIN	1
19	22982-0	ROD EYE, FEMALE M10X1.25	1
20	14552.00	PIN	1
21	20274-0	COLLAR, ABU20 DIN705	4
22	14436.00	PLATE	1
23	14435.01	PLATE	1
24	14432.00	ROLLER FOR TOOTH	1
25	14434.01	PLATE	1
26	14439.00	PIN	1
27	14438.00	BRAKET	1
28	14433.00	SHAFT	2
29	76537.00	BUSH, BRONZE 12-15-12	4
30	14431.01	TOOTH	1

rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
31	14437.00	SUPPORT FOR LIMIT SWITCH	1
32	25370-0	LIMIT SWITCH, SIEMENS 3SE3 120-1D	1
33	22711-0	CONNECTOR C/WITH 10 M. CABLE	1
34	22708-0	PROXIMITY.SWITCH, AM1/AP-2H-3W D.12	1
35	14553.00	PIN	1
38	25071-0	SPRING, CO 22X300 L=115	1
39	14561.00	MOBILE SIDE PLATE	1
40	35325-0	SPRING, TRACTION, STEEL C72 F.1,7 D.E.12 L=63 W/EYELET D.I.12,5	1
41	20069-0	BALL BEARING, 6002-2RS	2
42	25365-0	SNAP RING, E 6	2
43	20446-0	FLOW REGULATOR, 1/8" DIA. 8 HOSE (458080)	2
44	28993-0	SCREW UNBRAKO M10 12X30	4
45	28588-0	BUSHING, BRONZE 20-25-34	4
46	23852-0	SCREW, HEXAGON HEAD M6X30 UNI5739 ZINC.	1
47	23861-0	SCREW, HEXAGON HEAD M6X25 UNI5739 ZINC.	1
48	23890-0	NUT, M6 UNI5588 ZINC.	2
49	71887.01	SHIM	2
50	71889.01	PIN	4
51	71888.00	ROLLER, D.80	4
52	23912-0	NUT, M10 UNI5589 ZINC.	4
53	23869-0	HEXAGON SOCKET HEAD CAP SCREW, M10X25 UNI5931 ZINC.	4
54	20686-0	SNAP RING, E 17	4
55	21816-0	SNAP RING, I 35	4
56	21276-0	BALL BEARING 6003 2RS	4





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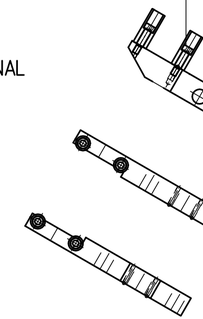
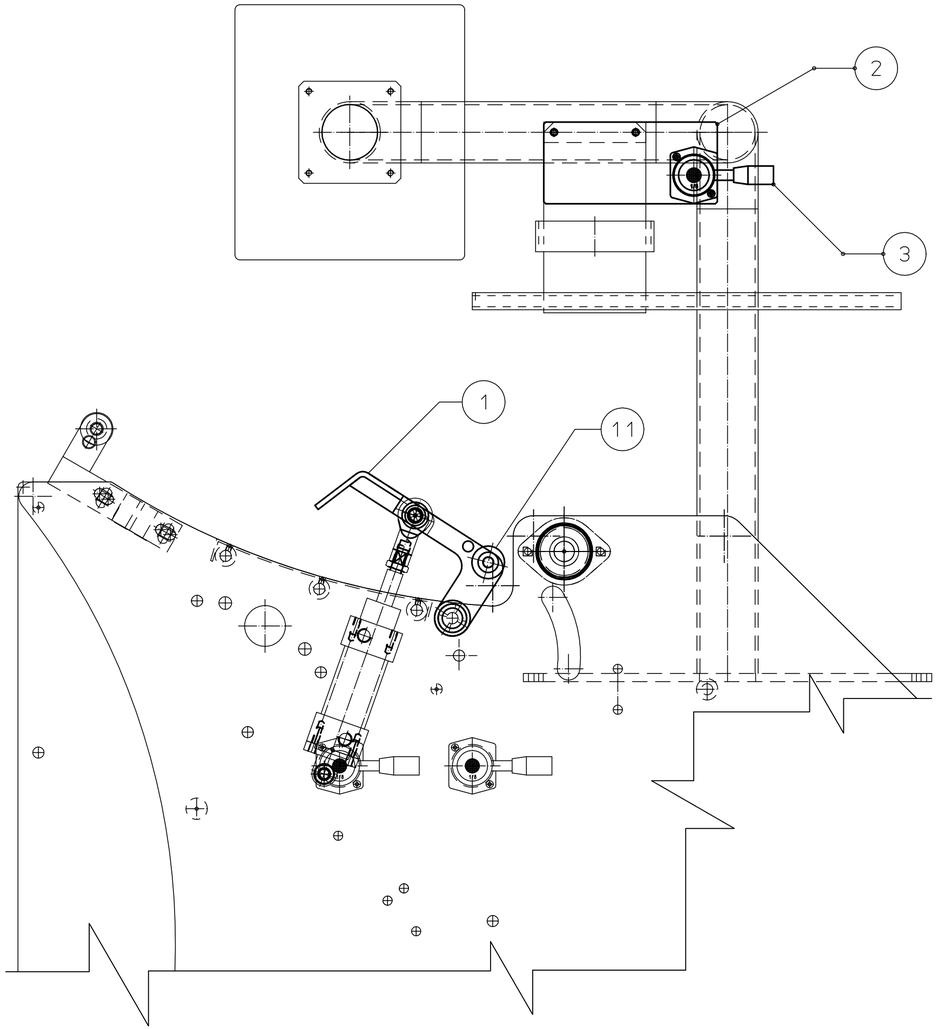
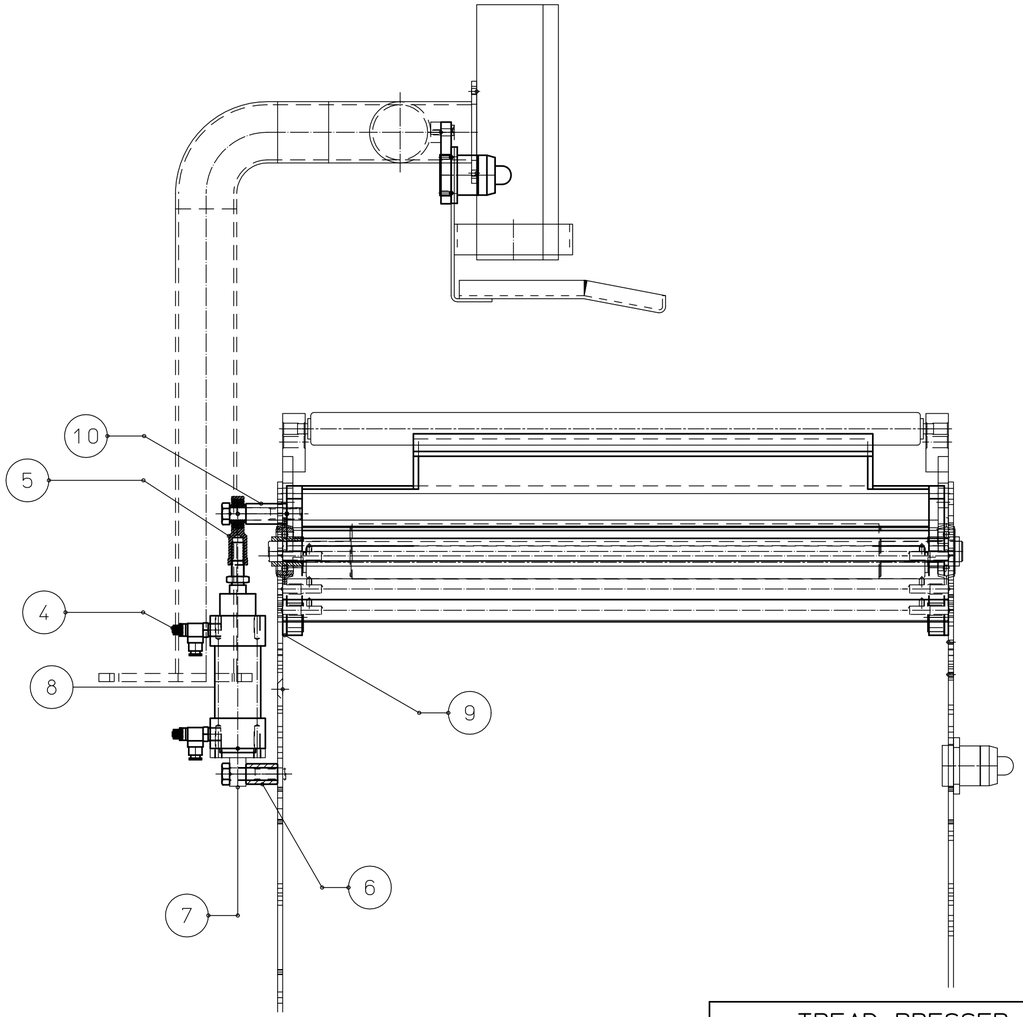


TREAD POSITIONER			
M40427	09	02/03/22	matteuzzi srl Calderara di Reno (BO) ITALY

rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
1	72070.1	TREAD PRESSER	1
2	71998.0	SUPPORT	1
3	20538.0	VALVE, 1/8” 4001I	1
4	20437.0	FLOW REGULATOR, 1/4” T.8 MV380814	2
5	23554.0	ROD EYE, FEMALE M12X1,25	1
6	71999.0	SPACER	1
7	24378.1	HINGE FOR CYLINDER, MALE ISO D.40 PNEUMAX	1
8	30558.0	CYLINDER, ISO FESTO D.40X25 DNCB-40-25-PPV-A ART.532737	1
9	22327.0	BUSHING	2
10	72071.0	SPACER	1
11	27492.1	ROLLER, ALFA 32/10B3 X606 Y612 Z632 STAINLESS STEEL 304 W/SPRING	1





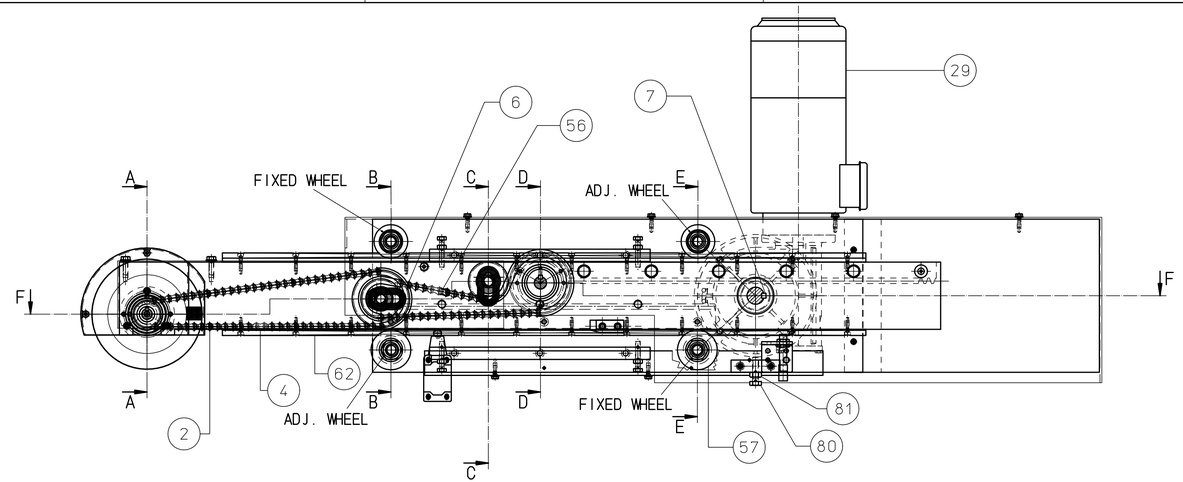
TREAD PRESSER

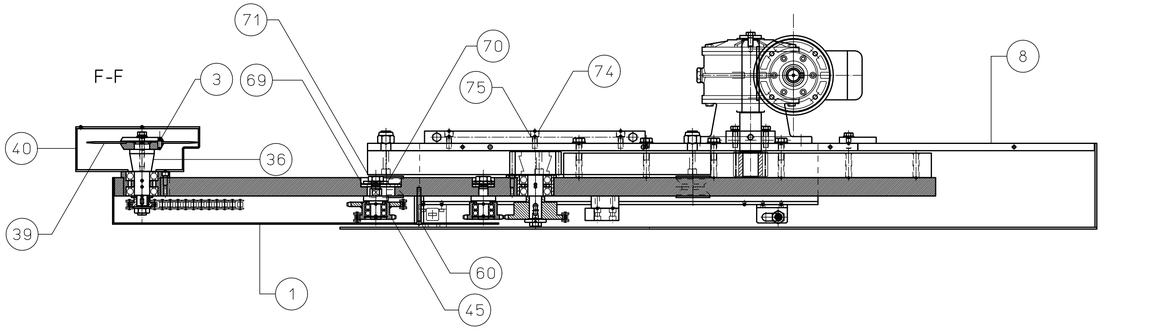
M41003	02	26/05/17	matteuzzi srl Calderara di Reno (BO) ITALY

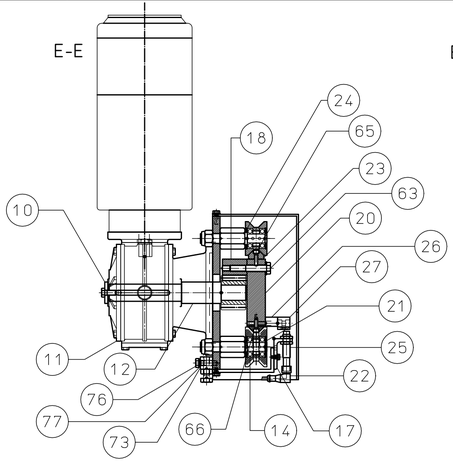
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
1	80646.01	CHAIN PROTECTION	1
2	14550.00	CHAIN 37 LINKS 1/2x5/16	1
3	20255-0	PIN UNI 6364 d6x14	1
4	20246-0	LINK FOR CHAIN 1/2 S	2
5	14542.02	PLATE	1
6	14549.01	CHAIN 31 LINKS 1/2x5/16	1
7	22758-0	KEY 8x7X80	1
8	14543.01	EXTENSION	1
9	14503.01	RACK FRONT PROTECTION	1
10	21012-0	WASHER di8.5 De35 Sp.5	1
11	32842-0	GEARBOX RMI70FL 1/80 PAM80 B14	1
12	83184.00	SHAFT	1
13	83186.00	PIN FOR ROTARY CUTTER WHEEL	2
14	20069-0	BALL BEARING 15x32x9 SKF 6002-2RS1	8
15	83187.00	WHEEL ECCENTRIC PIN	2
16	83194.00	SUPPORT	1
17	14530.00	PROXIMITY SUPPORT	1
18	83185.00	CUTTER RACK	1
19	14544.00	WHEEL	2
20	14440.00	FRAME	1
21	22175-0	SEEGER RING E 15	4
22	22711-0	CONNECTOR	2
23	14547.00	LINEAR GUIDE	1
24	21934-0	SNAP RING UNI 7437 32	8
25	22708-0	PROXIMITY M12	2
26	14468.01	SHIM	1
27	2171-0.00	FEELER	1
29	20728-0	MOTOR, SELF BRAKEING MA80 4P 1HP B14	1
30	20212-0	BALL BEARING 25x52x15 SKF 6205-2RS1	4
31	21967-0	KEY 5x5x10	1

