

ROTATOR

ROTAMATIC ST 15

SAFETY INSTRUCTIONS FOR USE AND MAINTENANCE

MACHINE N° W000315303 - W000315304
W000315305



EDITION : EN
REVISION : B
DATE : 04-2018

Instruction manual

REF : **8695 6431**

Original instructions

LINCOLN[®]
ELECTRIC

Thank you very much for the trust you have shown by choosing this piece of equipment. It will give you trouble-free service if it is used and maintained as recommended.

Its design, component specifications and manufacturing are in accordance with applicable European directives.

Please refer to the CE declaration enclosed to identify the directives applicable to it.

The manufacturer shall not be liable for any combination of parts not recommended by it.

For your safety, please follow the non-limitative list of recommendations and obligations, a large part of which are included in the Labour Code.

Please inform your supplier if you find any error in this instruction manual.

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INFORMATION

DISPLAYS AND PRESSURE GAUGES

Measurement instruments or displays of voltage, intensity, speed, accuracy etc. are to be considered as indicators, whether they are analogue or digital.

For operating instructions, adjustments, troubleshooting and spare parts, please refer to the special instructions for safe use and maintenance.

REVISIONS

REVISION B

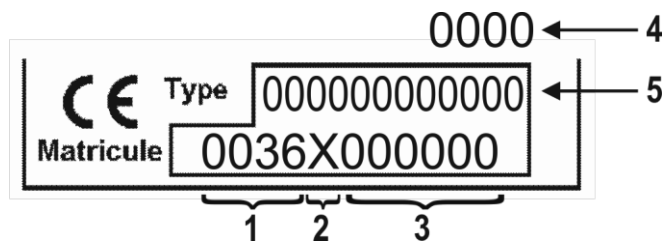
04/18

DESIGNATION	PAGE
To change logos	

A - IDENTIFICATION

The information below should be provided in all correspondence.

Please note the serial number of your equipment in the box below.



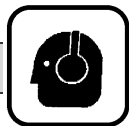
1	Manufacturing plant code	4	Year of manufacture
2	Year of manufacture code	5	Type of product
3	Product serial number		



CE	Type	
Matricule		

B - SAFETY INSTRUCTIONS

For general safety instructions, please refer to the specific manual supplied with the equipment.



1 - AIRBORNE NOISE

Refer to the special instructions "8695 7051" supplied with the equipment.

2 - PARTICULAR SAFETY INSTRUCTIONS



Do not exceed the permissible loads, torques and tangential forces or the minimum and maximum diameters of shells.



Make sure that the guard covers of the electrical and mechanical parts are in place before starting up the equipment.



Carry out a dry test run of the rotation movement.



Do not drop loads on the equipment.



Make sure that the working of the equipment is not hindered by tools and/or objects left close to the rotating part or by its appendages, which could strike fixed elements (ground, frame, posts).



Make sure that the power and control conductors of the equipment are in good condition.



Maintain the centre to centre distance of the rollers depending on the diameter of the shell (see section D).



No object is to be placed on the rolling tracks.



Before using the machine, make sure that all the guards are in place. All guard covers must be screwed in. Only authorised personnel may access electrical cabinets, which must have locking systems.



Clean the working area from time to time.



If the equipment is used for welding, make sure that the ground of the power source is connected to the piece before you start welding.



Never modify the machine.
The rotator **is not** designed for anchoring lifting equipment.



The use of Personal Protective Equipment (PPE) is **mandatory**.



Machine maintenance must be carried out **with all the energy supplies switched off**.
The disconnection and padlocking of all energy sources is **mandatory**.

C - DESCRIPTION

1 - DESCRIPTION

- **ROTAMATIC ST** rotators are designed for rotating cylindrical pieces with variable diameters and weights, depending on their range.
- Each rotator is made of a low-floor frame and rollers that may or may not be powered, with adjustable spacing.
- The powered version of the rotator has an electrical cabinet.
- It also has a remote control for both rotation directions, and a potentiometer for speed variation.
- As standard, powered rotators make it possible to automatically start rotator operation with the start of welding (simple external contact).
- As standard, powered rotators display the linear speed in cm/min on the variable drive display in the cabinet.
- The spacing of the rollers is adjustable by means of compound screws

The **ROTAMATIC ST 15** range can support shells weighing 15 tonnes or less.

2 - ROTAMATIC WITHOUT OPTIONAL EQUIPMENT



DOUBLE POWER VERSION

ROTAMATIC ST 15W
part no. W000315303



**NON-POWERED VERSION
(IDLER)**

ROTAMATIC ST 15F
part no. W000315305



SINGLE POWER VERSION

ROTAMATIC ST 15M
part no. W000315304

3 - ROTAMATIC WITH/WITHOUT OPTIONAL EQUIPMENT

	A	B	C	D	Description	Product no.
15T M	X	X			ROTAMATIC ST 15M	W000315304
	X	X	X		ROTAMATIC ST 15M ADR	W000272473
	X	X	X	X	ROTAMATIC ST 15M ADRC	W000272474
15T W	X	X			ROTAMATIC ST 15W	W000315303
	X	X	X		ROTAMATIC ST 15W ADR	W000272477
	X	X	X	X	ROTAMATIC ST 15W ADRC	W000272478

A) AUTO CONTROL (A)

This option makes it possible to automatically make the powered rotator start rotating with the start of welding (simple external contact).

B) DISPLAY (B)

This option makes it possible to display the linear speed in cm/min on the variable drive display in the cabinet.

C) OPTIONAL TIG-PLASMA REGULATION (C)

This option makes it possible to precisely regulate the rotator rotation speed to +/-1%. This option is required when the rotator is used along with a TIG or plasma welding installation.

D) OPTIONAL ENCODER, 5000 CPR (D)

This option makes it possible to accurately measure the distance covered by the shell using an encoder placed on the roller shafts.

E) OPTIONAL TRUCK W000272574

This option includes two supports (left and right hand), to move the ROTAMATIC rotator transversally on a track.

F) OPTIONAL SETPOINT $\pm 10V$ (ON REQUEST)

This option makes it possible to control the direction and speed of operation of the rotator by an external $\pm 10V$ setpoint.

G) OPTIONAL PEDAL KIT (OPTION ALONE W000273453)

The pedal kit makes it possible to put the powered rotator into rotation when the operator keeps the pedal pressed down.

