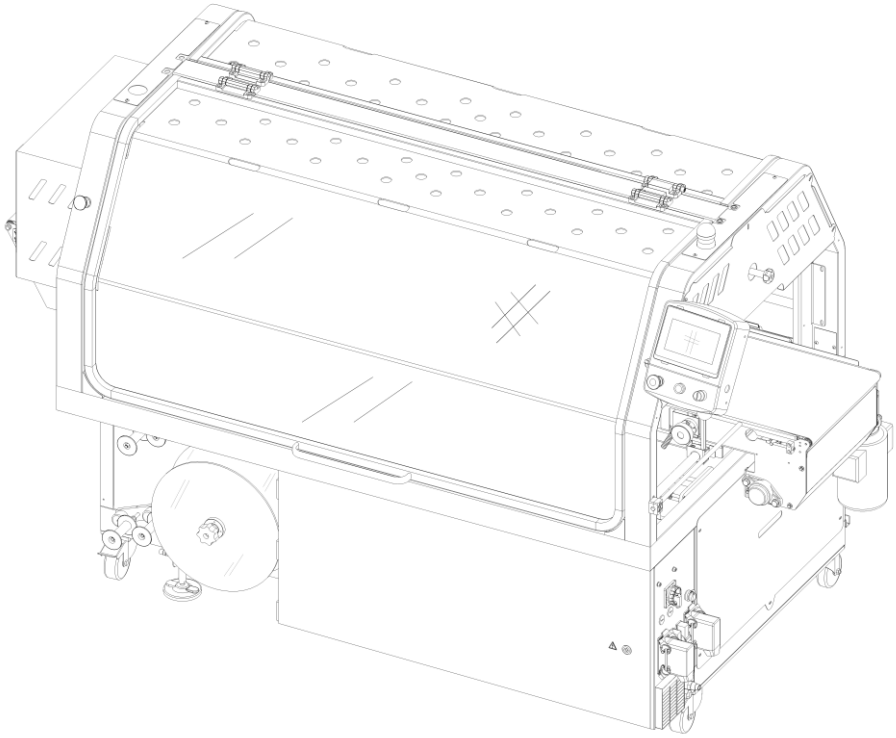
Minipack-torre S.p.A.
Via Provinciale, 54 - 24044 Dalmine (BG) - Italy
Tel. (035) 563525
E-mail: info@minipack.it
http://www.minipack.it

INSTRUCTIONS FOR USE AND MAINTENANCE

Pratika 56 MPE X1
Pratika 56 MPE X2

EN Rev.0: Valid from s.n. 2009463 dated 03.2020



BEFORE USING THE MACHINE PLEASE CAREFULLY READ THE INSTRUCTIONS

DOC. N. FM111246A
REV. 0
ED. 05.2022

TRANSLATION OF THE ORIGINAL INSTRUCTIONS

Contents EN

Chapter 1. Description | EN

1.1. Preface

This manual has been drawn up in compliance with the UNI10893 standard dated July 2000. It is meant for all users in order to enable them to use the machine correctly. Keep it in a place which can be easily accessed in the proximity of the machine and which is known to all users. This manual is an integral part of the machine for safety reasons. We wish to specify the symbols in use here below in order to improve understanding of them.

	**ATTENTION:** **Accident prevention rules for the operator. This warning indicates the presence of dangers which can injure the person operating on the machine.**
	**ATTENTION:** **Hot parts. Shows the danger of burning, thus involving the risk of a serious accident for the exposed person.**
	**WARNING:** **It indicates the possibility of damaging the machine and/or its components.**

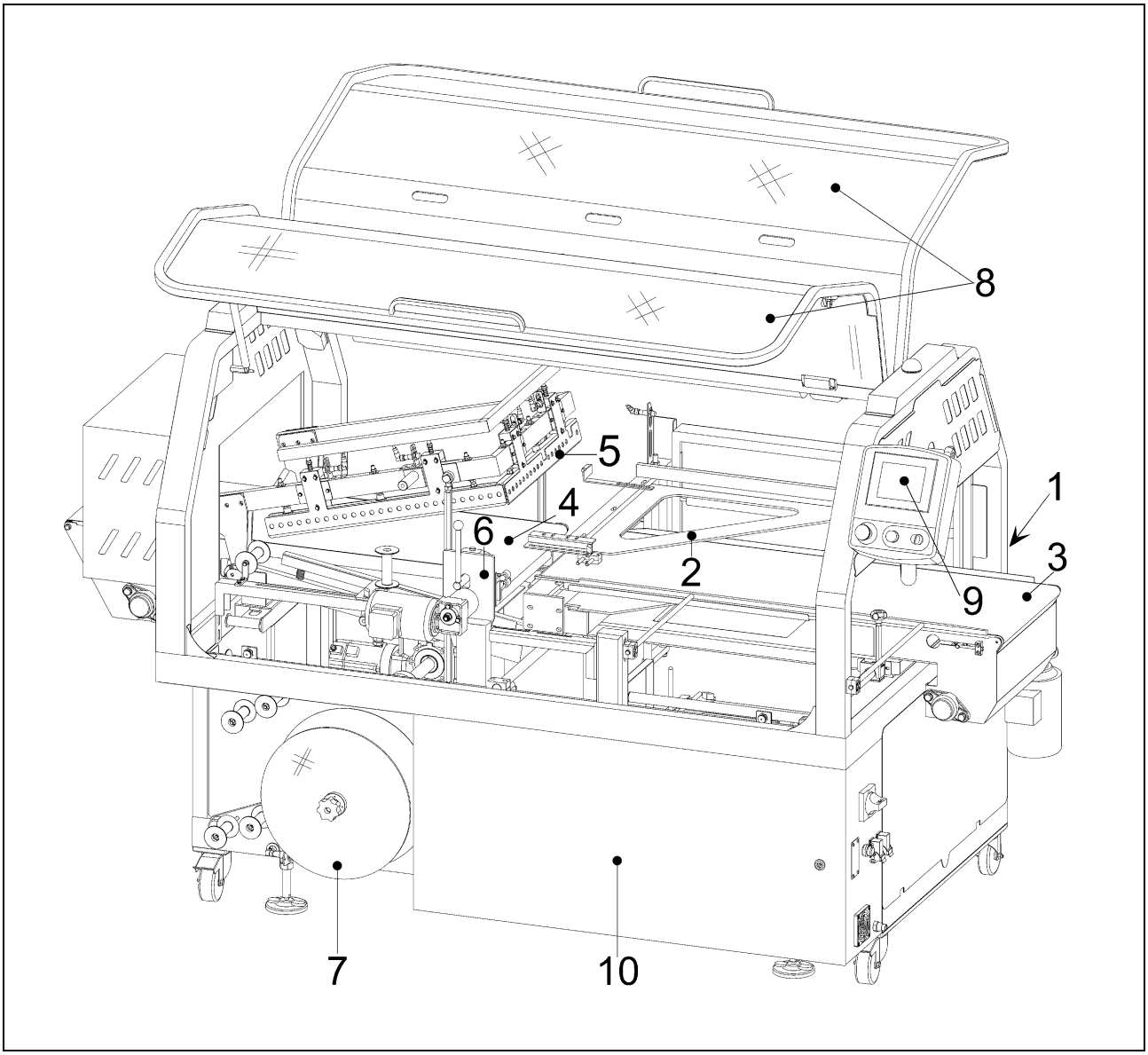
1.2. Machine features

The machine that you have purchased is an automatic packaging machine designed to package loose pieces or groups of products (foodstuffs, housewares, toys, etc) using a single-folded heat-shrink film.
The machine can be fed manually or operate in series with other machinery. If it is fed by a qualified technician (machine operator) he needs to be instructed accordingly, and he has to be able to advise it can maintenance technician in case of malfunctions or machine anomalies.
Operate in “AUTOMATIC” mode.
The machine is managed by a control logic housed in the PLC.
Thanks to the versatile design of the machine, a wide range of products can be processed with different shapes and sizes. Moreover it is possible to perform operations, using “MANUAL” mode controls. Packs are handled by conveyors housed inside the framework.
The machine is also equipped with a device for the recovery of scrap film, to avoid the presence of waste film inside the operator work zone.

Technical data:

- An L sealing system with “Centre Sealing” device that executes a seal with horizontal closing, mid product (for Pratika 56 MPE X2 only)
- A system that brings the belts together in the sealing area. Ideal for packaging small size products
- Brushless motor with servomotor that controls sealing unit movement. Greater sealing precision and high productivity speed
- This adapts to the operating length on both sides, thanks to the double guard and the control panel, adjustable by 180°
- It offers the possibility of following the line's production flows from right to left and vice versa
- Maximum function and flexibility of work configuration
- Improved access
- Maximum production: 3600 packages/hour.

1.3. Main machine components



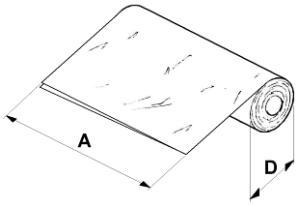
The main machine components are:

1. Film unwinder
2. Film-opening device
3. Infeed belt
4. Outfeed belt
5. Sealing bar
6. Film pulling
7. Film rewinder
8. Guards
9. Control panel
10. Electrical control panel.

Chapter 2. Film features EN

2.1. Films to be used

The machine can work with polyolefin heat-shrink film between 9 and 38 micron thick, both technical and suitable for food.
To guarantee the best results, it is recommended to use the films marketed by us. The special features of our films assure their outstanding reliability, with regard both to compliance with laws in force and to an excellent machine performance.



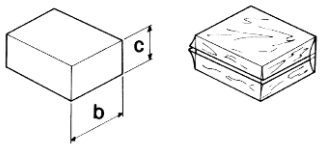
A = 700 mm / *27,56 in* MAX
D = 300 mm / *11,81 in* MAX

Consult the data and safety sheets of the films in use and observe the corresponding instructions!

2.2. Band A calculation

Band A = b + c + 100 mm / *3,94 in*
By band "A" we mean the width that the film must have to package the product.

Note: it may be necessary to increase the amount of film friction (100mm / *3,94in*) indicated in the formula, for high products or with complex shape.

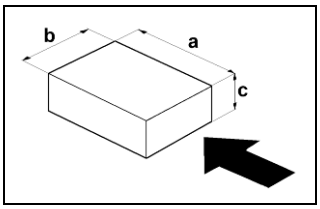


Chapter 3. Machine usage conditions EN

3.1. Max. pack sizes

Pratika 56 MPE X1 a = 600 mm / *23,62 in* b = 400 mm / *15,75 in* c = 160 mm / *6,30 in*
Pratika 56 MPE X2 a = 600 mm / *23,62 in* b = 400 mm / *15,75 in* c = 240 mm / *9,45 in*

Note: measurements shown refer to the maximum for the single dimension.
Refer to chapter **2.2.** to get max. dimension of pack (b x c); the addition of (b + c) is equal to film roll width minus 100 mm / *3,94 in.*



3.2. Items which may be packaged

These machines are capable of packing a wide range of completely different products. They are used successfully in the following sectors: food, marketing, graphics and mailing, large distribution, industry, fabrics.

3.3. Items which must not be packaged

The products listed below must absolutely not be wrapped to avoid permanent damage to the machine and serious injuries to the operator:

- Wet and unstable products
- Liquids of any kind and density in fragile containers
- Flammable and explosive materials
- Pressurised gas cylinder of any kind
- Loose and volatile powders
- Any materials and products not listed but which might harm operator and damage the machine.

Chapter 4. Safety standards | EN

4.1. Warnings

It is extremely important to read this entire chapter as it contains important information regarding risks that personnel are subject to in the event of incorrect use of the machine. These basic standards must be observed as well as specific standards applicable in the country of installation.

- The machine must be installed by trained and authorised technicians.
- This machine is not intended for use by persons (including children) with reduced physical, sensory or mental capabilities, or lack experience and knowledge, unless they have been given supervision or instruction concerning use of the machine by a person responsible for their safety.
- Never use the machine for purposes other than as specified in the sales contract.
- Never allow unauthorised personnel to perform repairs or other operations on the machinery.
- The operator must be familiar with all warnings related to the tasks in hand and always be informed by the head of the site regarding risks.
- Ensure that all clothing is tight fitting, with particular reference to cuffs or other loose clothing.
- It is forbidden to wear bracelets and loose accessories that can get entangled in the belts.
- Ensure that all operating areas and transit zones are kept clear, clean and adequately lit at all times.
- Eliminate all safety hazard conditions before using the machine and always notify the head personnel of any malfunction.
- Never use the machine in the event of fault.
- Never tamper with safety devices or circuits.
- Never perform modifications on the machine without prior authorisation from the manufacturer.
- If the supply cord is damaged, it must be replaced by the manufacturer, its service agent or similarly qualified persons in order to avoid a hazard.
- The electrical enclosure must remain closed during operation.
- The key to open the electrical enclosure must be kept by a specialised and authorised member of personnel.
- Smoking is forbidden while the machine is operating!
- Never performs maintenance and/or adjustments to the machine during operation. Guards may only be disassembled by suitably trained and qualified maintenance engineers.
- Never operate the machine without all guards fitted. Ensure correct position of all guards before resuming normal operation.
- The manufacturer declines all liability for damage or phisical injury caused by failure to observe safety standards.

	**CAUTION!** This machine is NOT designed for explosion-proof applications; it is a standard model and therefore must never be installed or operated in zones subject to the risk of explosion.

4.2. Description of safety stickers

The following safety stickers feature on the machine:

	❑ On machine front panel. **Danger of electrocution!** Risk due to presence of electrical power in electrical system inside panel. **While the machine is running, the panel must be mounted properly.**
	❑ On the sealing bar frame. **Hot members!** It shows the danger of burning, thus involving the risk of a serious accident for the exposed person.
	❑ At the conveyor belt infeed and outfeed. **Dragging hazard!** Hazard generated by moving elements (conveyor belts, motor driven rollers) in the event of contact during operation phases.
	❑ In the product loading area on the infeed belt.

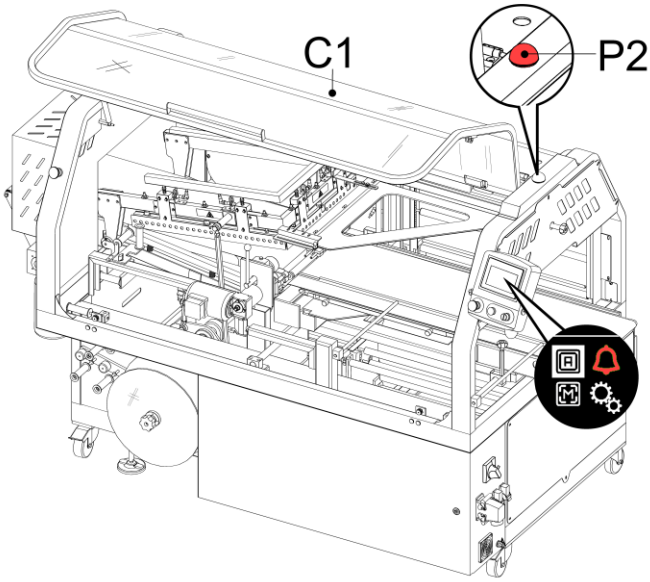
4.3. Individual protection devices

	Wear safety shoes that protect feet from impacts, crushing and compression while moving or handling the machine.
	Wear safety gloves that protect the hands from crushing and mechanical hazards and while moving or handling the machine.
	Wear safety gloves that protect the hands against the specific risks associated with the materials to be packed (mechanical, chemical) and against coming into contact with the high temperatures present on the seals and/or sealing blade (up to 200°C).
	Wear safety gloves that prevent the hands from coming into contact with foodstuffs when packaging them.

