WOODWORKING MACHINERY

MACHINE CODE 16303351

EN

MANUAL CODE 00003264
REV 00

THIS MANUAL SHOULD ALWAYS BE KEPT NEAR THE MACHINE FOR FUTURE REFERENCE

BORING SYSTEM 35

ORIGINAL USE and MAINTENANCE MANUAL

Page intentionally left blank

CE Declaration of Conformity

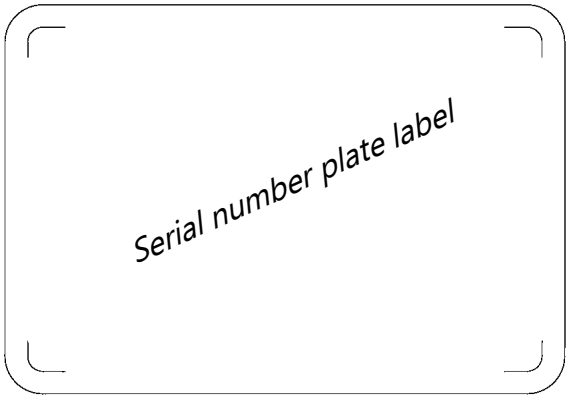
The manufacturer

Maggi Technology S.r.l.

Via delle Regioni, 299 - 50052 Certaldo (FI) ITALIA

Declares that the machine

The machine	*BORING SYSTEM*
Model	*35*



is in compliance with all provisions pursuant the following directives:

2006/42/EC (Machine)
2014/30/EU (EMC)
2014/35/EU (Low voltage)

and represents the technical file.

-Certaldo - Issues date :

The General Manager
Giacomo Landi

CE

Page intentionally left blank

WE WISH TO THANK YOU FOR CHOOSING ONE OF OUR PRODUCTS

All the information, advices and important warnings for a correct use of the machine, have been inserted into this manual. This manual also contains the rules for a correct periodical maintenance to keep this machine in perfect efficiency. We suggest that all the chapters of this manual are thoroughly read before you use the machine for the very first time.

INTRODUCTION

Some information and illustrations in this manual may differ from the machine in your possession, since all the configurations inherent in the machine complete with all the OPTIONALS are described and illustrated. Therefore, refer only to that information strictly connected with the machine configuration you have purchased. The manufacturer in his pursuit of a policy of costant development and updating of the product may make any modifications without any prior notice.

This manual has been drawn up exclusively for our customers' use, guaranteeing that at the date of issue it constitutes the latest update of the documentation related to use of the product. Use of this manual is on full responsibility of the user. The manufacturer does not grant any further guarantee for any imperfections, incompleteness and/or operating difficulties, expressly excluding any responsibility for direct or indirect damage deriving from use of this documentation. MAGGI ENGINEERING reserves the right to make any modifications to the product described in this manual at any time without prior notice.

INDEX

NOTES

GENERAL INFORMATION ON THE MANUFACTURER

Manufacturer:	MAGGI TECHNOLOGY S.r.l.
Address:	Via delle Regioni, 299 - 50052
Town:	CERTALDO (FI)
Country:	ITALIA
Tel.	+39 0571 63541
Fax.	+39 0571 664275
E-mail:	service@maggi-technology.com

1. SAFETY RULES AND GENERAL INFORMATION

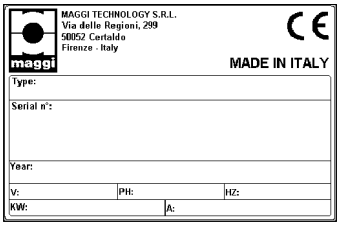
1.1 RECOMMENDATION FOR USE AND MAINTENANCE