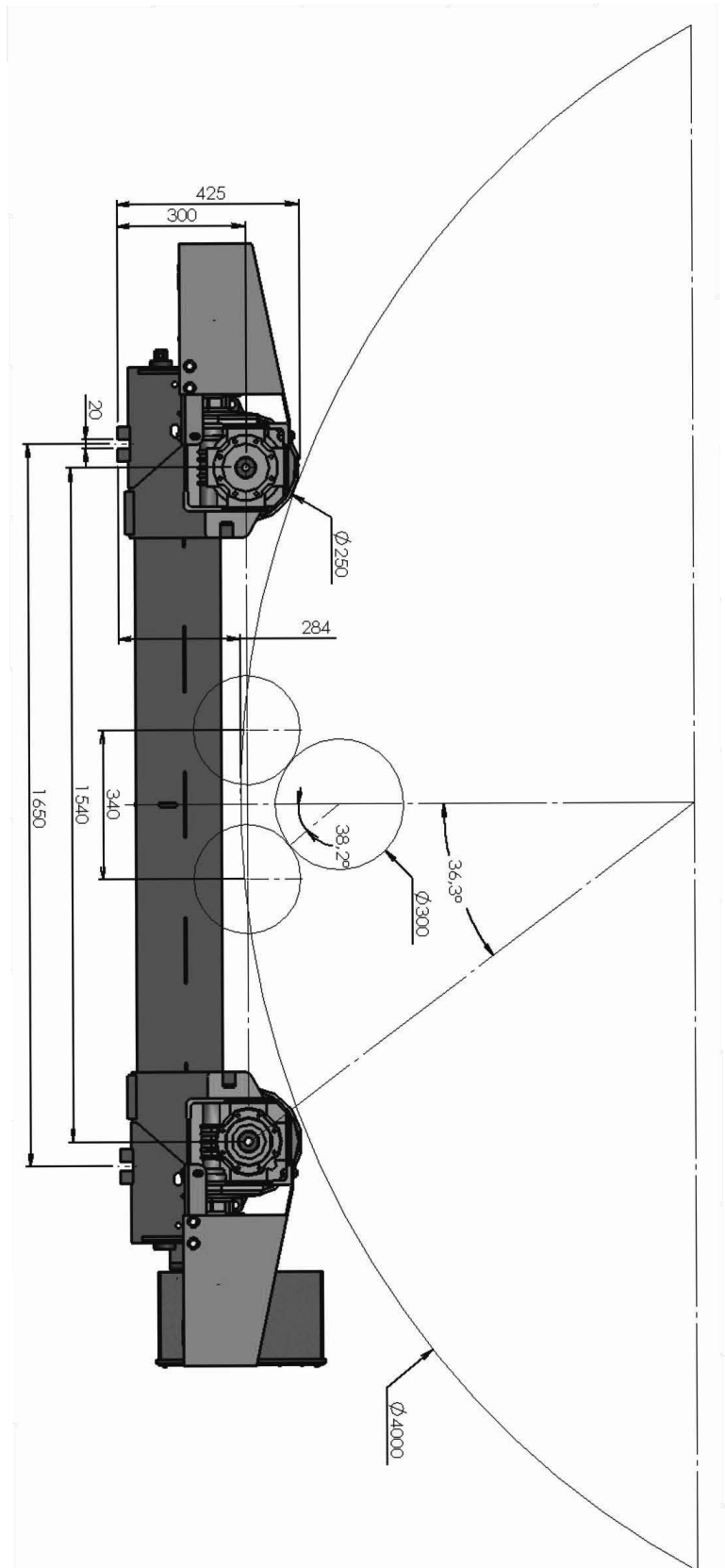
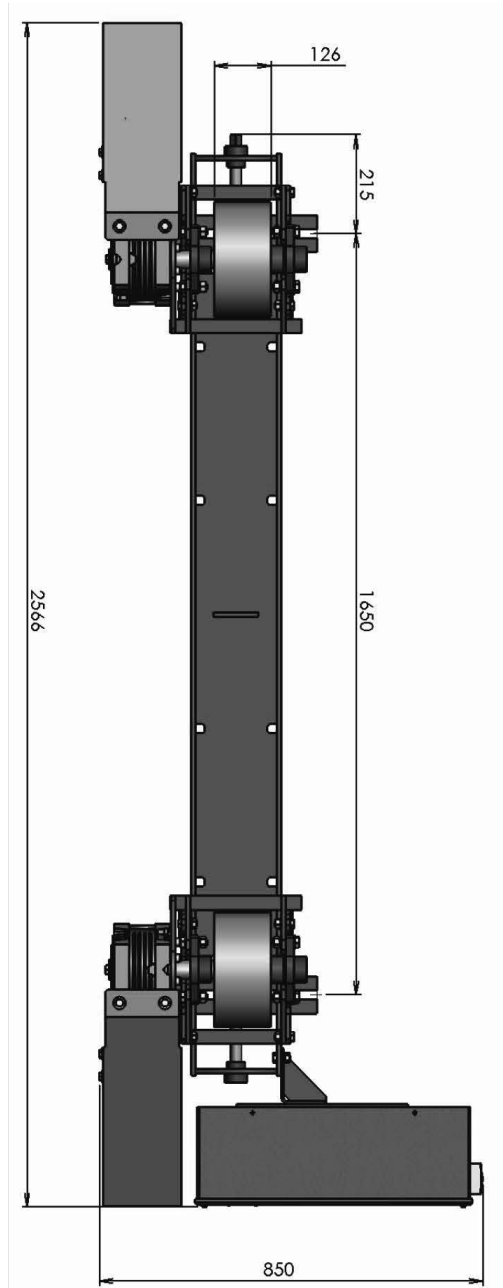
H) OPTIONAL STEEL ROLLER (ON REQUEST)

This option makes it possible to rotate pre-heated shells.
It is required when the temperature of the part is greater than 60°C.

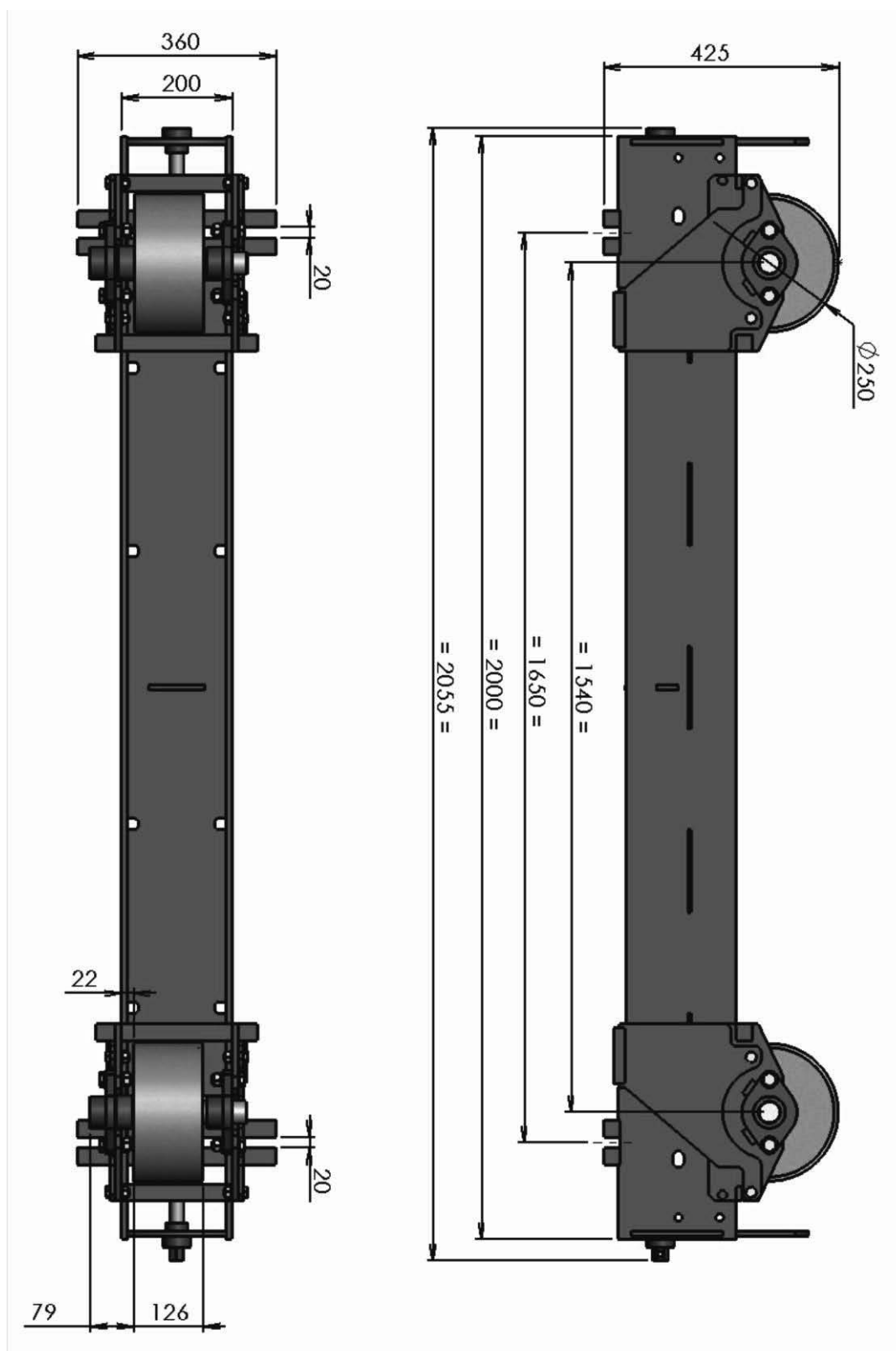
4 - SPECIFICATIONS

	ROTAMATIC ST 15M ROTAMATIC ST 15W	ROTAMATIC ST 15F
Rotation speed in cm/min	min : 12 max : 120	-
Permissible shell diameter (in mm)	min : 300 max : 4000	min : 300 max : 4000
Diameter of idler and drive rollers (mm)	250	250
Width (in mm) and material of rollers	110 polyurethane	110 polyurethane
Roller distance (in mm)	min : 340 max : 1540	min : 340 max : 1540
Power (kVA)	2,5	-
Supply voltage (V)	3 x 400 (50/60Hz)	-
Maximum consumed current (A)	3,6	-
Net weight (kg)	WPV : 210 MPV : 170	FPV : 140
Gross weight (kg)	WPV : 250 MPV : 210	FPV : 165
Maximum driven load (kg)	15000	-
Maximum supported load (kg)	7500	7500
Tangential force (daN)	W : 1216 M : 608	