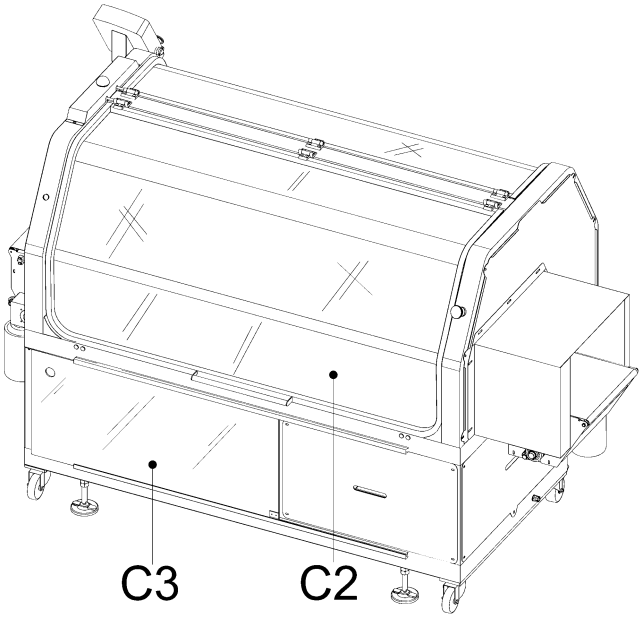
4.4. Guards

The machine is fitted with a front guard (C1) and two rear guards (C2) and (C3).

If one of these guards is opened, the machine stops.
The buzzer (P2) and the “Alarm” key on the display indicate that there is an alarm.
To reset machine operation, close the guards and press the RESET (S2) button.



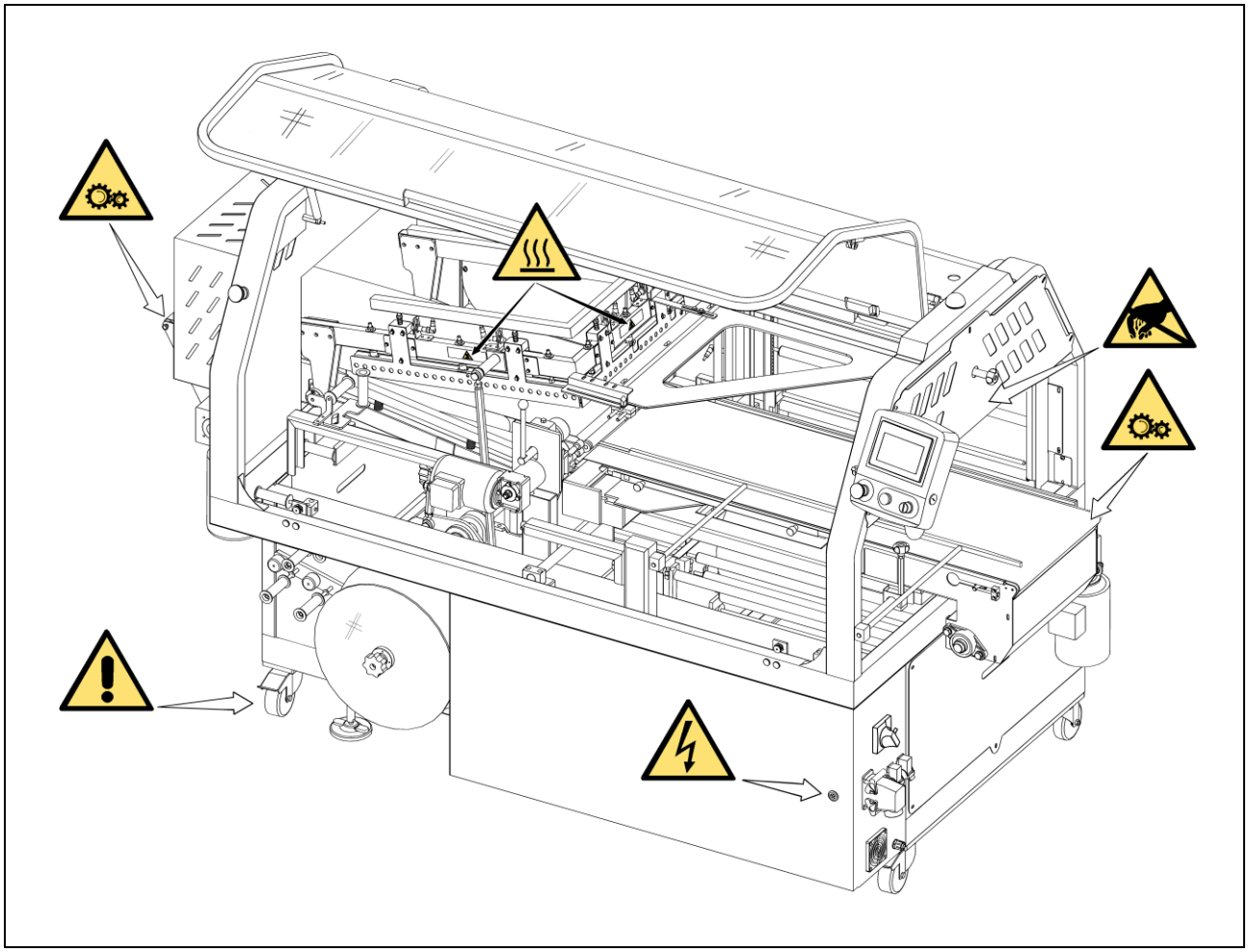
Front view



Rear view

4.5. Residual risks

Comply with the following prohibitions and warnings.

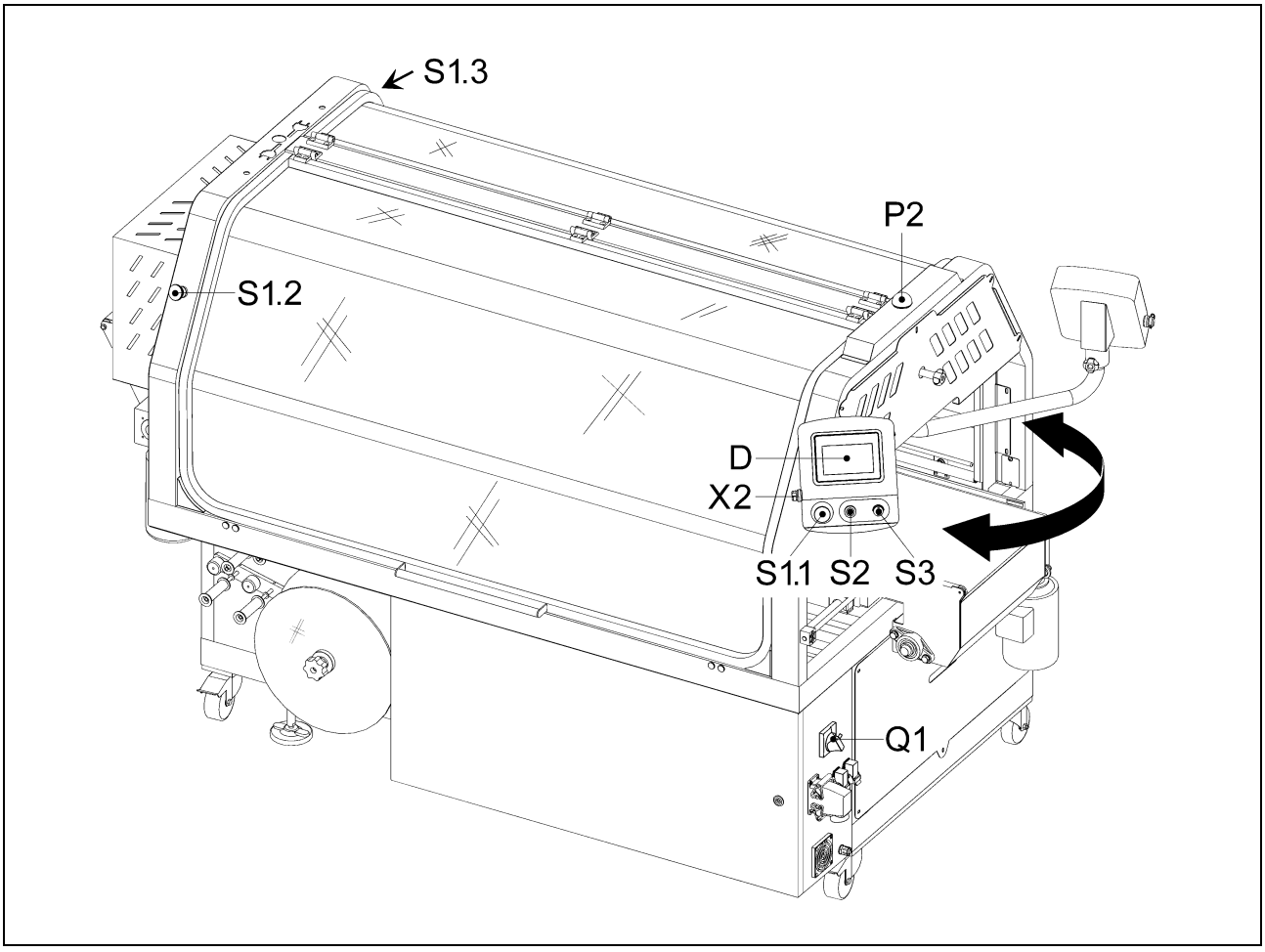


	**Dragging hazard!** Hazard generated by moving elements (conveyor belts, motor driven rollers) in the event of contact during operation phases.
	**Burn hazard!** ❑ Risk due to high temperature of the sealing bar. Do not touch the bar. Before performing operations in these zones, set the machine to “maintenance mode”, and wait for resistances to cool. Never perform operations without suitable personal protective equipment such as gloves and overalls.
	**Electric shock hazard!** Electric control board: risk due to electric energy inside electrical control board (upstream from the main switch). Before performing maintenance: ❑ switch the machine off by rotating the main switch (Q1) to “0” (OFF) ❑ remove the plug from the mains socket ❑ WAIT 15 minutes to allow the capacitors to discharge.
	❑ The wheels must be used only for moving the unit short distances across smooth, horizontal floors. ❑ Make sure the film reel is properly lodged in is place.
	**Danger of placing hands inside!** Danger caused by placing hands in the product loading area on the infeed belt.

5.1. Control panel

The machine is equipped with a touch control panel adjustable by 180°, where it is possible to set all operation and programming features.

	Only use one finger to select an object on the panel for correct touch panel use. If the panel is pressed in two or more points at the same time it is possible that you select an object unintentionally.



Q1 **Main switch.**
Turns the machine on and off.

D **Display**.
Displays selected functions and relative settings.

S1.1 **"EMERGENCY buttons.**
S1.2 These 3 buttons immediately stop the machine in case of immediate danger or to "place it in maintenance
S1.3 conditions". If they are pressed, they need to be turned clockwise to release them.

S2 **"RESET" button.**
To press on machine start-up and every time you want to restore power.

S3 **"BYPASS SAFETY PROTECTIONS" selector.**
If this selector switch is set to OFF, the machine may only be operated if the guards are closed (AUTOMATIC program).
If this selector switch is set to ON, the machine may be operated with the guards open. This condition is necessary "only" when carrying out the set-up procedures and when inserting or changing the film reel (MANUAL program only).

X2 USB connector for data transfer to the panel.

P2 Buzzer.
Its light/sound signals identify the machine status at any time.

5.1.1. Main keys and icons

Key	Description	Key	Description
	Select recipe		Alarm siren switch off
	Recipe quick load		Save recipe
	Start / Stop cycle		Load recipe
	Automatic / Manual		New recipe
	Alarm		Delete recipe
	Set up		Load recipe from USB
	Conveyor belt movement and execution of film pulling/winder/unwinder		Save recipe on USB
	Sealing		Recipe list
	Batch counter		Wait for the operation to finish (sealing bar homing, data saving, etc.)
	Logout		Info
	Main (home page)		

5.2. Buzzer

The machine is fitted with a buzzer, whose light/sound signals identify the machine status at any time.

Machine status	Light		Sound
The machine is ready		Flashing green (at a frequency of 1 s)	No
The machine is homing the triangle		Flashing green (at a frequency of 0.5 s)	No
The machine is in operation		Steady green	No
The emergency button has been pressed		Steady red	Yes
The machine is in alarm mode		Flashing red	Yes

5.3. Start-up

Turn the main switch (Q1) to ON.
The display comes on and the screen with the "company" logo appears.
Press the logo, then the “RESET” (S2) button.

Triangle homing is required at every start-up (this is recommended when packing batches of products with different heights).

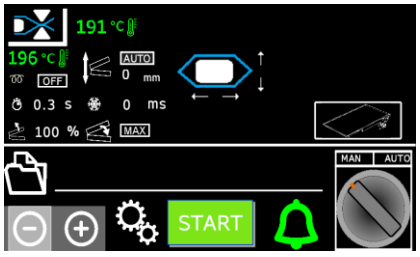
Press CONTINUE to run homing.

Press EXIT to not run homing.

5.4. Display

Home page

The home page is split into various areas, each one of which can be used to consult and/or edit parameters and functions.



“Sealing bars” parameters (paragraph 5.4.5.1)

“Film” parameters (paragraph 5.4.5.1)

“Manual/automatic mode” parameters (paragraph 5.4.1)

“Infeed belt and film unwinder” parameters (paragraph 5.4.5.1)

Select recipe key

Recipe quick load keys

START STOP Cycle start/stop keys

Automatic Key

Manual Key

Alarms Key

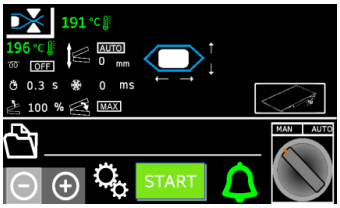
Set-up Key

5.4.1. How to use the machine

The machine can operate in 2 modes: **MANUAL and AUTOMATIC.**

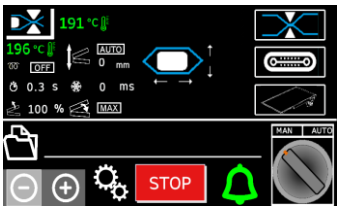
MANUAL mode

Condition of use of the machine immediately after starting.



Press  to enable Manual mode.

To enable Manual program controls, press the START start cycle key.



The screen will now display the “sealing” and “belt movement” controls.

Sealing

- By pressing this key, a sealing cycle is performed.

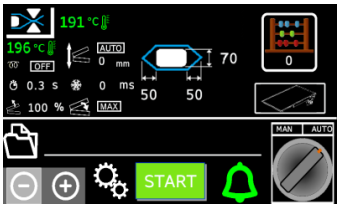
Belt movement

- When pressed, it moves the infeed belt, sealing belt, pulling film, film unwinder and film rewinder for the entire time the key is held down.

	The MANUAL mode is the condition required for the set-up and film reel insertion and change phases. In this phase, it is possible to open guards (C1) and (C2) by turning the selector (S3) to ON. By turning the selector (S3) to the OFF position, the alarm is reset. With the guards open (after pressing the start cycle key START), only  is active.

AUTOMATIC mode

This is the condition of use featuring fully automatic machine operation.

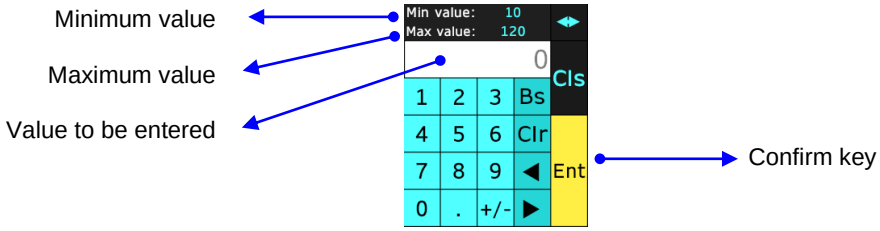


Press  to enable Automatic mode.

Press the start key START to start the automatic cycle.

5.4.2. Data entry keyboard

The keyboard is displayed when the value of a variable needs to be entered or changed.



