

- I** *Manuale di uso, manutenzione e ricambi*
- GB** *Operating, maintenance, spare parts manual*

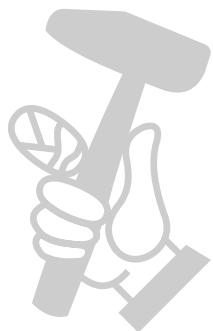
# **CUTTING MACHINE**

***mod. - S26 - S32 - S36 -  
S40 - S45 - S50 - S55***



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## 1. INTRODUCTION AND GENERAL PROVISIONS

This manual is directed at the user and operator who will be responsible for the safe, efficient and trouble free operation of the machine. Read and understand this manual and always follow the safety precautions outlined in the Instruction and Safety Manual. Keep this manual handy for frequent reference and to pass on to new operators or owners.

The machine is equipped with tested special safety devices and safety systems. SILLA cannot be held responsible for unauthorized modifications or procedures, replacements and/or all other modifications changing the use the machine has been designed and manufactured for.

### **Warranty:**

The mechanical and electrical products of the machine, which are not normal service items, have a one-year warranty starting from the date of the sale. The warranty does not cover the normal service items like tools, driving belts, liquids and oils.

The defective or not properly working products will be replaced by the Technical Personnel of the Manufacturer of the machine, after the defective product has been proven to be defective. The warranty does not cover the products in case of modification, abuse, misuse, improper use, negligence or improper maintenance (routine and extraordinary maintenance) as shown by this I.M. This warranty is valid in the territory of the European Community. The consumer is the right holder according to the applicable national laws governing the sale of consumables and this warranty makes those rights unprejudiced.

## 2. MARKING

A label with the following machine identification data is located on the machine:

- EC marking according to EC directive 2006/42, Enclosure III;
- Name and address of the manufacturer and/or legal representative in Europe;
- Machine designation;
- Machine type;
- Serial or part number;
- Year of construction.

For assistance and information or spare parts, refer to:



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**In case this Instruction Manual should get lost or destroyed ask the Company SILLA for a complete copy.**

### LIST OF ABBREVIATIONS AND DEFINITIONS USED IN THIS MANUAL

Danger	Source of probable injuries to the health
Dangerous area	Any area inside and/or next to a machine where the presence of a person is a risk for the safety and the health of said person.
Exposed person	Any person, in whole or in part, inside a dangerous area.
Operator	Person or persons having the task of install, making it work, regulating it, carrying out maintenance procedures, cleaning, repairing and transporting a machine.
Hazard	Combination of probabilities and seriousness of probable injuries to the health in a dangerous situation.
Guard	Machine element specifically used for granting protection by means of a material barrier.
Protection device	Device (other than a guard) reducing the hazard, alone or together with a guard.
Authorized use	The use of the machine according to the information given by the instructions for use.
Not authorized but reasonably predictable use	The use of the machine different from that shown in the instructions for use, but which can derive from easily predictable human behaviour.
	Caution: precautions and instructions to be strictly followed.



### 3. GENERAL PRECAUTIONS

- The operating safety of the machine is only granted for the functions listed in this instruction manual. **SILLA** cannot accept any responsibility, if the machine should be used for different uses than those listed in this manual or uses, which do not comply with the operating instructions.
- **SILLA** cannot accept any responsibility for safety, liability and performances of the machine, if the precautions and the instructions of this instruction manual, especially referred to use on building yards, maintenance and dismantling are disregarded.
- The correct use of this cutting machine implies good knowledge of these instructions for use and the hazards connected with its possible incorrect use.
- Consequently, the cutting machine shall only be used by skilled and authorised personnel. The operator using the cutting machine shall be trained on its correct use, the relevant protection devices and the accessory tools.
- The operating safety of the cutting machine is only guaranteed for the functions and the materials listed in this instruction manual.
- **SILLA** cannot accept any responsibility, if the cutting machine is used for other purposes than those outlined in this manual and which do not comply with the operating instructions.
- The cutting machine shall not be used in places with the presence of gas, inflammable liquids or other inflammable materials. The machine shall not be installed in environments with risk of explosion
- **SILLA** cannot accept any responsibility for safety, liability and performances of the machine, if the precautions and the instructions of this instruction manual, especially referred to: use, ordinary and extraordinary maintenance and repair are disregarded.
- The electric installation of the user shall comply with the CEI 64.8 standards ( CENELEC HD 384).  
The Manufacturer cannot accept any responsibility, if the cutting machine is not properly connected to the unipotential earthing system and if there are no protection devices installed upstream, which are coordinated to ensure automatic cut-off, according to the standards mentioned before.
- For maintenance works needing some components to be replaced, only use original spare parts or spares authorized by the Technical Dept. of Silla.  
In particular, ensure the maintenance of the electric installation is carried out by specialised and authorised personnel and by using original components.
- However, for service or repair works always refer to the After-Sales Service recommended by the supplier of the cutting machine.

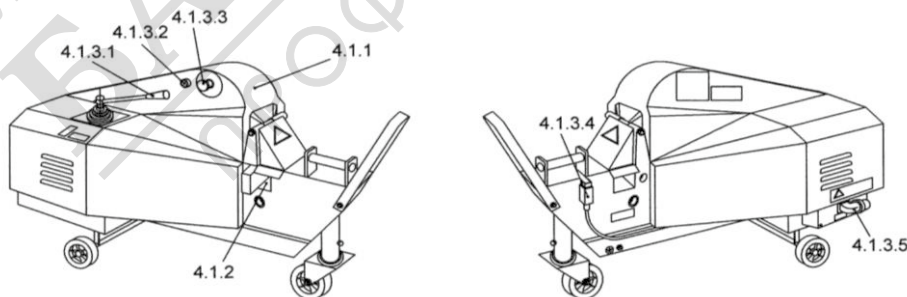
- The user of the cutting machine takes full responsibility for its good and safe operation, if the machine was not repaired or maintained by the specialized or authorised personnel.
- The cutting machine is delivered with the protection devices already installed and fixed. Check and maintain these protection devices and the whole cutting machine per the schedule recommendations.
- Do not wear any jewellery or clothing that can get caught or distract from the operation of the machine.
- Ensure good lighting (natural or artificial) of the cutting machine and the control panel to avoid shady areas, dangerous dazzling and stroboscopic effects.
- For extraordinary maintenance and repair use only original spare parts. For all repairs, please refer to the After-Sales Service authorised by the supplier of the machine.
- All the above-mentioned operations shall be carried out in an appropriate place with the machine switched off and the electric supply cable disconnected, in order to prevent other persons from starting the machine.
- All the operators using the machine shall be trained on its correct use, the safety devices, the behaviour and actions to perform for a correct use of the machine and operators' safety.
- During the use on the construction site, the machine shall be protected against falling objects by means of a solid plank covering (see also art. 114 DLgs 81/08)
- The machine is delivered with the protection devices already installed; however, the operator shall check their good working before starting to use the machine. Check and maintain these protection devices and the complete machine according to the maintenance schedule. The operator shall reflect upon the possible consequences before approaching with his hands, in particular:
  - **NEVER SWITCH ON THE MACHINE WITHOUT THE PROTECTION SHIELDS;**
  - **NEVER REMOVE AND NEVER OPEN THE PROTECTION SHIELDS WHEN THE MACHINE IS RUNNING.**
  - **NEVER SWITCH ON AND NEVER START WORKING WITH THE MACHINE IF THERE ARE BYSTANDERS.**
- The machine has a considerable mass; therefore do not use it in case of storms. Electrocutation hazard!
- Clear the area of unauthorized personnel or obstacles, before starting work.
- The operator shall wear appropriate clothing: work gloves, safety shoes, etc. Do not wear any jewellery or clothing that can get caught on the machine.
- Follow the safety precautions, in particular:
  - Switch off the machine before opening or cleaning it; ensure no one can turn it on by accident;
  - Use the protective equipment (work gloves, safety shoes, etc.) during use, assembly and maintenance of the machine;
  - Be cautious in approaching all the moving parts.

Follow the safety instructions shown in chapter **SAFETY PRECAUTIONS**.

## 4. CHARACTERISTICS

### 4.1 Description of the machine

The cutting machine has a metal structural work structure. The following are the machine units:



#### 4.1.1 Machine body.

The machine body has a welded metal structural work base, a screwed casing manufactured from sheet, a case protecting the cutting area (see section 5.4) and wheels.

#### 4.1.2 Cutting unit.

The cutting unit has a single-acting oil-pressure cylinder, which is connected to the arm of the cutting machine and controls the operation of the cutting blade. Cylinder reversal is done by means of two pull springs anchored to the machine body. A pump driven by an electric motor, which is connected to a flow distributor, feeds the cylinder with oil. Under the base there is tank for the oil.

#### 4.1.3 Control unit.

This unit has a control lever (4.1.3.1), a start button (4.1.3.2), a stop button (4.1.3.3), a safety switch in the cutting area (4.1.3.4) and a box with outlet 4.1.3.5.



## 4.2 Technical characteristics and dimensions

Technical data of Cutting Machines:

TECHNICAL DATA							
	S 26	S 32	S 36	S 40	S 45	S 50	S 55
LENGTH (mm)	890	1050	1150	1330	1330	1330	1330
WIDTH (mm)	510	530	600	680	680	680	680
HEIGHT (mm)	850	910	730	870	870	870	870
WEIGHT (Kg)	150	215	250	370	380	420	550
Electric motor	3	3	3	4	4	5,5	7,5



### 4.3 SAFETY PRESCRIPTIONS Limits for use, space, endurance

The cutting machine has been designed for continuous working 8 hours/day; it can also be used for 16 or 24 hours/day by suffering a proportional loss of endurance. Electric energy shall be used according to the parameters shown in section 5.7.

The electrical connection shall be carried out according to the parameters shown in the “wiring diagram” of page 9. The cutting machine shall be installed in a covered place with ambient temperature between +5° C and + 40° C and humidity up to 90 % at 20° C.

Lack of appropriate maintenance, as recommended in section 8, will reduce both endurance and reliability of the cutting machine.

The machine shall not be used in places at risk for explosions or fires (gas/powders) (no Ex protection). The machine has been designed and built just for cutting structural steel in different configurations (rod iron, square and flat drawn iron) on building yards.

Metal drawn products, made from low-carbon steel with dimensions deducible from the following schedule:

Mod.	Performances								
	45 Kg/mm <sup>2</sup>			65 Kg/mm <sup>2</sup>			85 Kg/mm <sup>2</sup>		
	∅	▣	▤	∅	▣	▤	∅	▣	▤
S55	55	50	80x25	50	40	70x20	45	35	70x15
S50	50	40	60x20	42	34	60x15	50	30	50x20
S45	45	36	40x20	34	30	35x20	32	24	30x15
S40	40	32	40x20	32	26	30x20	30	22	25x20
S36	36	28	35x15	30	24	30x15	26	22	25x15
S32	32	26	30x15	26	20	25x15	24	18	20x15
S26	26	26	30x15	22	20	25x15	20	18	20x15

The cutting machine performances may be different according to various external factors and to the type of product being processed.

In view of its specificity it is not possible to use the cutting machine for purposes other than those outlined in this instruction manual. Furthermore, the manufacturer cannot foresee other ways of using the machine, according to point 1.1.2 letter C of EEC directive 2006/42.

Ensure the areas of respect of the machine, according to its range of action and the relevant work area, also in view of the dimensions of the materials to be cut.

Do not exceed machine limits. Do not modify the machine to improve its performances.

Leaving the machine unattended in public places is dangerous. Therefore, provide appropriate barriers around the work area to prevent unauthorized persons from approaching it.

Do not make attempts to repair the machine, always call authorized repair shops.

Serious infection or toxic reaction can develop from hydraulic fluid piercing the skin surface. Wear proper hand and eye protection when searching for a high-pressure hydraulic leak. Use a piece of wood or cardboard as a backstop instead of hands to isolate and identify a leak. Should the oil pierce the skin surface, seek medical attention immediately.

Before connecting or disconnecting any electric component, you must know very well the electric system. A wrong connection may cause injuries and damages.

Oil is a special waste and must be disposed of according to the laws in force.

The electric installation of the user shall comply with CEI 64/8 standards and Law 46/90; it shall be equipped with automatic protection devices, which are coordinated with the earthing system. Ensure good lighting in the work area and around the machine, in order to avoid shady areas, dangerous dazzling and stroboscopic effects. The Manufacturer cannot accept any responsibility, if the cutting machine is not properly connected to the unipotential earthing system and if there are no protection devices installed upstream, which are coordinated to ensure automatic cut-off, according to the standards mentioned before.

The scrap materials, which are produced during the machining, must be collected and sent to specialized companies for disposal, according to the laws in force, in order to protect the environment.

The materials to be processed with their minimum/maximum dimensions are those stated in table 4.3 .  
Although the user strictly follows the instructions for use, there still might be some residual hazards during the use of the machine.

The machine shall be used by qualified and healthy adults only.