5 - DIMENSIONS



ROTAMATIC ST 15W and 15M

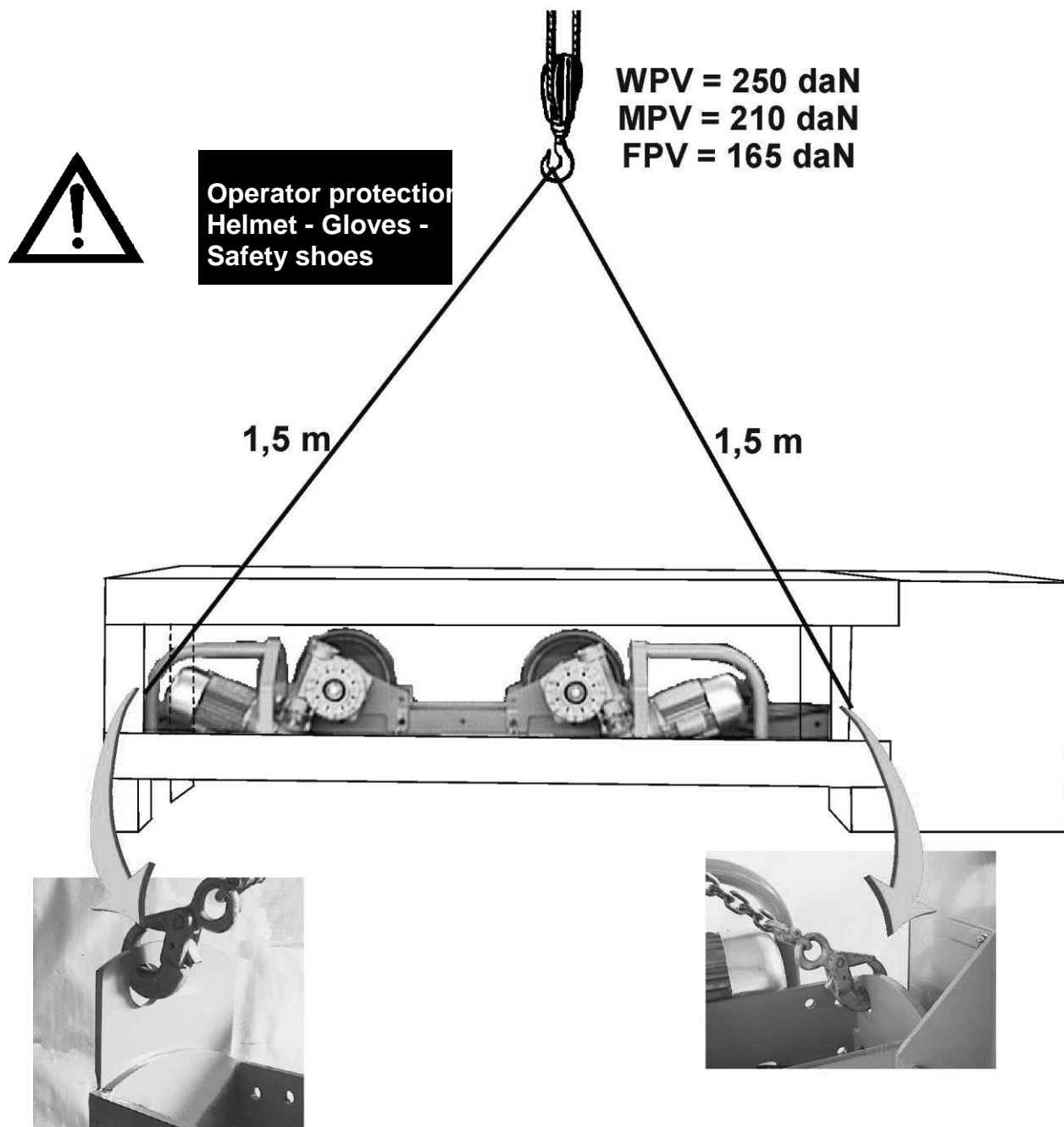


ROTAMATIC ST 15F

D - ASSEMBLY AND INSTALLATION

1 - HANDLING OF ROTAMATIC

- Sling the **ROTAMATIC ST** rotator in its wooden packaging as indicated in the drawing.
- Unpack the **ROTAMATIC ST** rotator from its delivery packaging.
- Sling the **ROTAMATIC ST** rotator, always using the opposite holes at each end.



2 - PUTTING IN PLACE



The cross members of the rotators must be placed parallel in order to avoid screwing effects.
The centre line of the shell must be parallel to the line of the supporting rollers.

In order to line up the cross members, you may use the pads fixed symmetrically under the rotator frame as your reference.

3 - FASTENING OF ROTAMATIC ST

This machine must imperatively be anchored to the floor with four anchoring points in a 20 Mpa (350 kg/m³) single continuous concrete screed with metal reinforcement, completed since at least 21 days (standard BAEL 91).

EQUIPMENT RECOMMENDED FOR FASTENING ROTAMATIC ST:

Brand	Type of anchors	Reference	Drilling diameter (mm)	Permissible load (daN)
HILTI	Metal	FBR M 16 x 130	Ø 16	800
	Chemical	HAS M 16 x 190 + HBP 16	Ø 18	2120
FISCHER	Metal	FA 16 x 20 FB 16 x 25	Ø 16 Ø 16	1200 1200
	Chemical	RM 16 + RGM 16 x 190	Ø 18	3750
SPIT	Metal	050680 FIX 16/45	Ø 16	810 à/to/bis 1270
	Chemical	M 16 - 5209 + SM 16 - 5224	Ø 18	2175

4 - ELECTRICAL CONNECTIONS

The **ROTAMATIC ST** is connected electrically to the network by means of the five-metre cable located at the rear of the supply cabinet.

The cable, which has four conductors, is to be connected to a standardised 3 x 400 V/50-60Hz system with equipotential bonding.



VERY IMPORTANT

For compliance with European safety standards, the connection to the electricity supply is to be made via a wall-mounted cabinet with an individual protective sectioning switch with rating appropriate for the mains voltage and the consumption by the equipment

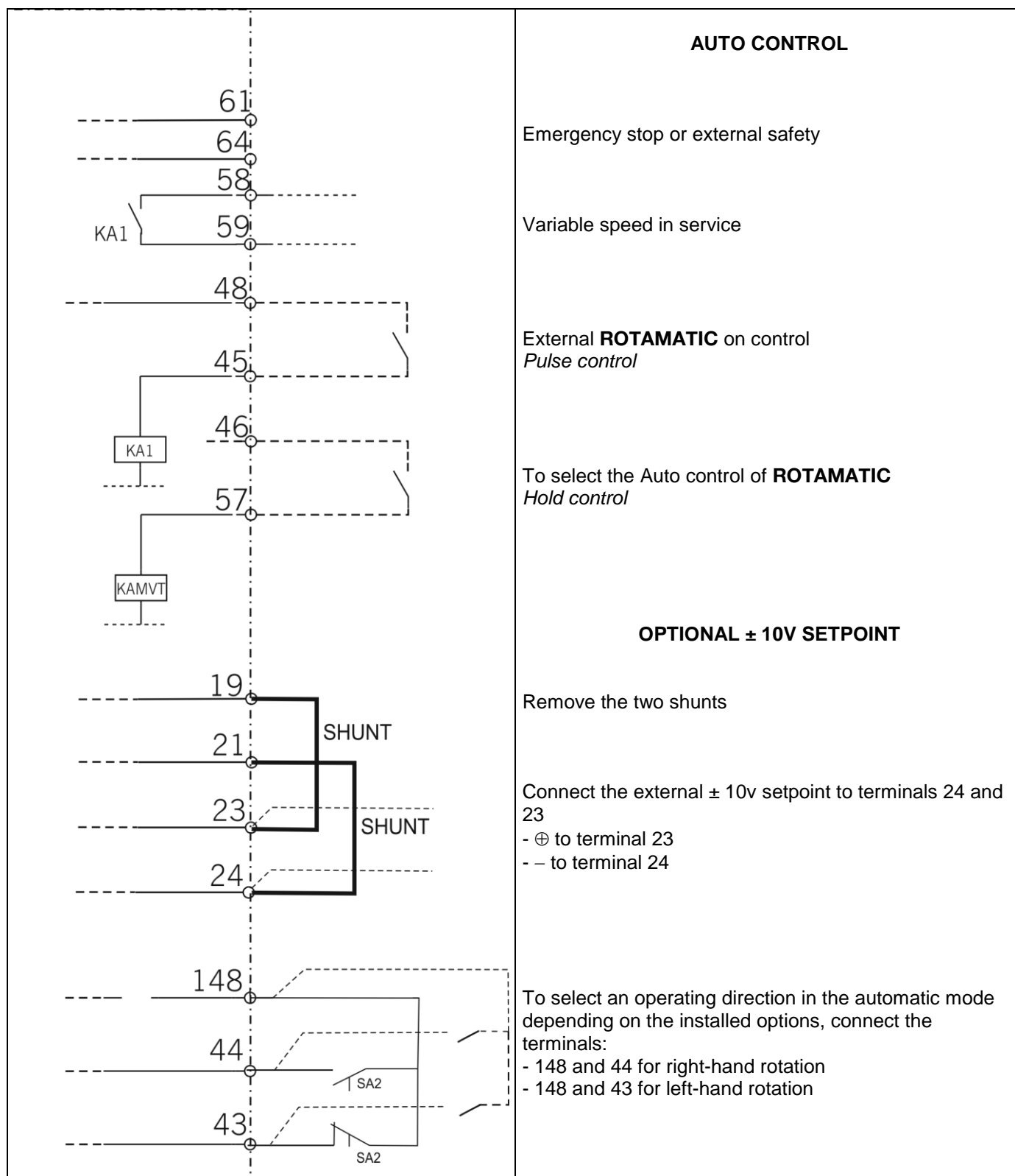
The protective sectioning switch must offer breaking capacity of 100KA.