5.4.3. Password

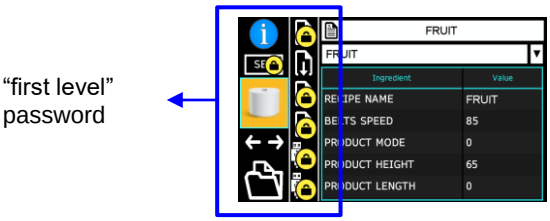
Some functions are password protected to guarantee correct operation of the machine and to prevent the operator from accidentally modifying the PLC program which controls all operations.
There are 3 password levels, each of which is protected by a different User Name and Password.

- Operator (first level) [User Name: abc / Password: abc]
- Maintenance technician (second level)
- Factory (third level).

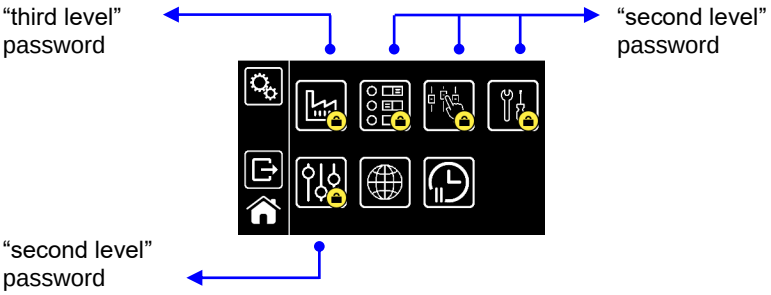
The "padlock" symbol next to a key indicates that the function is Password protected.

"Operator" Password (first level)

With this password enabled, it is not possible to save the changes to program variables.

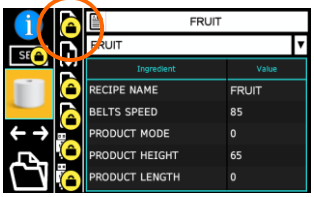


"Maintenance technician" and "Factory" Passwords (second and third levels)



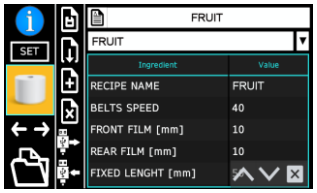
"Operator" Password Release (first level)

The operator must know the first level User Name and Password to release the Password.
To unlock it, follow the procedure below.



Press the password protected key.

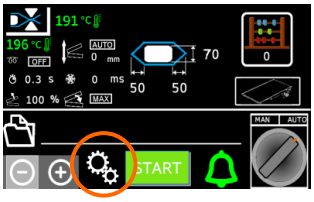
Enter the User Name and Password and press Login.



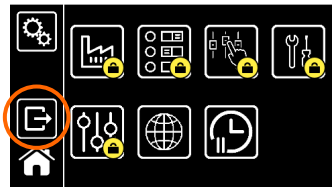
Note: the padlock symbol next to the key disappears.

Reset password

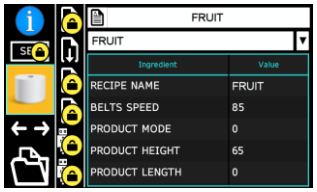
To restore program security with a password, follow the procedure described below.



From the home page screen, press .



Press .



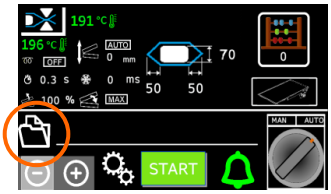
The "padlock" symbol has re-appeared indicating that the program is password-protected.

5.4.4. Recipe

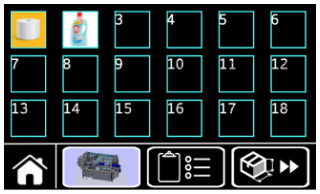
The machine is supplied with 18 recipes saved with standard parameters (it can however store up to 64 recipes).

Loading a recipe

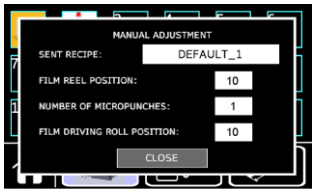
To load a recipe, follow the procedure below:



Press  .



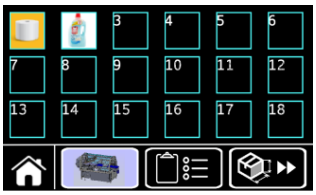
Press the key to select the recipe (1-18).



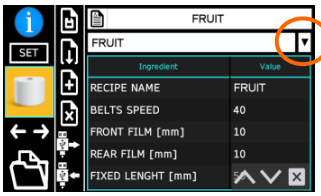
The pop-up window that comes up displays the manual adjustments to position the film reel.

Press CLOSE and then  .

This is another way of loading the recipe:



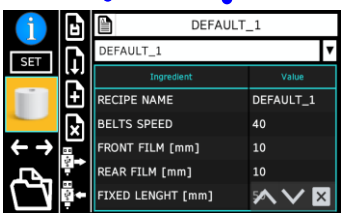
Press  .



Select the recipe you want to load.

The pop-up window that comes up displays the manual adjustments to position the film reel.

Press CLOSE ,  , and then  .



Key to display list of recipes

Recipe name

Key to select the recipe

List of variables

 “Save recipe” key

 “Load recipe” key

 “New recipe” key

 “Delete recipe” key

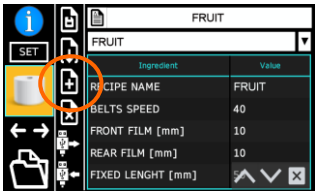
 “Load recipe from USB” key

 “Save recipe on USB” key

 “Info” key

SET “Assign image” key

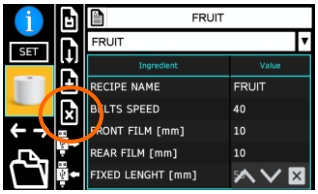
New recipe creation



Select the recipe you want to copy and press .
To rename the recipe, press the name (e.g. FRUIT) and enter the new name.

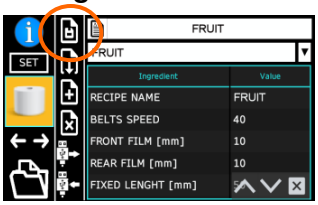
Then press .

Deleting a recipe



Press to delete the selected recipe.

Saving data



Press to save the changes made to the recipe.

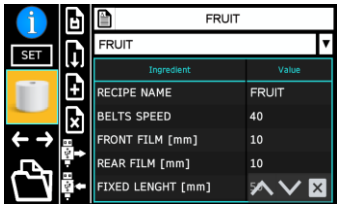
Associating an image to a recipe

Follow the procedure below to associate an image to a recipe.
Insert the USB drive with the images in the X2 outlet on the control panel.
The images (.png files, max 100Kb) must be saved in a folder named IMG.

Assigns the displayed image

Image viewer

Key to scroll images loaded on the USB drive



Use and to scroll through the images and confirm the displayed image with SET.

Finally, press .

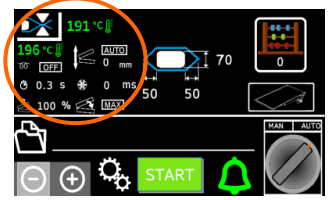
5.4.5. Recipe management

The recipes can be managed (edit parameters/create new programs) with a “standard” or a “fast” procedure.

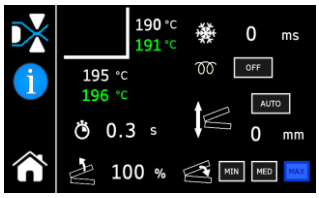
5.4.5.1. Standard management

“Standard” recipe management involves changing the parameters from the initial page by pressing the relevant area (e.g. sealing bars, film).

Sealing bars parameters

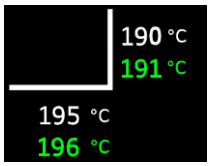


To edit the values, press anywhere on the screen and go to the settings page.



The parameters that can be adjusted are:

- Front and side sealing bar temperature
- Sealing time
- Sealing bar opening position
- Sealing cooling
- Pre-heating
- Sealing height (for Pratika 56 MPE X2 only)
- Sealing bar closing pressure.

	**Front and side sealing bar temperature** → “Set” front sealing bar temperature → “Actual” front sealing bar temperature → “Set” side sealing bar temperature → “Actual” side sealing bar temperature Press the number indicating the temperature to set and enter the value. Note: The initial page displays the “actual temperatures”. The colour of the thermometer indicates its status: Red thermometer The machine is in the heating phase. The actual temperature is lower than the set temperature. Blue thermometer The machine is in the cooling phase. The actual temperature is higher than the set temperature. Green thermometer The machine is at the set temperature. The actual temperature matches the set temperature.
	**Sealing time** Press the number indicating the sealing temperature and set the value.

Sealing bar opening position

Adjust the percentage opening of the sealing bar.

- Machine without “Belts approaching” 

: (30 ÷ 100)
- Machine with “Belts approaching” 

: (60 ÷ 100)
(see paragraph “Infeed belt parameters”)

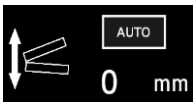
Set minimum sealing bar opening in order to reduce the closing and opening time and thus increase the packaging speed.

Sealing cooling

Press the number indicating the sealing cooling time and set the value (default: 0 ms).
The function is used for all plastic films, such as polyethylene, which require cooling time to consolidate the seal.
The sealing bar opens, but film advancement is delayed by a set amount of time.

Pre-heating

ON: adjusts the time of the first seals to ensure the contrast bar heats correctly. Recommended for low and light products.
OFF: Not set.



Sealing height

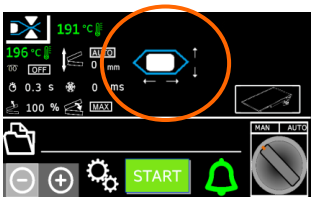
The function is only available for Pratika 56 MPE X2.

Adjusts the sealing position with respect to the belt. Values: AUTO / MAN.
If set at AUTO sealing is performed at half the height of the product. Ideal for standard products.
If set at MAN sealing is performed at the set measurement (measured starting from outfeed belt surface).
Values: 10 ÷ 110mm */ 0,4 ÷ 4,33in.*

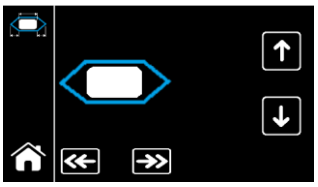
Sealing bar closing pressure

Regulates the pressure of the film sealing bar to optimise the cut.
Values: MIN / MED / MAX

Film parameters (with machine in MANUAL mode)



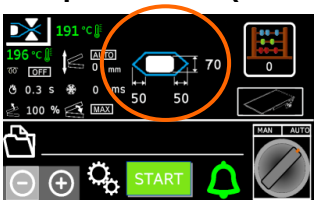
Press anywhere on the screen and go to the settings page.



The keys ↑ and ↓ allow you to open and close the upper triangle.
Adjust the position of the triangle so that it is 20 mm higher than the product.

Keys ⇐ and ⇒ are used to move the infeed belt in both directions of travel.

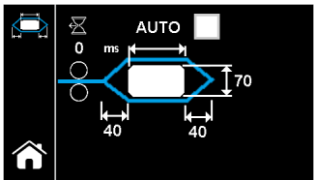
Film parameters (with machine in AUTOMATIC mode)



Press anywhere on the screen and go to the settings page.

Packaging of products with a regular shape

If packaging products with a regular shape, we recommend the automatic setting (do not mark the box with a flag, next to “Product length”).
In this case the film is sealed when the photocell reads the end of the product + the rear film height.
The available settings are: feeding start delay, product height, rear film, front film.



Feeding start delay: adjusts film feeding start with respect to product arrival (default: 0 ms).

Product height: adjust the position of the triangles.

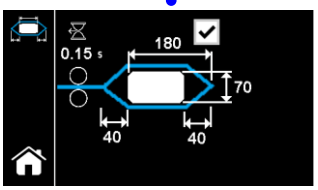
Rear film: adjust the amount of film you want to leave behind the product.

Front film: adjust the amount of film you want to leave in front of the product.

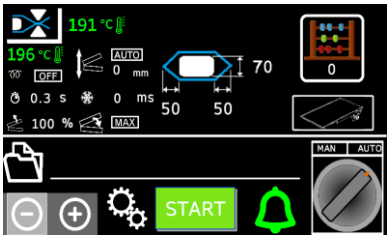
Packaging of products with an irregular shape

If packaging products with an irregular shape, we recommend the manual setting (do not mark the box with a flag next to “Product length”).
In this case the film is sealed when the photocell reads the start of the product + the set height (e.g. 180).
The available settings are: product length, feeding start delay, product height, front film, rear film (only with the horizontal photocell set).

Product length



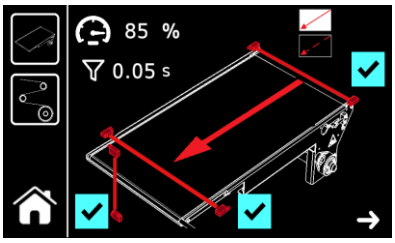
Infeed belt parameters



With the machine in  press  .
Used to go to the first settings page.

On the first page it is possible to set:

- Photocell filter,
- Belt speed,
- Belt mode: continuous or with pause,
- Loading photocell enabling (optional),
- Horizontal or vertical photocell selection.



Photocell filter: Adjusts the length of time for which the photocell must ignore a missing signal (advisable when processing irregular product formats). Values: 0 ÷ 1.

Belt speed: adjusts the belt speed (20-100%)


Belt mode “continuous”: belt always running


Belt mode “with pause”: belt stopped during sealing to make it easier to form the package.

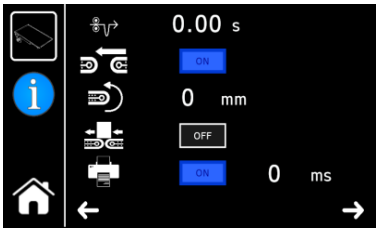
Loading photocell (OPTIONAL): to be used when you want the infeed and outfeed belts to stop if no products to be packaged are loaded (if the photocell does not read the product for 10 seconds, it stops the belts).
The function can be activated only if it is “included” among the OPTIONAL features.

The machine comes as standard with two types of photocells to read the product: horizontal and vertical. Select the most suitable photocell for the product being packaged. With “standard” products, the photocell is selected according to the height:

Horizontal photocell: suitable for product height > 200 mm / *7,9 in*
Vertical photocell: suitable for product height < 200 mm / *7,9 in*

On the second page it is possible to set:

- Film loosening,
- Belts approaching,
- Belt reversal,
- Conveyor belt,
- Printer.



Film loosening

Press the number indicating the film loosening time and set the value (default: 0.00 sec).
The function must be used when packaging high products (> 90 mm / *3,54 in*) with not a lot of rear film.
At the end of film unwinding, before sealing, the outfeed belt moves backwards in order to loosen the film tension.

Belts approaching

When set on ON, the system that brings the (IN) and (OUT) belts together in the sealing area is on. Ideal for packaging small size products.
Values: ON / OFF.

Belt reversal

Adjusts the distance between the products. After the belts have stopped running, the infeed belt (IN) runs backwards in order to move the product back by the programmed distance.
Values: 0 ÷ 500mm / *0 ÷ 19,69in*.

Conveyor belt

The function is only available with the machine in manual mode  .
It is the condition of use in which the machine works as a conveyor belt.
The belts convey the products from the infeed area to the outfeed area, without being film wrapped.
The sealing bar and opening film triangles fully open to allow the passage of products.
Values: ON / OFF.

Printer

The function is only available if 

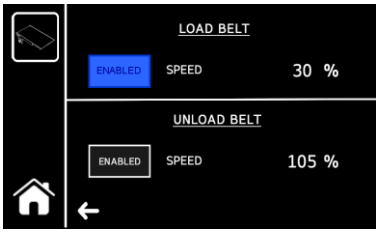
is included in the OPTIONAL FEATURES.