#### CAUTION !!!!!



**EVERY USE OF THE MACHINE DIFFERENT THAN THOSE OUTLINED BY THE MANUFACTURER IN THIS INSTRUCTION MANUAL IS AN IMPROPER USE. THEREFORE, THE COMPANY SILLA CANNOT ACCEPT ANY RESPONSIBILITY, IF THE MACHINE SHOULD BE USED BY THE OPERATOR FOR DIFFERENT USES THAN THOSE LISTED IN THIS INSTRUCTION MANUAL OR THOSE NOT COMPLYING WITH THE OPERATING INSTRUCTIONS.**

#### 4.4 Noise



- the noise emission level of the Cutting Machine measured at the operator's ear does not exceed the maximum value of 63 Pa, according to UNI 11200 standard

In order to not increase the noise level strictly follow these rules:

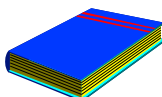
- Clean and grease the machine elements per the schedule recommendations;

- Ensure the machine parts are not obstructed or damaged.



With this noise emission level the use of protective equipment like earmuffs, earplugs, etc. **is not mandatory** but recommended.

These noise values are emission levels and are not necessarily safe work levels. While there is a correlation between the emission levels and the exposition levels, it cannot be used in a reliable way to evaluate whether there is or nor the need for additional precautions. The factors affecting the worker's real exposition level include the duration of the exposition, the environmental characteristics, other emission sources like for example the number of adjacent machines and types of machining. The single exposition levels may also differ from country to country. However, thanks to this information the user of the machine can better evaluate the dangers and risks.



#### 4.5 Conformity with safety regulations

The Cutting Machine has been designed and built in accordance with the following standards:

**"Machinery Safety Directive" EC 2006/42 published in the Official Gazette of European Union on**

**June 9, 2006.**

**" Electromagnetic Compatibility Directive " EC 2004/108 , published in the Official Gazette of European Union on December 31, 2004.**

- EN ISO 12100-1 (2003) Safety of machinery - basic concepts, general principles of design – Part 1: basic terminology, methodology.
- EN ISO 12100-2 (2003) Safety of machinery - basic concepts, general principles of design – Part 2: technical principles.
- EN ISO 14121-1 (2007) Safety of machinery – risk evaluation -Part 1: principles
- EN ISO 13850 (2008) Safety of machinery – emergency stop – principles of design.

## 5. INSTALLATION / NEW BUILDING YARD

### 5.1 Transport

The cutting machine is delivered to the Customer fully assembled and tested.

The packed machine, protected with proper material, is assembled on the pallet and fixed to it by means of two tie rods. Fix the package to the platform of the means of transport by means of proper retention instruments, such as: special belts, ropes, etc.

Unload the machine by means of suitable means, such as fork lifts, by inserting the forks in the special openings of the pallet. Then place the machine onto its wheels on a level soil capable of supporting its weight. Before transporting the machine to another building yard, pack and protect the machine with proper material, assemble and fix it on/to the pallet by means of two tie rods. Fix the packing to the platform of the means of transport by means of proper retention instruments, such as: special belts, ropes, etc.

The weight of the machines is outlined on the EC plate and in section 4.2 of this manual; due to their considerable weight you must provide accurate loading/unloading means.

Ensure your hoisting equipment has adequate dimensions and capacity.



**Be careful during hoisting and handling the machine to prevent injury to persons and damage to the machine.**

**The hoisting equipment shall be dimensioned according to the weight to be hoisted.**

The machine is delivered together with the following accessories:

- 1 Instruction Manual for use, maintenance and spare pieces with EC statement of conformance;
- 4 Allen wrenches size 4-5-6-10 for mod. S26 and size 4-5-6-14 for the other models;
- 1 flat setscrew wrench size 13-17 for mod. S26 and size 17-22 for the other models;
- 1 Grease pump (only for mod. S36-40-45-50);



**Never hoist the machine by hand, even if you are more than one person: it is too dangerous.**

**Follow the safety instructions shown in chapter SAFETY PRECAUTIONS**



### 5.2 Placing and earthing

Place the machine on a steady and level soil. Check the flatness of the soil before installation by means of a water level (longitudinally and crosswise).

The installation place shall be protected against atmospheric agents. During the use on the construction site, the machine shall be protected against falling objects by means of a solid plank covering (see also art. 114 DLgs 81/08).

Make sure the soil is correctly dimensioned to support the weight of the machine. It must be self-extinguishing and not combustible.

Next to the machine there must be a 3 P+T 16A plug for the connection with the electric installation. Connect the machine to the general ground system of the building yard by means of the power cable. Its resistance shall not exceed 883 Ohm, otherwise the cutting machine shall be connected to a supplementary ground rod by connecting it to the special ground screw (earth rod see fig. 2).

In case the machine shall be connected to a generating set, by means of electrical separation (NOT grounded generating set), the following conditions shall be respected, according to the CEI 64-8 standard:

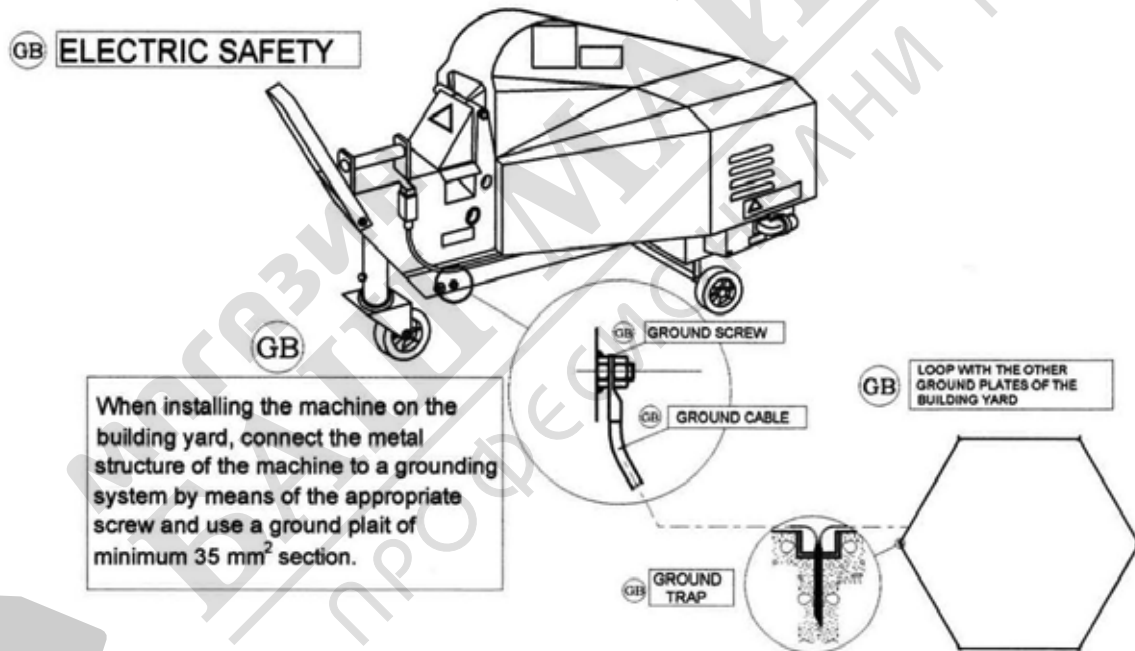
- the machine shall not be connected to a ground system;
- extension of the circuit below 250 metres;
- realisation of equipotential bonding between machine mass and other equipment mass powered by the same generating set;
- the power cables shall be properly isolated and it shall be possible to inspect their whole length.

However, follow provisions for electrical separations mentioned in the CEI 64-8 standard.

Make sure there is an area of respect of at least 2000 mm around the machine. During machining the machine produces scrap and dust, which must be disposed of by specialized companies.

Next to the machine there must be:

- Connection to the electric supply mains;
- areas for the hoisting and handling of work products;
- areas for the collection and discharge of residual products;



Never use the machine near inflammable or explosive materials and/or in places with the presence of gas.

Follow the safety instructions shown in chapter SAFETY PRECAUTIONS.

Unauthorised persons shall never use the machine.



### 5.3 Areas of respect and dimensions

The area of respect around the machine shall be at least 2 meters to ensure good working and correct maintenance of the machine. The personnel shall move within this area with the utmost care.

Inside the area of respect the operators shall move with the utmost care and eliminate all kinds of obstacles hindering the passage. The driving seat may become slippery because of work residuals. Use the personal protective equipment (safety shoes) and frequently clean the floor.



Caution! The use of additives or special products for cleaning the machine may injure the health of the person. Carefully read the prescriptions of the relevant products. These products may also modify the quality of the paint of the Cutting Machine and damage its hydraulic parts.

**5.4 Pre- operation checklist**

**Use work gloves during set-up and setting at work of the machine.**



Before the setting at work of the cutting machine, especially at first starting or when it is installed on a new work site, the following technical advices and suggestions concerning the various types of connections shall be respected.



**5.5 La Safety first**

All the machines can be dangerous. When the Cutting Machine is correctly used and properly maintained, it is a very safe machine. On the contrary, if it is badly used, it may become dangerous. Both in this manual and on the machine there are warning signs showing the possible hazards and how to avoid them. Do not operate the machine, until you are not able to control it. Do not start any work until you are not sure about your and other people's safety. You can cause serious damage, if you try to carry out some non-familiar operations, without prior testing on free areas, far from people and on level ground.

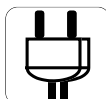
**Follow the safety instructions shown in chapter 4.3 SAFETY PRECAUTIONS**



**5.6 Putting into operation**

- On delivery the machine is connected to 380 V. Before starting the machine, ensure the following:
  - The motor voltage must correspond to the voltage of the external line.
- Grounding according to I.S.P.E.L.S standards is mandatory.
- The feeding cable shall not be below 4x1,5 mm.
- Change-over to 220 V voltage has to be carried out as follows:
  - a) Change the terminal board from "star" to "delta"
  - b) Displace the electric connection of the transformer at input from 380 V to 220 V.
- Check the area of respect and the work areas;
- Check the protections for good fixing;
- Check the caution/danger signs on the machine for good visibility.
- Test all the mechanical and electric machine controls, loadless, to check correctness, efficiency and working;
- Check the oil level inside the tank through the level pilot lamp placed on the rear side of the machine.

**5.7 Electric installation**



The electric installation of the user must be in compliance with CEI 64.8 standards (Italian law n. 46/90). The machine is fitted with an electric plug.

**The plug must be connected to the installation of the user according to the maximum electrical input.**

**Provide the following: - Unipotential grounding system,**



- **The sum of the discharger resistances and the mass of the protection wires shall be below 883 Ohm.**

The connector shall be of type 3P +T complying with the CEI 23-12 standard . The supply cable shall be of type H07RN-F or expressly indicated by the manufacturer for laying outside in wet environments with a section suitable to the current to be conducted. The cable shall be protected by strong raceways against the passage of means and/or people.

Voltage drop shall be verified according to the following formula:

$$\frac{\Delta V}{V} = K * L * I < 4 \%$$

$\Delta V$  =voltage coefficient L= length I = Intensity in ampere line current  
K= coefficient (1,73 for three-phase lines) (2 for single-phase lines)

The grounding connection shall be done by means of a self-extinguishing

yellow-green cable, its minimum section shall not be below the one of the supply cable. Ensure grounding of all the metallic parts of the machine. Ensure the protection against lightning and/or electric discharges.

For installations on building yards, connect to the grounding system of the building yard also the additional external earthing plug, placed on one machine structure: use a copper cable with a section of 35 square millimetres provided with cable terminal and fix the cable terminal to the clamp with a screw nut (Fig. 2).

Ensure good lighting and visibility of the machine installation place, according to the work area, and avoid shady areas, dangerous dazzling and stroboscopic effects. The Company cannot accept any responsibility in case of wrong connection of the electric system or bad grounding.

The motors on the machine are protected by means of a magneto-thermal device. The motors are provided with special devices to avoid accidental machine starts after electric cutoff. In the case of intervention of the thermal protections, open by means of the special screwdriver the electric panel and reset the thermal switch by pressing the green push-button. All the electric elements and apparatus are protected according to the place of use, they have a protection grade of minimum IP 54 (protection from dust and liquids).