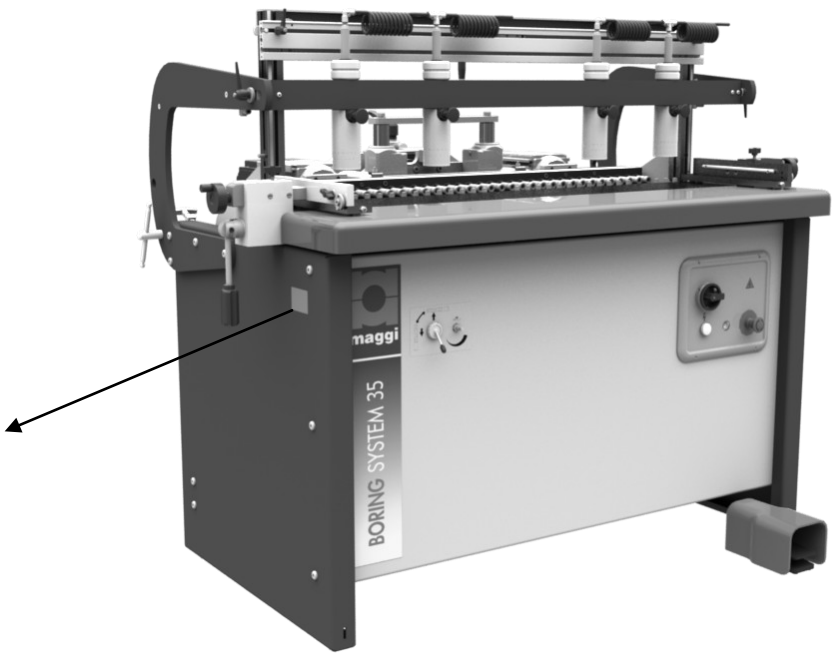
In this manual we put into evidence all the operations for a correct use and ordinary maintenance of the machine.
We strongly recommend not to make any other type of work repair or operation not suggested in this manual.
We suggest also to keep this manual in a place where the user can easily find and read it.

ANY ADULTERATION OR REMOVAL OF SAFETY PROTECTION DEVICES CAN CAUSE SEVERE DAMAGE. ANY REMOVAL, EXCLUSION OR MODIFICATION OF THESE DEVICES IS STRICTLY FORBIDDEN.
YOU MUST VERIFY AND GUARANTEE THE PERFECT RUNNING OF SAFETY DEVICES BY MEANS OF PERIODIC CHECKS. ANY DEFECT OR PROBABLE DRAWBACK MUST BE IMMEDIATELY RESOLVED.

1.2 MACHINE IDENTIFICATION

The data impressed in the plate placed on the left side of the machine (from the point of view of the operator) identify the machine itself.
When you eventually order spare parts or ask for any suggestions for use or maintenance, you have always to transmit the model type and identification number contained in the plate.
It is absolutely forbidden to remove the plate or modify the data it contains.
The following identification plate is placed on the boring system machine described into this manual:





2. OPERATIVE NOTES

WOODWORKING MACHINES CAN BE DANGEROUS

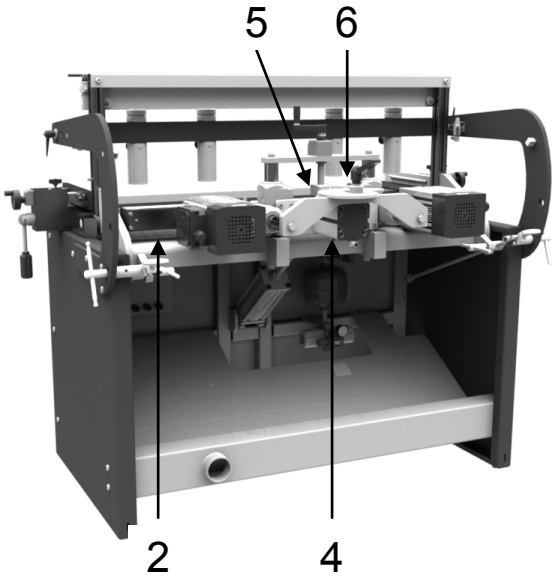
1) A safe and correct use can be obtained by carefully and scrupulously following all the instructions contained into this manual.
2) The machine must be used only by qualified users and personnel of age. The responsible for safety must be sure that users of the machine have read and understood all the information contained into this manual.
3) The personnel for both ordinary and extraordinary maintenance must be well prepared in mechanics and electricity.
4) Keep off any parts in movement of the machine. Never touch the spindles and/or their respective parts in movement of the machine.
5) Never put one working piece on top of another one. Correctly adjust the machine and then drill only one working piece at time.