We market cabinets that meet the criteria set out.

ARRANGEMENT OF CABLES AND FLEXIBLE HOSES

The customer must provide a means to support and protect cables and flexible hoses from mechanical, chemical or thermal damage, right from their point of origin.

EXTERNAL CONNECTION OF OPTIONAL EQUIPMENT



5 - POSITIONING OF SHELLS AND STARTING UP



Before starting up, always make sure that the following setting up conditions and precautions have been followed:

- Set the centre distance of the rollers depending on the diameter of the shell to work on.
- The cross members of rotators must be positioned under the pieces, away from any openings in the shells and away from protruding parts that could hinder the rotation of the shell.
- Balance the load on the two cross members on the basis of the tables below.
- With polygonal pieces, the maximum permissible loads must be divided in half.

ROTAMATIC ST 15M

15 000 Kg

Ø (mm)	E min (mm)	α (°)	E max (mm)	α (°)
300	340	76	380	87
500	350	56	520	88
1000	520	49	840	84
1500	700	47	1020	71
2000	900	47	1170	63
2500	1100	47	1300	56
3000	1300	47	1420	52
3500	1420	45	1530	48
4000	1540	42	1540	42

P 7500 kg

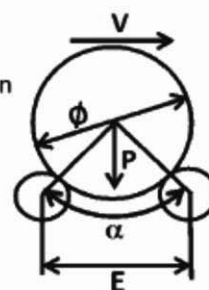
V 12-120 cm/mn

3x400 V

2,5 kVA

3,6 A

50/60 Hz



Ø (mm)	500	1000	1500	2000	2500	3000	3500	4000
α (°)	56	57	58	59	56	52	48	42
E (mm)	350	600	850	1100	1300	1420	1530	1540

M=2P (kg)	Balourd max / Max unbalance (m.kg)							
1000	14	28	43	57	70	80	90	96
2000	28	57	86	115	140	160	179	192
3000	42	85	128	172	210	240	269	288
4000	56	113	171	229	280	320	359	385
5000	69	141	214	286	350	400	449	481
6000	83	170	257	344	420	480	538	577
10000	102	203	304	405	510	618	727	840
15000	57	113	169	224	285	354	423	499

ROTAMATIC ST 15W

15 000 Kg

Ø (mm)	E min (mm)	α (°)	E max (mm)	α (°)
300	340	76	380	87
500	350	56	520	88
1000	520	49	840	84
1500	700	47	1020	71
2000	900	47	1170	63
2500	1100	47	1300	56
3000	1300	47	1420	52
3500	1420	45	1530	48
4000	1540	42	1540	42

P 7500 kg

V 12-120 cm/mn

3x400 V

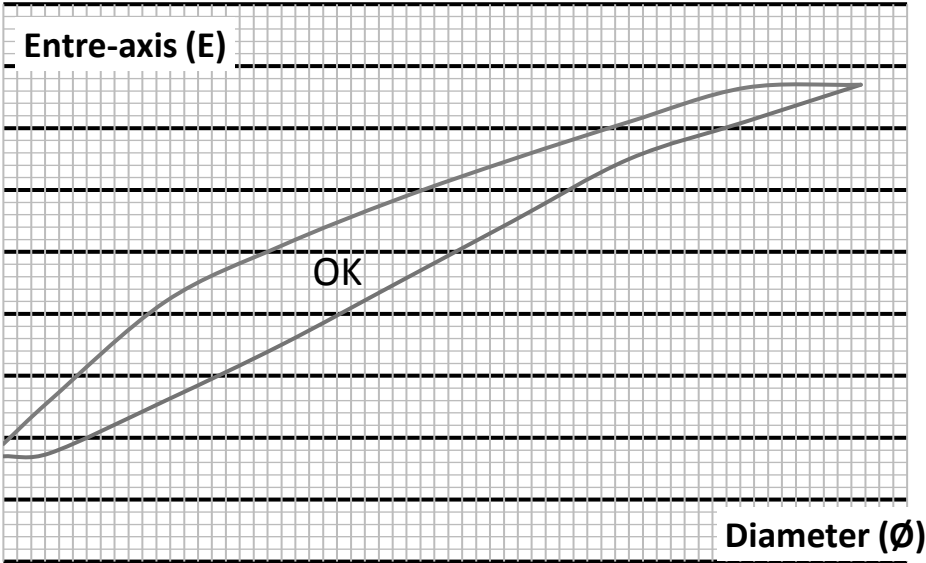
2,5 kVA

3,6 A

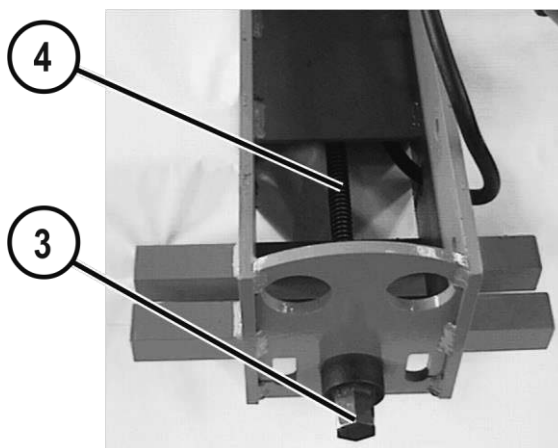
50/60 Hz

Ø (mm)	500	1000	1500	2000	2500	3000	3500	4000
α (°)	56	57	58	59	56	52	48	42
E (mm)	350	600	850	1100	1300	1420	1530	1540

M=2P (kg)	Balourd max / Max unbalance (m.kg)							
1000	27	55	83	112	135	151	167	174
2000	54	110	167	224	271	303	334	348
3000	80	165	250	335	406	454	501	521
4000	107	220	333	447	542	606	668	695
5000	134	275	417	559	677	757	834	869
6000	161	330	500	671	812	909	1001	1043
10000	251	502	752	1002	1256	1490	1642	1711
15000	115	221	324	426	565	742	901	1047



6 - PUTTING IN PLACE THE IDLER AND POWERED ROLLERS



VARIABLE PITCH

The variable-pitch rollers are fixed to a compound screw (**ref.4**) that allows them to be positioned symmetrically and accurately over the whole length of the frame.

They are positioned by turning a perforated screw (**ref 3**) using an appropriate hex key or a rod in the hole of the screw.



Users are strongly advised against changing the position of the variable-pitch rollers when a shell is placed on the rollers.