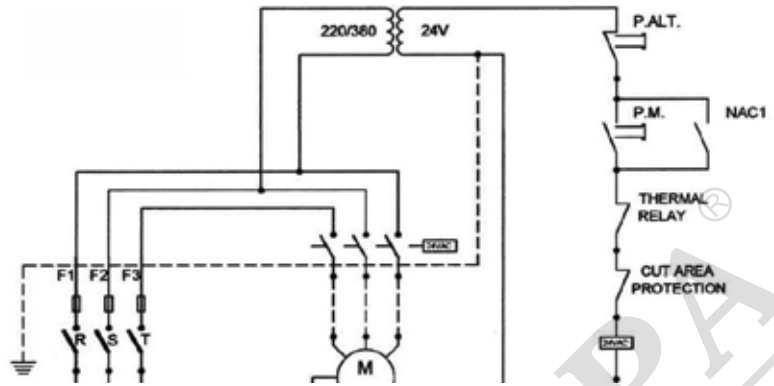
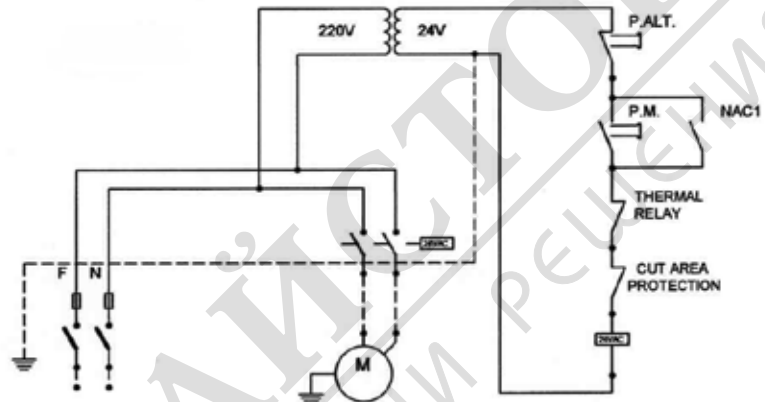
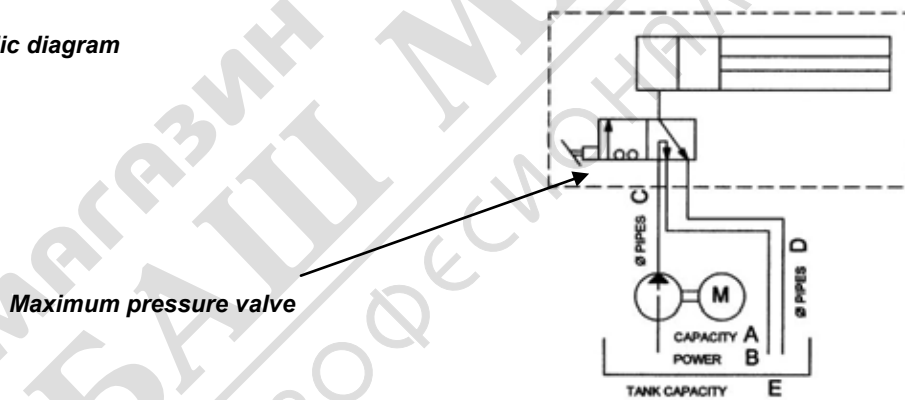
The control panel is placed so that is it visible by the operator, it also houses the supply plug. The machine is provided with a START/STOP push-button, which is placed on the machine case, on the side with the control level for fast machine starting/stopping.

**Follow the safety instructions shown in chapter SAFETY PRECAUTIONS**

**5.8 Diagrams**

GENERAL FEATURES OF CUTTING M/C
RATED POWER KW 2,2 -3 -4-5,5
RATED CURRENT A 4,4-6- 8-11
RATED VOLTAGE V 400
AUXILIARY VOLTAGE V 24
VALUE OF SHORT-CIRCUIT CURRENT MAX. = 30 KA
DEGREE OF PROTECTION IP 54



**5.8.1 Three-phase wiring diagram**

**5.8.2 Single-phase wiring diagram**

**5.8.3 Hydraulic diagram**


	S 26 Single-ph.	S 26 Three-ph.	S 32 Single-ph.	S 32 Three-ph.	S 36 Three-ph.	S 40 Three-ph.	S 45 Three-ph.	S 50 Three-ph.	S 55 Three-ph.
<b>A (l/1')</b>	3.8	6.3	9	11	11	11	11	11	11
<b>B (kW)</b>	2.2	2.2	2.2	2.2	2.2	3	4	5,5	5,5
<b>C (mm)</b>	1/2"	1/2"	3/4"	3/4"	3/4"	3/4"	3/4"	3/4"	3/4"
<b>D (mm)</b>	3/8"	3/8"	1/2"+1/4"	1/2"+1/4"	1/4"+1/2"	1/4"+1/2"	1/4"+1/2"	1/4"+1/2"	1/4"+1/2"
<b>E (l)</b>	6.5	6.5	9	9	9	9	12	12	12

## 5.9 Training



Before starting to use the machine, read this instruction manual and understand how to use the machine in a safe way.

## 6 ADJUSTMENTS

### 6.1 Adjusting the machine

At first operation on the building yard, the machine does not need any adjustments. However, we suggest to read the following paragraph:

- 5.4 Pre-operation checklist.



**Never carry out adjustments while the machine is running/working.**

**Do not alter or bypass any active safety devices installed on the cutting machine.**

**Follow the safety instructions shown in chapter SAFETY PRECAUTIONS.**

Every single adjustment and/or modification of the safety/work parameters set on the machine, which has not been authorised by the technical personnel of the company Silla or which is not outlined in this instruction manual, may influence the quality of the product and injure the operator's health. The company Silla decline any responsibility for liability, performances and safety of the machine in case of modification/alteration of the machine and of the relevant operation/safety parameters.

## 7. OPERATION

### 7.1 Control instruments

- The START and STOP push-buttons are placed on the main casing of the Cutting Machine.
- The STOP and the Emergency STOP push-button is installed next to the START push-button in a clearly visible way, in order to stop the machine at any time. To disengage it, turn it clockwise.
- The lever control placed on the upper side of the machine, allows the operator to carry out cutting operation by simply pulling the lever towards him. The control lever activates the cut because the oil enters the hydraulic cylinder. The control lever automatically returns into home position. The return of the cylinder is possible, even if the blade did not finish its stroke; you simply need to turn the lever into home position and the circuit reopens, thus allowing the return of the cutting unit.



During operation, follow the safety instructions shown in chapter SAFETY PRECAUTIONS.



### 7.2 Machine operation and controls

- **7.2.1 "START" push-button.**

It is used to start the oil-pressure pump or to reinitialise it after the emergency stop push button has been pressed and after power cutoffs. The oil-pressure pump does not automatically start after a power cutoff; it is the operator who must decide to start it again.

- **7.2.2 Emergency stop push-button**

It cuts the power supply to the electric motor, which starts the oil-pressure pump in case of need. The push-button is of type "mechanical interlock with rotary disengagement"; to disengage the push-button it must be turned cw. Another emergency stop push-button is placed on the machine opposite side in order to stop it at any time.



**Do not "play" with the emergency stop push-button. Use these buttons only for the use they have been designed for.**

- **7.2.3 Lever control**

The lever control placed on the upper side of the machine, allows the operator to carry out cutting operation by simply pulling the lever towards him. The control lever activates the cut because the oil enters the hydraulic cylinder.

The control lever automatically returns into home position.

The return of the cylinder is possible, even if the blade did not finish its stroke; you simply need to turn the lever into home position and the circuit reopens, thus allowing the return of the cutting unit.

### 7.2.4 Knob control

The models **S 36 - S40 - S45 -S50 –S55** also have a knob, placed on a machine side, for manual or automatic mode selection. By lowering this knob, before pulling the lever, you can set continuous cutting cycle. Consequently, after pulling the lever once, you can carry out cuts without the need to pull the lever again. All this is possible thanks to a mechanism that closes the oil circuit inside the cylinder, after the return of the arm of the cutting machine, thus starting a new cutting cycle.

### 7.3 Operation of the machine

#### 7.3.1 Starting the machine

- 1 – Connect the plug to the socket on the electric board; ensure the supply voltage is equal to the machine voltage.
- 2 – Lower the protection case of the cutting area.
- 3 – ONLY FOR MOD. S36 – S40 – S45 – S50: place the aforesaid knob in upper position (manual mode) or in lower position (automatic mode).
- 4 – Position the workpiece (or the workpieces) to be cut (see table at section 4.3).
- 5 – Press the “START” push-button to start the machine.



**Caution! If the protection case of the cutting unit is not closed, the machine will not work.**

**Do not alter or bypass any active safety devices installed on the cutting machine.**

- 6 – Pull the lever to cut.

#### 7.3.2 Stopping the machine

To switch off/stop the cutting machine, press the emergency stop push-button and cut the electric power supply or unplug.



**Keep the cutting machine always switched off when you do not use it.**

The operator shall always be careful and concentrate on what he is going to do and on the possible consequences.

#### 7.3.3 During operation

- Use the prescribed personal protective equipment.
- Never approach the moving and operating elements with your hands, arms or other parts of your body. Remove rubble with an appropriate device and always when the machine is stopped: **never use your hands! In case of accident, press the STOP push-button and lift the lever in to home position, the oil will automatically come out from the cylinder and the cutting unit will automatically return into its home position.** The same operation shall be repeated if one or several bars should jam inside the bar cutting unit.
- In case of machine trouble, or something to check, stop the machine and immediately disconnect it from the electric installation.
- During the operation of the machine, of its elements or of its accessories, it is strictly forbidden to remove any protection, safety switches, carters, barriers or other protection and safety elements. Never modify switches or other safety and/or operating cycle control devices, because such an intervention could seriously damage the mechanical elements of the machine and injure the health of the operator.
- Pay attention to the operating and the moving parts.
- Do not climb or position yourself on or inside the machine, even if it is switched off.
- In case of machine trouble, stop the machine with the emergency stop push-button and cut off the electric energy supply until the trouble has been eliminated.

**The operator is the person entitled to operate with the machine and consequently he is the only responsible for it.**

#### 7.3.4 Warning signs





## 8. MAINTENANCE

The machine does not require any particular maintenance work. The technical solutions and the components installed on the machine reduce maintenance at the minimum. However, we recommend to carry out a series of operations, which aim at ensuring safety, liability, efficiency and long life of the machine.



### Duing maintenance

- **Before performing any maintenance work on the machine, disconnect the power cable from the machine.** In case of mechanical or electric trouble, call the authorized personnel. If the machine is out of service because of trouble, maintenance or repair, place a special sign highlighting this status so as to avoid accidental starting.
- Always use the personal protective equipment (leather gloves of approved type, safety shoes, safety mask and safety goggles) during repair and replacement of the machine elements.
- Repairs of the electric installation shall be done by authorized and specialized personnel only.
- Do not approach hands, arms or other parts of your body to the movement and transmission area. Use appropriate means (brush, wooden piece, etc.) to remove possible rubble: **never use your hands!**
- To ensure long life, prevent damage and ensure the full functioning of the mechanical and electric machine elements the maintenance must be performed regularly. Periodically check the earthing system, according to the laws in force.
- Before starting the machine, ensure there are no tools or foreign matters left inside or on the machine.

### 8.1 Recommended lubricants

MINERAL OIL						
	23°E at 50°C – 320cSt at 40°C	32°E at 50°C – 450cSt at 50°C	AGIP			
HYDRAULIC SYSTEM	OSO 68		/			
	ISO – VG 68/460 TYPE					
GREASE						
LUBRIC. AND VARIOUS GEARS	MAKE	TYPE	PENETR.	DRIP	1 <sup>st</sup> LUBRIC.	FOLL.LUBR.
	ESSO	BEACON EP 2	265/295			

### 8.2 Ordinary Maintenance

- To be carried out every day at the end of the work.
- To be carried out every week at the end of the work.

#### A) DAILY CLEANING AND MAINTENANCE

Stop the cutting machine and cut off the electric energy supply, then remove material residuals and deposits from: the cutting area

**Caution!! Do not wash with high-pressure water jets.**

#### B) WEEKLY CLEANING AND MAINTENANCE

At the end of the week, after the cleaning of the cutting machine as explained above, provide for:

- Check tightening of clamping screws of main moving parts.
- Lubricate all the parts, which are not protected by means of painting.
- Check the oil level inside the tank through the pilot lamp placed on the rear side of the machine.
- Check the safety of the electric system: cable isolation, differential protection device, earthing conductor continuity, operation of safety switch of cutting area protection.
- Check the interlocks of the different mechanical components.
- Respect the lubricant replacement frequency (at least every two years), as stated in the lubrication table.



**Oil is a special waste and must be disposed of according to the laws in force.**

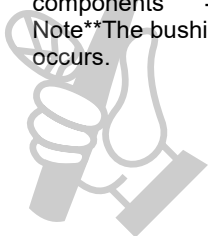
**IMPORTANT :**

**Los controles diarios y semanales son muy importantes también a nivel de prevención de las averías.**

**Daily and weekly checks are very important to prevent machine troubles. In fact, whenever during these checks you will find some worn or damaged components, immediately order the relevant spare parts to be kept on stock, before the component has definitively broken with consequent production stop.**

**8.3 Extraordinary maintenance** - Check the safety of the electric system: isolation of cables, working of differential protection device, continuity of protection wire, working of safety limit switch on guards. - Check interlocks of mechanical components - Change the lubricants according to the lubrication schedule.

Note\*\*The bushing, the electric motors and all other consumables must be immediately replaced whenever a running defect occurs.