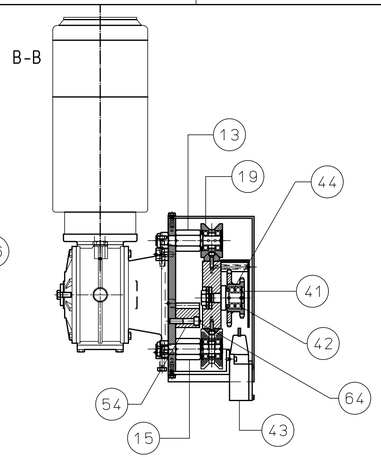
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
32	14460.00	IDLE PINION	1
33	14464.00	SPACER	1
34	14466.00	SPACER	1
35	14456.00	FLANGE	1
36	83188.00	SHAFT	1
37	11316-0.00	FLANGE	1
38	79407.01	COVER	1
39	2520.00	BLADE	1
40	83465.01	PROTECTION	1
41	20686-0	SEEGER RING E 17	2
42	21816-0	SNAP RING UNI 7437 35	2
43	25370-0	LIMIT SWITCH SIEMENS 3SE5-112-0CD02 (EX 3SE2-120-1D)	1
44	21276-0	BALL BEARING 6003 2RS	4
45	14442.00	PINION	1
46	14459.00	PINION	1
47	14467.00	PIN	2
48	20252-0	KEY 6x6x20 UNI 6604	1
49	14465.00	SPACER	1
50	27273-0	WASHER RGS 8-35	1
51	14463.01	MOTORIZED PINION	1
52	14443.00	SPACER	1
53	14444.00	FLANGE	1
54	83182.00	RACK	1
55	83183.01	GEAR Z=19 MODULE 4	1
56	22039-0	CONNECTING LINK 1/2" SIMPLE	1
57	83277.00	LOWER WHEEL	2
60	24042-0	SCREW, COUNTERSUNK HEXAGONAL HEAD M6X60 UNI5933 ZINC – COATED	1

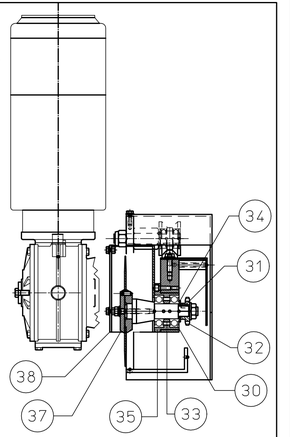
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
61	35381-0	SCREW, COUNTERSUNK HEXAGONAL HEAD M8X20 BN 1206	1
62	83278.00	LOWER LINEAR GUIDE	1
63	23691-0	SCREW, HEXAGONAL HEAD M10X60 UNI5739 ZINC – COATED	6
64	23850-0	SCREW, HEXAGONAL HEAD M8X40 UNI5931 ZINC – COATED	3
65	24974-0	SCREW, HEXAGONAL HEAD M5X20 UNI5931 ZINC - COATED	12
66	23882-0	SCREW, HEXAGONAL HEAD M5X16 UNI5931 ZINC - COATED	12
69	83658.00	WASHER	2
70	83657.00	LOCKING GUIDE	2
71	25757-0	HEX. NUT M14 UNI 5589	2
72	83655.00	FRAME	2
73	83656.01	BLOCK	1
74	24709-0	SCREW, COUNTERSUNK HEXAGONAL HEAD M8X20 UNI5931 ZINC - COATED	6
75	23739-0	WASHER SCHNORR D.8	6
76	23643-0	SCREW, HEXAGONAL HEAD M8X30 UNI5739 ZINC - COATED	2
77	25734-0	WASHER NORD LOCK NL8 I	2
78	24887-0	SCREW, HEXAGONAL HEAD M8X45 UNI5739 ZINC - COATED	4
79	23845-0	HEXAGONAL NUT M8 UNI5588 ZINC - COATED	4
80	23689-0	SCREW, HEXAGONAL HEAD M10X40 UNI5739 ZINC - COATED	1
81	23862-0	HEXAGONAL NUT M10 UNI5588 ZINC - COATED	1
82	24909-0	SCREW, HEXAGONAL SOCKED COUNTERSUNK FLAT HEAD M5X20 UNI5927 P.C.	1

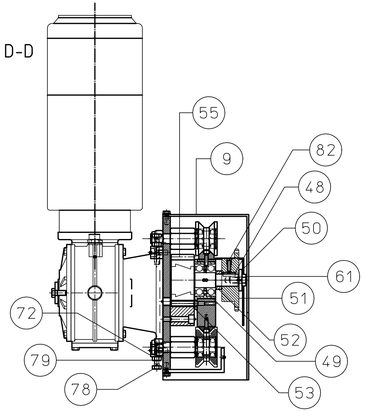


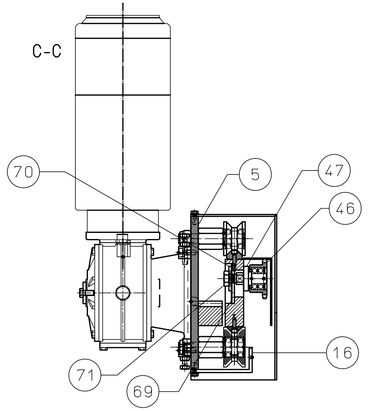










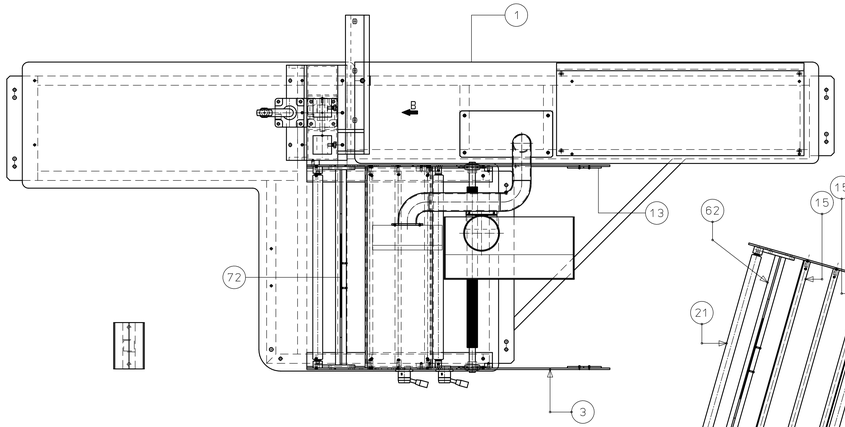


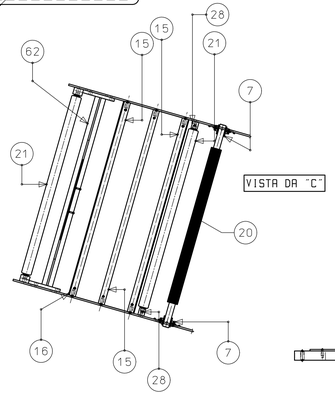
VALE DA MAT-21115

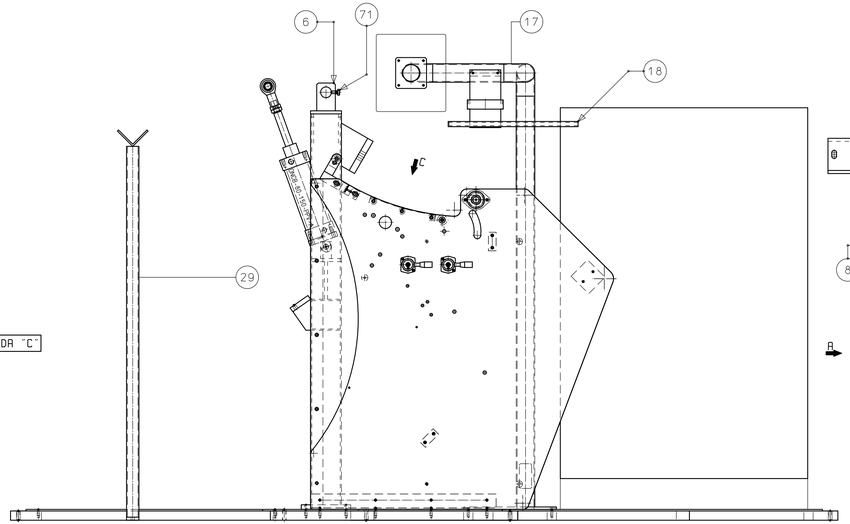
PRECURED TREAD CUTTER			
M41940	07	14/12/21	matteuzzi srl Calderara di Reno (BO) ITALY

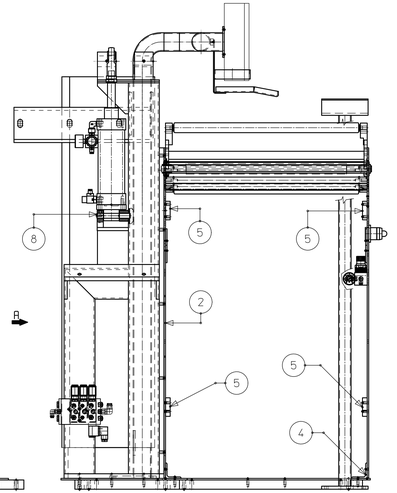
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
1	86203.01	FRAME	1
2	14474.01	REAR SIDE PLATE	1
3	14475.03	FRONT SIDE PLATE	1
4	14473.00	SUPPORT	2
5	14477.00	LIFT STOPPER	4
6	14483.03	COLUMN	1
7	22322.0	PILLOW BLOCK, BPFL204 (RATY20)	2
8	14478.00	PIN	1
13	14541.01	PLATE	2
15	14480.00	BAR	3
16	14482.00	TABLE	1
17	86204.00	CONTROL PANEL SUPPORT	1
18	14447.00	TRAY	1
20	84852.00	ROLLER	1
21	22227.1	ROLLER, ALFA 32/10 B3 X597 Y603 Z623 STAINLESS STEEL 304 W/SPRING	2
28	14548.00	SPACER	2
29	14448.00	SUPPORT FOR TRANSPORT PURPOSES	1
62	14517.05	PLATE	1
71	23879.0	SCREW, HEXAGONAL HEAD M10X20 ZINC-PLATED	2
72	83671.00	BLADE CONTRAST	1
-	33450-0	CABLE CHANNEL 50X100, ZINC COATED, ZAMET ART. T0 003 0510 01 L=3M	1
		L=950 (WITH NICHES)	1
		L=800 (WITHOUT NICHES)	1

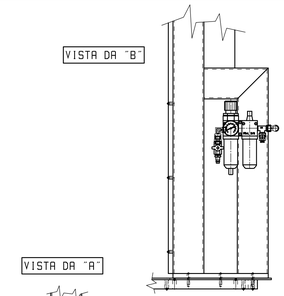
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Menge Cant.
-	33454-0	CABLE CHANNEL COVER 100, ZINC COATED, ZAMET ART. T0 023 0010 01 L=3M	1
		L=950	1
		L=800	1
-	-	CABLE CHANNEL - HORIZONTAL ELBOW+COVER 50X100 ZAMET ART. T0 083 0510 01	1
-	33445-0	CABLE CHANNEL – CONNECTING PLATE ZAMET H50 W/PINS ART. T0 200 0005 01	4
-	-	NUT, FLANGED, KNURLED,.D.6 ZAMET ART. T0 621 0600 01	8

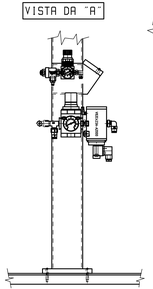












MACHINE FRAME			
M42219	01	03/02/21	matteuzzi srl

ALLEGATO – ANNEX – ANNEXE – ANHANG – ANEXO 2

lista dei componenti e schema elettrico

electrical part list and diagram

description des composants et schéma électrique

Elektroteile-Liste und elektrischer Schaltplan

lista de los componentes y esquema eléctrico

matteuzzi srl

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www.matteuzzi-srl.com
matteuzzi@matteuzzi-srl.com

Company / customer	Matteuzzi Srl
Project description	RAS 201 UL
Drawing number	MEC 5692.1
Commission	/

Project name	5692_1
Make	Matteuzzi Srl
Responsible for project	Matteuzzi Srl
Type	/
Place of installation	/

VOLTAGE =	480 Y / 277 VAC
PHASE =	3 + GND 4 WIRES
FREQUENCY =	60 Hz
TOTAL FLA =	6,22 A
LARGEST MOTOR FLA =	2,2 A
SCCR =	10KA RMS SYM AT 480V
MACHINE TYPE (ENVIRONMENT) =	1
ENCLOSURE TYPE =	12
FIELD WIRING DIAGRAM =	5692.1

INDUSTRIAL CONTROL PANEL FOR INDUSTRIAL MACHINERY
SHORT CIRCUIT CURRENT RATING OF THE PROTECTIVE DEVICE = 25KA

Created on	16/07/2020
Revision	Rev_00

0	1	2	3	4	5	6	7	8	9

IEC Sym.	JIC Sym.	Descrizione\Description
K	CR	RELAY COIL
Q	CON	CONTACTOR COIL
X	PL	PLUG
M	SOL	ELECTROMECHANICAL ACTUATOR
T	T	THREE PHASE TRANSFORMER
T	T	SINGLE PHASE TRANSFORMER
M 3~	MTR	THREE PHASE MOTOR
C	CAP	CAPACITOR
M	SOL	SOLENOID VALVE
R	RES	RESISTOR
E M 1AC	MTR MOT	ELECTROBLOWING FAN

IEC Sym.	JIC Sym.	Descrizione\Description
P	LT	LAMP
S	PB	PUSH BUTTON NO
S	PB	PUSH BUTTON NC
S	PB	EMERGENCY PUSH BUTTON NC
S	LS	LIMIT SWITCH NO (NOT OPERATED)
S	SS	TWO POSITION SWITCH
K	CR	RELAY NO CONTACT
K	CR	RELAY NC CONTACT
Q	CON	CONTACTOR NO CONTACT
Q	CON	CONTACTOR NC CONTACT
Q	CB	SINGLE POLE MAGNETIC THERMIC SWITCH

IEC Sym.	JIC Sym.	Descrizione\Description
Q	CB	TWO POLE MAGNETIC THERMIC SWITCH
Q	CB	THREE POLE MAGNETIC THERMIC SWITCH
F	FU	SINGLE POLE FUSE
F	FU	TWO POLE FUSE
F	FU	THREE POLE FUSE
B	PRS	PROXIMITY NO
B	PRS	PHOTOCELL NO
G AC 2~ AC =	PWS AC 2~ AC =	POWER SUPPLY
V	REC	BRIDGE DIODES

matteuzzi srl
Calderara di Reno
(BO) ITALY

REV.	MODIFY	DATE	SIGN

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: TABELLA CONVERSIONE SIMBOLI
SYMBOL CONVERSION TABLE

Plant: POWER AND AUXILIARY
RAS 201 UL

SHEET 2
NEXT 3

LISTA FOGLI \ INDEX

Foglio Sheet	Descrizione Description	Foglio Sheet	Descrizione Description
1	INTESTAZIONE / HEADING		
2	TABELLA CONVERSIONE SIMBOLI / SYMBOL CONVERSION TABLE		
3	LEGENDA FOGLI / LIST OF PAGES		
10	ARRIVO LINEA / POWER SUPPLY		
20	ALIMENTAZIONE 24VDC / SUPPLY 24VDC		
30	MOTORI PARTENZA DIRETTA / DIRECT START MOTOR		
31	MOTORI PARTENZA DIRETTA / DIRECT START MOTOR		
32	MOTORI PARTENZA DIRETTA / DIRECT START MOTOR		
41	INVERTER GRUPPO RULLATURA / STITCHING GROUP INVERTER		
70	AUSILIARI 24VDC / AUXILIARY 24VDC		
71	AUSILIARI 24VDC / AUXILIARY 24VDC		
90	CATENA EMERGENZA / EMERGENCY LINE		
91	EMERGENZA / EMERGENCY		
92	EMERGENZA / EMERGENCY		
95	SICUREZZA COMANDO A DUE MANI / BI-MANUAL COMMAND SAFETY DEVICE		
100	RACK PLC / PLC RACK		
110	INPUT DIGITALI / DIGITAL INPUTS		
111	INPUT DIGITALI / DIGITAL INPUTS		
112	INPUT DIGITALI / DIGITAL INPUTS		
130	OUTPUT DIGITALI / DIGITAL OUTPUTS		
131	OUTPUT DIGITALI / DIGITAL OUTPUTS		
800	MORSETTIERE XT0 E XT1 / TERMINALS XT0 E XT1		
801	MORSETTIERA XT2 / TERMINALS XT2		
900	LAYOUT QE RAS 201 UL / RAS 201 UL LAYOUT QE		
902	PANNELLO COMANDI / CONTROL PANEL LAYOUT		