Printer on.

Printer off.

On the third page it is possible to set:

- Load belt
- Unload belt.



Load belt

The function is only available if 

is included in the OPTIONAL FEATURES.

Loading belt on.
Adjust the load belt speed with regard to the speed of the infeed belt (IN). Values: 20 ÷ 100.

Loading belt off.

Unload belt

The function is only available if 

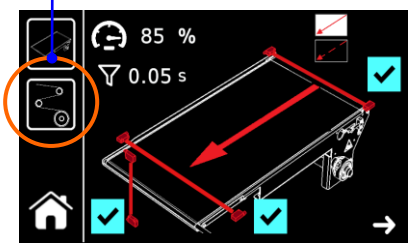
is included in the OPTIONAL FEATURES.

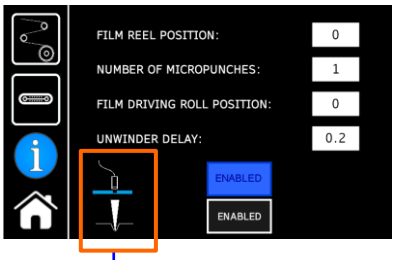
Unloading belt on.
Adjust the unload belt speed with regard to the speed of the outfeed belt (OUT). Values: 100 ÷ 130.

Unloading belt off.

Film unwinder parameters

Press the key to enter the data related to the manual settings of the film unwinder, so that every time you load a program, you can apply the saved settings.





Enter the film reel position with reference to the millimetre scale (X1) (paragraph 5.7 – Positioning of the film reel / figure 4)

Enter the number of micropunches (MF) used (paragraph 5.7 - Positioning of the micropunches)

Enter the position of the return roller (R5) with reference to the millimetre scale (X2) (paragraph 5.7 - Adjustment of “film separating rod” and return roller)

Used to slacken the film on the rewinder rollers, delaying the moment when the rewinder stops.

- 0.2 for product height < 100 mm / *3.9 in*
- 0.4 for product height > 100 mm / *3.9 in*

Mark readout

The function is only available if PRESENT is included in the OPTIONAL FEATURES.

ENABLED “Mark readout” on.
The function enables reading out the marks on opaque or coloured film by a specific photocell (OPTIONAL FEATURE).

ENABLED “Mark readout” off.

Film punch

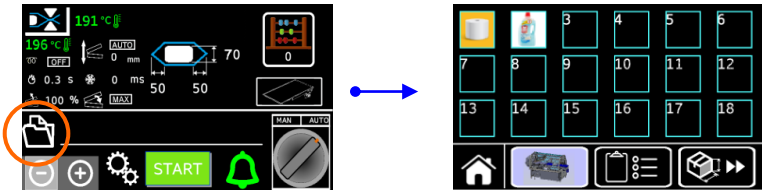
The function is only available if PRESENT is included in the OPTIONAL FEATURES.

ENABLED “Film punch” on.

ENABLED “Film punch” off.

Standard management (from “image”)

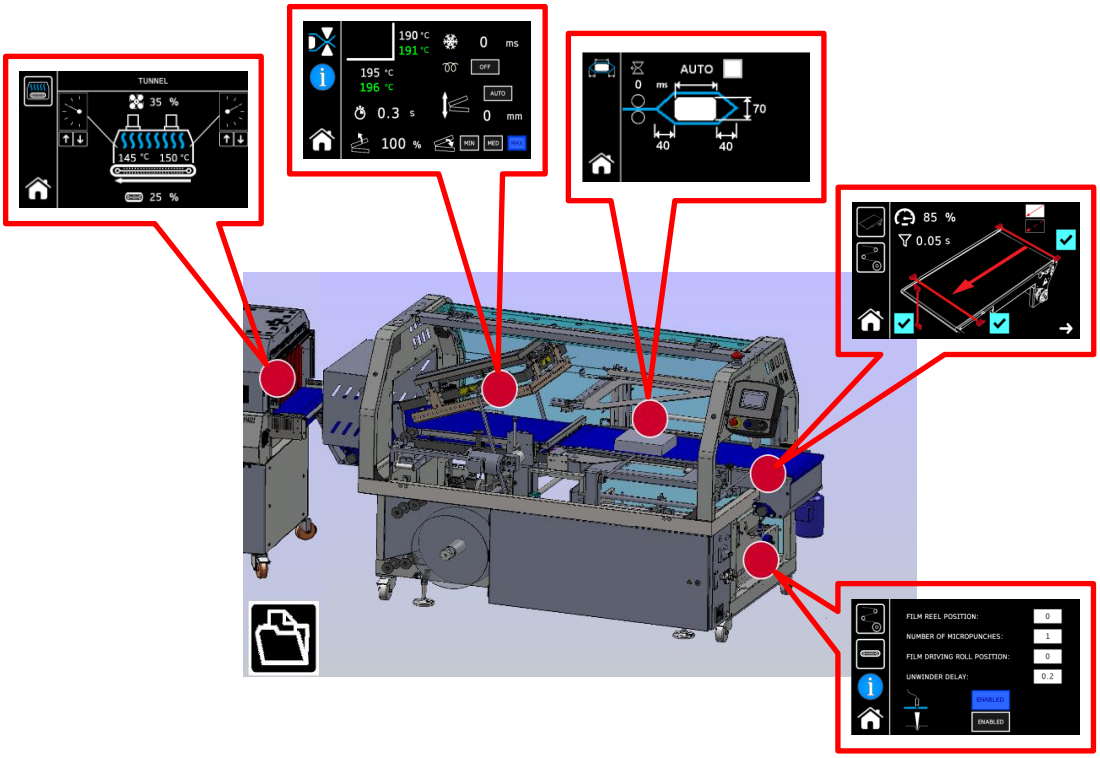
Another way of managing the parameters of a recipe is using key  .



Press  .

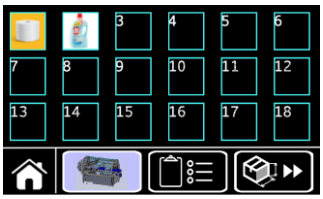
Press  .

This displays the image of the machine and, if selected, of the tunnel as well.
Press the “red dot” to display the screen with the parameters that can be set in the area involved.

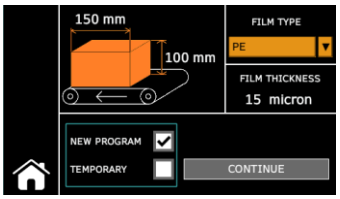


5.4.5.2. Fast management

"Fast" management is used to create a recipe by simply knowing the product size and the features of the film used. According to the entered data, the program sends a recipe to the machine that can be saved or used temporarily.

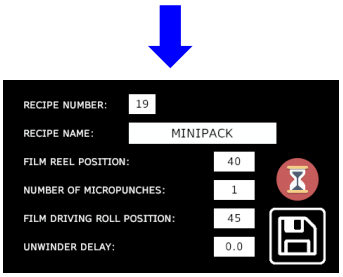


Press  and enter the requested data.



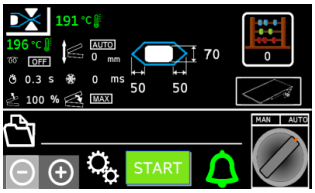
If you selected the TEMPORARY key, by pressing CONTINUE the data is sent to the machine (without creating a new recipe).

If you selected the NEW PROGRAM button, by pressing CONTINUE a new recipe is created and the new parameters are saved in it.

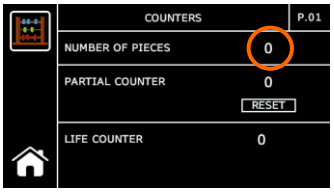


5.4.6. Batch counter

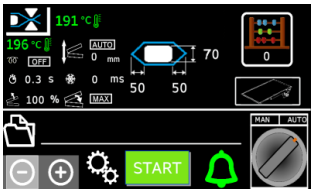
This function sets the number of products to be packaged.



With the machine in  press  .



Enter the number of products to pack (batch).
If set to "0", batch production is disabled.
Press  .



Press START.

With the batch function active, the number under the symbol  indicates how many products have been packaged since the production batch started.

Once the machine has packaged the programmed number of pieces, the „A025: BATCH NUMBER REACHED" alarm is activated.
To reset the alarm, see paragraph 5.5.

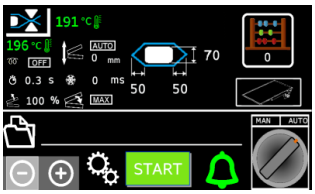
5.4.7. Configurations page

The configurations page can be accessed from the home page by pressing .

- Factory parameters
- Optional
- Manual controls
- Service
- Configuration
- Language
- Pause time
- Reset password (paragraph 5.4.3)

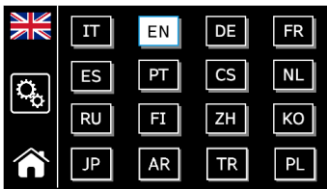
Language

To choose the language used on the display screen follow the procedure described below.



Press .

Press .

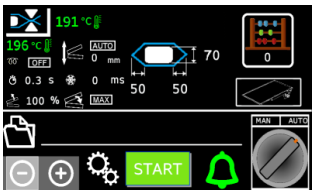


It displays the list of available languages:
Press the key that corresponds to the desired language, then press .

Pause time

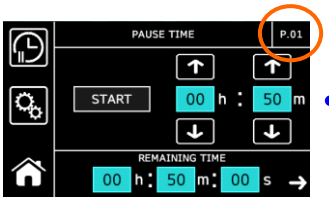
This function is used to programme the machine's "pause" time.
During this phase the sealing bar resistors switch off (a condition that ensures considerable energy savings), while all of the other machine functions stay on.
Once the pause time elapses, the resistors are heated up again.
This function is very useful for workers who, when they finish their lunch break or any kind of work break, start their shift again and need to have the machine at the right temperature, ready to work; or for maintenance procedures requiring adjustments with the sealing bars off.

Follow the procedure below to set the pause time.



Press  .

Press  to go to the 2 setting pages.



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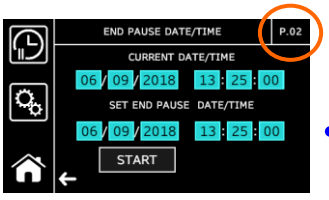
The first page is used to set the hours and minutes when the machine operation will be paused.

Press START to start the countdown, at the end of which the resistors resume operation.

Press  and the home page will display a pop-up window indicating the remaining time till the end of the pause.



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The second page is used to set the date and time to end the pause time.

Press START to pause the machine up to the set date and time.

Press  and the home page will display a pop-up window indicating the date and time when the pause will end.

5.5. Alarms

The machine provides a series of ALARMS needed to monitor any dangerous situations and malfunctioning.
The operations needed to clear alarms requiring operations on the machine, or inside of the electric panel, must be carried out by technical personnel trained and qualified for this type of operation.
A list of alarms is provided below:

NO.	ALARM	CAUSE	SOLUTION
A001	EMERGENCY ACTIVE	1 of the 3 “EMERGENCY” buttons (S1.1), (S1.2), (S1.3) has been pressed.	Remove the cause of the alarm. Release the “EMERGENCY” button by turning it to the right. Press the RESET button (S2).
		Only with “loading/unloading belt” optional feature The outlet plug for the belt connection has been removed, but the belt power cable is not connected correctly	Check whether the belt power cable has been inserted correctly into both the machine outlet and the belt outlet. • Press the RESET button (S2) • press RESET on the display on the alarm page.
A002	OPEN GUARDS	1 of the 3 guards (C1), (C2), (C3) has been opened	Close the guard and press “RESET” (S2).
A003	BYPASS SAFETY GUARDS	The selector switch “BYPASS SAFETY PROTECTIONS” (S3) is ON	Turn the selector switch (S3) OFF.
A006	MAXIMUM TRIANGLE HEIGHT	Sensor malfunctioning (B32)	• Make sure that the sensor (B32) is in the right position • check that the contactor (QM5) works properly • place the machine in MANUAL mode and lower the upper triangle.
A010	MACHINE HEATING	The machine is in the heating phase	Wait for the set temperatures of the sealing bars to be reached.
		The thermocouples (BT1) and (BT2) do not work	Check the electrical connections of the thermocouples and replace them, if faulty.
		The static relay of the lateral (QS1) and frontal (QS2) sealing bar, do not work	Open the electrical panel and check the relay function.
A011	REWINDER FULL	The film scrap collection rewinder is full	• Remove the film from the rewinder • press RESET on the display on the alarm page.
		“Full rewinder” photocell (B10) malfunction	• Check the photocell electrical connection and that it is properly fixed to its support • check that the photocell does not read any film scrap between the photocell and the reflector • press RESET on the display on the alarm page.
A012	UNWINDER: ROLL FINISHING with optional “reel end warning photocell kit”	The film reel is almost finished. It is only a warning: the machine will not stop but continue running	• Wait for the reel to finish and replace it • press RESET on the display on the alarm page.
		"End of reel" photocell (B53) malfunction	• Check the photocell electrical connection and that it is properly fixed to its support • press RESET on the display on the alarm page.
A013	UNWINDER: FILM FINISHED with optional “Film end photocell kit”	The film reel has finished	• Replace the reel • press RESET on the display on the alarm page.
		“End of film” photocell (B54) malfunction	• Check the photocell electrical connection and that it is properly fixed to its support • press RESET on the display on the alarm page.

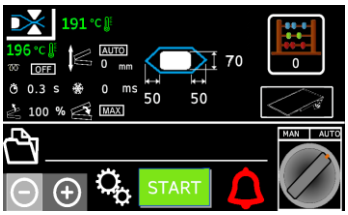
NO.	ALARM	CAUSE	SOLUTION
A014	BELTS NOT SPACED	Motor malfunctioning (M8)	• Check operation and electrical connection of the motor • press RESET on the display on the alarm page.
		Sensor malfunctioning (B3) and/or(B12)	• Check the sensors' electrical connection and ensure they are properly fixed to their supports • press RESET on the display on the alarm page.
A015	TEMPERATURE CIRCUIT ERROR	The thermocouples (BT1) and (BT2) do not work	Check the electrical connections of the thermocouples and replace them, if faulty.
A017	UNWINDER: TIME OUT	The film unwinder has turned for too long due to a mechanical block of the lever (L).	Fix the failure preventing correct oscillation of the lever.
		Sensor malfunctioning (B8)	• Check the sensor electrical connection and that it is properly connected to its support • press RESET on the display on the alarm page.
A020	INVERTER: INVERTER ERROR	The inverter is in error	• Check the code of the error shown on the inverter display and fix it • press the emergency button (S1.1) • wait about 10 seconds, then release the emergency button by turning it to the right • press the RESET button (S2).
A022	MAINTENANCE IN PROGRESS	The operator is controlling outputs in the “Manual Controls” menu. It is only a warning, the machine continues to run	When you have finished working in the “Manual Controls” menu, press the RESET key on the display on the alarms page.
A023	EMPTY LOAD BELT with optional “Products on infeed reading photocell kit”	The photocell (B51) is waiting to read the product. It is not an alarm but an indication of the stand-by status of the photocell	The product passes in front of the photocell.
		Photocell malfunctioning (B51)	• Check the photocell electrical connection and that it is properly fixed to its support • press RESET on the display on the alarm page.
A025	BATCH NUMBER REACHED	The machine has packaged the set number of products	Press RESET on the display on the alarm page.
A026	REWINDER: FILM BREAK	Film break	• Fix the film • press RESET on the display on the alarm page. Note: Make sure the film on the triangles is not excessively stretched out. If so, this means that the film unwinder is not working.
A027	PHOTOCELL TIMEOUT	A product longer than the lateral sealing bar is being packaged	Package a product shorter than the lateral sealing bar.
A029	BELT APPROACHING: INVERTER ERROR	The inverter (TS3) is in error	• Check the code of the error shown on the inverter display and fix it • press the emergency button (S1.1) • wait about 10 seconds, then release the emergency button by turning it to the right • press the RESET button (S2).