**8.4 Bolt torque.** Tightening is executed by means of dynamometric wrenches, according to the toques shown in the following pages and in the tables shown below:

LARGE PITCH			SMALL PITCH		
Diameter screw x pitch	Nut torque Kgm	Screw torque Kgm	Diameter screw x pitch	Nut torque Kgm	Screw torque Kgm
6 x 1	1,1	1,2	8 x 1	2,7	1,2
8 x 1,25	2,6	2,8	10 x 1,25	5,5	2,8
10 x 1,5	5,1	5,6	12 x 1,25	9,7	5,6
12 x 1,75	8,9	9,7	14 x 1,50	15,3	9,7
14 x 2	14,1	15,5	16 x 1,50	23	15,5
16 x 2	21,5	23,6	18 x 1,50	33	23,6
18 x 2,5	29,5	32	20 x 1,50	46	32
20 x 2,5	42	46	22 x 1,50	62	46
22 x 2,5	57	62,5	24 x 2	79	62,5
24 x 3	72,5	79,5	27 x 2	115	79,5
27 x 3	107	117	30 x 2	160	117
30 x 3,5	145	159			

### 8.5 Troubleshooting

PROBLEM	CAUSE	SOLUTION
The machine does not run	No or low power in the supply line. The electric plug and socket are not properly connected. The cable from the plug to the electric panel is broken. A wire has become disconnected inside the panel. A wire has become disconnected on the terminal board. The switch is faulty. Intervention of a thermal protection. Tripped fuse.	Check supply line and voltage. Make a proper connection. Replace the cable. Remake the connection. Remake the connection. Replace the switch. Wait some minutes and try again. Change fuse.

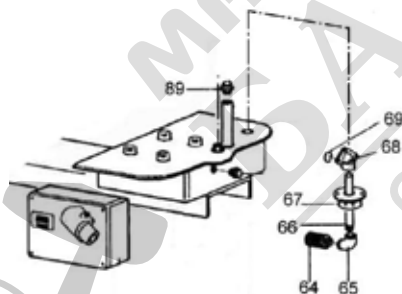


For all other kinds of troubles, please refer to the After-Sales Dept. of the Company SILLA.

**CAUTION!!!!!! SILLA DECLINES ANY RESPONSIBILITY IN CASE THE MACHINE DOES NOT UNDERGO MAINTENANCE AS PRESCRIBED IN THIS INSTRUCTION MANUAL AND IN CASE OF USE OF SPARE PARTS AND ACCESSORIES OTHER THAN ORIGINAL AND NOT APPROPRIATE.**

### 8.6 Maintenance of hydraulic unit

This unit is airtight and waterproof and does not need special maintenance. Periodically carry out level checks and ensure the oil is always clean. To change the filter cartridge inside the tank, drain the oil (from the plug placed under the tank) and remove the cover of the cutting machine.



Use only clean containers and fill in the oil through a funnel with filter. Every other operation on this unit shall be carried out by specialized personnel equipped with appropriate.

### 8.7 Ordering spare parts

When ordering spare parts, order the component from the supplier and/or manufacturer of the machine. Always mention the machine model, part number, type of machine, description of the desired component, quantity and the main features.

## 9 DISMANTLING

Before long-term storage (e.g. holidays), follow the instructions below:

1. Carefully clean the whole machine, remove dust, deposits and dirt.
2. Oil all the moving parts exposed to seizure and the mechanical components exposed to oxidation.
3. Store the machine in a dry and ventilated place.
4. Remove the patch cords and whatsoever to prevent unauthorized persons from using the machine.

### 9.1 Disassembling / dismantling

Before carrying out any dismantling or disassembling operation, disconnect the battery.

- Disconnect all the electric and mechanical components; - Disassemble the driving parts, bridges, motor and brakes. -
- Disassemble the oil-hydraulic parts of the distributor, pipes, cylinder, pump and hydrodrive.
- Disconnect and disassemble all the other mechanical components and the wheels.

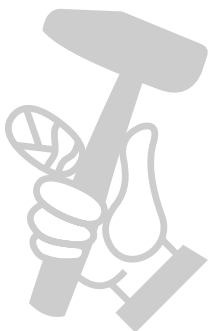
### 9.2 Disposal

The following are the materials the machine is made of:

- Painted steel, aluminium and other metallic components. - Plastic materials. - Oil-hydraulic materials
- Electric cables, electric components, electric motor. - Oil



**These materials must be disposed of through specialised companies in accordance with current laws in the country of use.**





**DECLARATION OF CONFORMITY**

***SILLA Macchine Edili e Stradali Srl***

Via S.Gimignano , 96 - 53036 – POGGIBONSI (SI) – ITALY

In the person of Mr Neri Angiolo as Legal Representative  
declare  
under their sole responsibility that the machine:

<b>GENERIC NAME</b>	<b>CUTTING MACHINE</b>
<b>FUNCTION</b>	<b>CUTTING OF REINFORCED CONCRETE RODS</b>
<b>MODEL</b>	<b>S</b>
<b>TYPE</b>	
<b>SERIAL NUMBER</b>	
<b>TRADE NAME</b>	...

complies with the essential requirements of the directives of the European Parliament and of the Council:

- “Machines 2006/42/CE published in O.G.E.U. on June 9, 2006.
- “Electromagnetic compatibility” 2004/108/CE published in O.G.E.U. on December 31, 2004

Furthermore it is declared that the machine has been designed and built according to the following harmonised standards:

- EN ISO 12100-1 (2003) Safety of machinery - basic concepts, general principles of design - Part 1: basic terminology, methodology,
- EN ISO 12100-2 (2003) Safety of machinery - basic concepts, general principles of design - Part 2: specifications and technical principles
- EN ISO 14121-1 (2007) Safety of machinery – risk evaluation -Part 1: principles
- EN 60204-1 (2006) Safety of machinery - electric system of the machine – Part 1: general rules
- EN ISO 13857 (2008) Safety of machinery - safety distances to prevent the upper and lower limbs from attaining dangerous areas
- EN ISO 13850 (2008) Safety of machinery – emergency stop – principles of design.
- EN ISO 13849-1 (2008) Safety of machinery - parts of the control systems concerning safety -Part 1: general principles of design one
- EN ISO 13849-2 (2008) Safety of machinery - parts of the control systems concerning safety -Part 2: validation

The legal person entitled to form the technical dossier and that has custody of the technical documents is

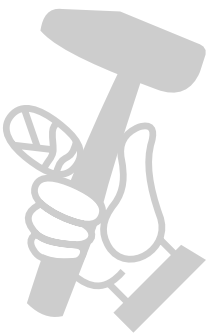
***SILLA Macchine Edili e Stradali Srl***

Via S.Gimignano , 96 - 53036 – POGGIBONSI (SI) – ITALY

Poggibonsi, date .....

Signature

МАГАЗИН  
БАШ МАЙСТОРА®  
ПРОФЕСИОНАЛНИ РЕШЕНИЯ





**11. WARRANTY REGISTRATION FORM**

Machine type	Part number
--------------	-------------

**IMPORTANT**

This form must be filled out and stamped by the Dealer at the time of purchase of the machine. The Dealer or the buyer must send this form by registered mail to the After-Sales Dept. of the Company SILLA within 3 days from the purchase, together with a copy of the delivery note or of the invoice.

The mailing of this form, together with a copy of the transport document or a copy of the invoice, is an essential requirement to start warranty period. The warranty is void if not registered.

Date .....

Stamp and Signature of the Dealer

Messrs.

**SILLA Macchine Edili e Stradali Srl**

Via S.Gimignano , 96 - 53036 – POGGIBONSI (SI) – ITALIA

**11.1 WARRANTY CONDITIONS**

Warranty means the repair and/or the replacement of those parts, which are proven to be defective in manufacture. The replacement of the whole machine is excluded.

The warranty is for the period of 1 year from the date of delivery to the user, that is to say the date written in the Warranty Registration Form.

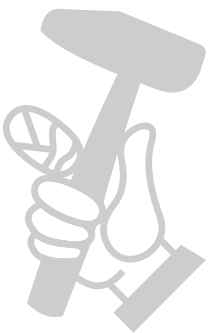
The defective materials must be sent, free delivered, to our factory. After technical approval the material will be replaced and sent carriage forward.

**The warranty expires in case of:**

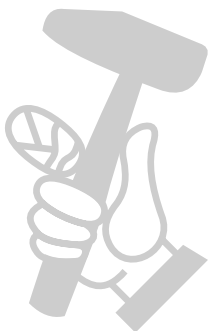
- modifications, repairs, alterations of the machine carried out by the buyer and not expressly authorised by SILLA.
- improper assembling or failure to use the machine according to the instructions of the instruction manual.
- The electric components are not covered by this warranty, because a wrong connection done by the user and/or line problems may cause damage to these components.
- Any repair under warranty will not interrupt the warranty period.

- **We recommend to the dealers to write the part number of the Cutting Machine both on the delivery note and on the invoice.**

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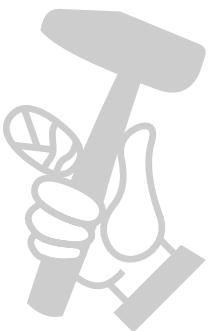
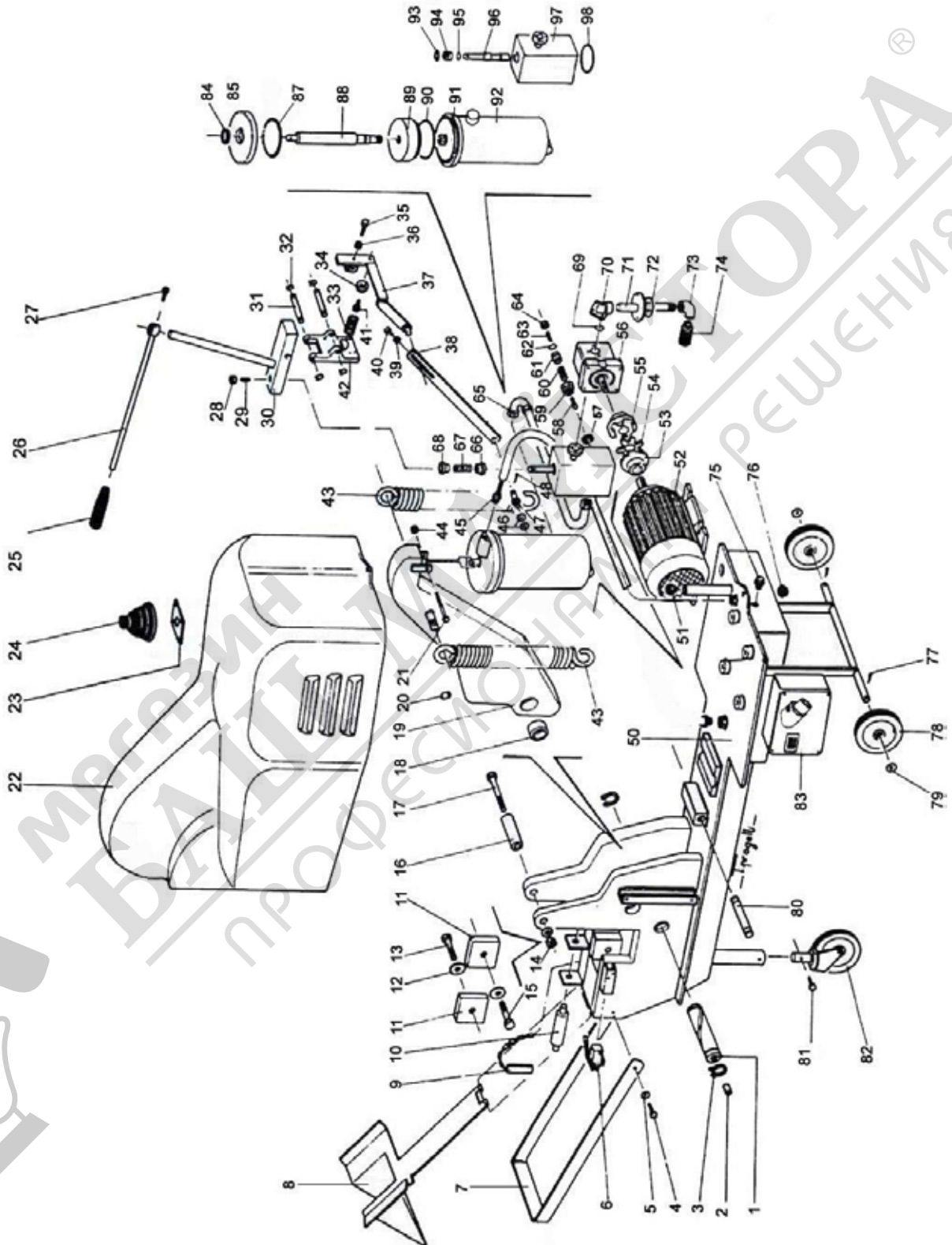
**“I” - RICAMBI -**  
**“GB” - PARTS MANUAL -**