Note :

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(BO) ITALY

REV.	MODIFY	DATE	SIGN

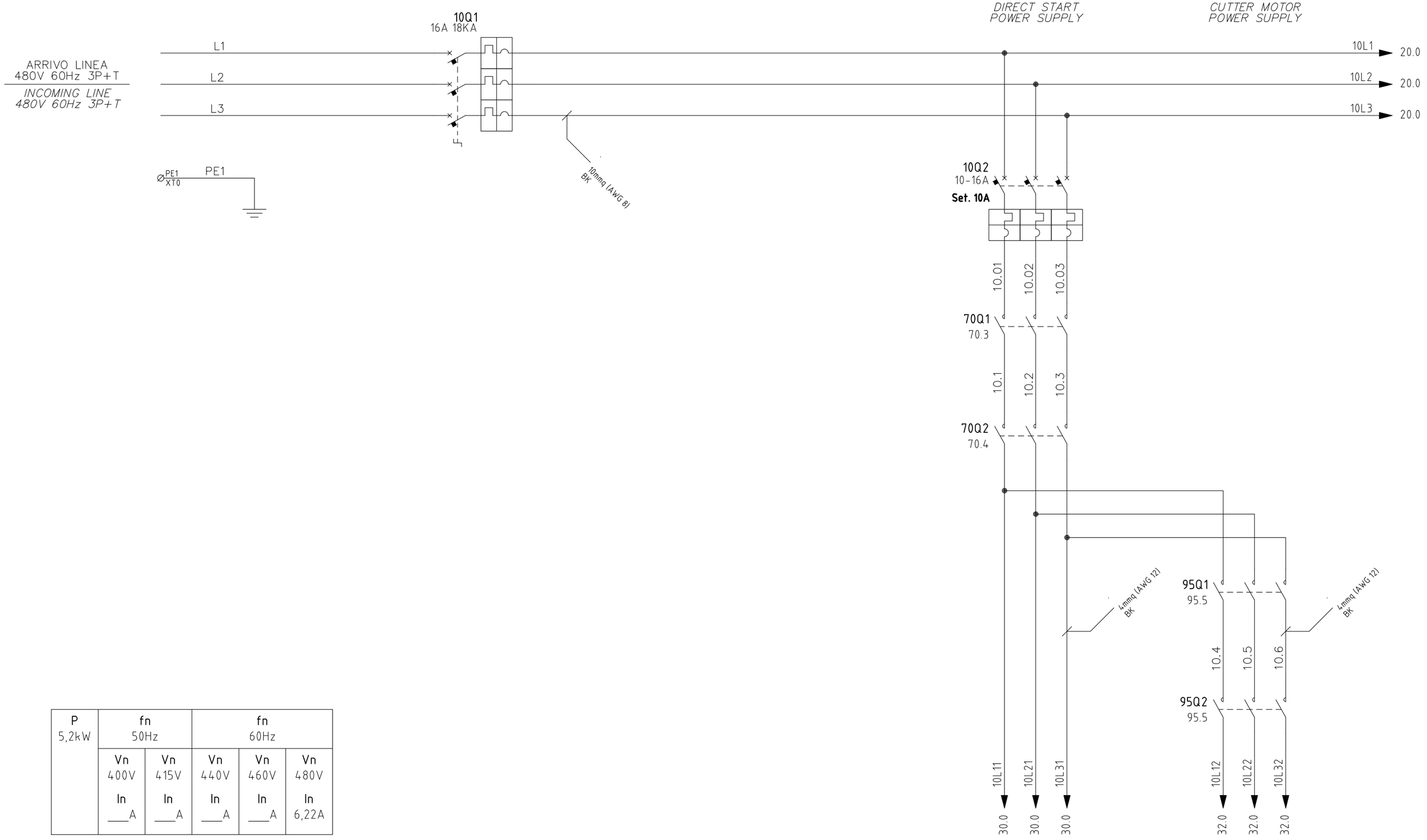
Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: LEGENDA FOGLI / *LIST OF PAGES*

Plant: *POWER AND AUXILIARY RAS 201 UL*

SHEET 3

NEXT 10



P	fn 50Hz		fn 60Hz		
	Vn 400V	Vn 415V	Vn 440V	Vn 460V	Vn 480V
5,2kW	In ___A	In ___A	In ___A	In ___A	In 6,22A

REV.	MODIFY	DATE	SIGN	

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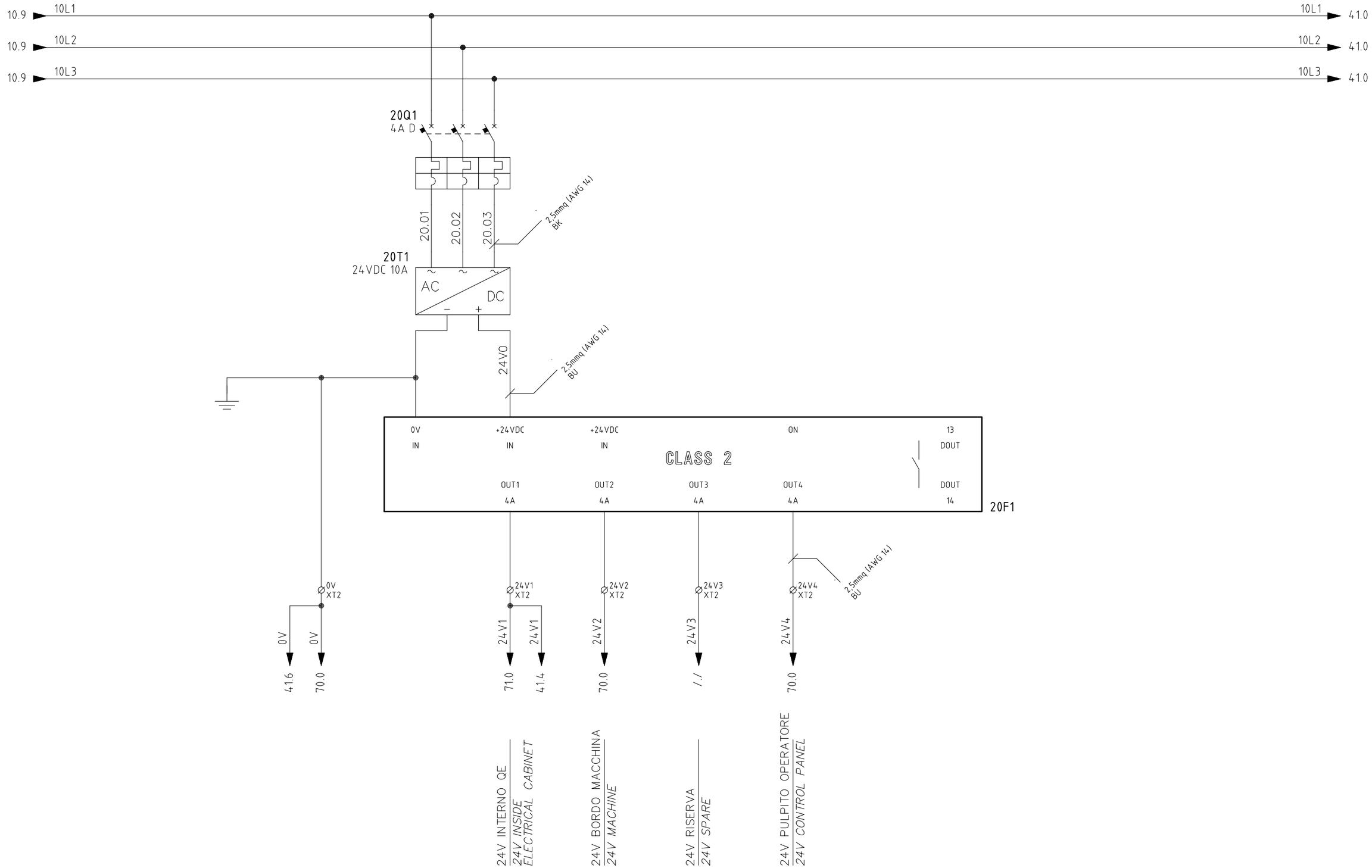
(BO) ITALY

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: ARRIVO LINEA / *POWER SUPPLY*
Plant: *POWER AND AUXILIARY RAS 201 UL*
SHEET 10
NEXT 20

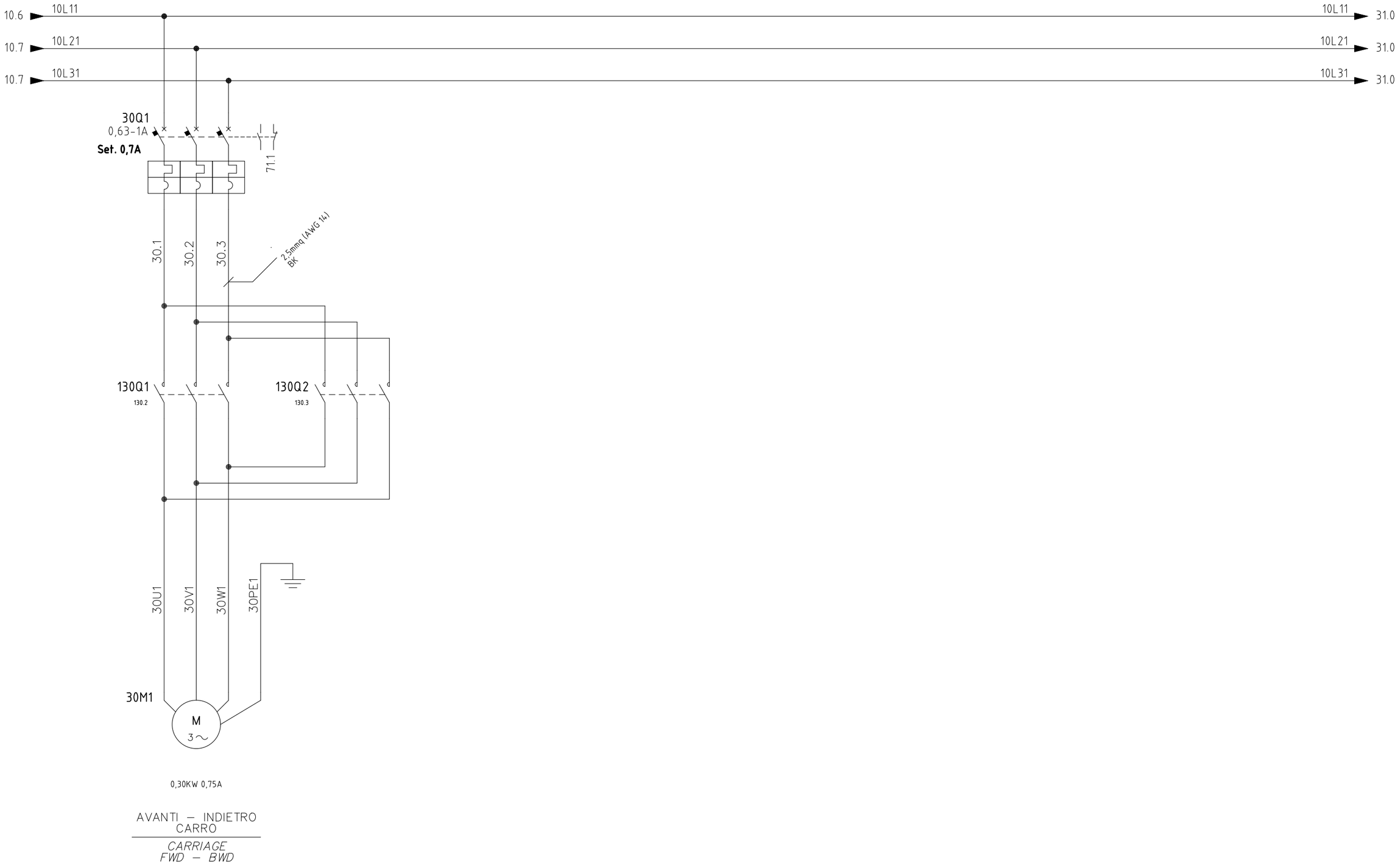


REV.	MODIFY	DATE	SIGN

matteuzzi srl
Calderara di Reno
(BO) ITALY

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: ALIMENTAZIONE 24VDC / *SUPPLY 24VDC*
Plant: *POWER AND AUXILIARY RAS 201 UL*
SHEET 20
NEXT 30



REV.	MODIFY		DATE	SIGN

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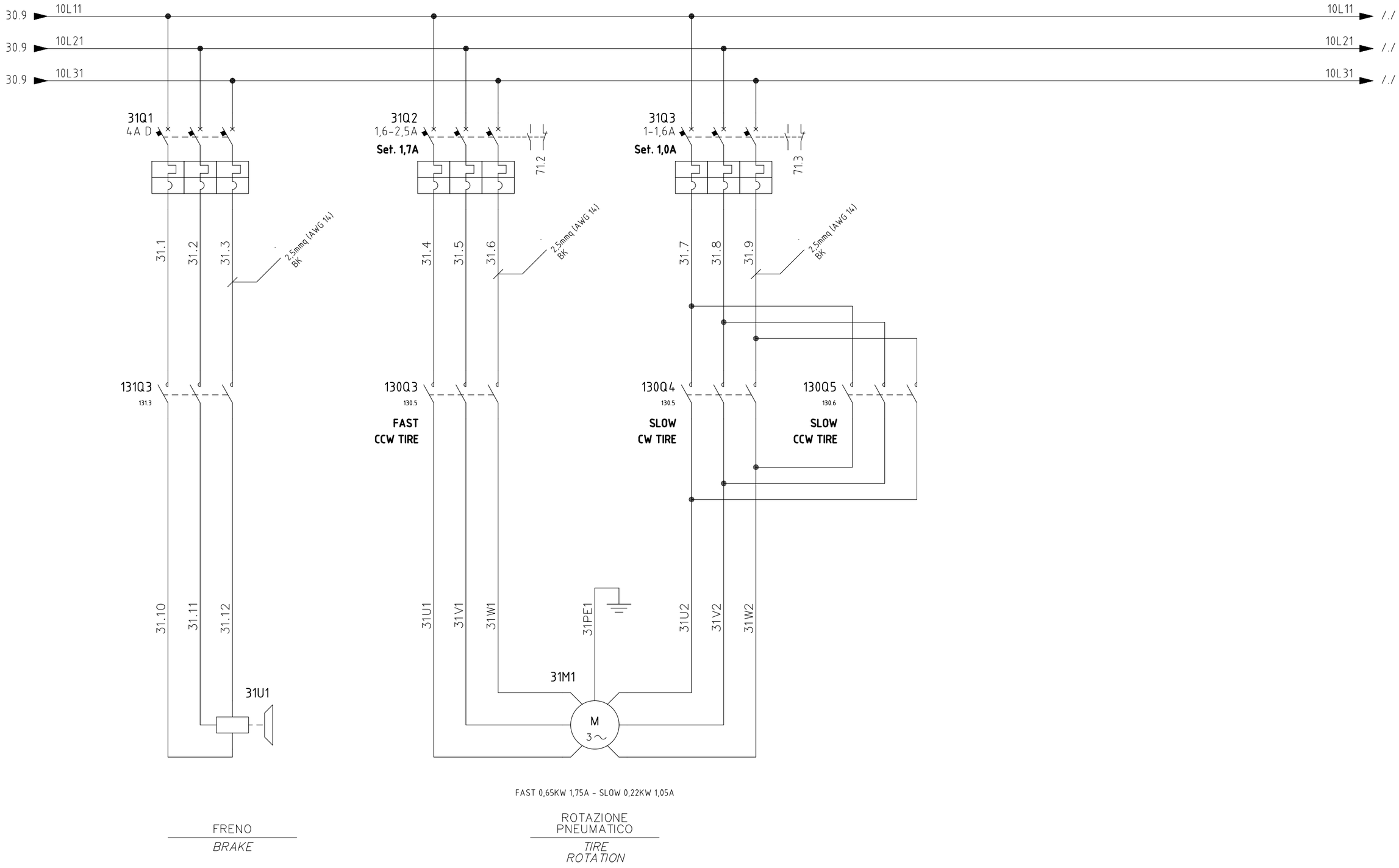
Calderara di Reno
(BO) ITALY