NO.	ALARM	CAUSE	SOLUTION
A033	CENTER SEALING: TOP LIMIT SWITCH	Sensor malfunctioning (B40)	• Make sure that the sensor (B40) is in the right position • check that the contactor (QM7) works properly • from the “MANUAL CONTROLS” menu scroll the pages until the “CENTER SEALING” control and press ↓ to lower it • press RESET on the display on the alarm page.
A034	UNWINDER OUT POSITION	Sensor malfunctioning (B35)	• Check the sensor electrical connection and that it is properly connected to its support • press RESET on the display on the alarm page
A035	TRIANGLE: MOVEMENT ERROR	Sensor malfunctioning (B2)	• Check the sensor electrical connection and that it is properly connected to its support • press RESET on the display on the alarm page
A041	HOMING: TIMEOUT	The sealing bar homing does not end within the set time	Contact the technical assistance service.
A042	HOMING: FAILED PROCEDURE	The machine receives the sealing bar homing command, but is not ready	Contact the technical assistance service.
A046	CENTER SEALING: MOVEMENT ERROR	Sensor malfunctioning (B42)	• Check the sensor electrical connection and that it is properly connected to its support • press RESET on the display on the alarm page
A048	PRINTER ERROR	Printer malfunctioning	Check operation of the printer
A050	SEALING BAR: DRIVE ERROR	Drive error	Check the alarm code that appears on the TS2 brushless drive display and contact the technical assistance service.
A051	LOAD BELT: NOT AVAILABLE	The inverter of the load belt is in error	• Open the box of the belt’s electric system and check the code of the error shown on the inverter display and fix it • press the emergency button (S1.1) • wait about 10 seconds, then release the emergency button by turning it to the right • press the RESET button (S2).
A052	UNLOAD BELT: NOT AVAILABLE	The inverter of the unload belt is in error	• Open the box of the belt’s electric system and check the code of the error shown on the inverter display and fix it • press the emergency button (S1.1) • wait about 10 seconds, then release the emergency button by turning it to the right • press the RESET button (S2).
A054	SEALING BAR: MOVEMENT TIMEOUT	A problem occurred during the sealing phase	Contact the technical assistance service.
A055	SEALING BAR: OBSTACLE PRESENT	The sealing bar has encountered an obstacle during its movement.	• Remove the obstacle • press RESET on the display on the alarm page.
A073	DOWNSTREAM LINE: NO LINE CONSENT	No downstream line consent for outfeed belt (additional belt at machine outfeed).	• Go to the OPTIONAL menu and enable the downstream line consent (set to ON) • press RESET on the display on the alarm page.
		In the “OPTIONAL” menu, the downstream line consent is enabled (ON), but the optional is not installed.	Install the unloading belt correctly.

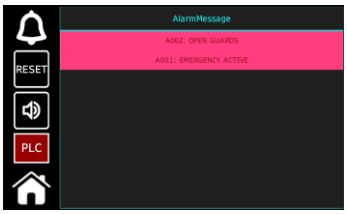
If the alarm persists even after having carried out the operations and checks indicated for resetting the machine, contact the technical assistance service.

Each time an ALARM occurs, the machine stops.

The buzzer (P2) turns red and emits an acoustic signal (paragraph 5.2). The symbol appears on the display.
The alarm reset procedure is as follows:



Press .



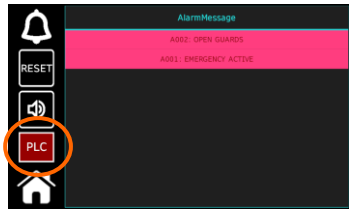
The display shows which alarm has been triggered.
Press RESET followed by .

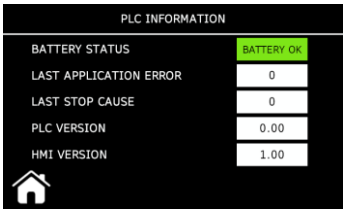
Note: press to stop the acoustic signal

⚠	The machine is equipped with 3 “EMERGENCY” buttons, (S1.1), (S1.2), (S1.3). Press them together to block the machine instantly, stopping the work cycle.

The procedure for restoring this alarm is the following:
Remove the cause of the alarm.
Release the “EMERGENCY” button by turning it to the right.
Press RESET (S2).

PLC diagnosis





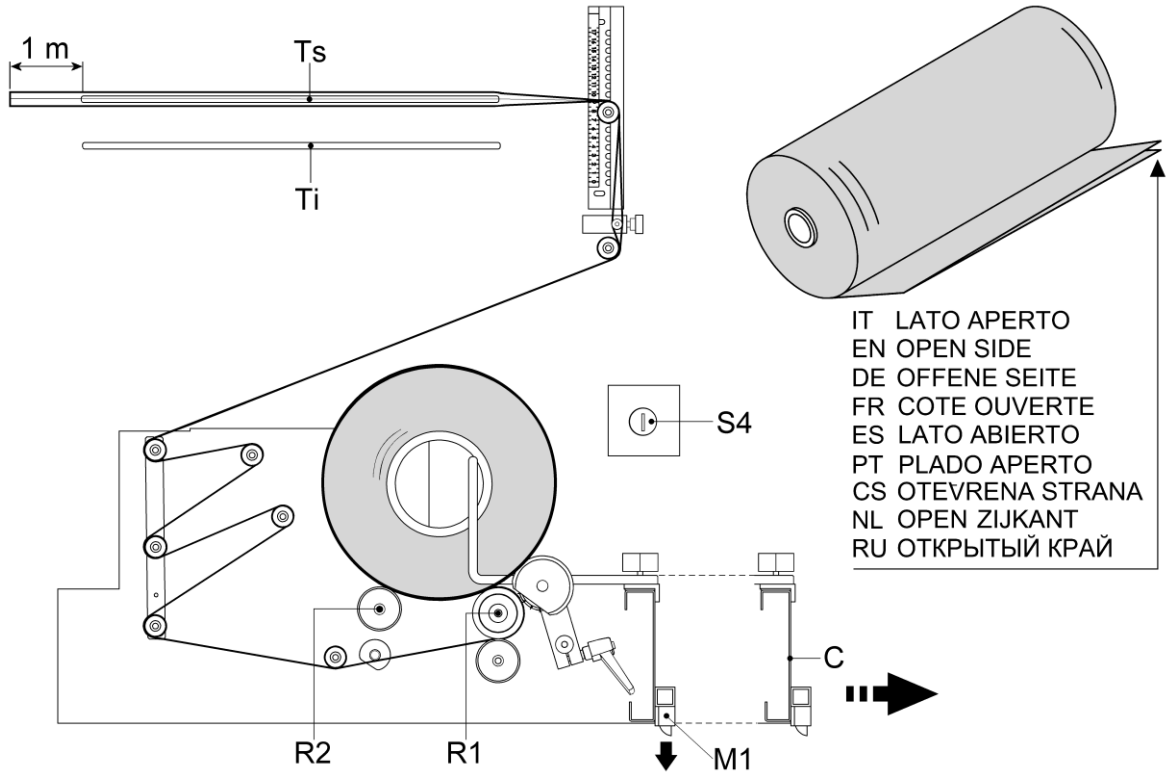
- Battery charge status
- Code of last cause of application error
- Code of last cause of PLC STOP
- PLC version
- HMI version

The PLC key displays some information on the PLC status. It is useful when diagnosing problems.

5.6. Introducing of the film

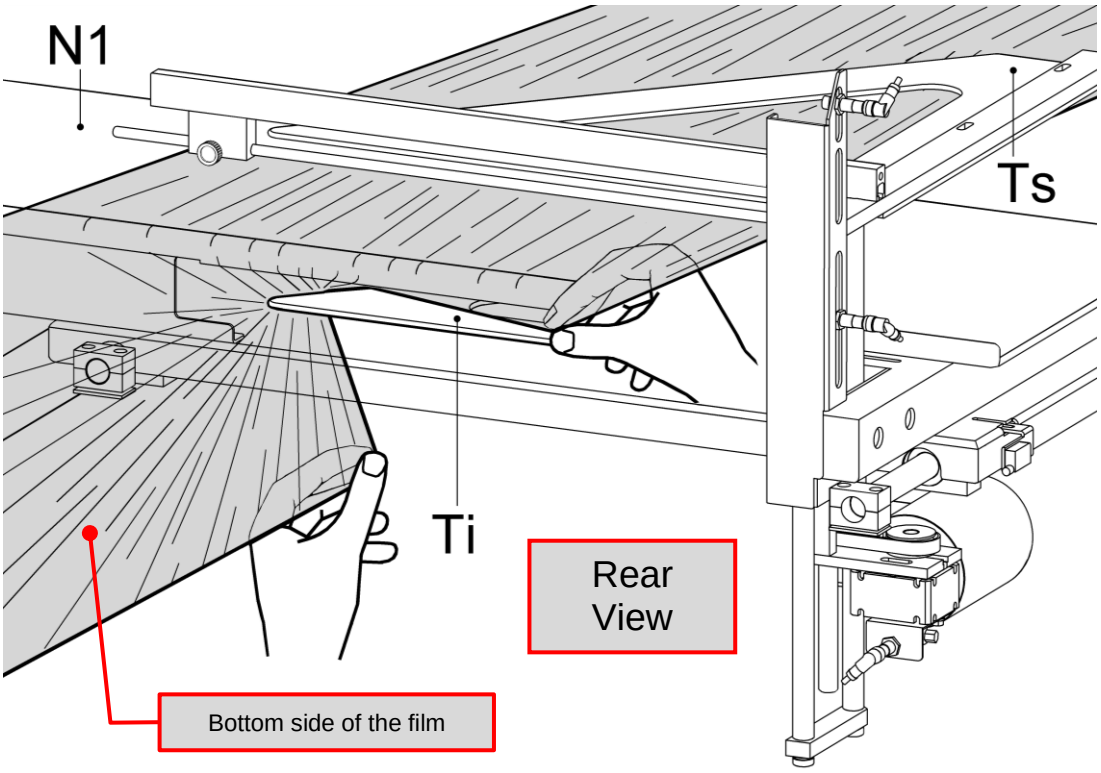
To insert the film, set the machine to “Manual” mode (paragraph 5.4.1).
Turn the “SAFETY DEVICE EXCLUSION” switch (S3) to ON and open the guards (C1), (C2), (C3).

PHASE 1



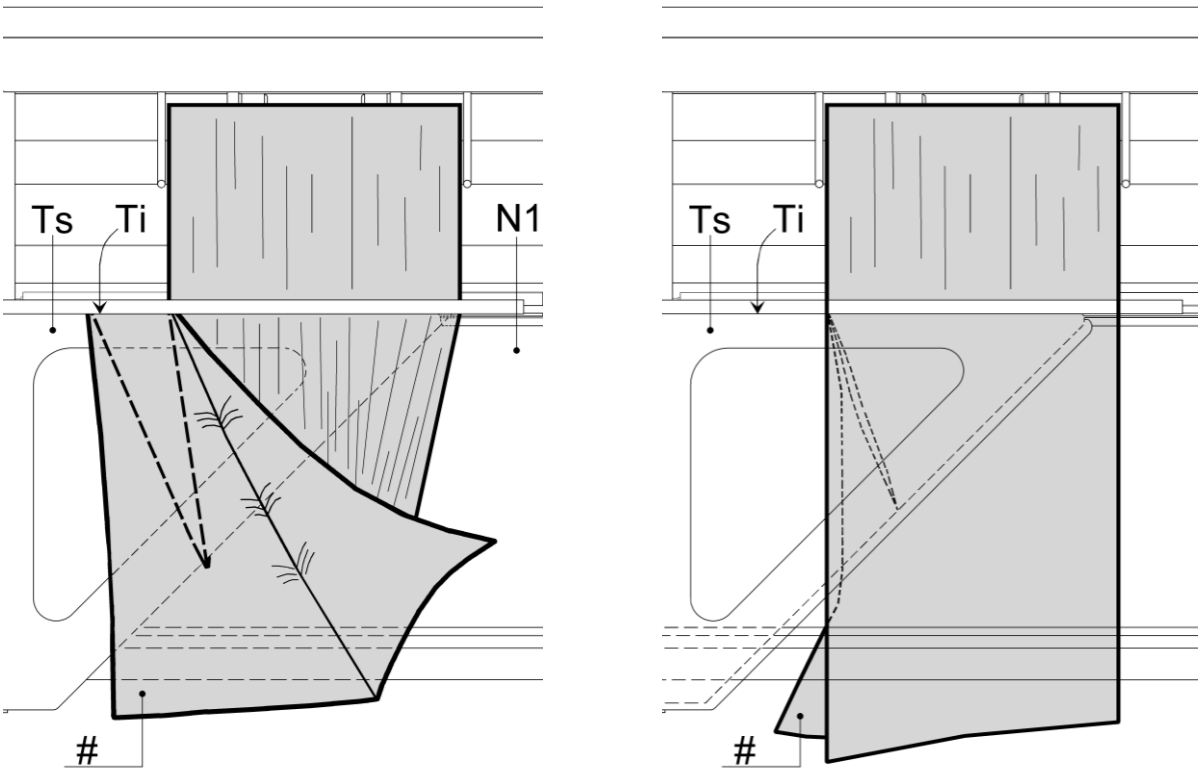
To make it easier to position the film reel, take out the carriage (C) supporting the reel (which means lowering handle M1 and pulling the carriage).
Position the film reel on rollers (R1) and (R2).
The open side of the film must always be as indicated by the arrow.
(Note: the unwinding direction of the reel must be specified when ordering the film).
Insert the film as shown in the figure.
To make it easier to insert the film, press button (S4) to the right of the reel.
Press the button to activate the motorised roller that the reel is resting on, thereby providing the required amount of film.
Insert the two ends of the film, one on top and one under the upper guide triangle (Ts).
Take the two ends of the film and unwind about 1 metre of it.

PHASE 2



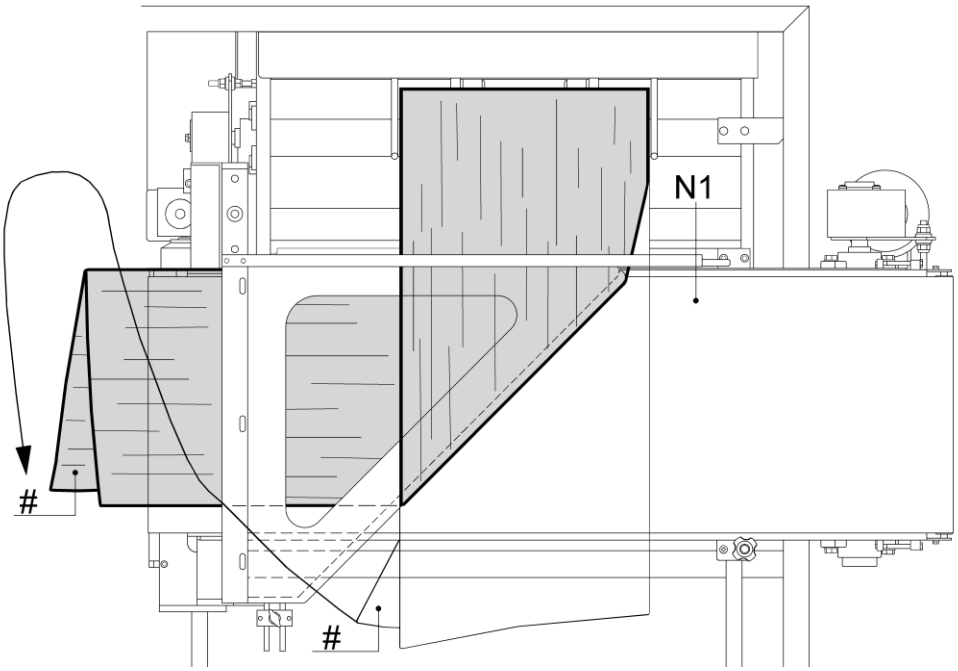
Take the lower end of the film near the rear of the reversal triangle and pass it under the lower triangle (Ti) from the outside inwards and over the infeed belt (N1).