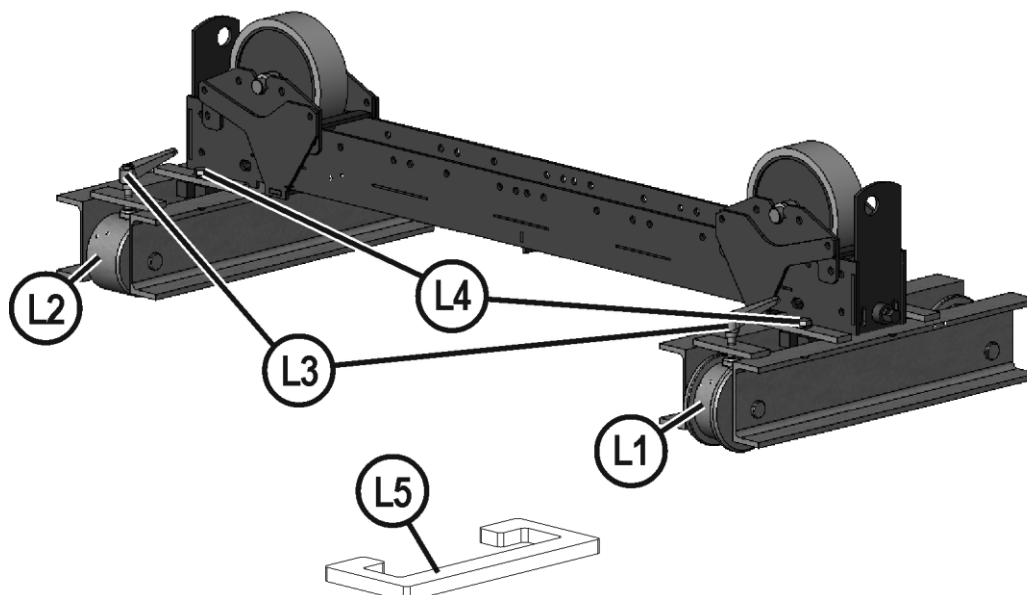
If pneumatic or electrical equipment is used for manoeuvring a compound screw, the operator must take care to not strike the stops too hard.

7 - PUTTING IN PLACE THE TRUCKS

- Place truck L1 on the track with side machining.
- Place truck L2 on the other track.
- Immobilise the truck by fastening the handles L3.
- Place the **ROTAMATIC** on the trucks and fix with the four L4 screws. (Check if **ROTAMATIC** is perpendicular to the tracks before tightening the screws).

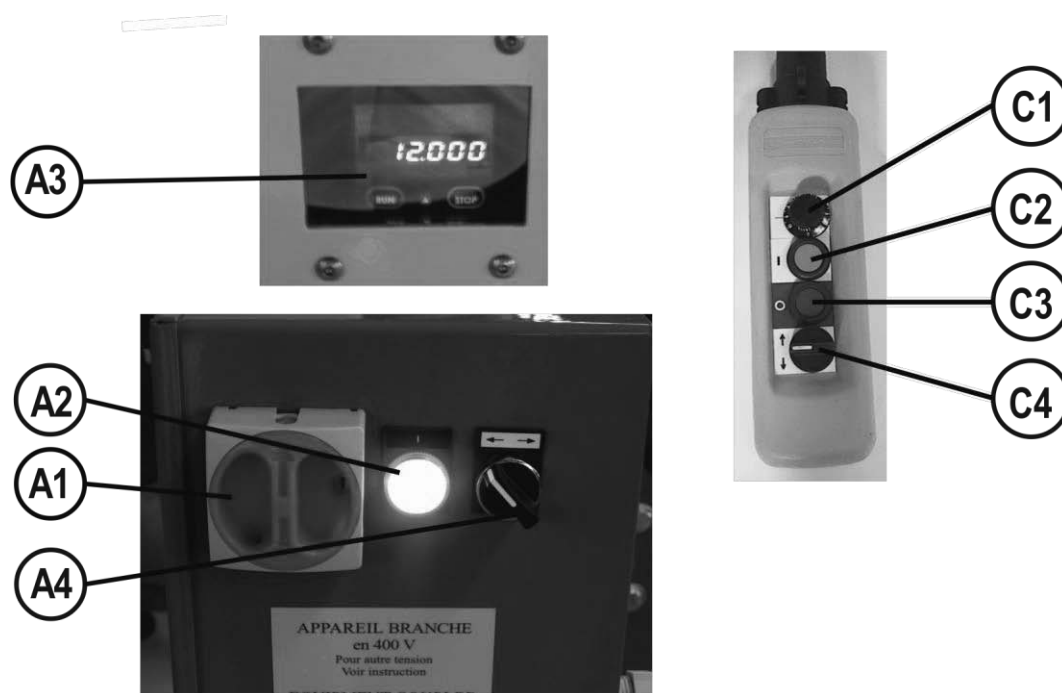
NB:

The pieces L5 are not used with **ROTAMATIC ST6** and **ST15**.



E - OPERATING MANUAL

1 - CONTROL BUTTONS ON CABINET



Ref.	Description
A1	Main power button.
A2	Power on indicator
A3	Variable drive speed display
A4	Rotation direction with automatic starting up
C1	Rotation speed adjustment potentiometer, variable from 12 to 120 cm/min.
C2	Power on pushbutton (variable drive)
C3	Power off pushbutton (variable drive)
C4	Switch with three fixed positions for rotation direction. The central position is the idle position.

2 - OPTIONAL SYNCHRONISATION (FACTORY ASSEMBLED ONLY)

This option allows the synchronised or non-synchronised operating of two powered **ROTAMATIC**. It makes it possible to rotate a piece supported by several powered and idler rollers from a single remote control or a single external control.

- Synchronised mode (*master/slave*):

This mode controls two **ROTAMATIC** via the remote control or from the external inputs of the main (master) **ROTAMATIC**. An indicator on each **ROTAMATIC** confirms that the synchronised mode has been selected. The remote control of the slave **ROTAMATIC** is inactive, with the exception of the stop button.

- Desynchronised mode (*independent*):

This mode makes it possible to control the **ROTAMATIC** via their remote controls or from the external inputs of the **ROTAMATIC**, independently from each other. All the remote controls of the **ROTAMATIC** are active.

- Selecting the synchronised/desynchronised mode:

Switching from the synchronised mode to desynchronised mode is via the connecting cable between the powered **ROTAMATIC** rotators.

Synchronised mode: connecting cable connected and synchronisation indicator on cabinets on.

Desynchronised mode: connecting cable disconnected and synchronisation indicator on cabinets off.

In synchronised mode, the maximum driven load is 3/2 times the load of the powered rotator:

For **ROTAMATIC ST15**: $3/2 \times 15T = 22.5T$

F - MAINTENANCE

1 - CARE

- For a long and trouble-free life, the machine requires a minimum level of care and maintenance.



Before working on the machine, it is **MANDATORY** to lock out all the supplies of utilities to the machine (electricity, air, gas etc.).
Locking an emergency stop button is not sufficient.

LUBRICATION

The reduction drives of **ROTAMATIC ST** have permanent lubrication and have no oil filling, topping up or draining plugs.

As a result, they need no maintenance.

These reduction drives can operate at an ambient temperature from 0 °C to +50 °C.

INSPECTION AND SAFETY

All the instructions in this manual must be followed closely, particularly those relating to the limits of use. Further, the main parts of the equipment, particularly the screws and nuts of the roller spacing system, the wearing of wheel and screw reduction gear, power cables of motors and remote control, motor ventilation etc., must be inspected after every three months.

TYRE MAINTENANCE AND PROTECTION

For a long life, the instructions below must be followed:

- ⇒ Do not overload (no impact when the shell is squeezed)
- ⇒ Do not place the rollers under a heavy load, as that could permanently deform their solid tyres
- ⇒ Do not put hydrocarbons on the rollers. If that were to happen, clean them very promptly.

In the event of pre-heating, the temperature of the shell area in contact with the tyres may not exceed 60 to 70 °C and the piece must be in continuous motion.

2 - TROUBLESHOOTING

Possible symptoms	Probable causes	Possible remedies									
The rotator indicator goes off after the power is switched on with the switch QS1.	The indicator lamp has blown	Replace the bulb									
	Fuses FU1 or FU3 have blown	Replace the blown fuses on the basis of the fuse rating table.									
The rotator will not rotate after it is started up.	No rotation direction has been selected.	Select a rotation direction using the switch ↑↓.									
		With automatic control, the connection is not made between terminals 148 and 44 (right-hand rotation) or 148 and 43 (left-hand rotation) to control the operating direction. Make the connection with a shunt or external contact; see electrical connections.									
		When using an external ± 10V setpoint, check the presence of voltage between terminals 23 and 24 (0V → no rotation).									
	The motor is not powered	Check and replace the fuses FU2 if needed.									
		Check that the thermal relays FR1 or FR2 have not tripped. Then check that the thermal relay is correctly adjusted according to the table below: Double power rotator:									
		<table><tr><td>type:</td><td>15T</td><td></td><td></td><td></td></tr><tr><td>valeur (A)</td><td>1,2</td><td></td><td></td><td></td></tr></table>	type:	15T				valeur (A)	1,2		
type:		15T									
valeur (A)	1,2										
The rotator runs for a short time and then stops.	Over-intensity leading to: - a thermal relay fault or over-intensity leading to: - a variable drive fault F0102 or F0103	Check the condition and adjustment of the thermal relays (double power version) according to the table above.									
		Check that you have followed the table with the admissible load and unbalance values for your rotator.									
		Check that the load has not increased suddenly.									
		Check that the terminals U, V and W of the variable drive are not shorted.									
		Check that the motor cable is not shorted and that the motor is correctly coupled.									