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: MOTORI PARTENZA DIRETTA / *DIRECT START MOTOR*
Plant: *POWER AND AUXILIARY RAS 201 UL*
SHEET 30
NEXT 31



REV.	MODIFY	DATE	SIGN	

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Calderara di Reno
(BO) ITALY

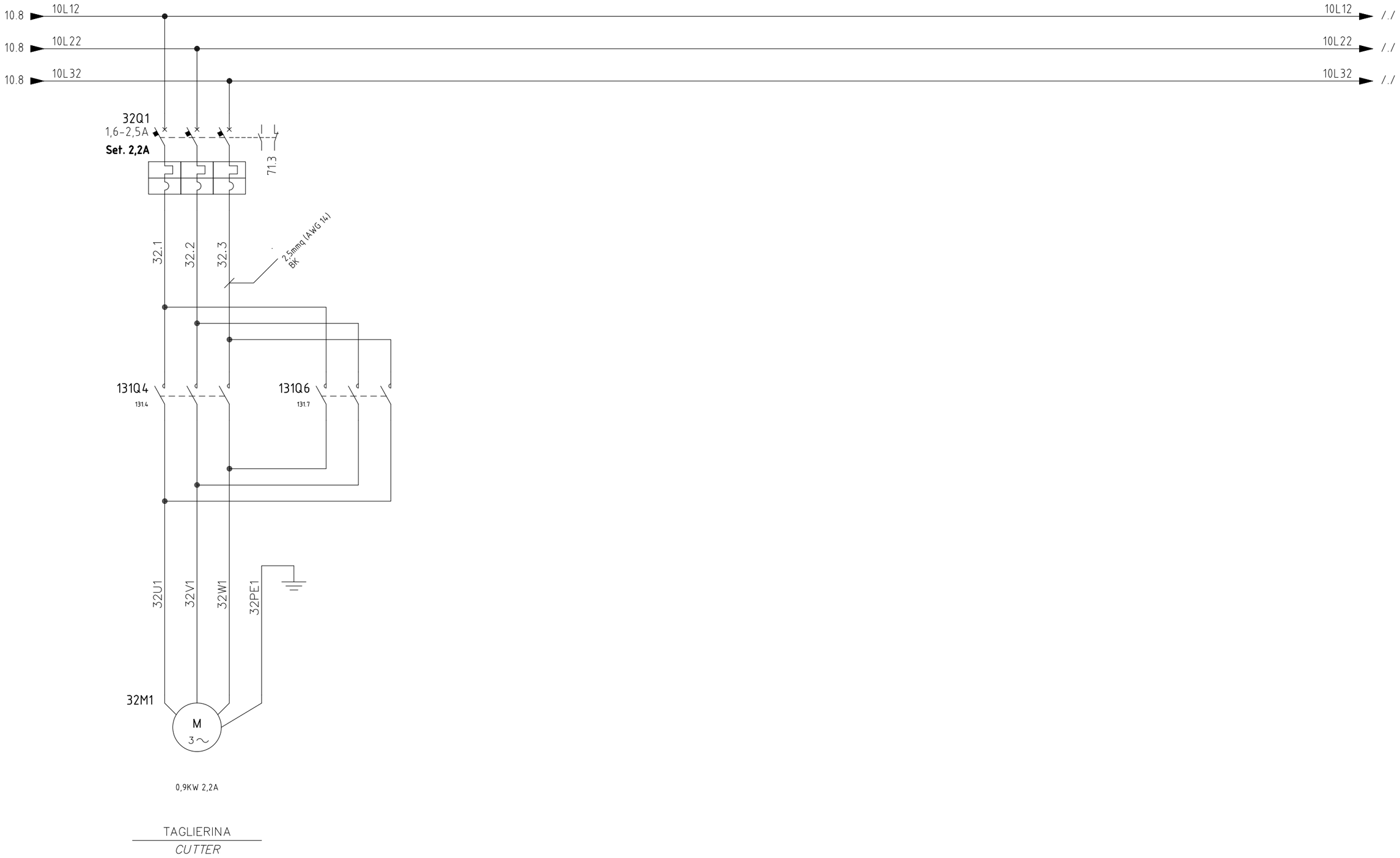
Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: MOTORI PARTENZA DIRETTA / *DIRECT START MOTOR*

Plant: *POWER AND AUXILIARY RAS 201 UL*

SHEET 31

NEXT 32



TAGLIERINA

CUTTER

matteuzzi srl

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(BO) ITALY

REV.	MODIFY	DATE	SIGN

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: MOTORI PARTENZA DIRETTA / *DIRECT START MOTOR*

Plant: *POWER AND AUXILIARY RAS 201 UL*

SHEET 32

NEXT 41

0	1	2	3	4	5	6	7	8	9

20.9 10L1 → 10L1 /./

20.9 10L2 → 10L2 /./

20.9 10L3 → 10L3 /./

41Q1
2,5-4A
Set. 2,5A

41.1 41.2 41.3

2,5mmq (AWG 14)
BK

PE L1 L2 L3
LINE

ALLEN BRADLEY - POWERFLEX 525 0,75KW

ETHERNET IP
IP 10.0.0.10

MOTOR: U V W

24V 01 | OPEN 02 | CLOSE 03 | FAST 05 | STITCH SPEED 06 | COM 04 | STO S1 | STO S2 | ETH 1 | ETH 2 | DOUT MA | DOUT MC | DOUT MB

41T1

41U1 41V1 41W1

41PE1

41M1

M
3~

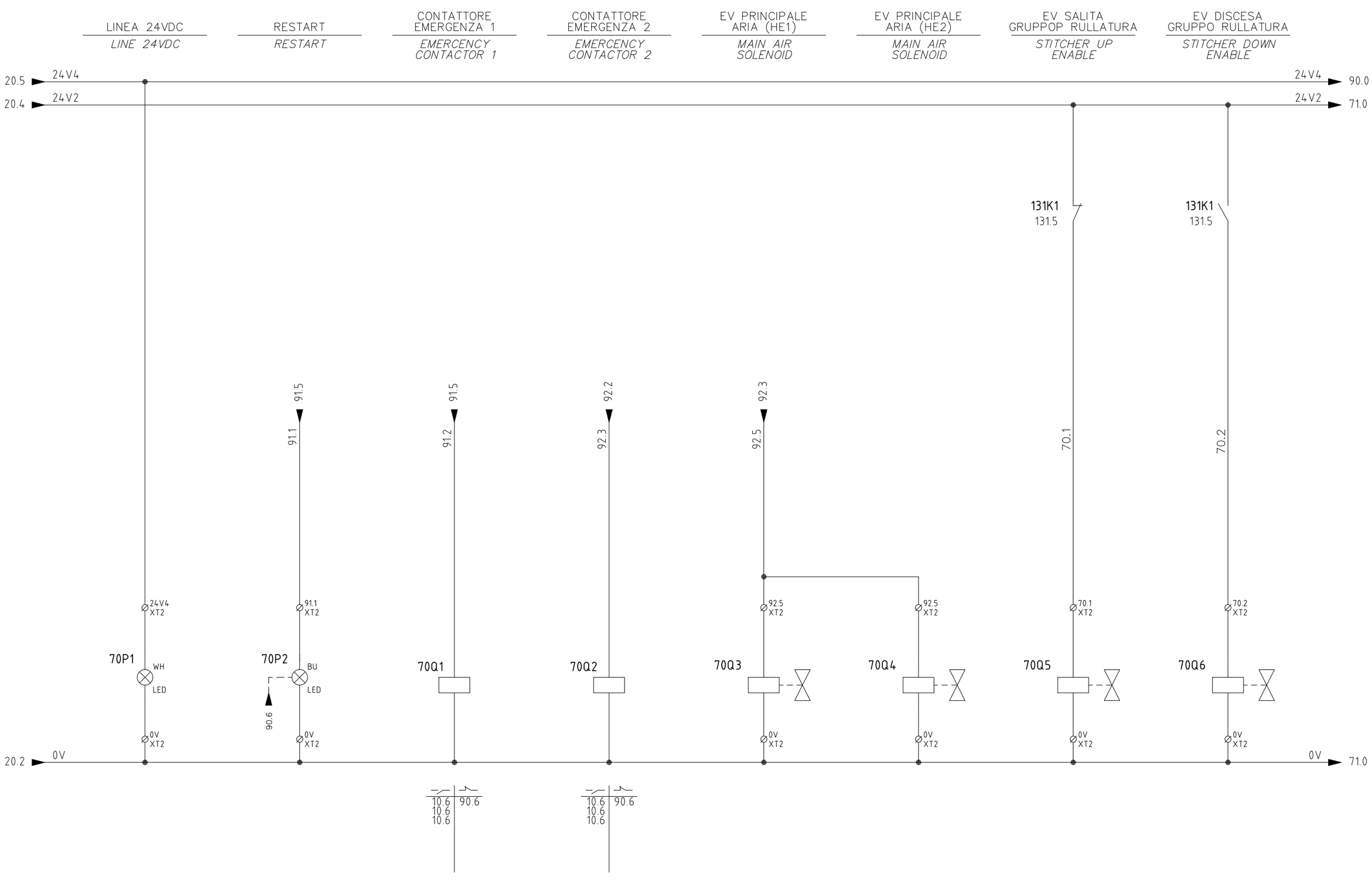
0,18KW 0,66A

24V1 → 20.3
00.2 → 130.3
00.3 → 130.4
01.4 → 131.5
0V → 20.2
92.10 → 92.6
92.11 → 92.7

GRUPPO
RULLATURA
STITCHING GROUP

matteuzzi srl Calderara di Reno (BO) ITALY							
				Drawn Matteuzzi	Job MEC 5692.1	Title INVERTER GRUPPO RULLATURA *STITCHING GROUP INVERTER*	SHEET 41
				Verified Matteuzzi	File Name 5692_1		
				Customer MATTEUZZI	Date 16/07/2020	Plant *POWER AND AUXILIARY RAS 201 UL*	NEXT 70
REV.	MODIFY	DATE	SIGN				

0	1	2	3	4	5	6	7	8	9



REV.	MODIFY	DATE	SIGN	

matteuzzi srl
Calderara di Reno
(BO) ITALY

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: AUSILIARI 24VDC
AUXILIARY 24VDC

Plant: *POWER AND AUXILIARY RAS 201 UL*

SHEET 70

NEXT 71

TERMICI SCATTATI
OVERLOAD TRIP

GRUPPO RULLATURA APERTO
STITCHER GROUP AT MAX OPEN POSITION

GRUPPO RULLATURA CILINDRO SINISTRO ALTO
STITCHER GROUP LH CYLINDER UP

GRUPPO RULLATURA CILINDRO DESTRO ALTO
STITCHER GROUP RH CYLINDER UP

70.9 24V2 → 92.0 24V2
20.3 24V1 → 91.0 24V1
70.9 0V → 91.0 0V

30Q1 (30.1) 31Q2 (31.3) 31Q3 (31.4) 32Q1 (32.1)