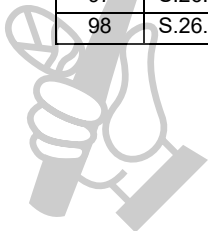
	Tav. 01	Complessivo Telaio	Frame group	Cesoia S26 – Cutting machine S26
		I	GB	
Rif	Codice			
1	S.26.01.001	Perno	Pin	
2	S.26.01.002	Oliatore	Lubricator	
3	S.26.01.003	Anello Seeger	Seeger	
4	S.26.01.004	Vite	Screw	
5	S.26.01.005	Rondella	Washer	
6	S.26.01.006	Contatto elettrico	Electric contact	
7	S.26.01.007	Maniglia	Handle	
8	S.26.01.008	Protezione coltelli	Blades protection	
9	S.26.01.009	Spess. avvicinam. coltello fisso	Parcking for blades fixed	
10	S.26.01.010	Rullo scorrimento ferro	Roller coil sliding	
11	S.26.01.011	Coltello	Blade	
12	S.26.01.012	Rondella	Washer	
13	S.26.01.013	Vite	Screw	
14	S.26.01.014	Dado	Nut	
15	S.26.01.015	Vite	Screw	
16	S.26.01.016	Distanziale	Spacer	
17	S.26.01.017	Vite	Screw	
18	S.26.01.018	Bronzina	Bushing	
19	S.26.01.019	Braccio	Cutting lever	
20	S.26.01.020	Oliatore	Lubricator	
21	S.26.01.021	Vite	Screw	
22	S.26.01.022	Carter	Casing	
23	S.26.01.023	Supporto soffietto	Hood support	
24	S.26.01.024	Soffietto	Cover	
25	S.26.01.025	Pomello	Pommel	
26	S.26.01.026	Leva	Lever	
27	S.26.01.027	Vite	Screw	
28	S.26.01.028	Dado	Nut	
29	S.26.01.029	Grano	Screw	
30	S.26.01.030	Bilanciere	Rocker	
31	S.26.01.031	Perno	Pin	
32	S.26.01.032	Anello Seeger	Seeger	
33	S.26.01.033	Molla	Spring	
34	S.26.01.034	Boccola	Bushing	
35	S.26.01.035	Vite	Screw	
36	S.26.01.036	Dado	Nut	
37	S.26.01.037	Cerniera	Fixed hinge	
38	S.26.01.038	Biella	Rod	
39	S.26.01.039	Dado	Nut	
40	S.26.01.040	Vite	Screw	
41	S.26.01.041	Vite	Screw	
42	S.26.01.042	Supporto	Rocker holder	
43	S.26.01.043	Molla braccio	Arm spring	
44	S.26.01.044	Dado	Nut	
45	S.26.01.045	Tubo di drenaggio	Hose	
46	S.26.01.046	Rondella	Washer	
47	S.26.01.047	Perno	Pin	
48	S.26.01.048	Copiglia	Split pin	
50	S.26.01.050	Telaio	Frame	
51	S.26.01.051	Tappo olio	Oil cap	
52	S.26.01.052	Motore	Electric motor	
53	S.26.01.053	Metà giunto lato motore	Joint motor side	
54	S.26.01.054	Gomma per giunto	Rubber joint	
55	S.26.01.055	Metà giunto lato pompa	Semi-joint pump side	



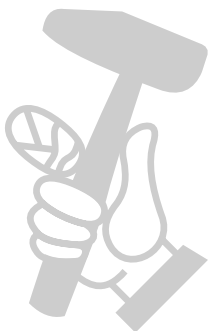
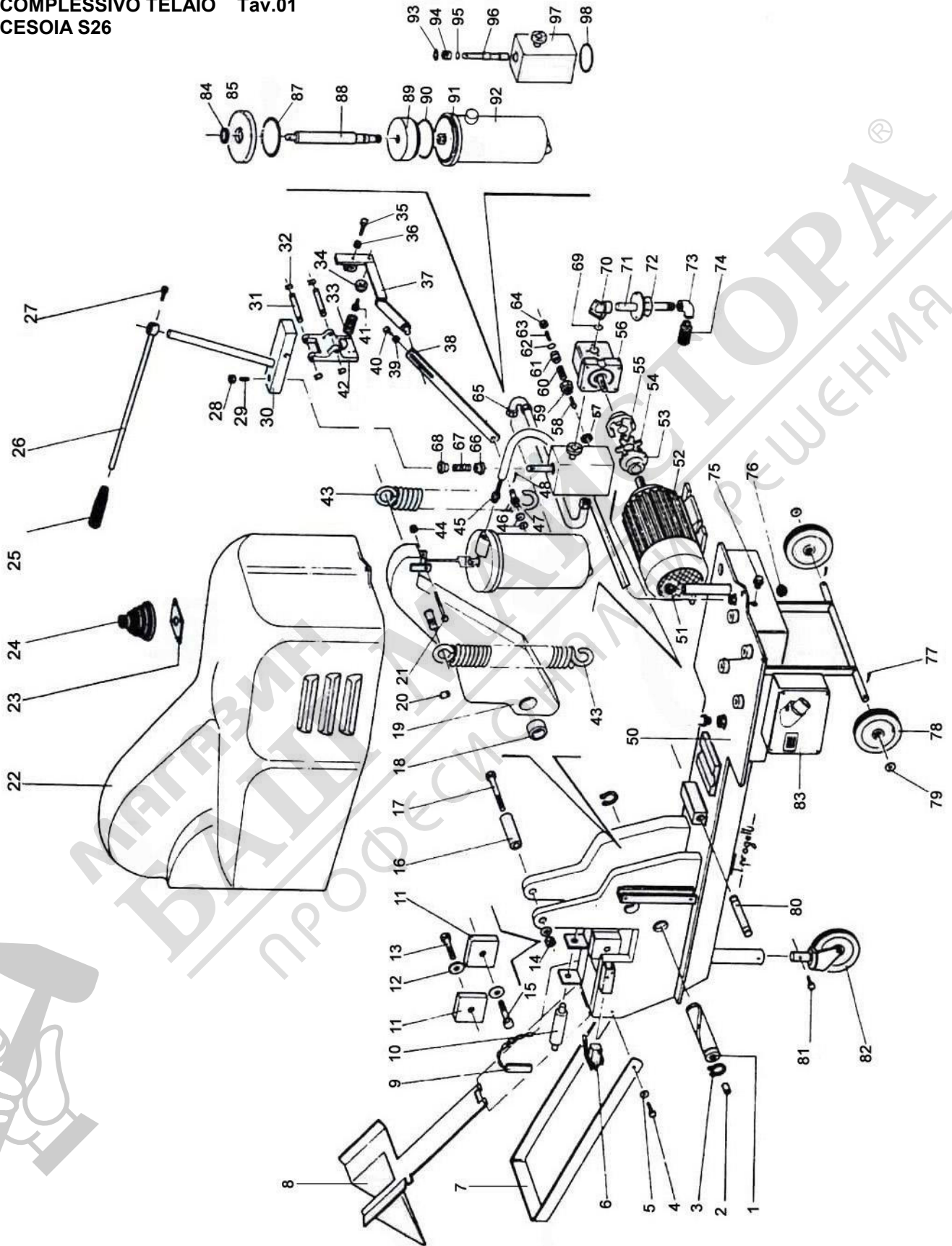
**COMPLESSIVO TELAIO Tav.01**  
**CESOIA S26**



	Tav.01	Complessivo Telaio	Frame group	<u>Cesoia S26 – Cutting machine S26</u>
		I	GB	
56	S.26.01.056	Pompa idraulica	Oil pump	
57	S.26.01.057	Rondella	Washer	
58	S.26.01.058	Valvola	Valve	
59	S.26.01.059	Corpo valvola	Valve	
60	S.26.01.060	Molla	Spring	
61	S.26.01.061	Piattello spingimolla	Spring pushing plate	
62	S.26.01.062	Anello OR	O-Ring	
63	S.26.01.063	Grano	Screw	
64	S.26.01.064	Dado	Nut	
65	S.26.01.065	Tubo di pressione	Pressure hose	
66	S.26.01.066	Boccola	Sleeve	
67	S.26.01.067	Molla	Spring	
68	S.26.01.068	Boccola	Sleeve	
69	S.26.01.069	Anello OR	O-Ring	
70	S.26.01.070	Raccordo a flangia	Elbow connection	
71	S.26.01.071	Tubo aspirazione olio	Oil suction pipe	
72	S.26.01.072	Anello OR	O-Ring	
73	S.26.01.073	Raccordo a 90°	Elbow connection	
74	S.26.01.074	Filtro aspirazione	Suction filter	
75	S.26.01.075	Livello olio	Oil level	
76	S.26.01.076	Tappo	Oil cap	
77	S.26.01.077	Copiglia	Split pin	
78	S.26.01.078	Ruota posteriore	Wheel	
79	S.26.01.079	Rondella	Washer	
80	S.26.01.080	Perno	Pin	
81	S.26.01.081	Vite	Screw	
82	S.26.01.082	Ruota anteriore	Wheel	
83	S.26.01.083	Quadro elettrico completo	Complete electric box	
84	S.26.01.084	Anello MIM	Sealing Ring	
85	S.26.01.085	Coperchio cilindro	Cylinder cap	
87	S.26.01.087	Anello OR	O-Ring	
88	S.26.01.088	Stelo	Piston rod	
89	S.26.01.089	Pistone	Piston	
90	S.26.01.090	Guarnizione	Sealing ring	
91	S.26.01.091	Dado	Nut	
92	S.26.01.092	Cilindro	Cylinder	
93	S.26.01.093	Anello MIM	Sealing ring	
94	S.26.01.094	Boccola	Sleeve	
95	S.26.01.095	Anello OR	O-Ring	
96	S.26.01.096	Pistoncino distributore	Distributor ring	
97	S.26.01.097	Distributore	Distributor	
98	S.26.01.098	Anello OR	O-Ring	