ANY ADULTERATION OR REMOVAL OF SAFETY PROTECTION DEVICES CAN CAUSE SEVERE DAMAGE. ANY REMOVAL, EXCLUSION OR MODIFICATION OF THESE DEVICES IS STRICTLY FORBIDDEN. YOU MUST VERIFY AND GUARANTEE THE PERFECT RUNNING OF SAFETY DEVICES BY MEANS OF PERIODIC CHECKS. ANY DEFECT OR PROBABLE DRAWBACK MUST BE IMMEDIATELY RESOLVED.

3. MACHINE DESCRIPTION

Our boring machines have been manufactured to make holes on wood at a fixed distance of 32 mm (with maximum accuracy) between each centre.
The head has its fulcrum on the machine table and it can be tilted up to a 90-degree angle. The operator place the work piece on the working table, does some adjustments by using the pedal control, block the piece using the clamp units and then start drilling.
The machine consists of:

1. a steel frame structure
2. one head group equipped with its trasmission system
3. clamp group for vertical blocking of the work piece
4. pneumatic system for head positioning and head feed
5. reference stops to obtain the same drilling distance from vertical to horizontal position
6. leaflet for positioning the spindle height, a mechanical counter and the “Spiral System” device ti regulate the hole depth from 0 mm to 85 mm



3.1 USABLE TOOLS

Drills for quick change spindles, 10 mm O. D. and 20 mm length shank (Fig. A)
Drills up to 40 mm O. D. can be used (Fig. B)

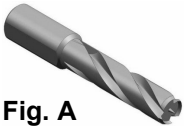


Fig. A

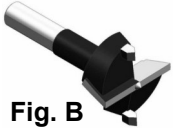


Fig. B

4. ACCESSORIES

CODE	DESCRIPTION	
36000061	BUSHES FOR QUICK CHANGE DRILL	See Fig. A
26054810	ALUMINIUM FENCE WITH 4 STOPS (1500 + 1500 mm)	See Fig. B
26054812	ALUMINIUM FENCE RH WITH 2 STOPS (1500 mm)	Without Fig.
26054813	ALUMINIUM FENCE LH WITH 2 STOPS (1500 mm)	Without fig.
29970202	FENCE EXTENSION (1000 mm)	See Fig. C
26050801	EXTRA STOP FOR ALUMINIUM FENCE	See Fig. D
26001058	REFERENCE FENCE FOR QUICK AND EXACT SETUP OF STOPS ON THE LONG FENCE FOR LNE BORING (1088 mm)	See Fig. E
29900100	STOP REFERENCE PIN FOR LINE BORING	See Fig. F
26000069	SET OF REFERENCE FENCES FOR MOULDINGS AT 45° AND 90°	See Fig. G
26000071	REFERENCE STOP TO MATCH THE LONG PANEL DURING TRANSVERSE BORING	See Fig. H
26000061	REFERENCE FENCE FOR REAR FENCE PARALLELISM (500 mm)	See Fig. I
29971019	EXTRA CLAMPING PRESSER	See Fig. L