PHASE 3



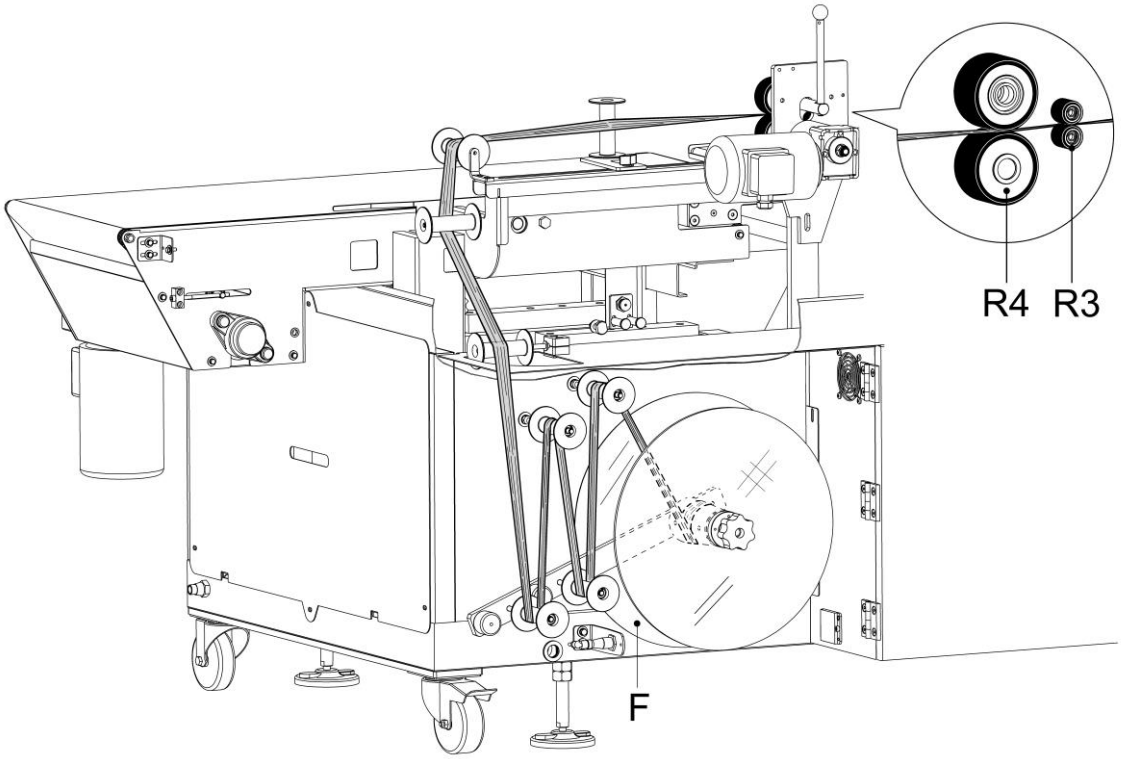
Then pass the upper side of the film over the upper triangle (Ts).

PHASE 4



Move the end of the film (#) that will go inside the triangles to the left, parallel with the infeed belt (N1) and pass the film under and above the infeed belt, aligning the ends of the film right after the belt itself.

PHASE 5



Pass the film between the two rollers (R3) and between the two wheels (R4) of the pulling device.

At this point perform a number of sealing cycles by pressing the key, so as to create a length of film that is long enough to complete insertion as shown in the diagram.
In order to seal the film you must close the front (C1), (C2), (C3) guards.
Lastly, tie the film onto the pin attached to the rear flange (F).

5.7. Adjustments

Before packaging, it is necessary to make a few “manual” adjustments.

Film reel positioning

The film reel must be positioned according to opening **“H”** of the triangle.

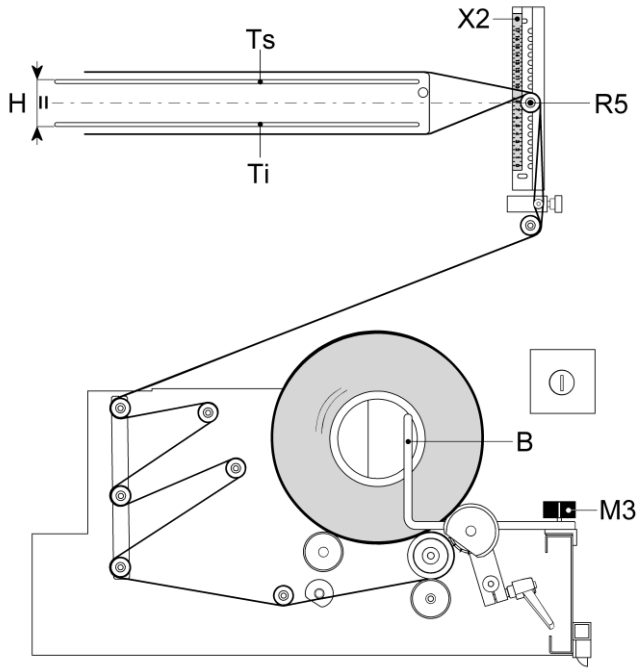


Figure 1

Reel positioning is correct when the right side of the reel is at distance **“A”** equal to half the distance of opening **“H”**.

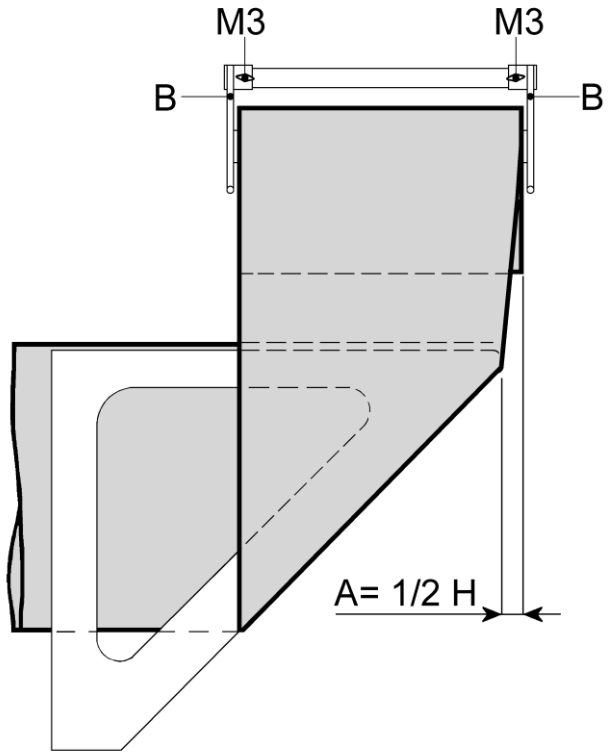


Figure 2

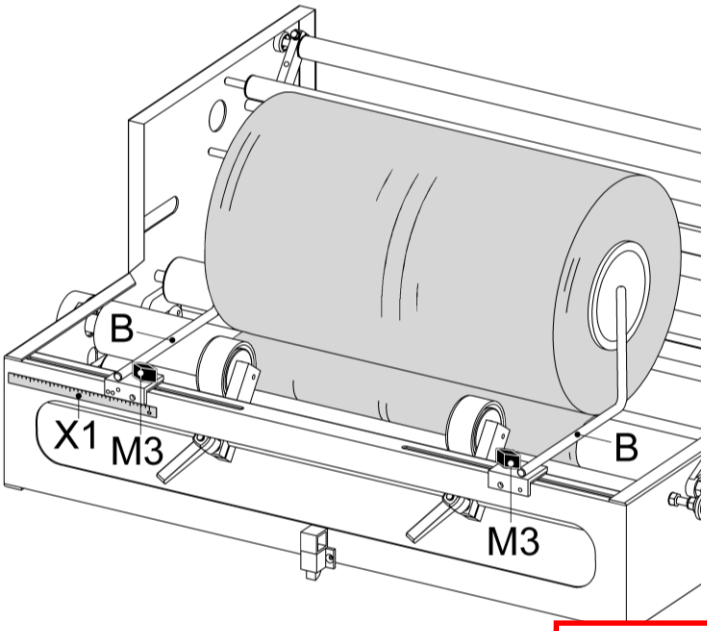


Figure 3

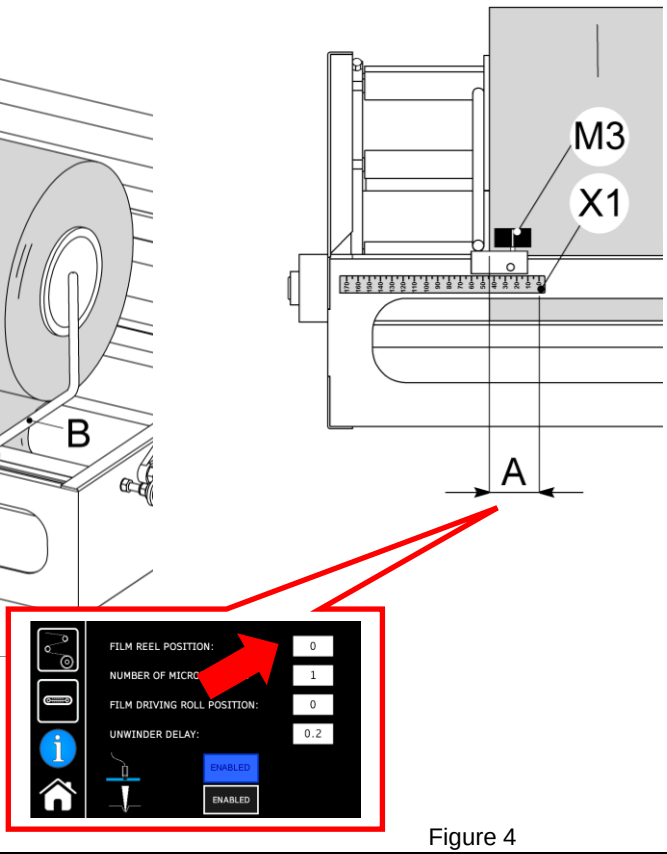
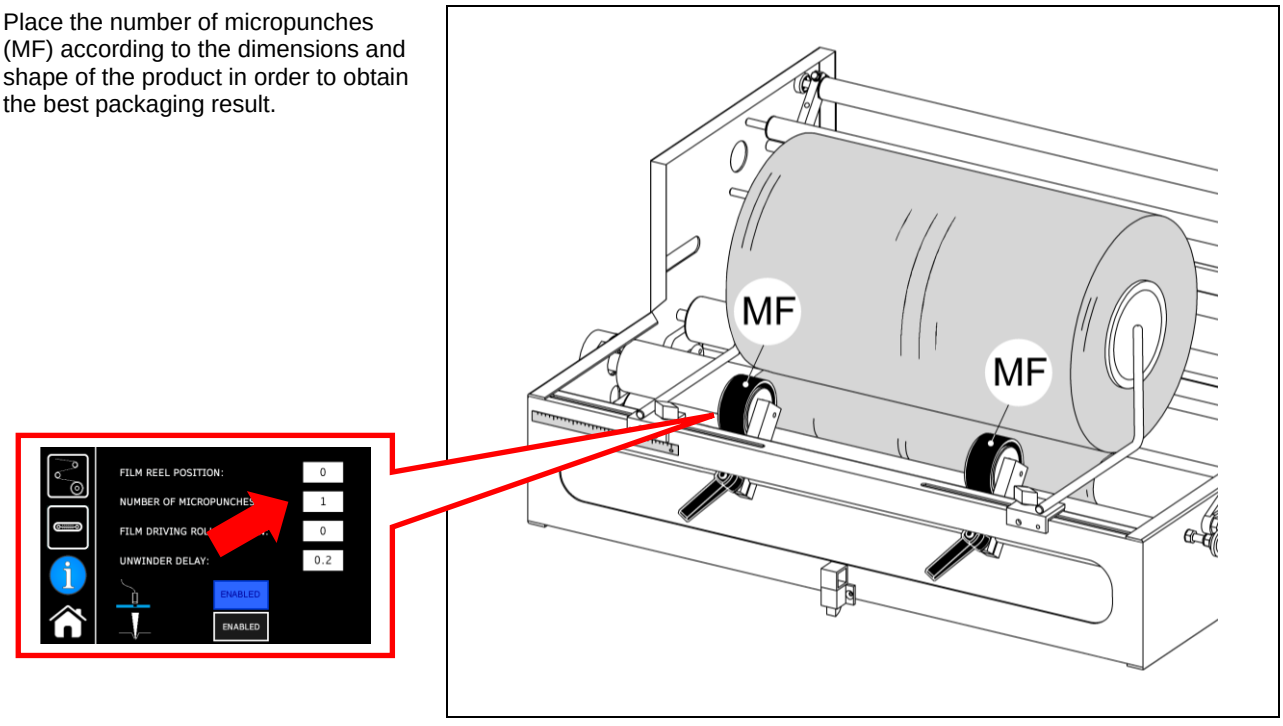


Figure 4

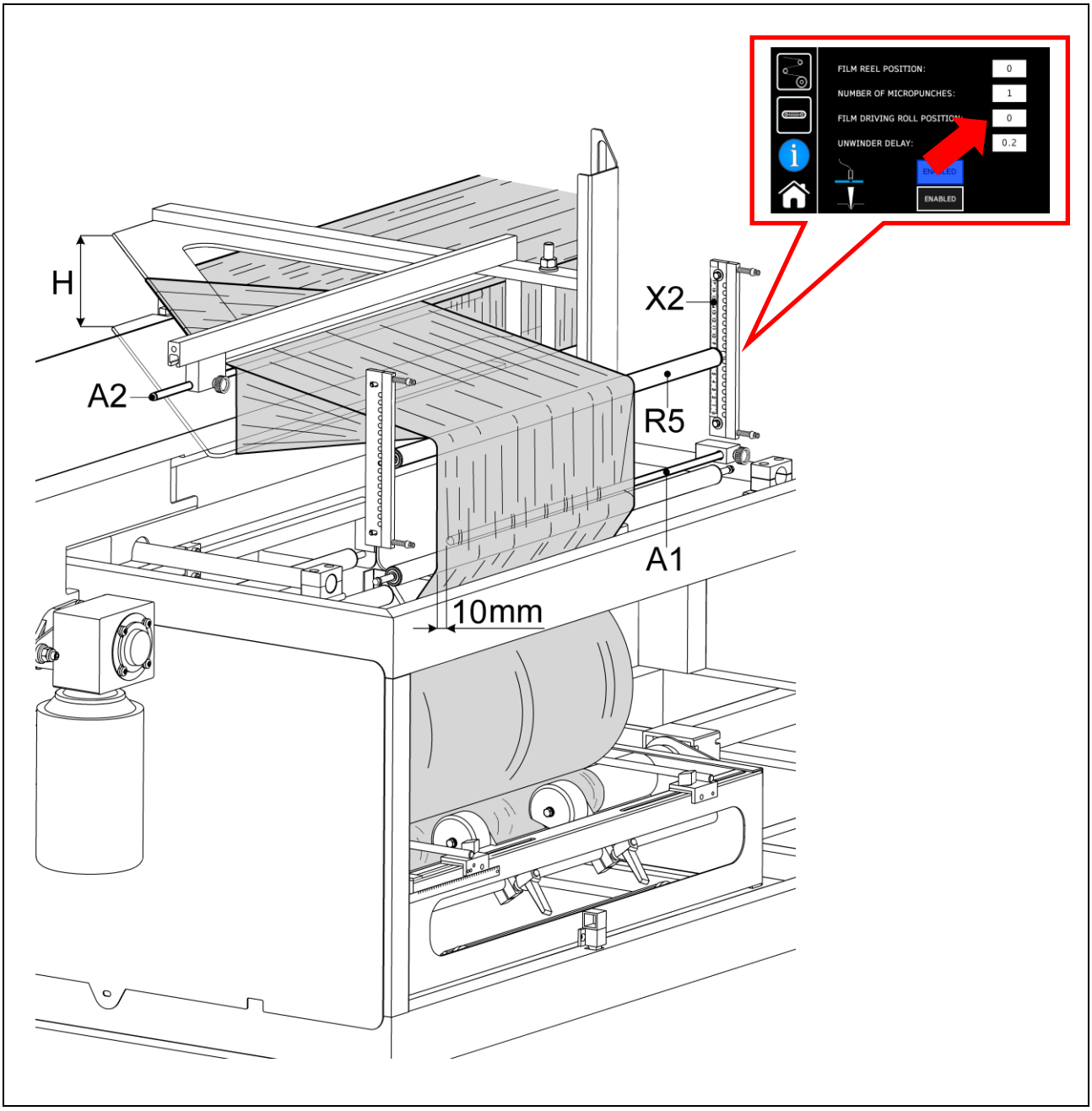
Then place the reel with reference to the millimetre ruler (X1) on the support.
Adjust the 2 containment guides (B) by using the knobs (M3) in order to block the reel, leaving 5 mm (*0,2 in*) of space between the guides and the reel.