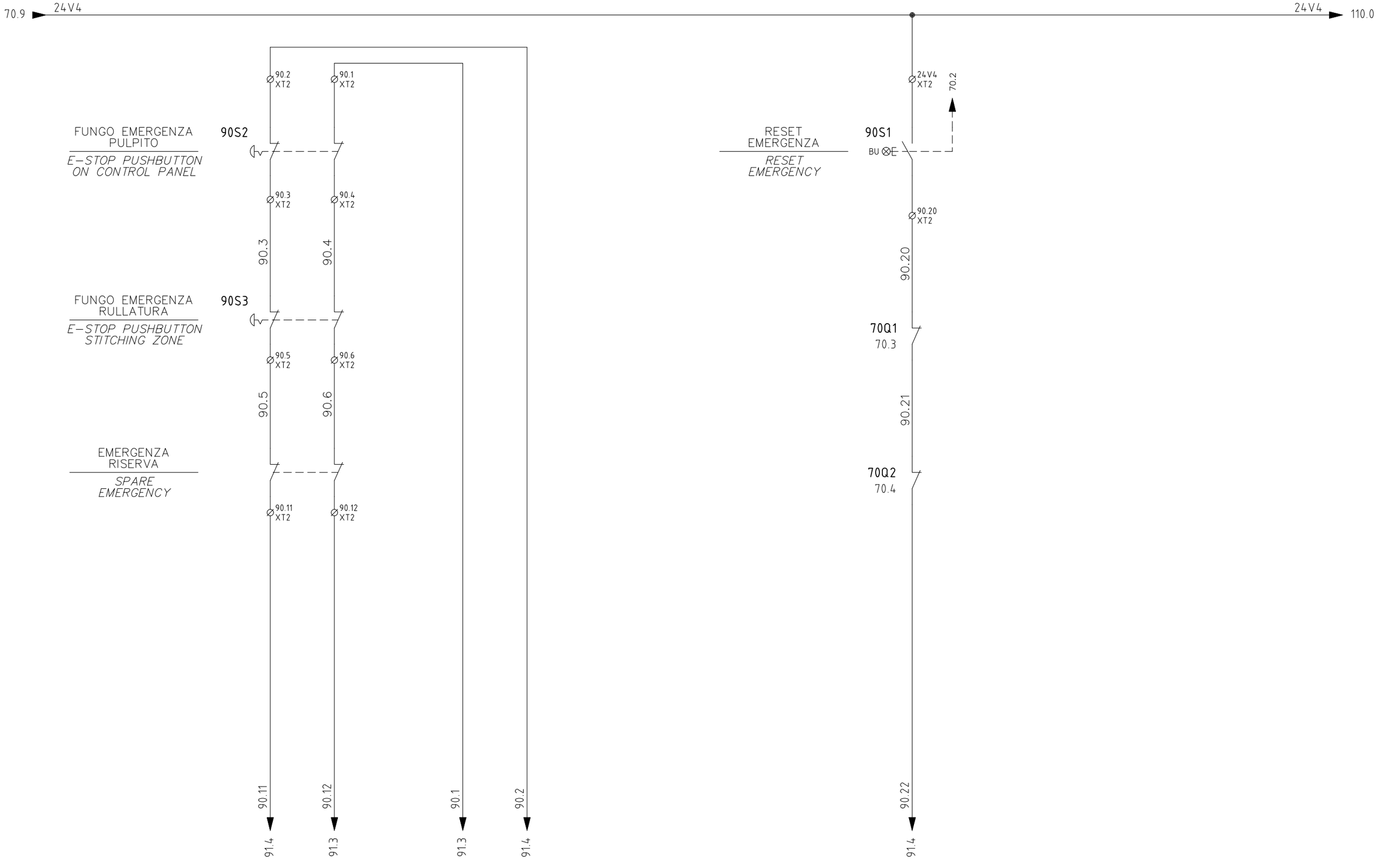
71B1 71B2 71B3 — Fe

24V2 XT2, 0V XT2, I1.6 XT2

I1.8 → 112.5

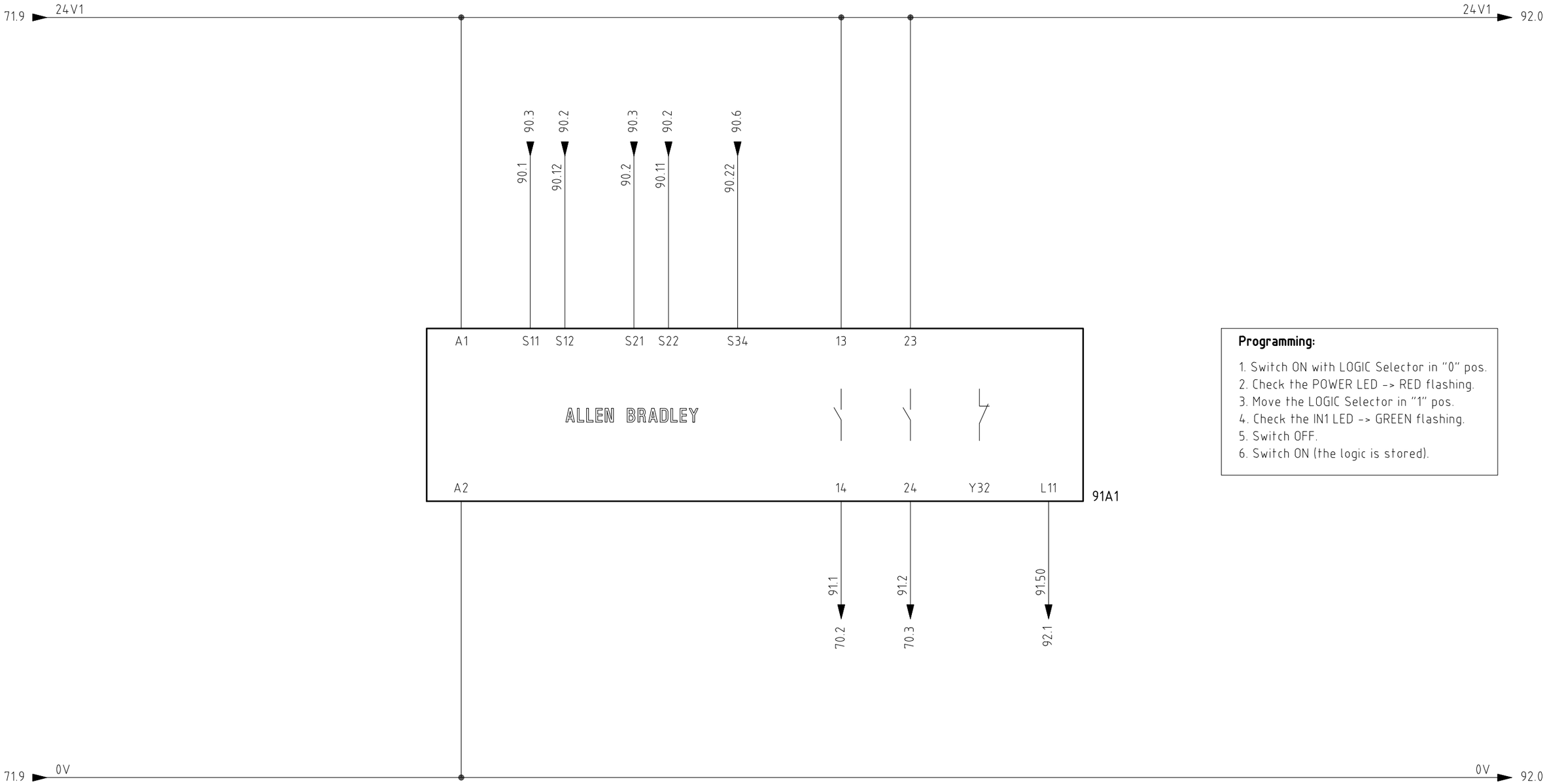
I1.6 → 112.4

matteuzzi srl Calderara di Reno (BO) ITALY					Drawn Matteuzzi	Job MEC 5692.1	Title AUSILIARI 24VDC *AUXILIARY 24VDC*	SHEET 71
					Verified Matteuzzi	File Name 5692_1		
					Customer MATTEUZZI	Date 16/07/2020	Plant *POWER AND AUXILIARY RAS 201 UL*	NEXT 90
	REV.	MODIFY	DATE	SIGN				



matteuzzi srl Calderara di Reno (BO) ITALY					Drawn	Matteuzzi	Job	MEC 5692.1
					Verified	Matteuzzi	File Name	5692_1
					Customer	MATTEUZZI	Date	16/07/2020
	REV.	MODIFY	DATE	SIGN				

Title	CATENA EMERGENZA *EMERGENCY LINE*	SHEET 90
Plant	*POWER AND AUXILIARY* *RAS 201 UL*	NEXT 91



Programming:

1. Switch ON with LOGIC Selector in "0" pos.
2. Check the POWER LED -> RED flashing.
3. Move the LOGIC Selector in "1" pos.
4. Check the IN1 LED -> GREEN flashing.
5. Switch OFF.
6. Switch ON (the logic is stored).

matteuzzi srl
Calderara di Reno
(BO) ITALY

REV.	MODIFY	DATE	SIGN

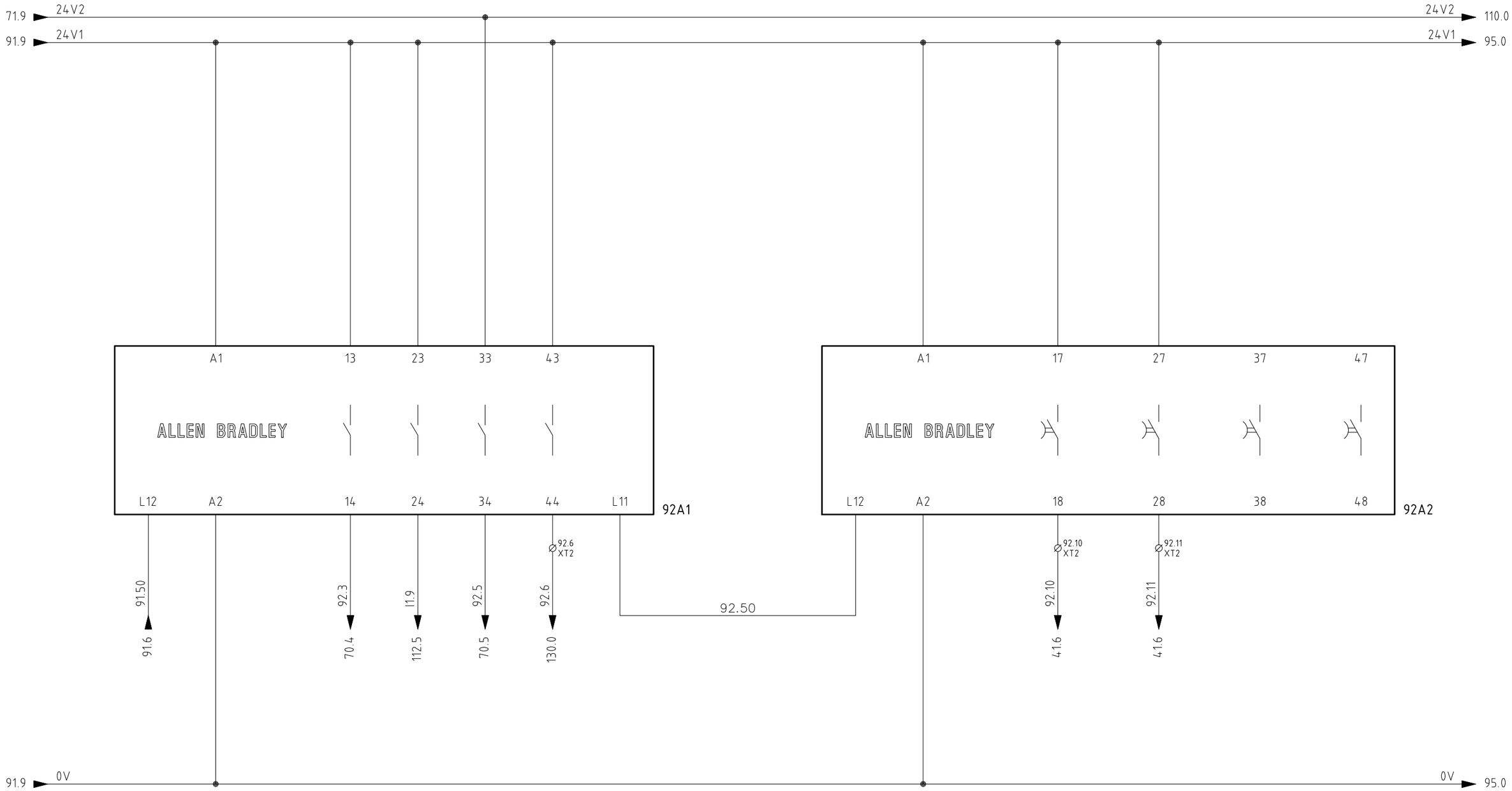
Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: EMERGENZA / *EMERGENCY*

Plant: *POWER AND AUXILIARY RAS 201 UL*

SHEET 91

NEXT 92



REV.	MODIFY	DATE	SIGN	

matteuzzi srl
Calderara di Reno
(BO) ITALY

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: EMERGENZA
EMERGENCY

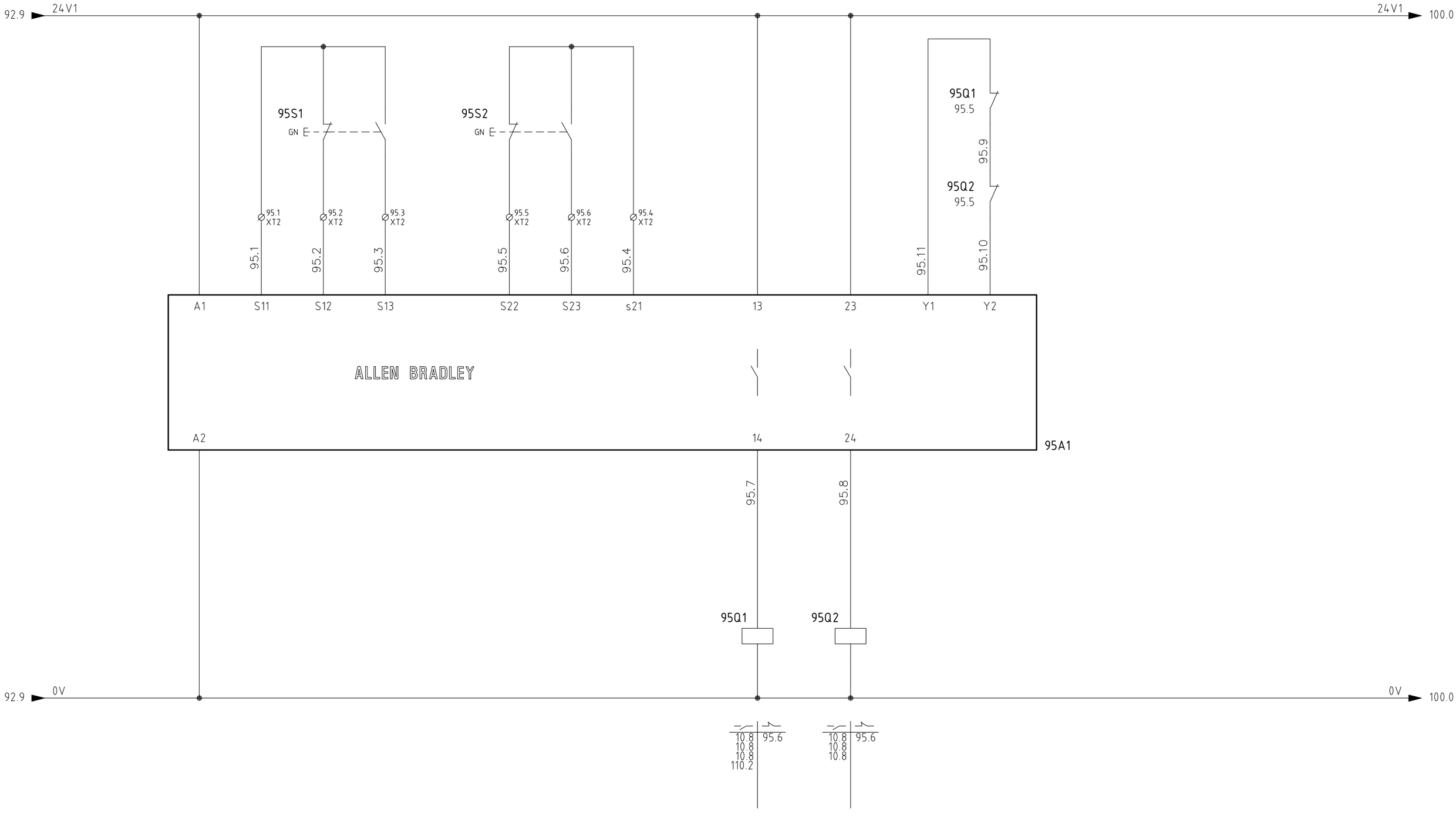
Plant: *POWER AND AUXILIARY*
RAS 201 UL

SHEET 92
NEXT 95

0	1	2	3	4	5	6	7	8	9

ABILITAZIONE
MOTORE LAMA

CUTTER MOTOR ENABLE



REV.	MODIFY	DATE	SIGN	

matteuzzi srl

Calderara di Reno
(BO) ITALY

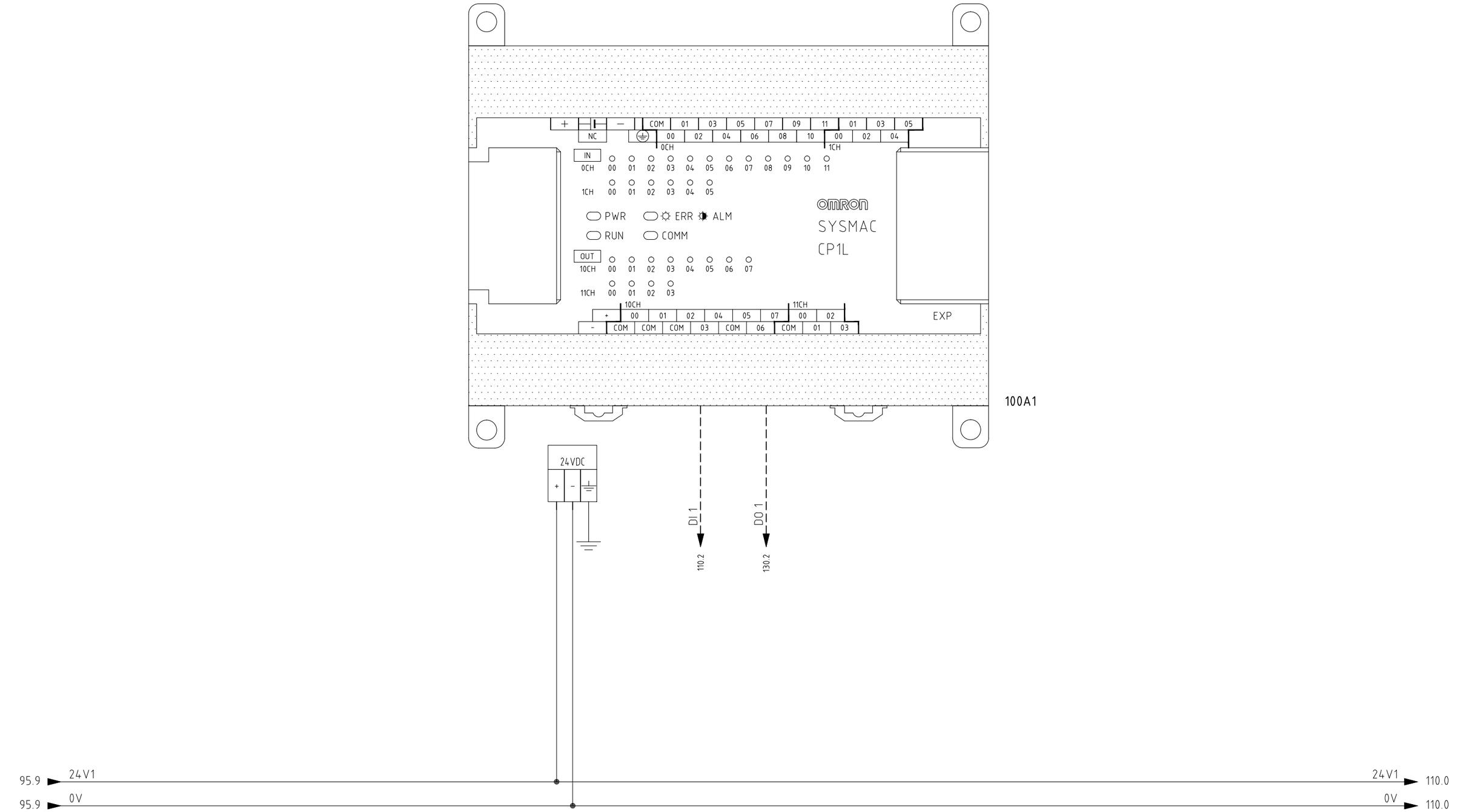
Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: SICUREZZA COMANDO A DUE MANI
BI-MANUAL COMMAND SAFETY DEVICE