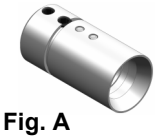


Fig. A

Fig. B

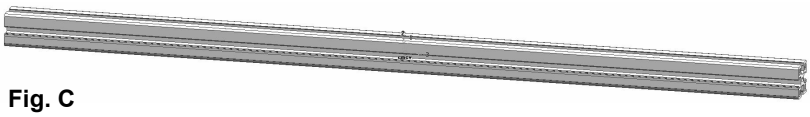


Fig. C

Fig. D

Fig. E

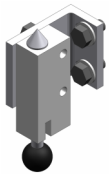


Fig. F

Fig. L

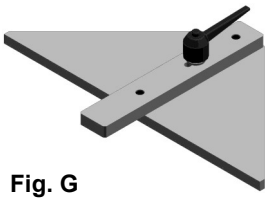


Fig. G

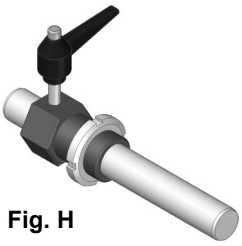


Fig. H

Fig. I

5. SAFETY PROTECTIONS DEVICES AND ADHESIVE WARNING

- The operator assigned to the machine must be well trained on its correct use, its safety protection devices and its accessories.
- The machine drilling devices must be correctly blocked and adjusted.
- The whole machine must undergo ordinary and extraordinary maintenance procedures, following the scheduled timing.
- Before you switch on the machine or start any work session, verify that the working table is free of the shaving left from the wood previously drilled.
- Before making any operation with the machine, verify that the entire working area is free of persons and of any obstacles which could be potentially source of danger.
- Verify that the connecting cable to the electrical power supply is safe, well stretched out and not rolled up.
- Do not enter the drilling zone before turning off the machine.
- Do not put any inflammable substances nearby the machine because of risk of explosion and/or fire due to possible sparks production.
- The operator must pay maximum attention using the pneumatic pedal to work with the machine.
- The operator must think carefully about possible consequences before approaching with his hands the most dangerous areas of the machine: the drilling zone and the working area of the clamp units.
- The machine must be turned off when not in use.

The main risk is due to moving drills. Our machine is equipped with following protection devices to reduce risks to the minimum:

A) Emergency push button

It is inserted in the control panel, in the front side of the machine. All the movements of the machine stop immediately when the emergency push button is pushed.

B) Series of stickers and plates

They describe in details all the safety instructions, the correct working procedures and identify the main parts of the machine. One plate shows the identification and serial number of the machine.

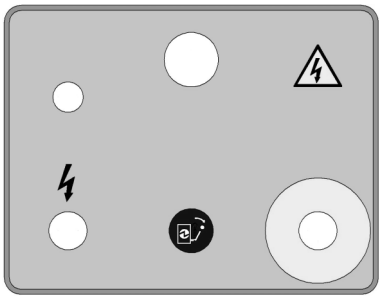
C) Safety clamp (patented)

They are on the surface of the working table or of the already positioned working piece, so that the operator can not put unintentionally his hands below.

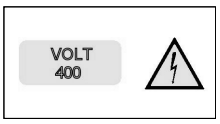
D) Safety protection device

No-way-back coil preserve against accidental start. No-way-back coil preserve against accidental start