Positioning the micropunches

Place the number of micropunches (MF) according to the dimensions and shape of the product in order to obtain the best packaging result.



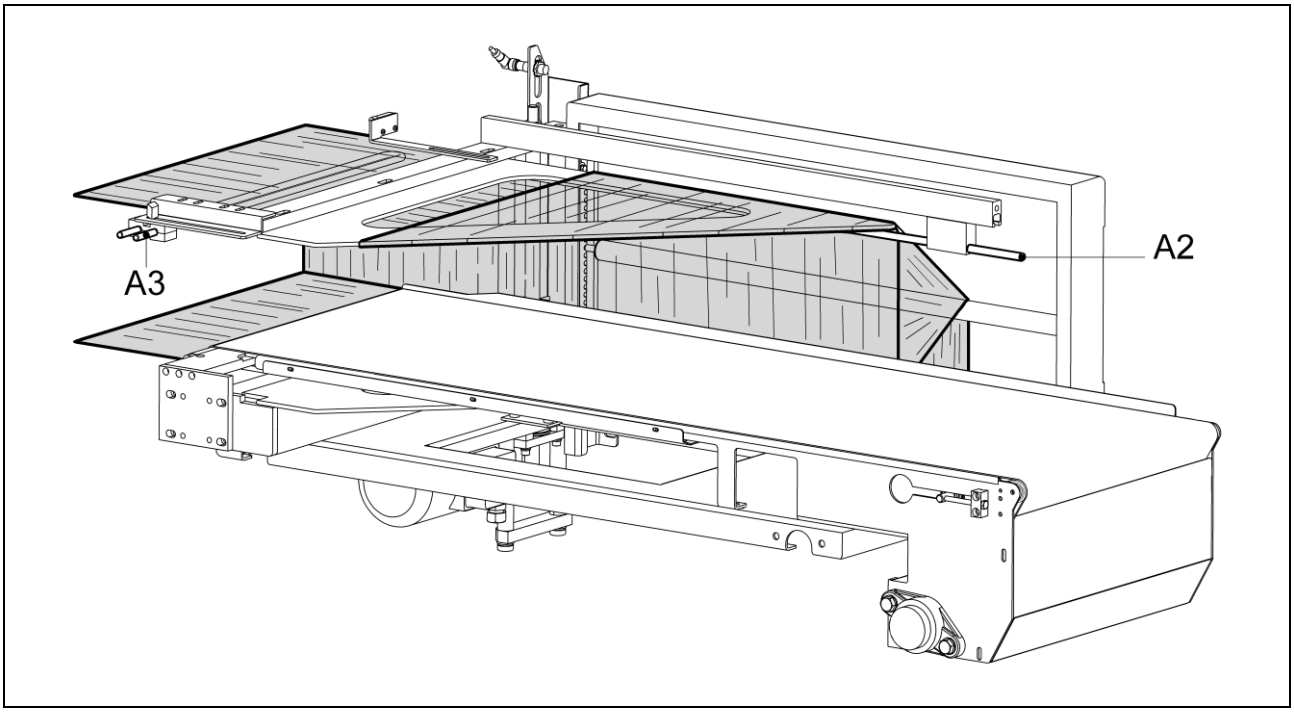
Adjustment of “film separating” rod and return roller



- The rod (A1) allows the 2 edges of the film reel to be separated.
  Position the rod inside the 2 edges so that the end is 10 mm (*0,39 in*) behind the crease of the film.

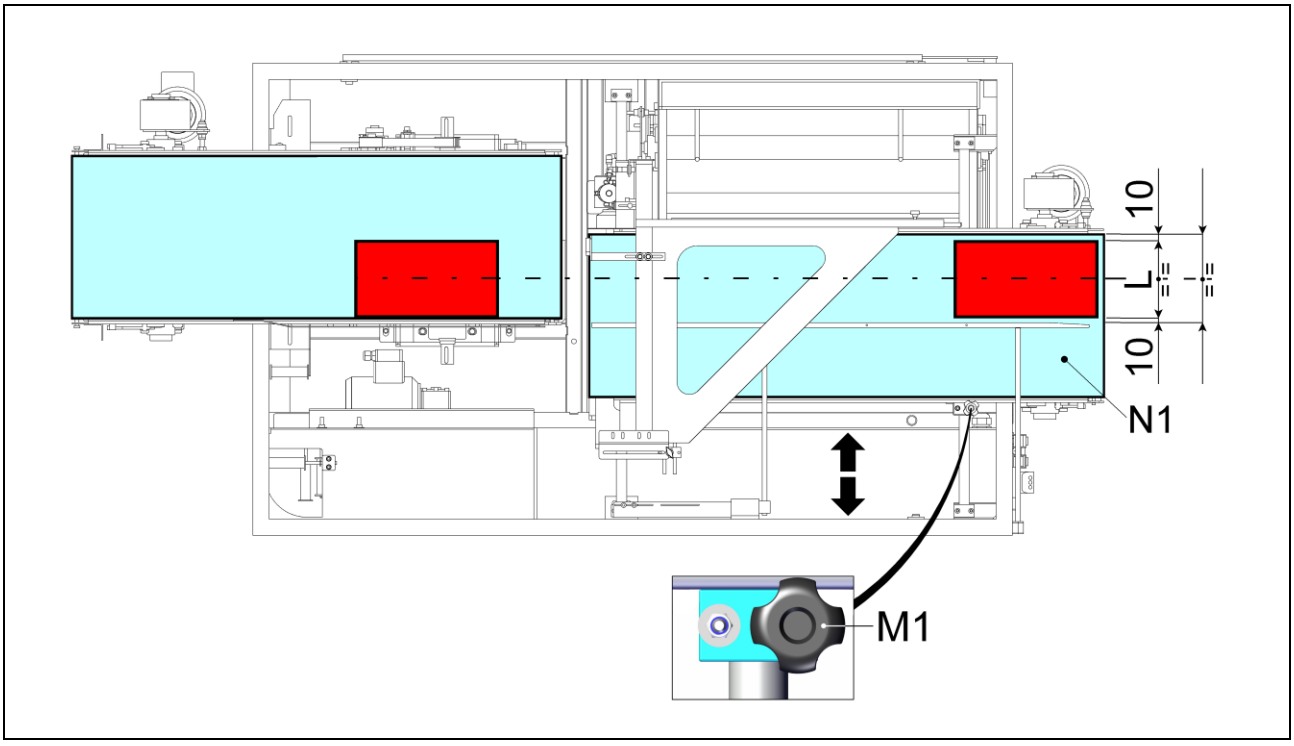
- Position the return roller (R5) according to the “H” opening of the triangles.
  Refer to the millimetre ruler (X2) and position the roller at a measurement corresponding to half the opening of the triangles.

Adjustment of “film lifting” rods



- Rods (A2) and (A3) are used to keep the film lifted correctly during product insertion.
  Adjust their position according to the dimension and shape of the product being packaged until the best packaging result is obtained.

Infeed belt adjustment



Adjust the position of the infeed belt (N1) according to the width (W) of the product being packaged, as shown below:

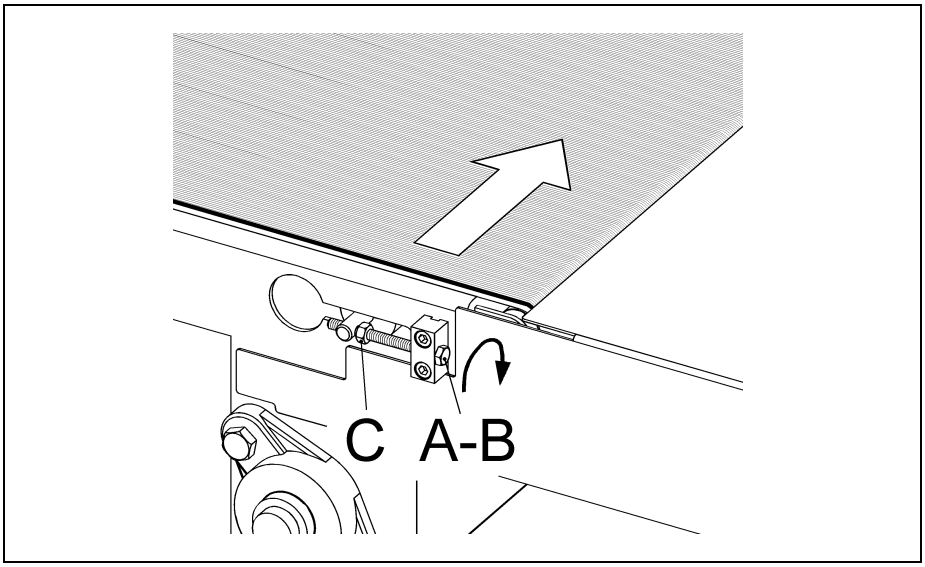
- Loosen the handle (M1) and adjust the position of the infeed belt (N1) so that the product has minimum clearance between the guide rod approximately 10 mm (*0.39 in*) and the rear shoulder of the belt approximately 10 mm (*0.39 in*).

Belt tension adjustment

With the first package, and at least once a month, check that the infeed and outfeed belts are aligned in the middle when moving. Should disbandment be noted, or noises heard, it means the rollers where the belt slides are not at perfect right angles with the drive direction.
To reset centring, you are required to adjust the belts tension be means of the screws located on the side.

To adjust tension:

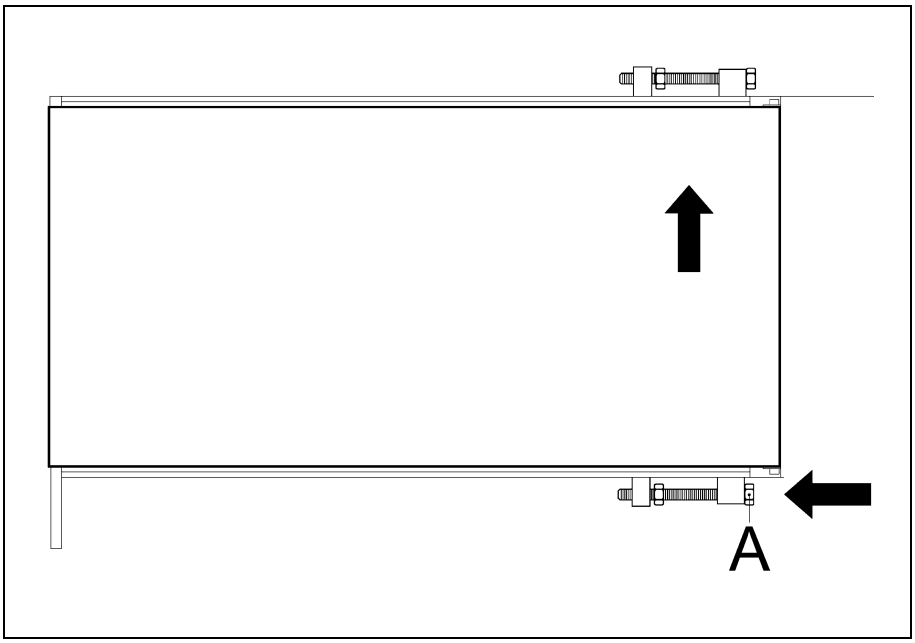
- loosen the locking nut (C);
- tighten or loosen screw (A) according to the type of adjustment to execute,
- and lock the nut.



Infeed belt

Turn screw (A) clockwise in order to shift the infeed belt in the direction shown in figure ⬆ .

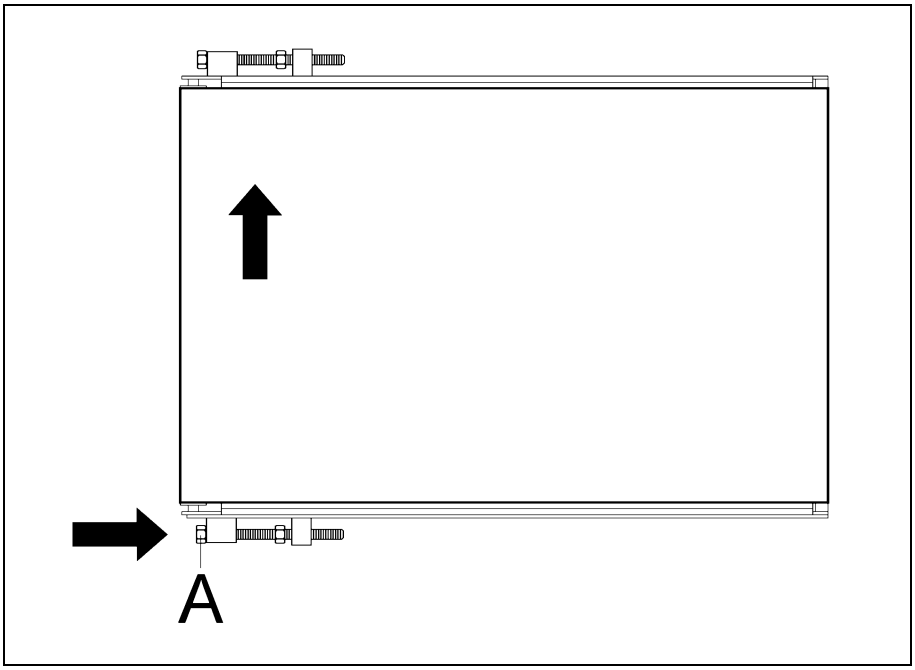
To move the belt in the opposite direction ⬇ turn screw (A) anti-clockwise.



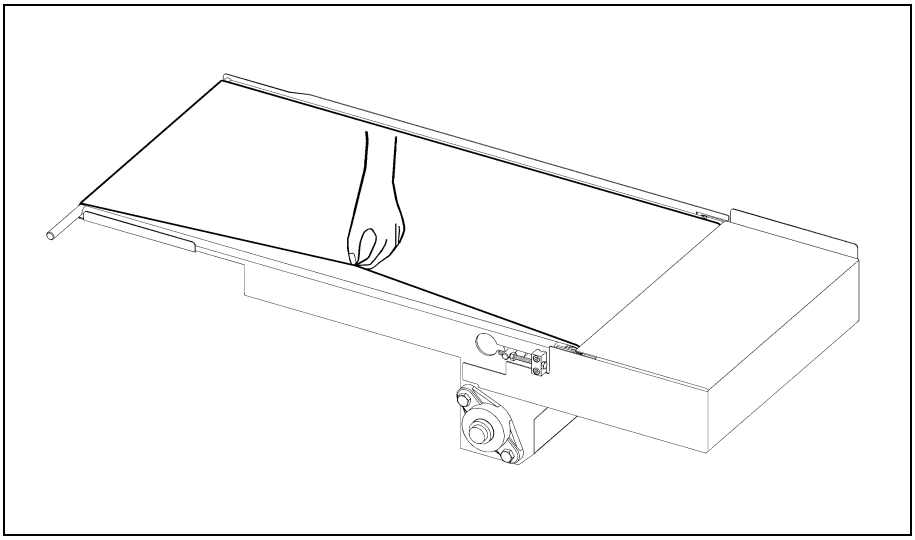
Outfeed belt

Turn screw (A) anti-clockwise in order to shift the outfeed belt in the direction shown in figure ⬆ .