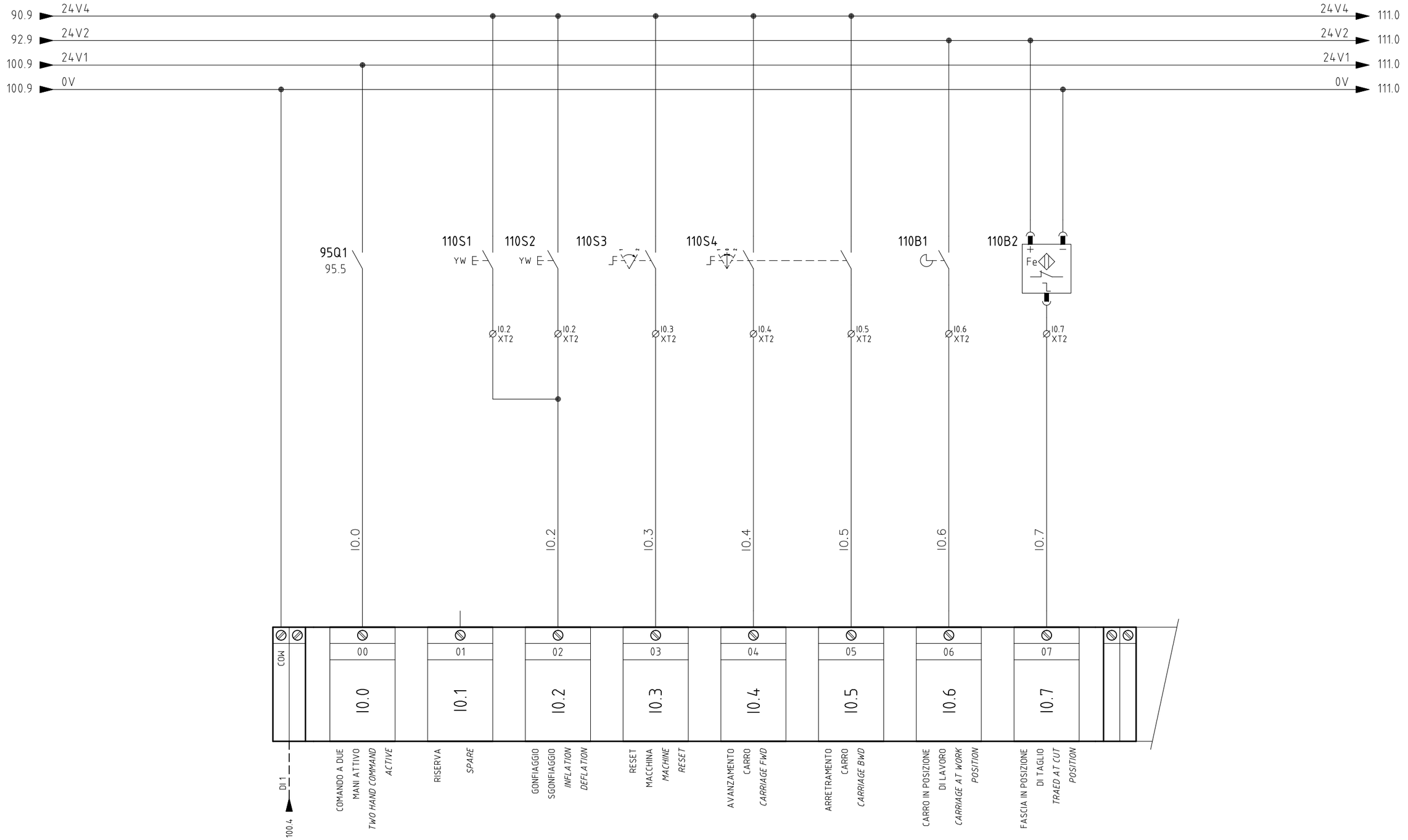
Plant: *POWER AND AUXILIARY RAS 201 UL*

SHEET 95

NEXT 100



matteuzzi srl Calderara di Reno (BO) ITALY					Drawn	Matteuzzi	Job	MEC 5692.1	Title: RACK PLC PLC RACK	SHEET 100
					Verified	Matteuzzi	File Name	5692_1		
					Customer	MATTEUZZI	Date	16/07/2020	Plant: PLC RAS 201 UL	NEXT 110
	REV.	MODIFY	DATE	SIGN						

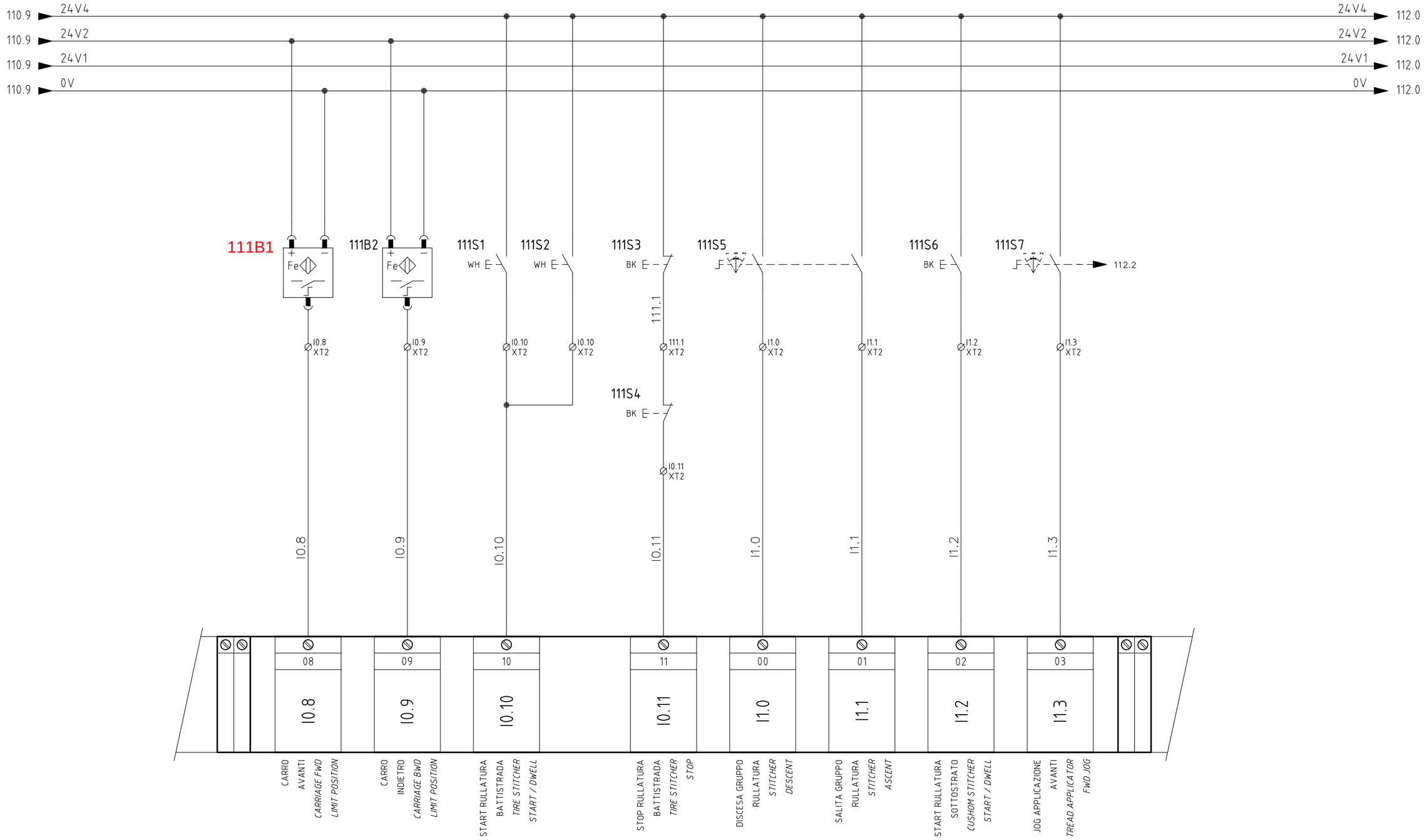


matteuzzi srl
Calderara di Reno
(BO) ITALY

REV.	MODIFY	DATE	SIGN

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: INPUT DIGITALI / *DIGITAL INPUTS*
Plant: *PLC RAS 201 UL*
SHEET 110
NEXT 111

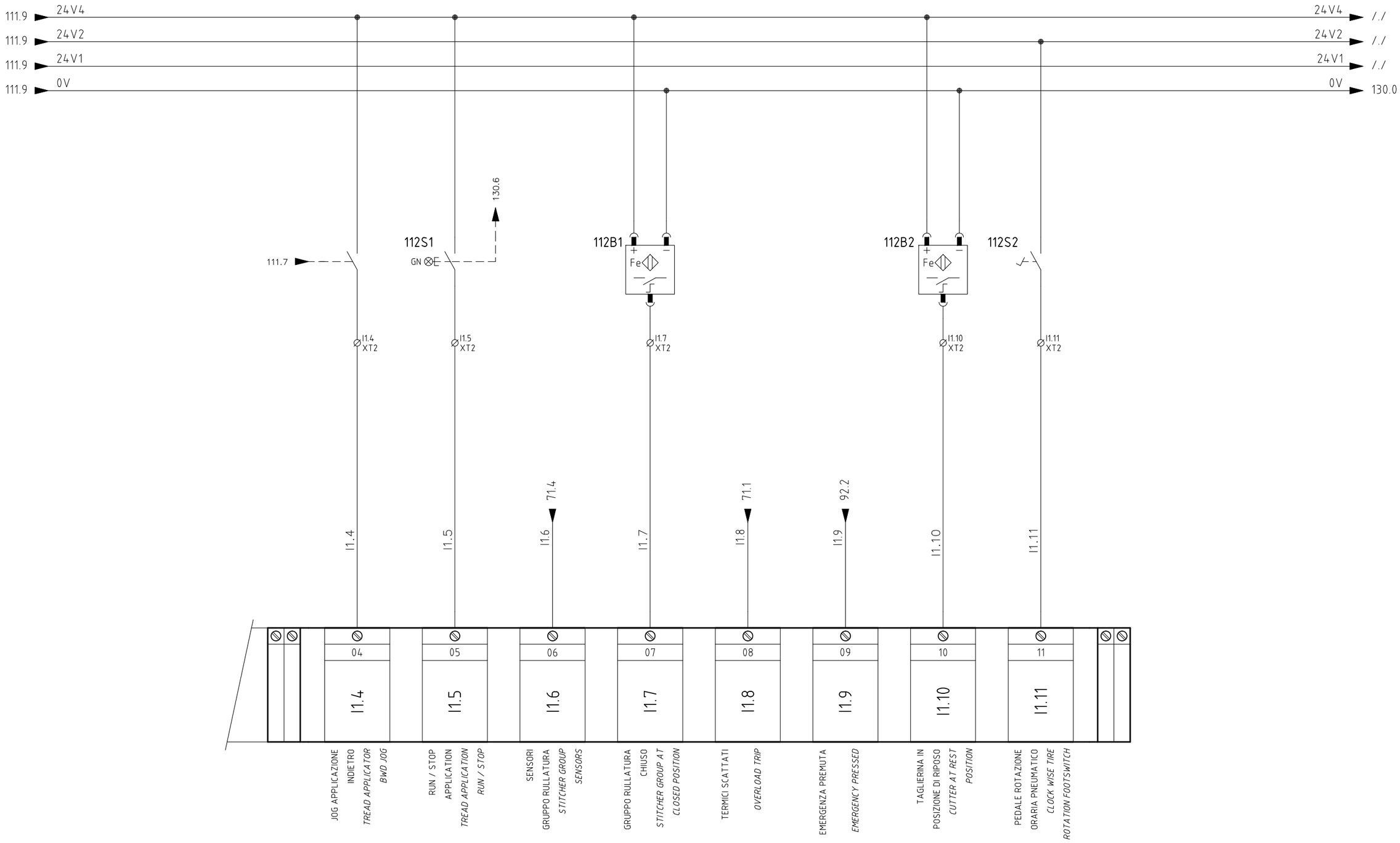


REV.	MODIFY	DATE	SIGN

matteuzzi srl
Calderara di Reno
(BO) ITALY

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: INPUT DIGITALI / *DIGITAL INPUTS*
Plant: *PLC RAS 201 UL*
SHEET 111
NEXT 112