DEFINITIONS OF ERRORS DISPLAYED ON THE VARIABLE DRIVE

NUMERO NUMBER/NUMMER	DESCRIPTION
F0102,F0103	Variable drive overload. Check the load behaviour. Check the motor parameter adjustments.
F0200...F0300	Temperature too high. Check cooling, flap, sensor and ambient temperature. Temperature low. Check the ambient temperature and the heating of the electrical cabinet.
F0400, F0403	Motor temperature too high or sensor faulty. Check the connection to X12.4. Phase fault. Check the motor and the wiring
F0500...F0507	Overload, short circuit or dispersion in the ground, motor current or phase fault. Check the load behaviour and the gradients (P420...P423). Check the motor and the wiring.
F0700...F0706	DC bus voltage too high or too low. Check the deceleration gradients (P421, P423) and the connected braking resistor. Check the network voltage. Check the network voltage, the fuses and the network circuit.
F0801,F0804	Electrical voltage (24V) too high or too low. Check the wiring of the control terminals
F1100...F1110	Maximum frequency reached. Check the control signals and adjustments. Inspect the deceleration gradients (P421, P423) and the connected braking resistor
F1310	Minimum output current. Check the motor and the wiring.
F1401	Signal of the reference value on the input X12.3 faulty, check the signal.
F1407	Over-intensity at input X12.3, check the signal.
F1408	Over-intensity at input X12.4, check the signal.
A0001...A0004	Variable drive overload. Check the load behaviour. Check the motor and application parameters.
A0008,A0010	Temperature too high. Check cooling, flap and ambient temperature.
A0080	Once the maximum motor temperature is reached, check the motor and sensor.
A0100	Network phase failure, check the main fuses and the power cable
A0400	Once the frequency limit is reached; output frequency limited.
A0800	Input signal at X12.3 too low. Increase the value
A1000	Input signal at X12.4 too low. Increase the value
A4000	The voltage of the DC bus has reached the minimum value

ROTATOR FUSE RATINGS:

	STANDARD ROTATORS			OPTIONAL REGULATION
	FU1 (5x20)	FU2 (10x38)	FU3 (5x20)	FU2 (10x38)
ROTAMATIC ST 15	1 AaM	6 AaM	6 AgF	10 AaM

3 - SPARE PARTS

How to order

The photos or sketches identify nearly every part in a machine or an installation

The descriptive tables include 3 kinds of items:

- those normally held in stock: ✓
- articles not held in stock: ✕
- those available on request: no marks

(For these, we recommend that you send us a copy of the page with the list of parts duly completed. Please specify in the Order column the number of parts desired and indicate the type and the serial number of your equipment.)


For items noted on the photos or sketches but not in the tables, send a copy of the page concerned, highlighting the particular mark.

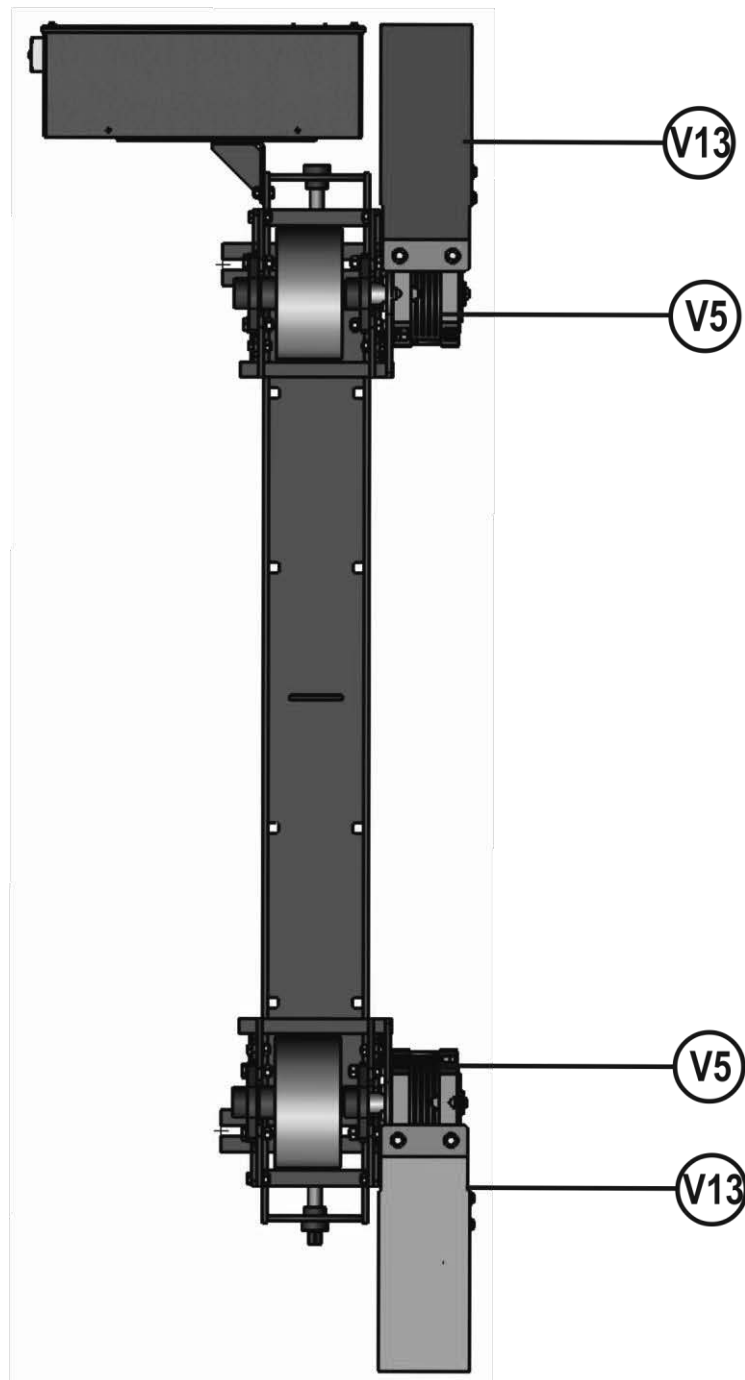
For example:

		✓	normally in stock
		✕	not in stock
			on request

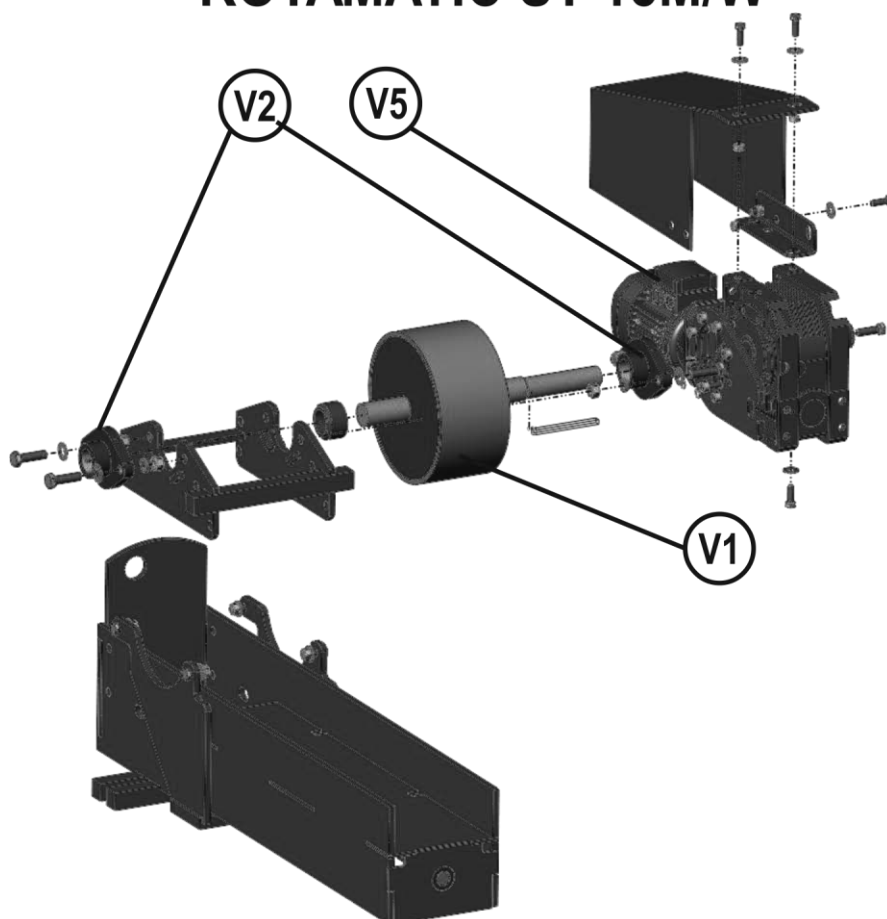
Item	Ref.	Stock	Order	Designation
1	W000XXXXXX	✓		Machine interface board
2	W000XXXXXX	✕		Flowmeter
3	9357 XXXX			Silk-screen printed front panel

- For parts order, give the quantity required and put the number of your machine in the box below.