To move the belt in the opposite direction ⬇ turn screw (A) clockwise.



Correct belt tension is obtained when there is approximately 40 mm (*1,6 in*) between the loading surface and the said belt when lifting it.



5.8. Packaging

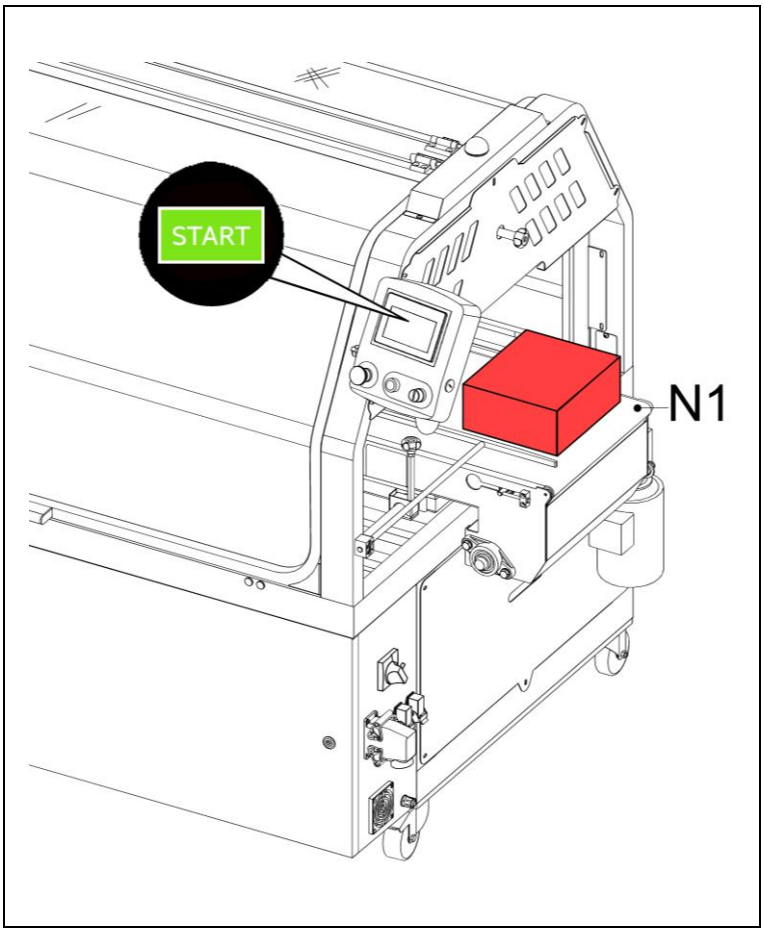
Having made all the necessary adjustments, the machine is ready to proceed with packaging.

With the machine in “AUTOMATIC” mode,

press the start cycle key START .

The belts will start operating and it is possible to place the product on the infeed belt (N1).
When the product passes along the outfeed belt, the sealing frame lowers in order to seal the film.

The packaged product moves towards the roller conveyor or inside the tunnel to shrink the film.



Chapter 6. Ordinary maintenance | EN

6.1. Precautions and setting to maintenance mode

CAUTION!

- Maintenance must be performed exclusively by skilled personnel familiar with the machine.
- Never carry out maintenance, lubrication, or repairs when the machine is in operation and/or connected to the power supply.
- Never carry out maintenance on moving parts.
- After each operation re-mount any guards that have been removed, and bring the machine back to its original state.
- Always observe all safety standards as specified in this manual and these currently applied in the country of installation.

SETTING THE MACHINE TO THE MAINTENANCE MODE

This procedure must be performed before all routine maintenance, cleaning and special maintenance, to shut off the machine from all power sources, as follows:

- Switch the machine off by rotating the main switch (Q1) to “0” (OFF)
- Remove the plug from the mains socket
- WAIT 15 minutes to allow the capacitors to discharge.

6.2. Maintenance table

Routine maintenance plan

This type of machine is designed for minimal maintenance; however always observe Maintenance schedule set out below.

Frequency	Component	Operation
Every day	Machine	Remove any residues left by the products being processed, which could affect correct machine operation. It is recommended to use compressed air.
Every day	Photocell, sensors and reflector	Clean with soft cloths.
Every day	Blades	Use cloths or paper to clean the surface that comes in contact with the film. Do not use objects that could damage their surface.
Every month	Infeed and sealing belts	Check alignment and tension.
Every month	Blades and contrast bars	Check the wear status of the Teflon adhesive and the silicone strip.
Every 12 months	Belt supports	Lubricate with high-viscosity grease for high temperatures (e.g.: SKF LGHB 2 or similar).
Every 12 months	Gear couplings	Check for the presence of lubricating grease.

Maintenance plan of safety devices

The periodical control of the “**SAFETY DEVICES”** listed in the table is required.

Frequency	Component	Operation
Every month	Front and rear guards (paragraph 4.4)	▪ Opening of front guards (C1) and rear guards (C2) and (C3) guards, both in manual and automatic mode ▪ **Check the consequences:** ▪ luminous and acoustic alarm, the machine blocks.
Every month	Sealing bar protections	▪ Movement of guards placed around the sealing bar near the four sensors, in manual mode ▪ **Check the consequences:** ▪ luminous and acoustic alarm, the machine blocks.
Every month	Emergency button	▪ Activation of emergency button in manual and automatic mode ▪ **Check the consequences:** ▪ luminous and acoustic alarm, the machine blocks.

Record of control

Each control of the safety devices must be recorded, indicating the data and result of the control performed: date of check, inspector, result.

Reporting fault

Should a fault be detected, contact the Assistance Service of the Supplier for its restoration.

Chapter 6. Ordinary maintenance | EN

6.3. Disassembling, demolition and elimination of residuals

ATTENTION!
All disassembling and demolition operations must be done by qualified personnel with mechanical and electrical expertise required to work in safe conditions.

Proceed as follows:
- disconnect machine from power mains
- disassemble components

All wastes must be treated, eliminated or recycled according to their classification and to the procedures in force established by the laws in force in the country where the equipment has been installed.

The symbol indicates that this product shall **not** be treated as household waste. By making sure that the product will be properly disposed of, you will facilitate the prevention of potential negative effects for the environment and human health, which might be otherwise caused by the improper waste treatment of this product. For more detailed information about the recycling of this product, please contact the product seller or, as an alternative, the after-sales service or the corresponding waste treatment service.

Chapter 7. Guarantee | EN

7.1. Guarantee conditions

The guarantee runs for 12 months and comes into force on the installation date of the machine. The guarantee covers free replacement or repair of any parts due to defects arising from faulty material. The repairs or replacement are usually carried out at the manufacturer's premises, with transport or labour charged to the buyer. If the repair or replacement is carried out at the buyer's premises, he shall bear the travelling, transfer and labour costs. Work under guarantee can be carried out exclusively by the manufacturer or by the authorised dealer. In order to be entitled to repairs under the guarantee, the faulty part must be sent for repair or replacement to the manufacturer or his authorised dealer. The return of such repaired or replaced part will be considered fulfilment of the guarantee.
The guarantee is voided:
- in case of inappropriate installation, power supply, misuse and mishandling by unauthorised persons.
- in case of changes made to the machine without prior agreement in writing from the manufacturer.
- if the machine is no longer the property of the first buyer.

The manufacturer declines all liability for personal injury or damage in case of inappropriate installation or connection to the power mains or omission of connection to earth or in case of any mishandling of the machine. The manufacturer undertakes to carry out any variations and changes made necessary by technical and operating requirements.

IN THE EVENT OF DISPUTES THE COURT OF BERGAMO (ITALY) SHALL HAVE SOLE JURISDICTION.

IT	DICHIARAZIONE CE DI CONFORMITA'	EL	ΔΗΛΩΣΗ ΠΙΣΤΟΠΟΙΗΣΗΣ CE
EN	CE DECLARATION OF CONFORMITY	CS	ES PROHLÁŠENÍ O SHODĚ
DE	KONFORMITÄTSERKLÄRUNG	NL	CE GELIJKVORMIGHEIDSVERKLARING
FR	DECLARATION CE DE CONFORMITE'	FI	EY-VAATIMUSTENMUKAISUUSVAKUUTUS
ES	DECLARACIÓN CE DE CONFORMIDAD	RU	ДЕКЛАРАЦИЯ СООТВЕСТВИЯ CE
SV	ÖVERENSTÄMMELSEFÖRKLARING EC	한국어	적합성의 CE 선언
PT	DECLARAÇÃO CE DE CONFORMIDADE		

IT	Noi:	SV	Vi:	FI	Me:
EN	We:	PT	Nós:	RU	Мы:
DE	Wir:	EL	Εμείς:	한국어	자사:
FR	Nous:	CS	My:		
ES	Nosotros:	NL	Wij:		

MINIPACK-TORRE S.p.A.
Via Provinciale, 54 – 24044 Dalmine (BG) - Italy

IT dichiariamo sotto la nostra esclusiva responsabilità che il prodotto
EN declare under our responsibility that the product
DE erklären unter unserer ausschließlichen Verantwortung, dass das in dieser Erklärung genannte Produkt
FR déclarons sous notre exclusive responsabilité que le produit
ES declaramos bajo nuestra exclusiva responsabilidad que el producto
SV förklarar under eget ansvar, att produkten
PT declaramos sob a nossa exclusiva responsabilidade que o produto
EL δηλώνουμε υπεύθυνα ότι το προϊόν
CS prohlašujeme výhradně na vlastní zodpovědnost, že produkt
NL verklaren op onze exclusieve verantwoordelijkheid dat het product
FI vakuutamme yksinomaisella vastuullamme, että tuote
RU под нашу исключительную ответственность заявляем, что данное изделие
한국어 자사의 독점적인 책임 하에 다음을 선언합니다. 제품

IT	MACCHINA CONFEZIONATRICE TIPO:	SV	PACKNINGSMASKIN TYP:	FI	PAKKAUSKONE TYYPPI:
EN	PACKAGING MACHINE MODEL:	PT	MÁQUINA CONFECCIONADORA TIPO:	RU	УПАКОВОЧНАЯ МАШИНА ТИПА:
DE	VERPACKUNGSMASCHINE TYP:	EL	ΜΗΧΑΝΗ ΣΥΣΚΕΥΑΣΙΑΣ ΤΥΠΟΥ:	한국어	포장 기계 유형:
FR	MACHINE D'EMBALLAGE MODELE:	CS	BALICI SROJ MODEL:		
ES	MÁQUINA CONFECCIONADORA TIPO:	NL	VERPAKKINGSMACHINE TYPE:		

☐ **Pratika 56 MPE X1** **n° /**

☐ **Pratika 56 MPE X2** **n° /**

IT è conforme ai requisiti essenziali di sicurezza e a tutte le disposizioni pertinenti delle direttive applicabili
EN conforms to the essential safety requirements and all the provisions of the applicable directives
DE entspricht den grundlegenden Sicherheitsanforderungen und allen betreffenden Bestimmungen der einschlägigen Richtlinien
FR est conforme aux exigences essentielles de sécurité et à toutes les dispositions pertinentes des directives applicables
ES cumple los requisitos fundamentales de seguridad y todas las normas pertinentes de las directivas aplicables
SV uppfyller de väsentliga säkerhetskraven och relevanta bestämmelser i gällande direktiv
PT é conforme os requisitos essenciais de segurana e a todas as disposições pertinentes das directrizes aplicáveis
EL συμμορφώνεται με τις βασικές απαιτήσεις ασφαλείας και όλες τις συναφείς διατάξεις των εφαρμόσιμων οδηγιών
CS splňuje základní požadavky na bezpečnost a všechna příslušná ustanovení platných směrnic
NL conform is met de essentiële veiligheidsvereisten en met alle pertinente bepalingen van de richtlijnen die van toepassing zijn
FI vastaa kaikkia olennaisia turvallisuutta koskevia vaatimuksia ja kaikkia sovellettavien direktiivien asiaakoskevia määräyksiä
RU соответствует основным требованиям безопасности и всем соответствующим положениям в действующих директивах
한국어 은 필수 안전 요구사항들과 적용할 수 있는 지침들의 관련된 모든 규정을 준수합니다

2006/42/CE, 2014/30/UE, 2014/35/UE

IT E inoltre dichiariamo che sono state applicate le seguenti norme armonizzate
EN And furthermore we declare that the following rules have been applied
DE außerdem bestätigen wir, dass folgende harmonisierte Richtlinien angewendet wurden
FR Nous déclarons également que les normes harmonisées suivantes ont été appliquées
ES Además declaranos que han sido aplicadas las siguientes normas armonizadas
SV Dessutom förklarar vi, att följande harmoniserade normer har använts
PT E, além disso, declaramos que foram aplicadas as seguintes normas harmonizadas
EL Επίσης δηλώνουμε ότι εφαρμόσθηκαν οι εξής εναρμονισμένες προδιαγραφές
CS A kromě toho prohlašujeme, že byly aplikované následující harmonizované normy
NL We verklaren bovendien dat de volgende geharmoniseerde normen worden toegepast
FI Tämän lisäksi vakuutamme, että olemme soveltaneet seuraavia yhdenmukaistettuja standardeja
RU Также мы заявляем, что были применены следующие согласованные нормативы
한국어 또한 일치되는 다음 규범들이 적용되었음을 선언합니다

EN 12100:2010, EN 61000-6-3:2007, EN 61000-6-1:2007, EN 60204-1:2010

IT Persona autorizzata a costituire il Fascicolo Tecnico: Responsabile Ufficio Tecnico
EN Person authorized to draft the Technical File: Head of the Technical Dept
DE Zur Erstellung des Technischen Merkhefts befugte Person: Verantwortlicher der Technischen Abteilung
FR Personne autorisée à constituer le Fascicule Technique : Responsable Bureau Technique
ES Persona autorizada a elaborar el Fascículo Técnico: Responsable del Departamento Técnico
SV Person med behörighet att skapa den Tekniska Dokumentationen: Tekniskt ansvarig
PT Pessoa autorizada a compilar o Processo Técnico: Responsável pelo Gabinete Técnico
EL Άτομο εξουσιοδοτημένο να καταρτίσει το Τεχνικό Τεύχος: Υπεύθυνος Τεχνικού Γραφείου
CS Osoba autorizovaná k vystavení Technické dokumentace: Vedoucí technického oddělení
NL Persoon bevoegd om het technisch dossier op te stellen: Verantwoordelijke technische dienst
FI Teknisten asiakirjojen laatimiseen valtuutettu henkilö: Teknisen toimiston vastuuhenkilö
RU Лицо, уполномоченное для составления технического файла: начальник технического отдела
한국어 기술 파일을 제조하도록 공인된 인력: 공식 기술 책임자

Dalmine,

Torre P.I. Fabio Emanuele

IT	Consigliere Delegato	SV	Verkställande Direktör	FI	Toimitusjohtaja
EN	Managing Director	PT	Conselheiro Delegado	RU	Управляющий директор
DE	Geschäftsführer	EL	Ο Διευθύνων Σύμβουλος	한국어	대표 이사
FR	Directeur Général	CS	Generální ředitel		
ES	Consejero Delegado	NL	Gedelegeerd bestuurder		