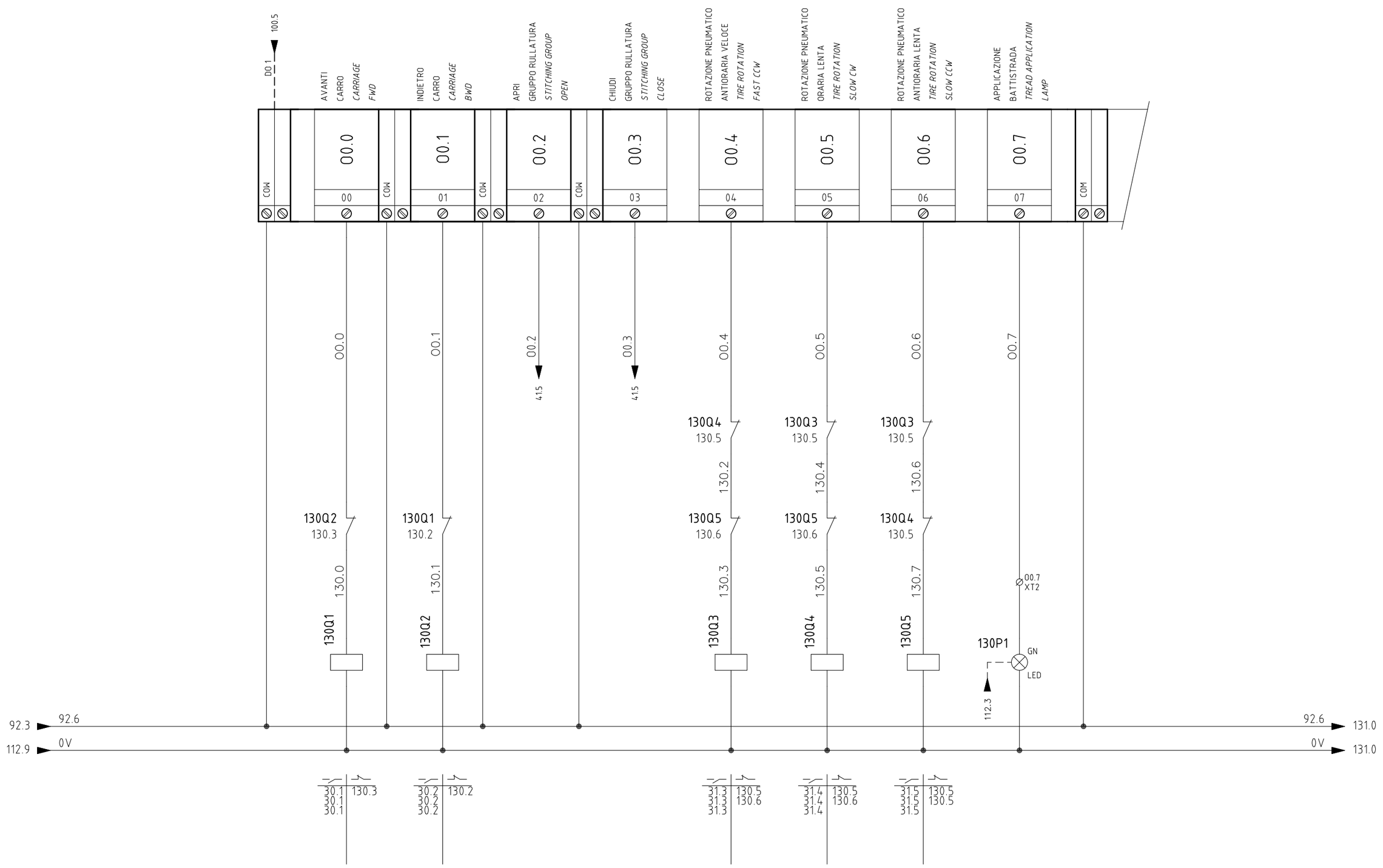


REV.	MODIFY	DATE	SIGN

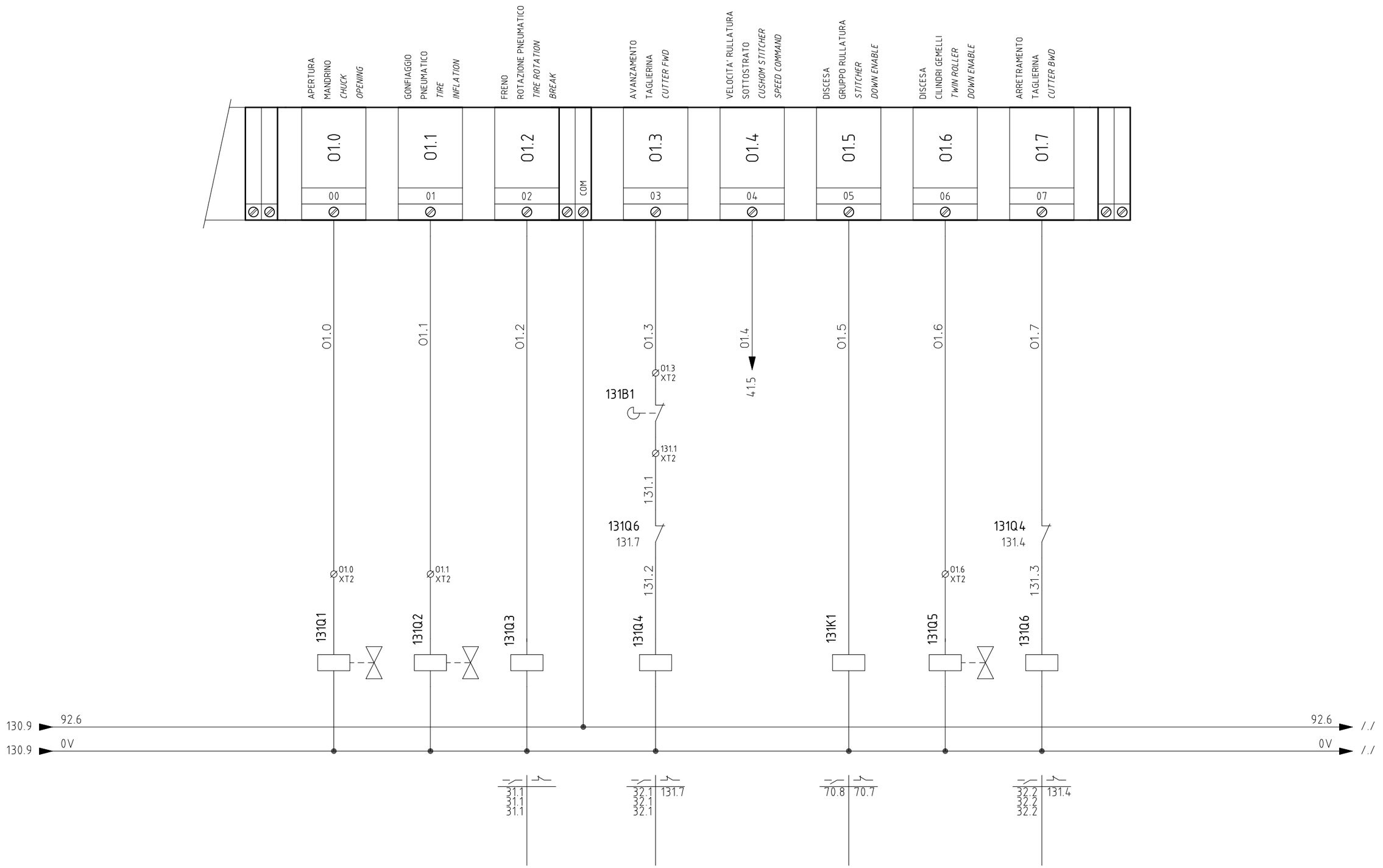
matteuzzi srl
Calderara di Reno
(BO) ITALY

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: INPUT DIGITALI / *DIGITAL INPUTS*
Plant: PLC RAS 201 UL
SHEET 112
NEXT 130



matteuzzi srl Calderara di Reno (BO) ITALY					Drawn	Matteuzzi	Job	MEC 5692.1	Title: OUTPUT DIGITALI / DIGITAL OUTPUTS	SHEET 130
					Verified	Matteuzzi	File Name	5692_1		
					Customer	MATTEUZZI	Date	16/07/2020	Plant: PLC RAS 201 UL	NEXT 131
	REV.	MODIFY	DATE	SIGN						

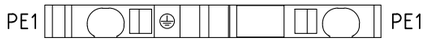


matteuzzi srl Calderara di Reno (BO) ITALY					Drawn	Matteuzzi	Job	MEC 5692.1	Title: OUTPUT DIGITALI / *DIGITAL OUTPUTS*	SHEET 131
					Verified	Matteuzzi	File Name	5692_1		
					Customer	MATTEUZZI	Date	16/07/2020	Plant: *PLC RAS 201 UL*	NEXT 800
	REV.	MODIFY	DATE	SIGN						

0	1	2	3	4	5	6	7	8	9

=QG - XT0

Morsettiera / Terminals XT0



REV.	MODIFY	DATE	SIGN

matteuzzi srl
Calderara di Reno
(BO) ITALY

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title: MORSETTIERE XT0 E XT1
TERMINALS XT0 E XT1

Plant: *TERMINALS AND LAYOUT*
RAS 201 UL

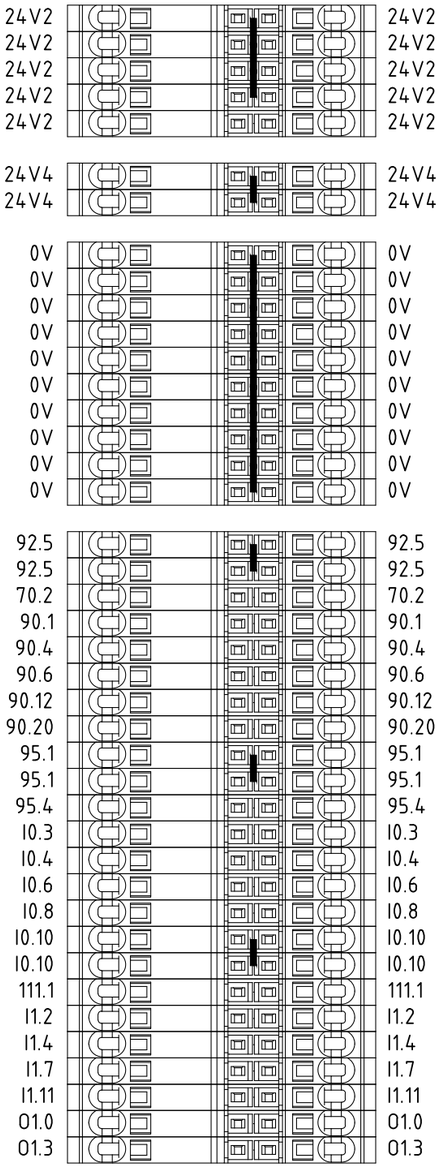
SHEET 800

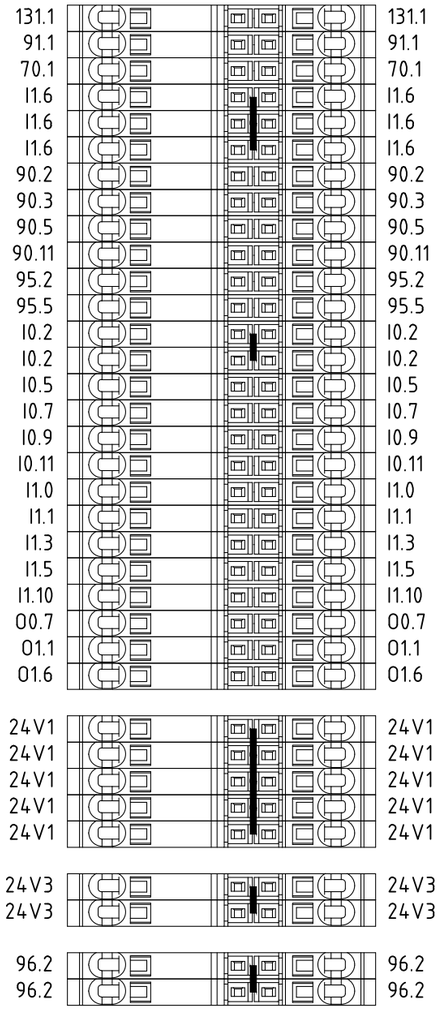
NEXT 801

0	1	2	3	4	5	6	7	8	9

=QG - XT2

Morsettiera XT2



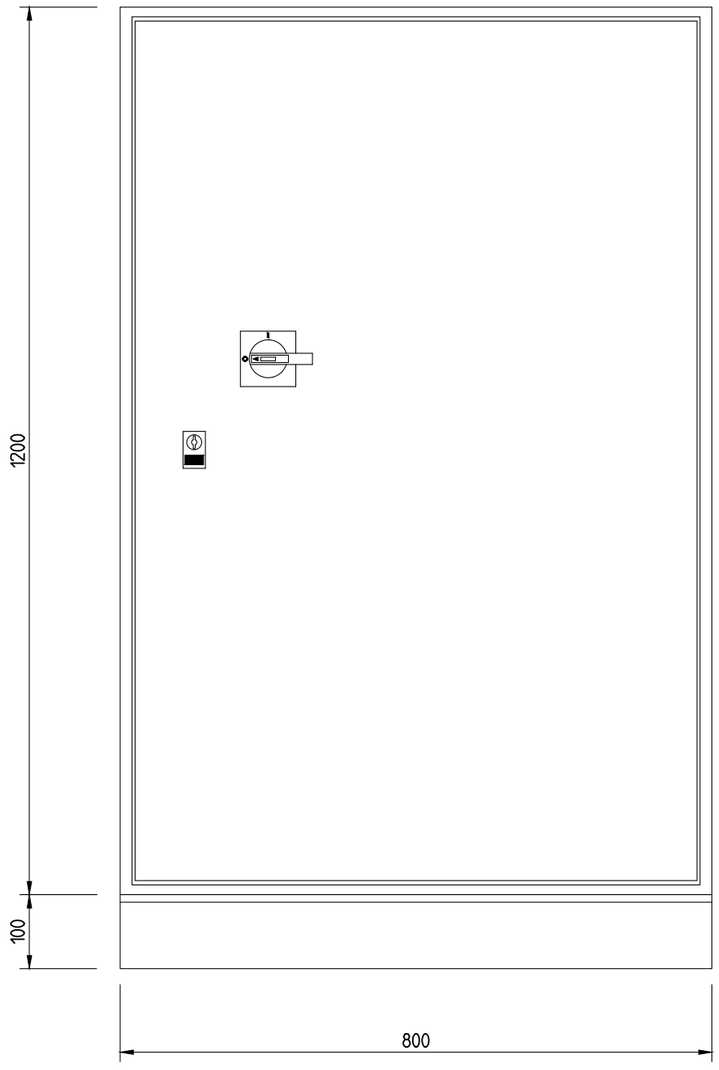


matteuzzi srl
Calderara di Reno
(BO) ITALY

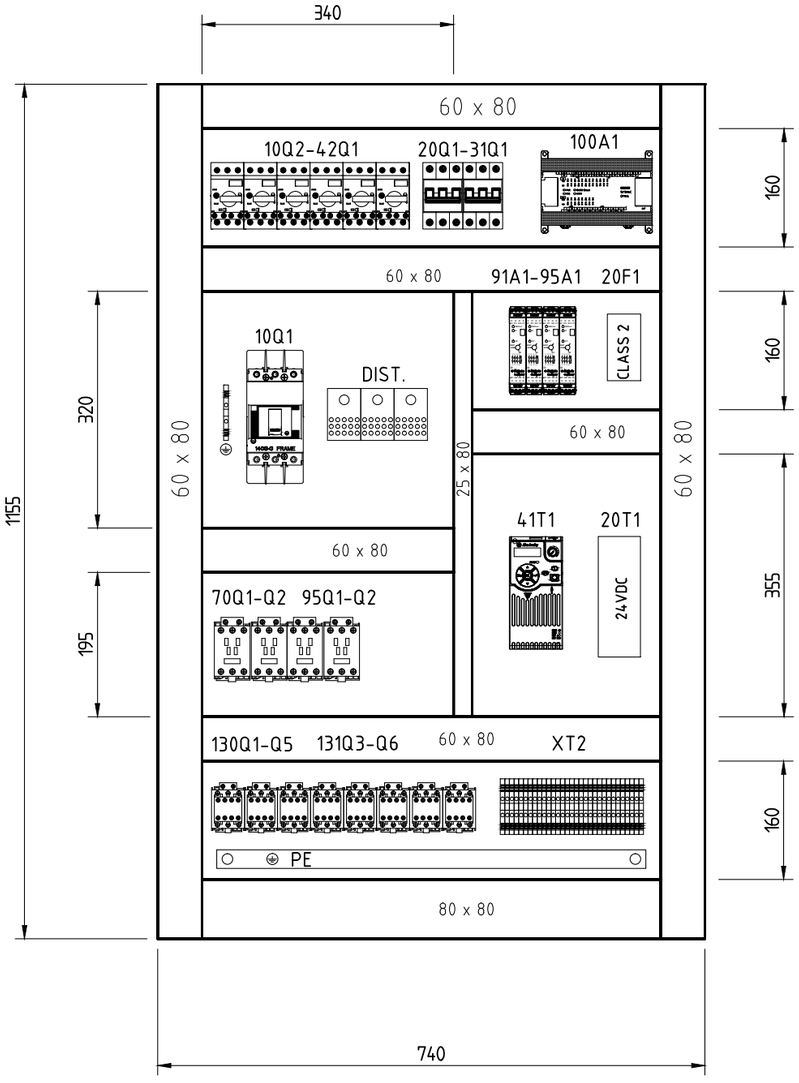
REV.	MODIFY	DATE	SIGN

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title	MORSETTIERA XT2 *TERMINALS XT2*	SHEET	801
Plant	*TERMINALS AND LAYOUT* *RAS 201 UL*	NEXT	900