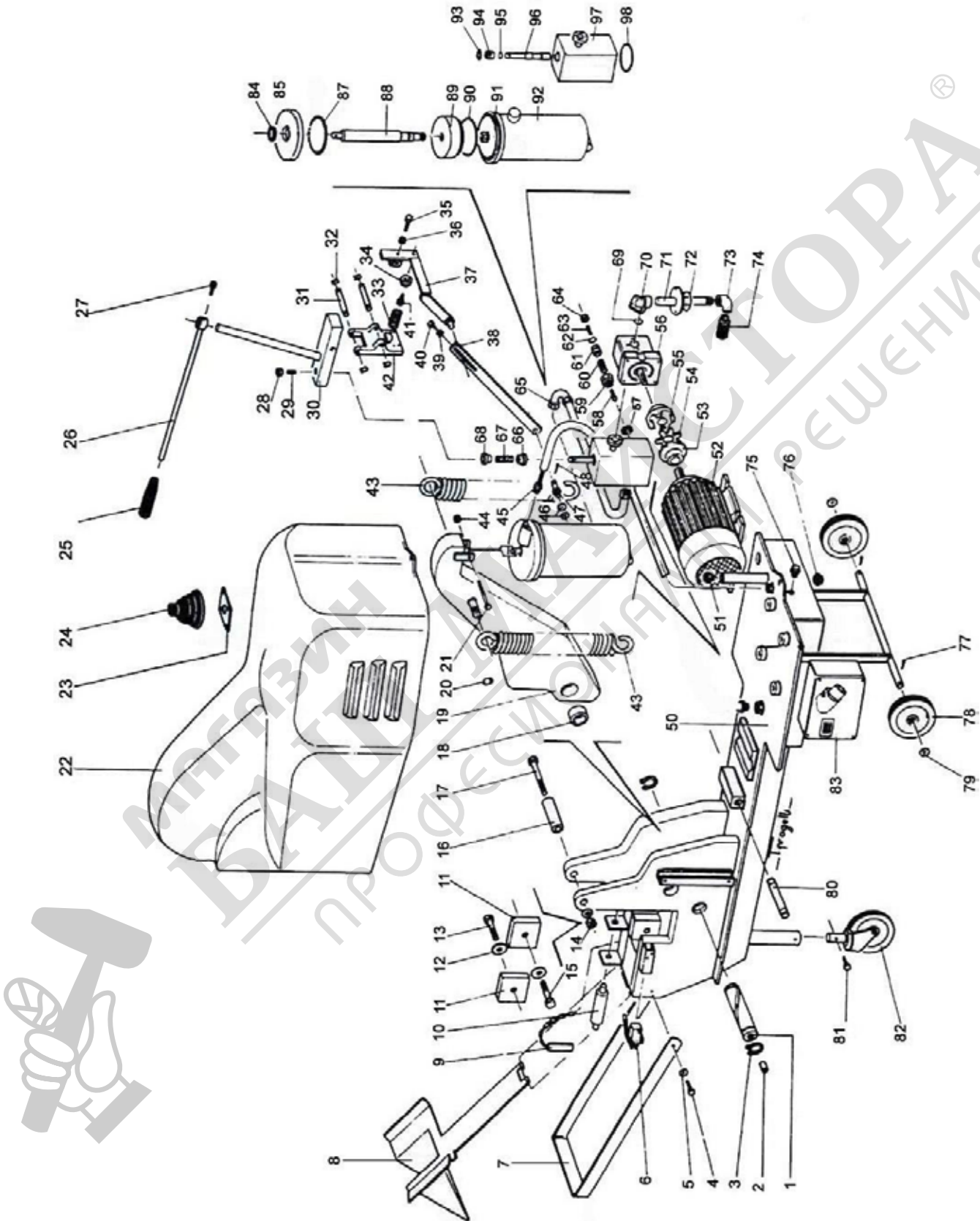
COMPLESSIVO TELAIO Tav.01  
 CESOIA S26



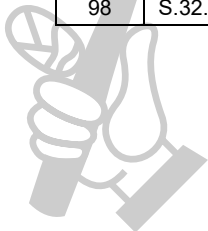
	<b>Tav. 02</b>	<b>Complessivo Telaio</b>	<b>Frame group</b>	<b>Cesoia S32 – Cutting machine S32</b>
Rif	Codice	I	GB	
1	S.32.02.001	Perno	Pin	
2	S.32.02.002	Oliatore	Lubricator	
3	S.32.02.003	Anello Seeger	Seeger	
4	S.32.02.004	Vite	Screw	
5	S.32.02.005	Rondella	Washer	
6	S.32.02.006	Contatto elettrico	Electric contact	
7	S.32.02.007	Maniglia	Handle	
8	S.32.02.008	Protezione coltelli	Blades protection	
9	S.32.02.009	Spess. avvicinam. coltello fisso	Parcking for blades fixed	
10	S.32.02.010	Rullo scorrimento ferro	Roller coil sliding	
11	S.32.02.011	Coltello	Blade	
12	S.32.02.012	Rondella	Washer	
13	S.32.02.013	Vite	Screw	
14	S.32.02.014	Dado	Nut	
15	S.32.02.015	Vite	Screw	
16	S.32.02.016	Distanziale	Spacer	
17	S.32.02.017	Vite	Screw	
18	S.32.02.018	Bronzina	Bushing	
19	S.32.02.019	Braccio	Cutting lever	
20	S.32.02.020	Oliatore	Lubricator	
21	S.32.02.021	Vite	Screw	
22	S.32.02.022	Carter	Casing	
23	S.32.02.023	Supporto soffietto	Hood support	
24	S.32.02.024	Soffietto	Cover	
25	S.32.02.025	Pomello	Pommel	
26	S.32.02.026	Leva	Lever	
27	S.32.02.027	Vite	Screw	
28	S.32.02.028	Dado	Nut	
29	S.32.02.029	Grano	Screw	
30	S.32.02.030	Bilanciere	Rocker	
31	S.32.02.031	Perno	Pin	
32	S.32.02.032	Anello Seeger	Seeger	
33	S.32.02.033	Molla	Spring	
34	S.32.02.034	Boccola	Bushing	
35	S.32.02.035	Vite	Screw	
36	S.32.02.036	Dado	Nut	
37	S.32.02.037	Cerniera	Fixed hinge	
38	S.32.02.038	Biella	Rod	
39	S.32.02.039	Dado	Nut	
40	S.32.02.040	Vite	Screw	
41	S.32.02.041	Vite	Screw	
42	S.32.02.042	Supporto	Rocker holder	
43	S.32.02.043	Molla braccio	Arm spring	
44	S.32.02.044	Dado	Nut	
45	S.32.02.045	Tubo di drenaggio	Hose	
46	S.32.02.046	Rondella	Washer	
47	S.32.02.047	Perno	Pin	
48	S.32.02.048	Copiglia	Split pin	
50	S.32.02.050	Telaio	Frame	
51	S.32.02.051	Tappo olio	Oil cap	
52	S.32.02.052	Motore	Electric motor	
53	S.32.02.053	Metà giunto lato motore	Joint motor side	
54	S.32.02.054	Gomma per giunto	Rubber joint	
55	S.32.02.055	Metà giunto lato pompa	Semi-joint pump side	



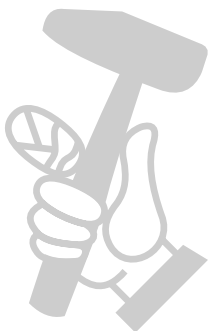
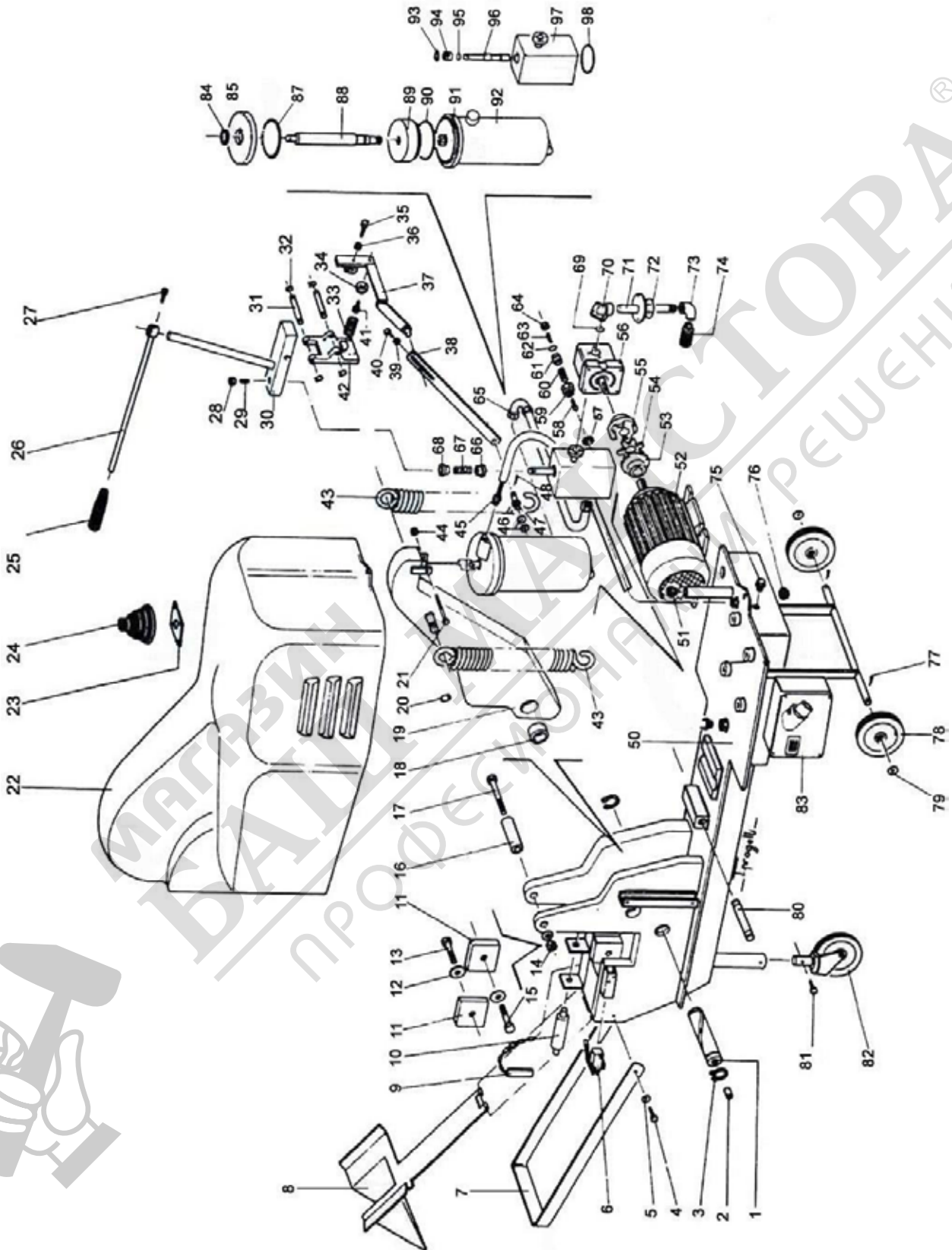
**COMPLESSIVO TELAIO Tav.02**  
**CESOIA S32**



	<b>Tav. 02</b>	<b>Complessivo Telaio</b>	<b>Frame group</b>	<b>Cesoia S32- Cutting machine S32</b>
		<b>I</b>	<b>GB</b>	
56	S.32.02.056	Pompa idraulica	Oil pump	
57	S.32.02.057	Rondella	Washer	
58	S.32.02.058	Valvola	Valve	
59	S.32.02.059	Corpo valvola	Valve	
60	S.32.02.060	Molla	Spring	
61	S.32.02.061	Piattello spingimolla	Spring pushing plate	
62	S.32.02.062	Anello OR	O-Ring	
63	S.32.02.063	Grano	Screw	
64	S.32.02.064	Dado	Nut	
65	S.32.02.065	Tubo di pressione	Pressure hose	
66	S.32.02.066	Boccola	Sleeve	
67	S.32.02.067	Molla	Spring	
68	S.32.02.068	Boccola	Sleeve	
69	S.32.02.069	Anello OR	O-Ring	
70	S.32.02.070	Raccordo a flangia	Elbow connection	
71	S.32.02.071	Tubo aspirazione olio	Oil suction pipe	
72	S.32.02.072	Anello OR	O-Ring	
73	S.32.02.073	Raccordo a 90°	Elbow connection	
74	S.32.02.074	Filtro aspirazione	Suction filter	
75	S.32.02.075	Livello olio	Oil level	
76	S.32.02.076	Tappo	Oil cap	
77	S.32.02.077	Copiglia	Split pin	
78	S.32.02.078	Ruota posteriore	Wheel	
79	S.32.02.079	Rondella	Washer	
80	S.32.02.080	Perno	Pin	
81	S.32.02.081	Vite	Screw	
82	S.32.02.082	Ruota anteriore	Wheel	
83	S.32.02.083	Quadro elettrico completo	Complete electric box	
84	S.32.02.084	Anello MIM	Sealing Ring	
85	S.32.02.085	Coperchio cilindro	Cylinder cap	
87	S.32.02.087	Anello OR	O-Ring	
88	S.32.02.088	Stelo	Piston rod	
89	S.32.02.089	Pistone	Piston	
90	S.32.02.090	Guarnizione	Sealing ring	
91	S.32.02.091	Dado	Nut	
92	S.32.02.092	Cilindro	Cylinder	
93	S.32.02.093	Anello MIM	Sealing ring	
94	S.32.02.094	Boccola	Sleeve	
95	S.32.02.095	Anello OR	O-Ring	
96	S.32.02.096	Pistoncino distributore	Distributor ring	
97	S.32.02.097	Distributore	Distributor	
98	S.32.02.098	Anello OR	O-Ring	



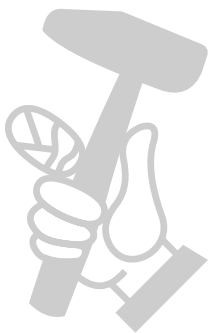
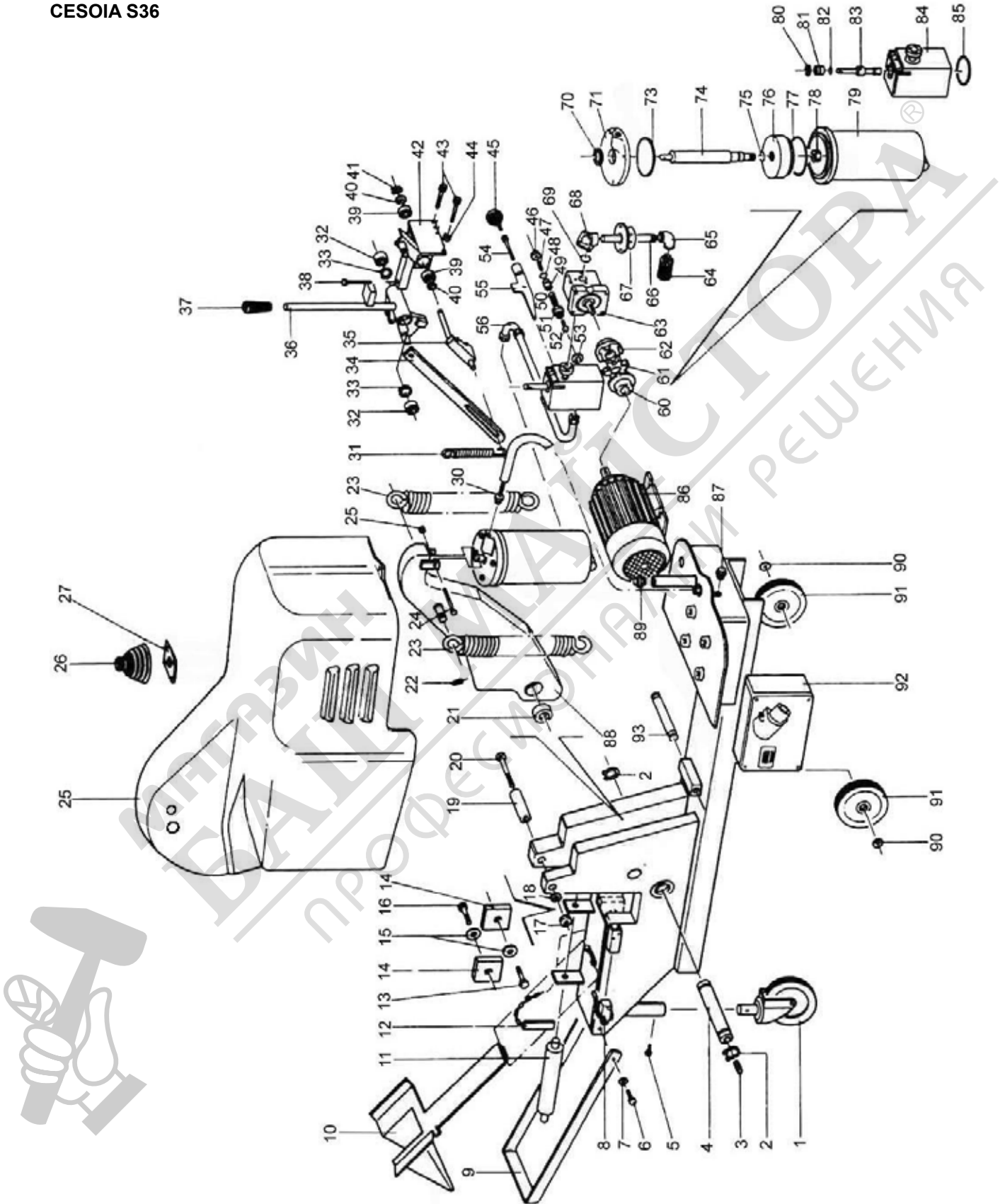
**COMPLESSIVO TELAIO Tav.02**  
**CESOIA S32**