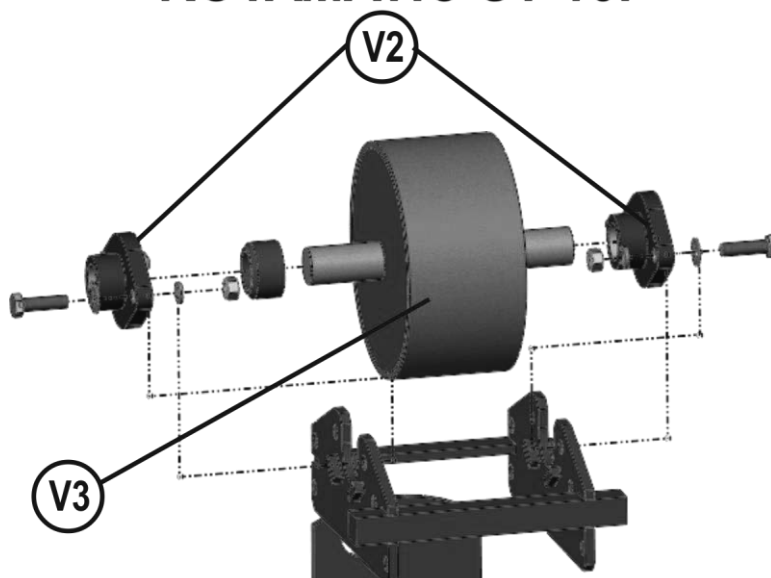
	TYPE:
	Number:

MECHANICAL PART**ROTAMATIC ST 15W**

ROTAMATIC ST 15M/W



ROTAMATIC ST 15F



MECHANICAL PART

<input checked="" type="checkbox"/>	normally in stock
<input checked="" type="checkbox"/>	not in stock
<input type="checkbox"/>	on request

Item	Ref.	Stock	Order	Designation
V1	W000275298	<input checked="" type="checkbox"/>		Drive roller
V2	W000138020	<input checked="" type="checkbox"/>		Drive roller bearing
V3	W000138019	<input checked="" type="checkbox"/>		Equipped idler roller
V5	W000383728	<input checked="" type="checkbox"/>		Motorgear 15T
V13	0300 1534			Motor guard cover
V20	0300 1526			Drive trunnion

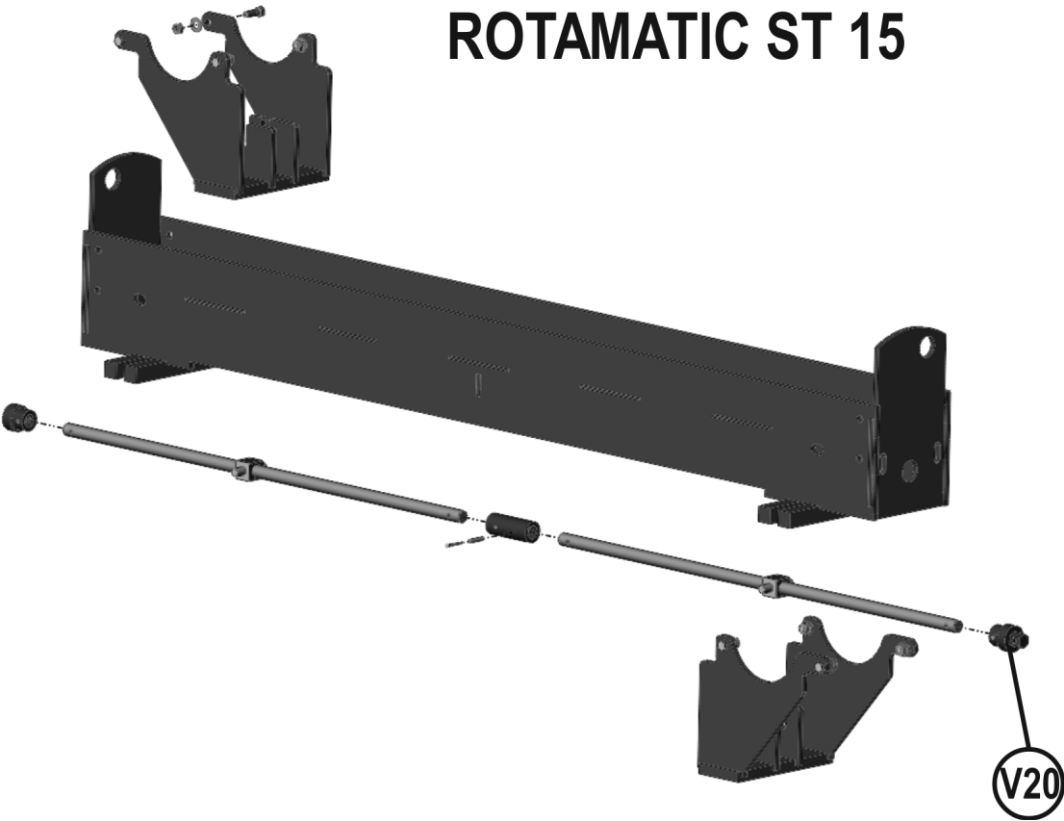
➤ For parts order, give the quantity required and put the number of your machine in the box below.

CE Type

Matricule

TYPE:

Number:



OPTIONAL TRUCK

✓	normally in stock
✗	not in stock
	on request

Item	Ref.	Stock	Order	Designation
L1	0300 5012			Flanged roller
L2	0300 5013			Smooth roller
L4	.620 7303			Indexable handle
	.620 7304			Pad screw
	.620 7305			Pad

➤ For parts order, give the quantity required and put the number of your machine in the box below.