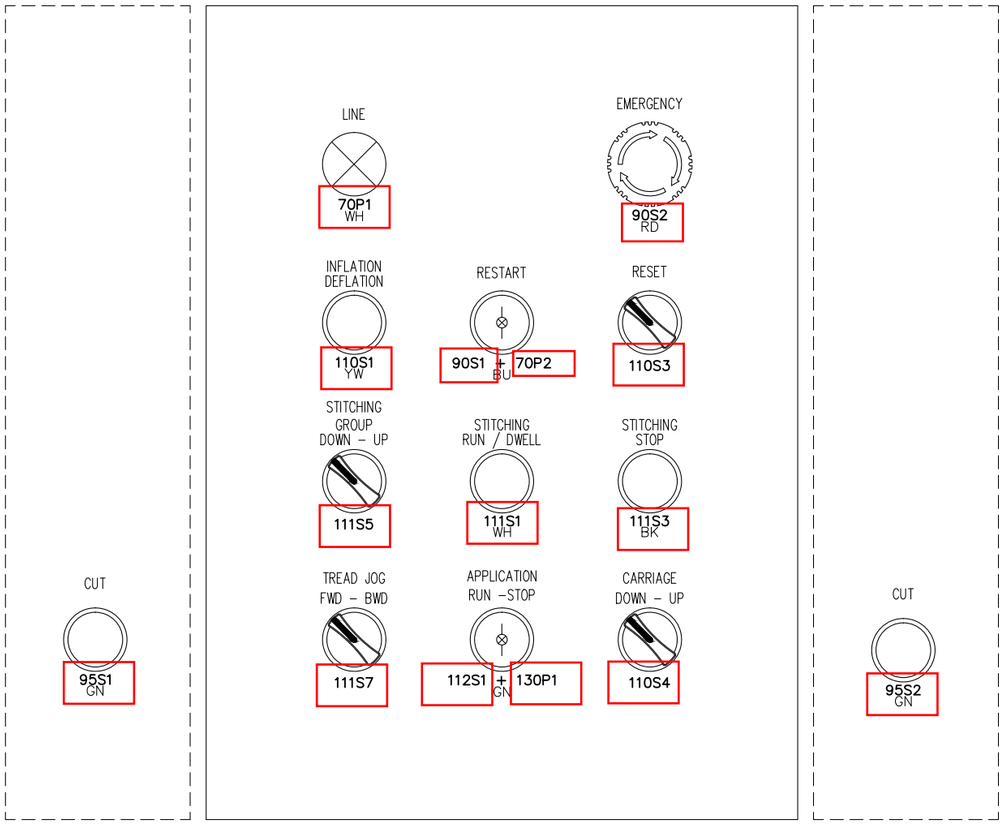
P=300



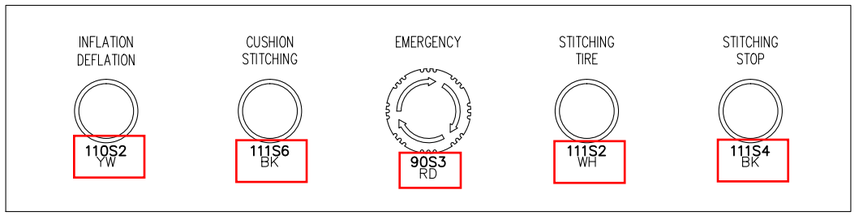
matteuzzi srl Calderara di Reno (BO) ITALY					Drawn	Matteuzzi	Job	MEC 5692.1	Title: LAYOUT QE RAS 201 UL RAS 201 UL LAYOUT QE	SHEET 900
					Verified	Matteuzzi	File Name	5692_1		
					Customer	MATTEUZZI	Date	16/07/2020	Plant: TERMINALS AND LAYOUT RAS 201 UL	NEXT 902
	REV.	MODIFY	DATE	SIGN						

0	1	2	3	4	5	6	7	8	9

BUILDING ZONE CONTROL PANEL



STITCHING ZONE CONTROL PANEL



matteuzzi srl
Calderara di Reno
(BO) ITALY

REV.	MODIFY	DATE	SIGN

Drawn	Matteuzzi	Job	MEC 5692.1
Verified	Matteuzzi	File Name	5692_1
Customer	MATTEUZZI	Date	16/07/2020

Title	PANNELLO COMANDI *CONTROL PANEL LAYOUT*	SHEET	902
Plant	*TERMINALS AND LAYOUT* *RAS 201 UL*	NEXT	/

ALLEGATO – ANNEX – ANNEXE – ANHANG – ANEXO 3

lista dei componenti e schema pneumatico

pneumatic part list and diagram

description des composants et schéma pneumatique

Pneumatikteile-Liste und pneumatischer Schaltplan

lista de los componentes y esquema neumático

SCHEMA PNEUMATICO – PNEUMATIC DIAGRAM
SCHEMA PNEUMATIQUE – PNEUMATISCHER SCHALTPLAN
ESQUEMA NEUMÁTICO

6617.06

AIR SUPPLY

TYRE OPERATING INFLATION

VALVE ASSEMBLY

HUB INFLATION

STITCHING TWIN ROLLERS

STITCHING GROUP

POLY REMOVAL

SCHEMA PNEUMATICO – PNEUMATIC DIAGRAM
SCHEMA PNEUMATIQUE – PNEUMATISCHER SCHALTPLAN
ESQUEMA NEUMÁTICO

6617.06

LIFT

TREAD PRESSER

SCHEMA PNEUMATICO – PNEUMATIC DIAGRAM
SCHEMA PNEUMATIQUE – PNEUMATISCHER SCHALTPLAN
ESQUEMA NEUMÁTICO

6617.06

AIR SUPPLY			
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Cant. Menge
12	24227.0	INTERMEDIATE FLANGE, FR+L 3/8"	1
13	23226.0	PRESSURE GAUGE, 50 1/8" POST. 0-12	1
30	24485.0	LOCKABLE INLET VALVE 3/8" STAMPOTECNICA 050-25-V3	1
31	23346.0	FILTEREGULATOR. 3/8" STAMPOTECNICA	1
29	22932.0	CHECK VALVE 1/2”	1

TYRE OPERATING INFLATION			
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Cant. Menge
14	24604.0	PRESSURE REGULATOR, 3/8" 0-4BAR	1
15	20575.0	PRESSURE GAUGE, D.50 1/8" POST.0-6 BAR	1
20	22255.0	QUICK EXHAUSTER, VSR 1/2"	1
8	27264.0	SOLENOID VALVE NORGREN V62C423A-A2000	1
9	26748-0	COIL NORGREN QM/48/13J/21 24VDC	1
11	21567-0	CONNECTOR 10/50V. ART. S02209TC421	1
21	20646.2	SAFETY VALVE 1/4" SET TO 2,5BAR ART. 200C02.5	1

VALVE ASSEMBLY			
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Cant. Menge
3	35007.0	MANIFOLD, FIBO, 4 SLOTS, FOR VALVE NORGREN V60 ART.FFV1992	1
4	35008.0	PLATE FOR MANIFOLD FIBO ART.FFV1316	1

SCHEMA PNEUMATICO – PNEUMATIC DIAGRAM
SCHEMA PNEUMATIQUE – PNEUMATISCHER SCHALTPLAN
ESQUEMA NEUMÁTICO

6617.06

HUB INFLATION			
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Cant. Menge
6	27265.0	SOLENOID VALVE, NORGREN V60A517A-A2000	1
7	26748-0	COIL NORGREN QM/48/13J/21 24VDC	1
10	21567-0	CONNECTOR 10/50V. ART. S02209TC421	1

STITCHING TWIN ROLLERS			
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Cant. Menge
1	27265.0	SOLENOID VALVE, NORGREN V60A517A-A2000	1
17	21199.0	PRESSURE GAUGE, D.40 1/8" 0-6BAR	1
22	29051.0	CYLINDER, FESTO COMPACT D.40X80 ADN-40-80-IPA	2
5	26748-0	COIL NORGREN QM/48/13J/21 24VDC	1
10	21567-0	CONNECTOR 10/50V. ART. S02209TC421	1
16	20573.0	REGULATOR 1/4" STAMPOTECNICA 0-8BAR	1
19	20655-0	QUICK EXHAUST ART. VSC544 1/4"	1

STITCHING GROUP			
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Cant. Menge
2	27266.0	SOLENOID VALVE, NORGREN V60A611A-A2000	1
23	29049.0	CYLINDER, ISO FESTO D.80X150 DNCB-80-150PPV-A	1
16	20573.0	PRESSURE REGULATOR, 1/4" STAMPOTECNICA 0-8BAR	1
17	21199.0	PRESSURE GAUGE, D.40 1/8" 0-6BAR	1
-	22485-0	ROD EYE, FEMALE, R. H. FITMENT M20X1,5	1
-	23712-0	HING, MALE ISO D.80	1
-	22146-0	FLOW REGULATOR, 90° FITMENT, G 3/8 – T8	1
5	26748-0	COIL NORGREN QM/48/13J/21 24VDC	2
10	21567-0	CONNECTOR 10/50V. ART. S02209TC421	2
19	20655-0	QUICK EXHAUST ART. VSR 1/4"	1
28	20525.0	FLOW REGULATOR DIRFU14/0	1

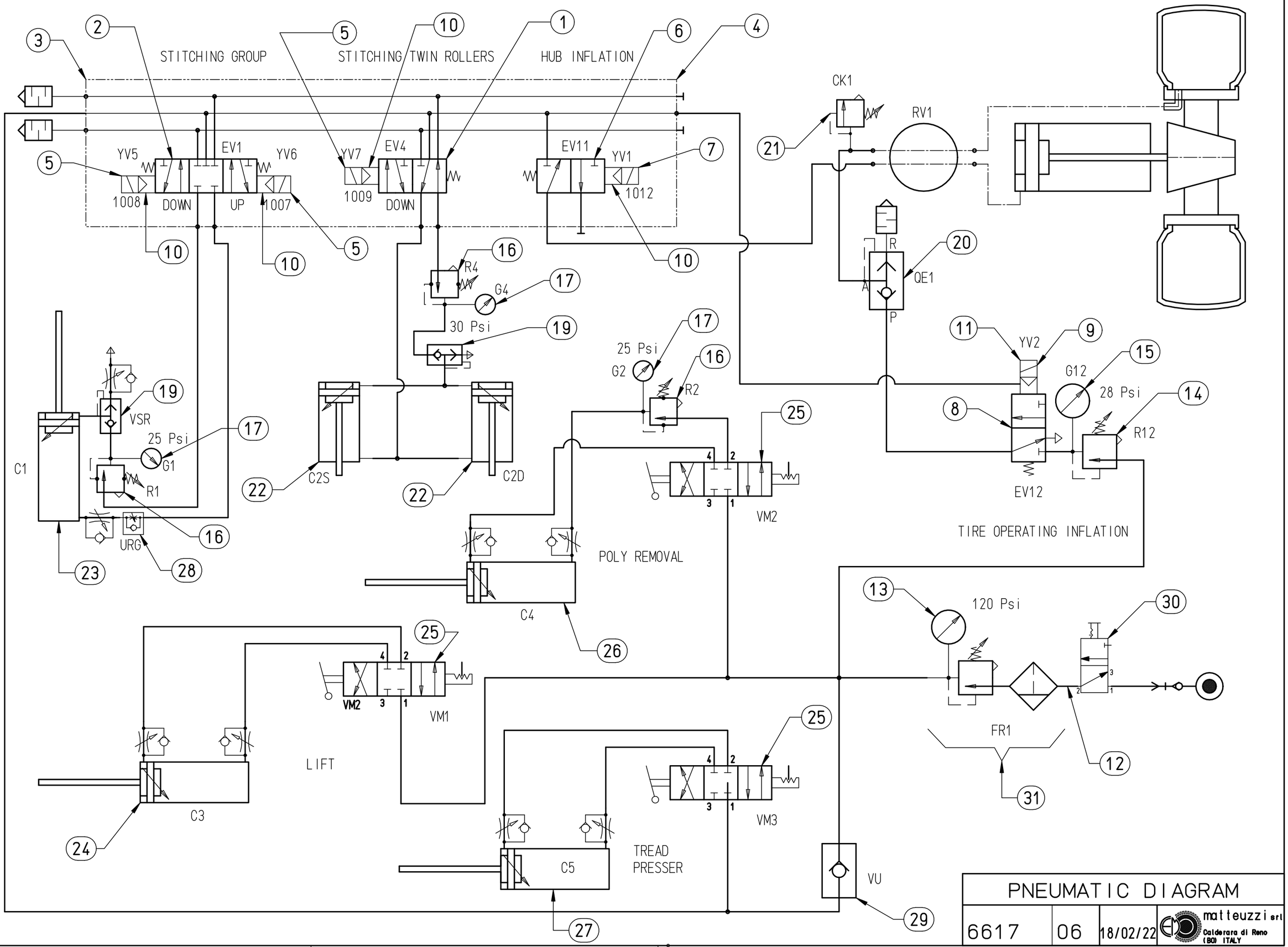
SCHEMA PNEUMATICO – PNEUMATIC DIAGRAM
SCHEMA PNEUMATIQUE – PNEUMATISCHER SCHALTPLAN
ESQUEMA NEUMÁTICO

6617.06

POLY REMOVAL			
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Cant. Menge
25	20538.0	PNEUMATIC CONTROL, 1/8" 4001 I	1
26	29050.0	CYLINDER, ISO FESTO D.32X50 DNCB-32-50PPV-A	1
16	20573.0	REGULATOR 1/4" STAMPOTECNICA 0-8BAR	1
17	21199.0	PRESSURE GAUGE, D.40 1/8" 0-6BAR	1
18	23183.0	FEMALE HINGE W/PIN D.32	1

LIFT			
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Cant. Menge
24	30797.0	CYLINDER, ISO FESTO D.80X300 DSBC-80-300-PPSA-N3 ART.2126641	1
25	20538.0	PNEUMATIC CONTROL, 1/8" 4001 I	1
-	23175-0	FEMALE HINGE W/PIN D.80	1

TREAD PRESSER			
rif. ref. rep.	**Descrizione – Description – Beschreibung – Descripción**		Q.tà Q.ty Q.tè Cant. Menge
25	20538.0	PNEUMATIC CONTROL, 1/8" 4001 I	1
27	30558-0	CYLINDER ISO FESTO D.40X25 DNCB-40-25-PPV-A ART.532737	1
-	24378-2	CYLINDER HINGE, MALE FITMENT, ISO D.40 CAMOZZI ART.R41-40	1


STITCHING GROUP
STITCHING TWIN ROLLERS
HUB INFLATION
YV5
EV1
YV6
1008
DOWN
UP
1007
YV7
EV4
1009
DOWN
EV11
YV1
1012
CK1
RV1
R
A
P
QE1
R4
G4
30 Psi
25 Psi
G2
R2
VSR
25 Psi
G1
R1
URG
C1
C2S
C2D
YV2
G12
28 Psi
R12
EV12
TIRE OPERATING INFLATION
POLY REMOVAL
C4
VM2
VM1
VM3
LIFT
C3
C5
TREAD
PRESSER
VU
120 Psi
FR1
PNEUMATIC DIAGRAM
6617
06
18/02/22
matteuzzi srl
Calderara di Reno
(BO) ITALY

RAS 201 BUILDER

PRECURED TREAD BUILDING AND STITCHING MACHINE FOR TRUCK TYRES

ANNEXES 1, 2, 3

to OPERATION AND MAINTENANCE MANUAL

since 1956 matteuzzi

MACCHINE PER PNEUMATICI E PER I PROCESSI DI RICOSTRUZIONE
EQUIPMENT FOR THE TYRE AND RETREADING INDUSTRIES

matteuzzi srl
Via Serra 1/E - 3
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Fax +39 - 051726283
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