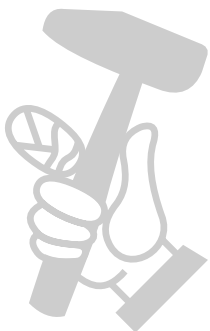
	<b>Tav. 03</b>	<b>Complessivo Telaio</b>	<b>Frame group</b>	<b>Cesoia S36 – Cutting machine S36</b>
Rif	Codice	I	GB	
1	S.36.03.001	Ruota anteriore	Wheel	
2	S.36.03.002	Anello Seeger	Seeger ring	
3	S.36.03.003	Oliatore	Lubricator	
4	S.36.03.004	Perno	Pin	
5	S.36.03.005	Vite	Screw	
6	S.36.03.006	Vite	Screw	
7	S.36.03.007	Rondella	Washer	
8	S.36.03.008	Contatto elettrico	Electric contact	
9	S.36.03.009	Maniglia	Handle	
10	S.36.03.010	Protezione coltelli	Blades protection	
11	S.36.03.011	Rullo scorrimento ferro	Roller coil sliding	
12	S.36.03.012	Spess. avvicinam. coltello fisso	Packing for blades fixed	
13	S.36.03.013	Vite	Screw	
14	S.36.03.014	Coltello	Blade	
15	S.36.03.015	Rondella	Washer	
16	S.36.03.016	Vite	Screw	
17	S.36.03.017	Dado	Nut	
18	S.36.03.018	Rondella	Washer	
19	S.36.03.019	Distanziale	Spacer	
20	S.36.03.020	Vite	Screw	
21	S.36.03.021	Bronzina	Bushing	
22	S.36.03.022	Oliatore	Lubricator	
23	S.36.03.023	Molla	Spring	
24	S.36.03.024	Vite	Screw	
25	S.36.03.025	Carter	Carter	
26	S.36.03.026	Soffietto	Cover	
27	S.36.03.027	Supporto soffietto	Hood support	
28	S.36.03.028	Dado	Nut	
30	S.36.03.030	Tubo di drenaggio	Hose	
31	S.36.03.031	Molla	Spring	
32	S.36.03.032	Cuscinetto	Bearing	
33	S.36.03.033	Anello Seeger	Seeger ring	
34	S.36.03.034	Biella	Rod	
35	S.36.03.035	Leva	Lever	
36	S.36.03.036	Bilancere	Rocker	
37	S.36.03.037	Pomolo	Pommel	
38	S.36.03.038	Vite	Screw	
39	S.36.03.039	Cuscinetto	Bearing	
40	S.36.03.040	Rondella	Washer	
41	S.36.03.041	Anello Seeger	Seeger ring	
42	S.36.03.042	Supporto	Rocker support	
43	S.36.03.043	Vite	Screw	
44	S.36.03.044	Dado	Nut	
45	S.36.03.045	Pomolo	Pommel	
46	S.36.03.046	Dado	Nut	
47	S.36.03.047	Grano	Screw	
48	S.36.03.048	Anello OR	O-Ring	
49	S.36.03.049	Piattello spingimolla	Spring pushing plate	
50	S.36.03.050	Molla	Spring	
51	S.36.03.051	Corpo valvola	Valve	
52	S.36.03.052	Valvola	Valve	
53	S.36.03.053	Rondella	Washer	
54	S.36.03.054	Vite	Screw	
55	S.36.03.055	Leva scatto	Lever	



**COMPLESSIVO TELAIO Tav.03**  
**CESOIA S36**

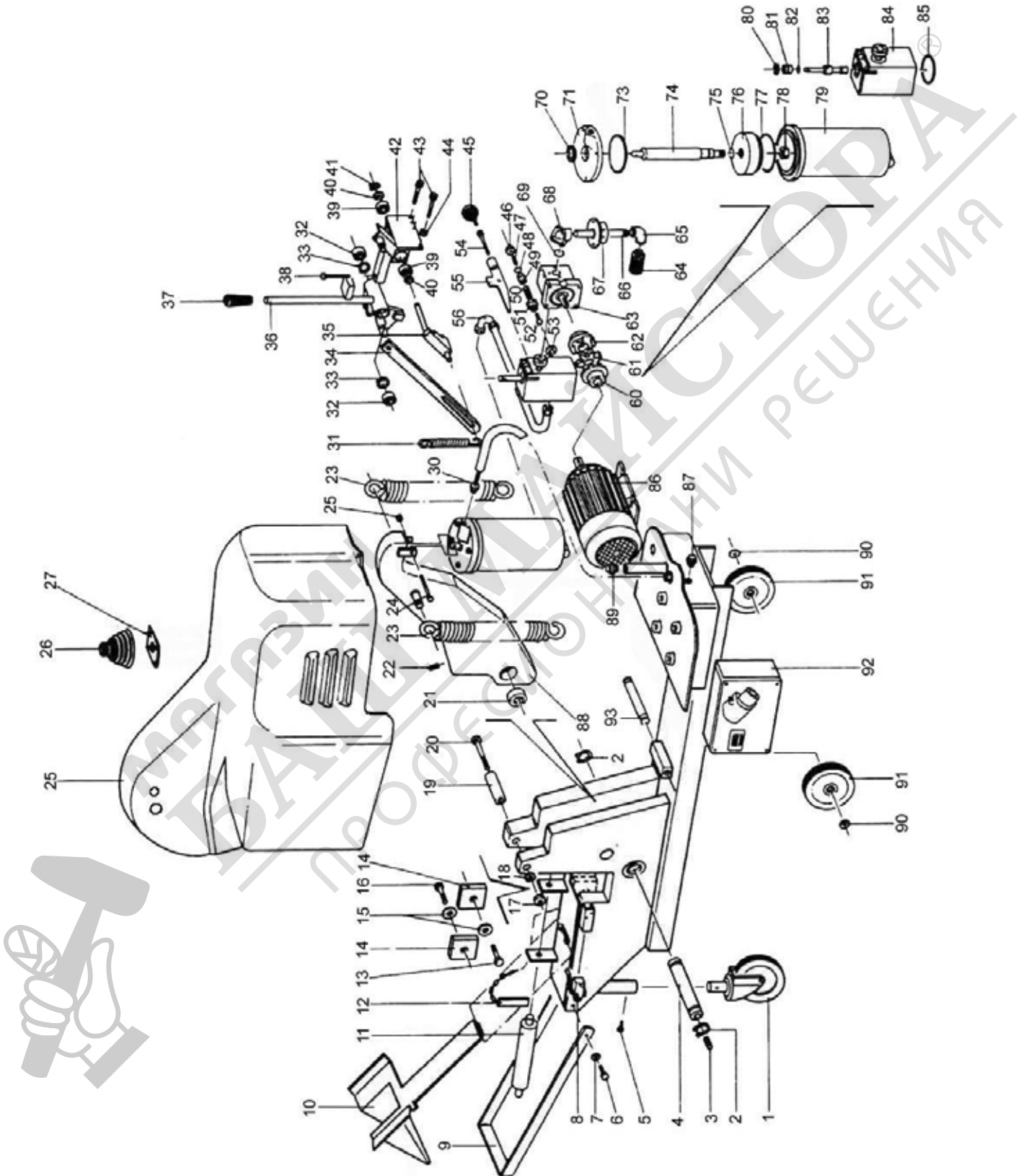


	<b>Tav. 03</b>	<b>Complessivo Telaio</b>	<b>Frame group</b>	<b>Cesoia S36 – Cutting machine S36</b>
		<b>I</b>	<b>GB</b>	
56	S.36.03.056	Tubo di pressione	Pressure hose	
57	S.36.03.057	Molla	Spring	
58	S.36.03.058	Boccola	Sleeve	
59	S.36.03.059	Boccola	Sleeve	
60	S.36.03.060	Metà giunto lato motore	Joint motor side	
61	S.36.03.061	Gomma per giunto	Rubber joint	
62	S.36.03.062	Metà giunto lato pompa	Semi-joint pump side	
63	S.36.03.063	Pompa idraulica	Oil pump	
64	S.36.03.064	Filtro aspirazione	Suction filter	
65	S.36.03.065	Raccordo a 90°	Elbow connection	
66	S.36.03.066	Tubo aspirazione olio	Oil suction pipe	
67	S.36.03.067	Anello OR	O-Ring	
68	S.36.03.068	Raccordo a flangia	Elbow connection	
69	S.36.03.069	Anello OR	O-Ring	
70	S.36.03.070	Anello MIM	Sealing ring	
71	S.36.03.071	Coperchio cilindro	Cylinder cap	
73	S.36.03.073	Anello OR	O-Ring	
74	S.36.03.074	Stelo	Piston rod	
75	S.36.03.075	Anello OR	O-Ring	
76	S.36.03.076	Pistone	Piston	
77	S.36.03.077	Guarnizione	Sealing ring	
78	S.36.03.078	Dado	Nut	
79	S.36.03.079	Cilindro	Cylinder	
80	S.36.03.080	Anello MIM	Sealing ring	
81	S.36.03.081	Boccola	Sleeve	
82	S.36.03.082	Anello OR	O-Ring	
83	S.36.03.083	Pistoncino distributore	Distributor piston	
84	S.36.03.084	Distributore	Distributor	
85	S.36.03.085	Anello OR	O-Ring	
86	S.36.03.086	Motore	Electric motor	
87	S.36.03.087	Livello olio	Oil level	
88	S.36.03.088	Braccio	Cutting level	
89	S.36.03.089	Tappo olio	Oil cap	
90	S.36.03.090	Rondella	Washer	
91	S.36.03.091	Ruota posteriore	Wheel	
92	S.36.03.092	Quadro elettrico completo	Complete electric box	