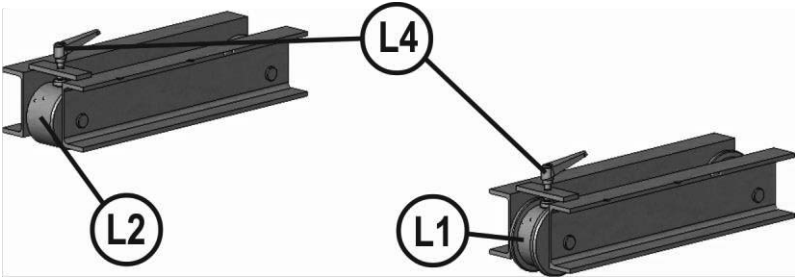
CE

Type

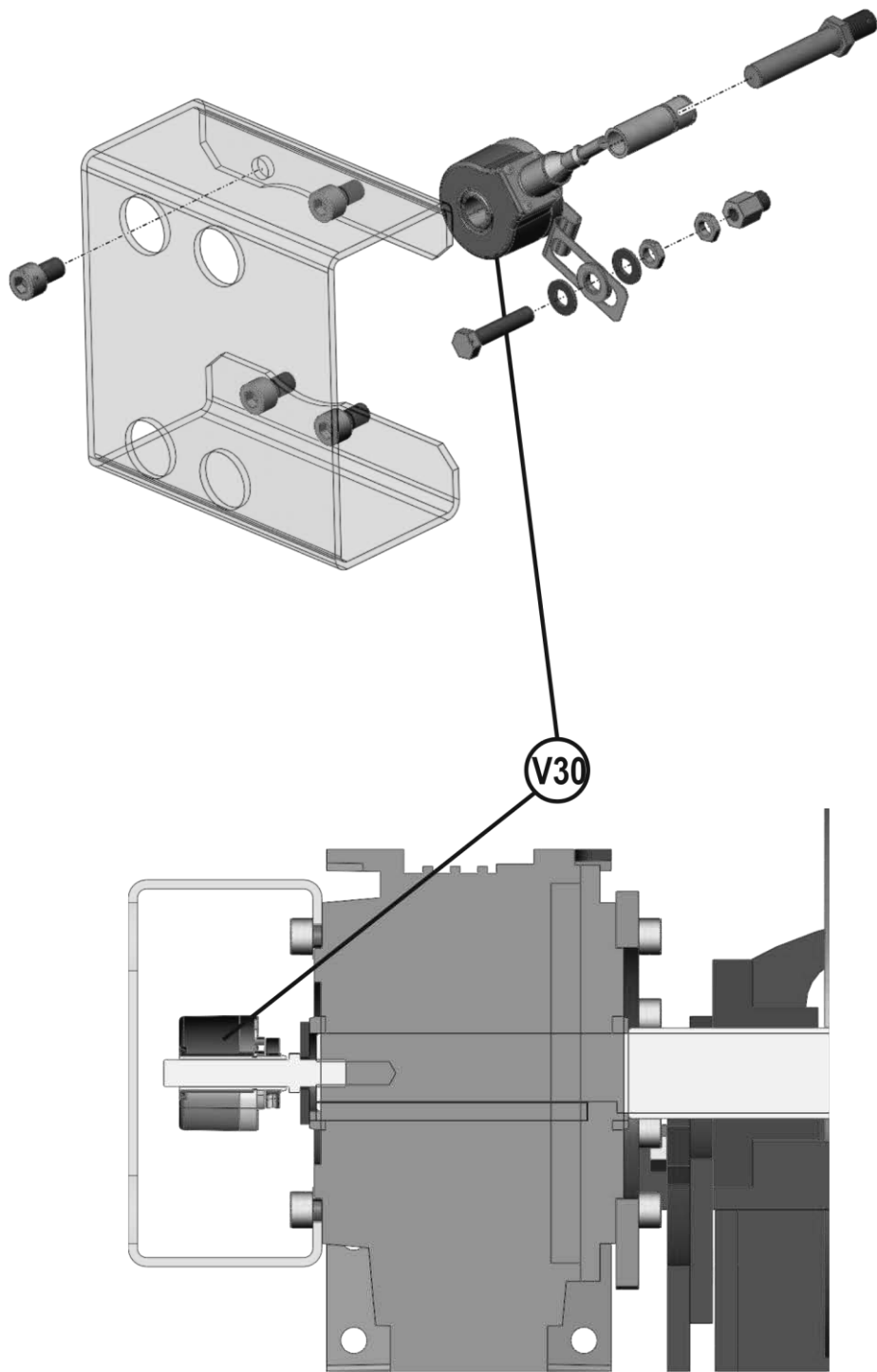
Matricule

TYPE:

Number:



OPTIONAL ENCODER



✓	normally in stock
✗	not in stock
	on request

Item	Ref.	Stock	Order	Designation
V30	W000383727			Encoder

➤ For parts order, give the quantity required and put the number of your machine in the box below.

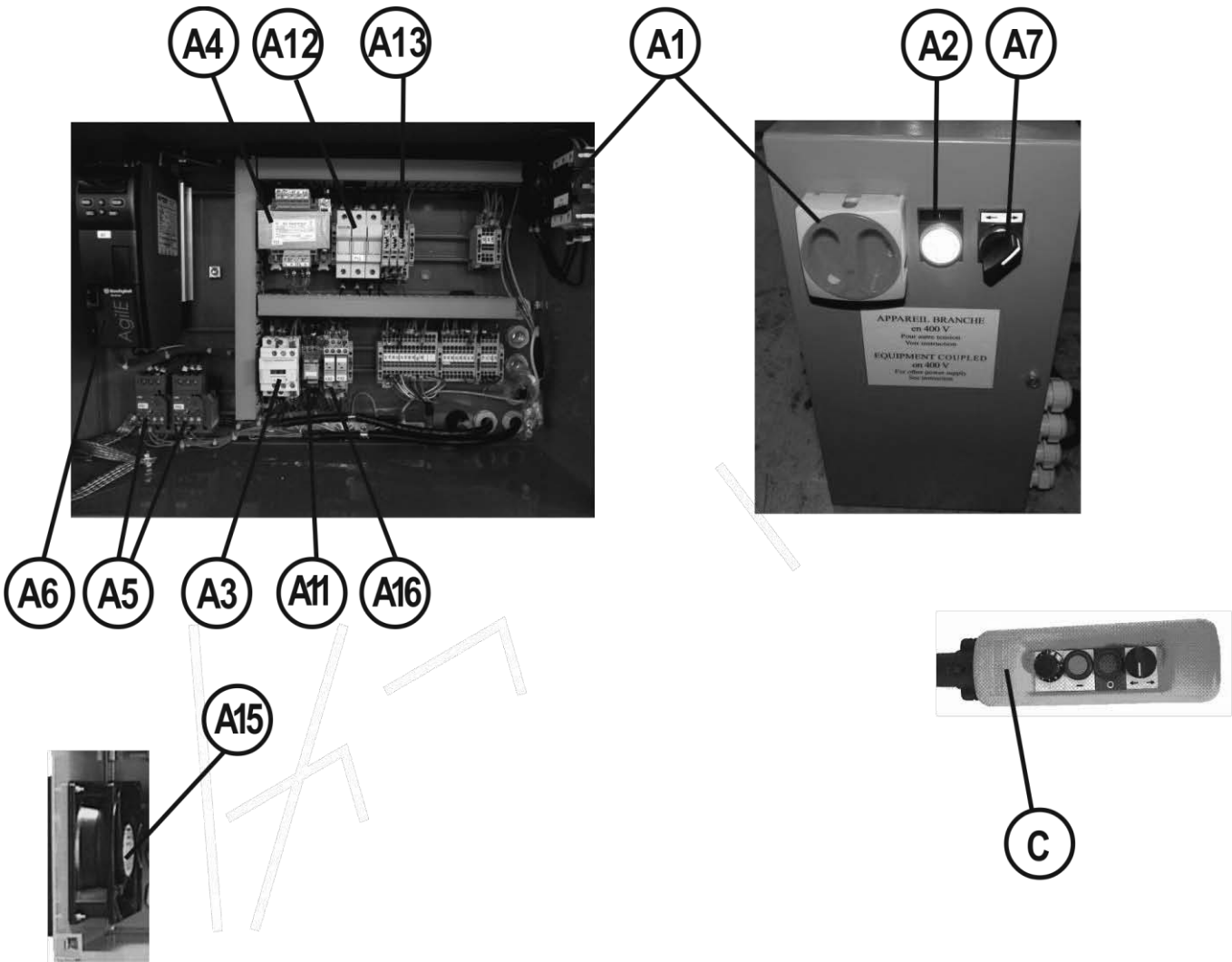
CE Type

Matricule

TYPE:

Number:

ELECTRICAL PART



ELECTRICAL PART

Valid for serial number greater than 00361502155

✓	normally in stock
✗	not in stock
	on request

Item	Ref.	Stock	Order	Designation
A1	W000140748	✓		Main switch
A2	W000137799	✓		24V BA9S bulb
A2	.570 4057			Indicator body
A2	.570 4054			Power on indicator head
A3	.570 1064			Auxiliary contactor KA1
A4	.570 6078			63VA 220-380/2x24V transformer
A5	.570 5027			Thermal relay
A6	W000383723	✓		0.75kW Agile variable drive for 15TM - 15TMR-15TWR
A6	W000383724	✓		0.75kW Agile variable drive for 15TW
A7	W000366020	✗		Two fixed pitch selector head
A7	W000366042	✗		Body
A7	W000366044	✗		Contact
A11	9109 3173			Four-contact relay
A12	.570 5167			10x38 three-pole cut-off (FU2)
A13	.551 3716			5x20 fuse holder (FU1-FU3)
A13	.551 3727			Accessory - 5x20 fuse holder (FU1-FU3)
A13	.551 3728			Accessory - 5x20 fuse holder (FU1-FU3)
A15	W000140321	✓		Fan
A16	.5606743			Relay 2 RT
C	W000137972	✓		Control housing with cable

➤ For parts order, give the quantity required and put the number of your machine in the box below.

CE Type	
Matricule	

TYPE:	
Number:	

[illegible]