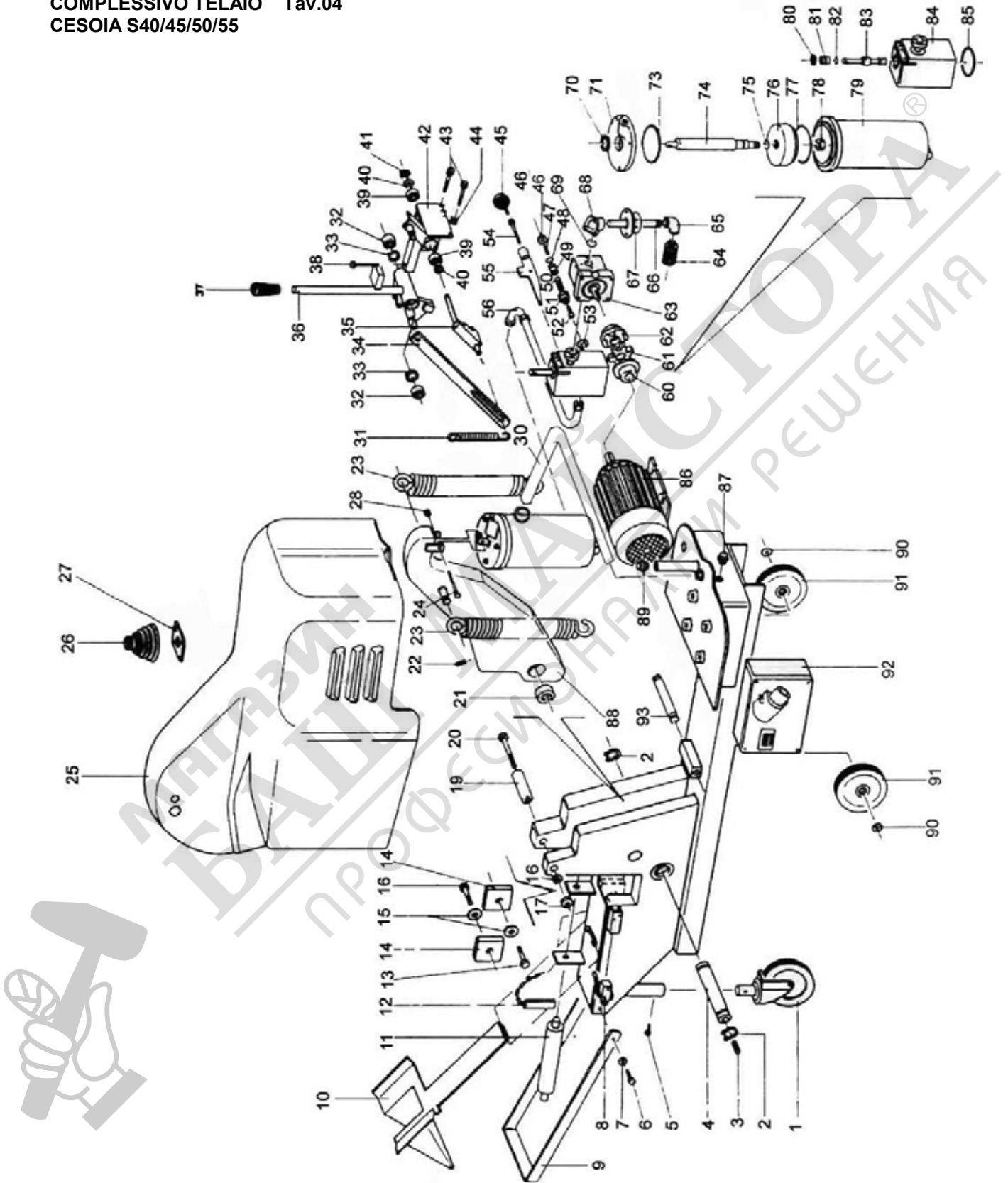


**COMPLESSIVO TELAIO Tav.03**  
**CESOIA S36**

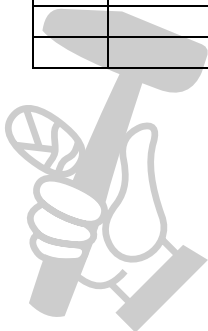


	<b>Tav. 04</b>	<b>Complessivo Telaio</b>	<b>Frame group</b>	<b>Cesoia-Cutting machine S40-45-50-55</b>
Rif	Codice	I	GB	
1	S.40/45/50/55.04.001	Ruota anteriore	Wheel	
2	S.40/45/50/55.04.002	Anello Seeger	Seeger ring	
3	S.40/45/50/55.04.003	Oliatore	Lubricator	
4	S.40/45/50/55.04.004	Perno	Pin	
5	S.40/45/50/55.04.005	Vite	Screw	
6	S.40/45/50/55.04.006	Vite	Screw	
7	S.40/45/50/55.04.007	Rondella	Washer	
8	S.40/45/50/55.04.008	Contatto elettrico	Electric contact	
9	S.40/45/50/55.04.009	Maniglia	Handle	
10	S.40/45/50/55.04.010	Protezione coltelli	Blades protection	
11	S.40/45/50/55.04.011	Rullo scorrimento ferro	Roller coil sliding	
12	S.40/45/50/55.04.012	Spess. avvicinam. coltello	Packing for blades fixed	
13	S.40/45/50/55.04.013	Vite	Screw	
14	S.40/45/50/55.04.014	Coltello	Blade	
15	S.40/45/50/55.04.015	Rondella	Washer	
16	S.40/45/50/55.04.016	Vite	Screw	
17	S.40/45/50/55.04.017	Dado	Nut	
18	S.40/45/50/55.04.018	Rondella	Washer	
19	S.40/45/50/55.04.019	Distanziale	Spacer	
20	S.40/45/50/55.04.020	Vite	Screw	
21	S.40/45/50/55.04.021	Bronzina	Bushing	
22	S.40/45/50/55.04.022	Oliatore	Lubricator	
23	S.40/45/50/55.04.023	Molla	Spring	
24	S.40/45/50/55.04.024	Vite	Screw	
25	S.40/45/50/55.04.025	Carter	Carter	
26	S.40/45/50/55.04.026	Soffietto	Cover	
27	S.40/45/50/55.04.027	Supporto soffietto	Hood support	
28	S.40/45/50/55.04.028	Dado	Nut	
30	S.40/45/50/55.04.030	Tubo di drenaggio	Hose	
31	S.40/45/50/55.04.031	Molla	Spring	
32	S.40/45/50/55.04.032	Cuscinetto	Bearing	
33	S.40/45/50/55.04.033	Anello Seeger	Seeger ring	
34	S.40/45/50/55.04.034	Biella	Rod	
35	S.40/45/50/55.04.035	Leva	Lever	
36	S.40/45/50/55.04.036	Bilanciere	Rocker	
37	S.40/45/50/55.04.037	Pomello	Pommel	
38	S.40/45/50/55.04.038	Vite	Screw	
39	S.40/45/50/55.04.039	Cuscinetto	Bearing	
40	S.40/45/50/55.04.040	Rondella	Washer	
41	S.40/45/50/55.04.041	Anello Seeger	Seeger ring	
42	S.40/45/50/55.04.042	Supporto	Rocker support	
43	S.40/45/50/55.04.043	Vite	Screw	
44	S.40/45/50/55.04.044	Dado	Nut	
45	S.40/45/50/55.04.045	Pomello	Pommel	
46	S.40/45/50/55.04.046	Dado	Nut	
47	S.40/45/50/55.04.047	Grano	Screw	
48	S.40/45/50/55.04.048	Anello OR	O-Ring	
49	S.40/45/50/55.04.049	Piattello spingi molla	Spring pushing plate	
50	S.40/45/50/55.04.050	Molla	Spring	
51	S.40/45/50/55.04.051	Corpo valvola	Valve	
52	S.40/45/50/55.04.052	Valvola	Valve	
53	S.40/45/50/55.04.053	Rondella	Washer	

**COMPLESSIVO TELAIO Tav.04**  
**CESOIA S40/45/50/55**

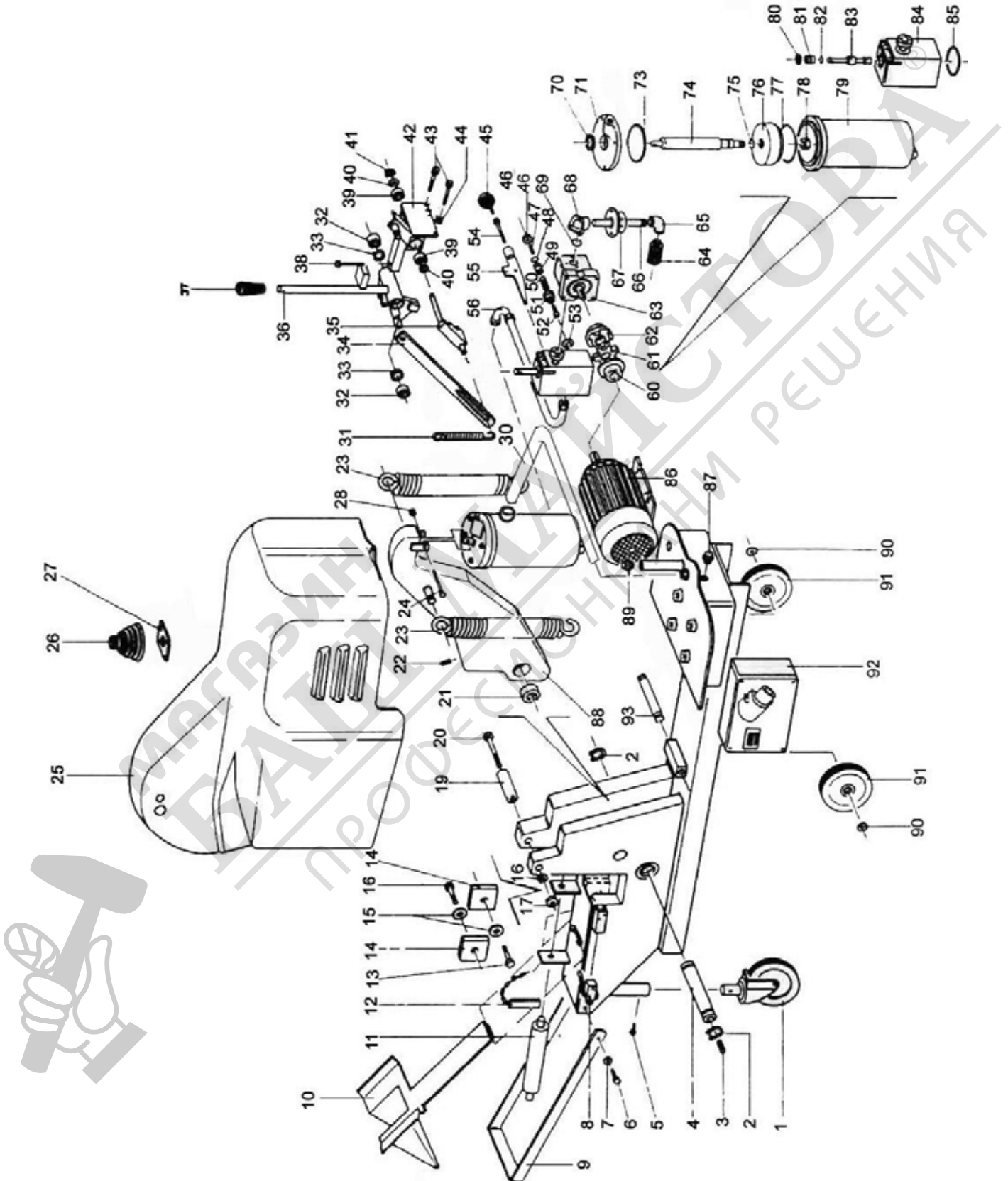


	<b>Tav. 04</b>	<b>Complessivo Telaio</b>	<b>Frame group</b>	<b>Cesoia-Cutting machine</b>
		<b>I</b>	<b>GB</b>	<b>S40-45-50-55</b>
Rif	Codice			
54	S.40/45/50/55.04.054	Vite	Screw	
55	S.40/45/50/55.04.055	Leva scatto	Lever	
56	S.40/45/50/55.04.056	Tubo di pressione	Pressure hose	
60	S.40/45/50/55.04.060	Metà giunto lato motore	Joint motor side	
61	S.40/45/50/55.04.061	Gomma per giunto	Rubber joint	
62	S.40/45/50/55.04.062	Metà giunto lato pompa	Semi-joint pump side	
63	S.40/45/50/55.04.063	Pompa idraulica	Oil pump	
64	S.40/45/50/55.04.064	Filtro aspirazione	Suction filter	
65	S.40/45/50/55.04.065	Raccordo a 90°	Elbow connection	
66	S.40/45/50/55.04.066	Tubo aspirazione olio	Oil suction pipe	
67	S.40/45/50/55.04.067	Anello OR	O-Ring	
68	S.40/45/50/55.04.068	Raccordo a flangia	Elbow connection	
69	S.40/45/50/55.04.069	Anello OR	O-Ring	
70	S.40/45/50/55.04.070	Anello MIM	Sealing ring	
71	S.40/45/50/55.04.071	Coperchio cilindro	Cylinder cap	
73	S.40/45/50/55.04.073	Anello OR	O-Ring	
74	S.40/45/50/55.04.074	Stelo	Piston rod	
75	S.40/45/50/55.04.075	Anello OR	O-Ring	
76	S.40/45/50/55.04.076	Pistone	Piston	
77	S.40/45/50/55.04.077	Guarnizione	Sealing ring	
78	S.40/45/50/55.04.078	Dado	Nut	
79	S.40/45/50/55.04.079	Cilindro	Cylinder	
80	S.40/45/50/55.04.080	Anello MIM	Sealing ring	
81	S.40/45/50/55.04.081	Boccola	Sleeve	
82	S.40/45/50/55.04.082	Anello OR	O-Ring	
83	S.40/45/50/55.04.083	Pistoncino distributore	Distributor piston	
84	S.40/45/50/55.04.084	Distributore	Distributor	
85	S.40/45/50/55.04.085	Anello OR	O-Ring	
86	S.40/45/50/55.04.086	Motore	Electric motor	
87	S.40/45/50/55.04.087	Livello olio	Oil level	
88	S.40/45/50/55.04.088	Braccio	Cutting level	
89	S.40/45/50/55.04.089	Tappo olio	Oil cap	
90	S.40/45/50/55.04.090	Rondella	Washer	
91	S.40/45/50/55.04.091	Ruota posteriore	Wheel	
92	S.40/45/50/55.04.092	Quadro elettrico completo	Complete electric box	





**COMPLESSIVO TELAIO Tav.04**  
**CESOIA S40/45/50/55**



	Tav. 05	Quadro elettrico	Electric box
		I	GB
Rif	Codice		
1	S26/32/36/40/45/50/55.05.001	Vite	Screw
2	S26/32/36/40/45/50/55.05.002	Presa trifase	Threephase plug switch
3	S26/32/36/40/45/50/55.05.003	Pulsante arresto	Stop button
4	S26/32/36/40/45/50/55.05.004	Pulsante marcia	Gear button
5	S26/32/36/40/45/50/55.05.005	Scatola elettrica nuda	Electric box
6	S26/32/36/40/45/50/55.05.006	Trasformatore	Trasformer
7a	S26/32/36 05.007	Contattore/ relè termico C09-10	Contactore/Thermal relay
7b	S40/45 05.007	Contattore/ relè termico C12-10	Contactore/Thermal relay
7c	S50/55 05.007	Contattore/ relè termico C16-10	Contactore/Thermal relay
11a	S26/32/36	Salvamotore 6,3A - 10A	Motor protection
11b	S40/45/50/55	Salvamotore 10A - 16A	Motor protection