Cod. 36054016



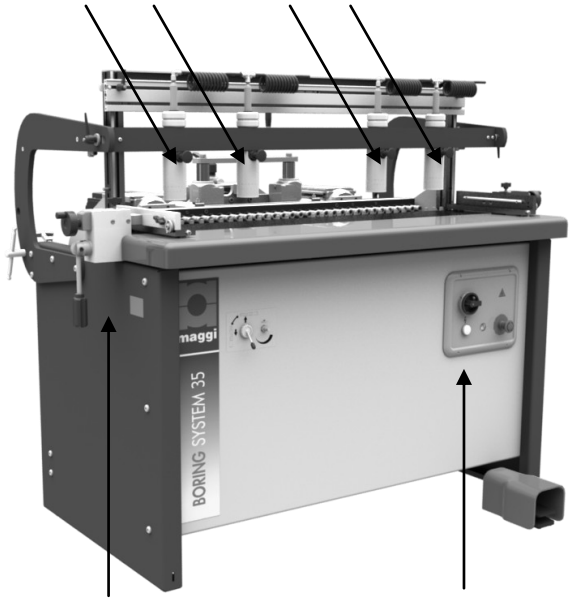
Cod. 36054032

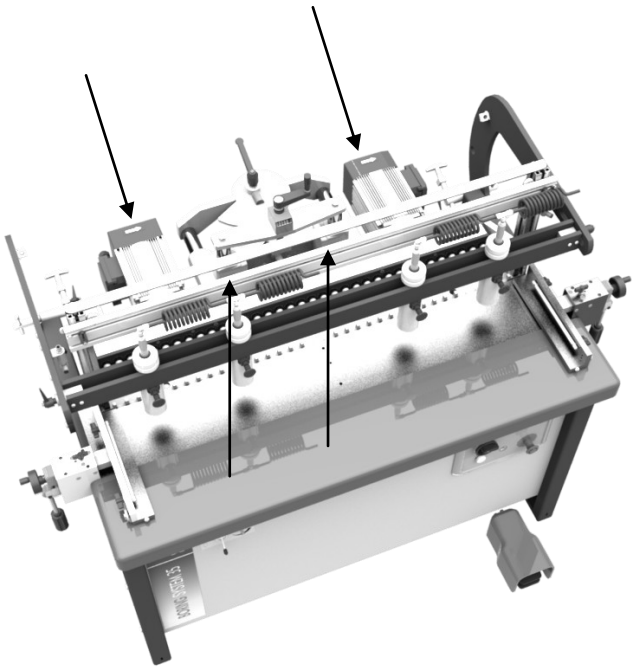


Cod. 36054018

Cod. 36054019

WARNING SYMBOL: ALL THE OPERATIONS HIGHLIGHTED WITH THIS SYMBOL ARE DANGEROUS TO THE OPERATOR; PLEASE BE VERY CAREFUL IN DOING THESE OPERATIONS.





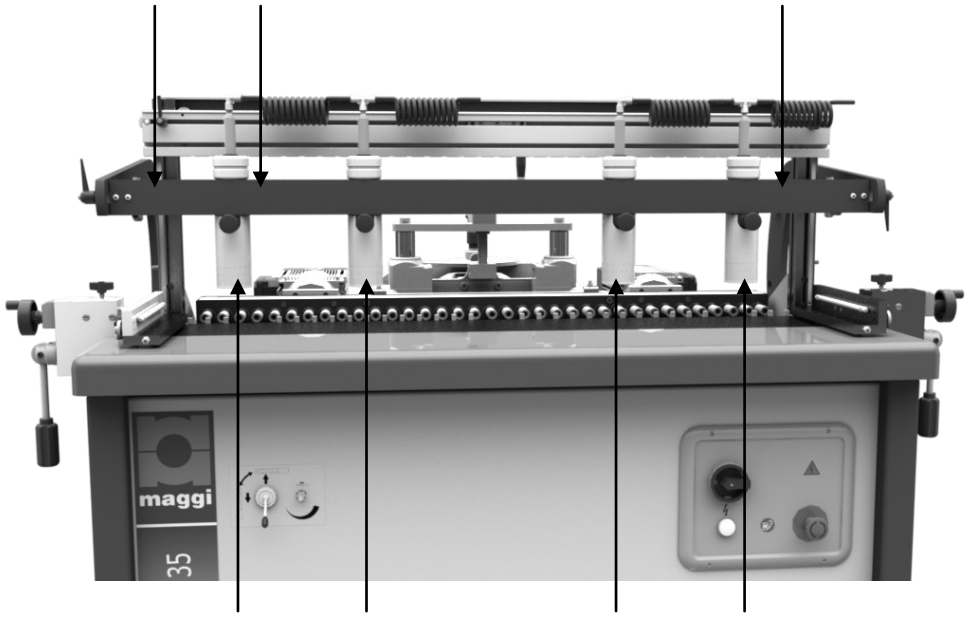
U.S.A. WARNING SYMBOLS

WARNING SYMBOL: ALL THE OPERATIONS HIGHLIGHTED WITH THIS SYMBOL ARE DANGEROUS TO THE OPERATOR; PLEASE BE VERY CAREFUL IN DOING THESE OPERATIONS.

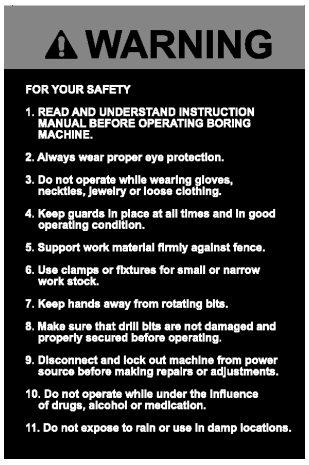
Cod. 36050506

Cod. 36050507
Cod. 36050508

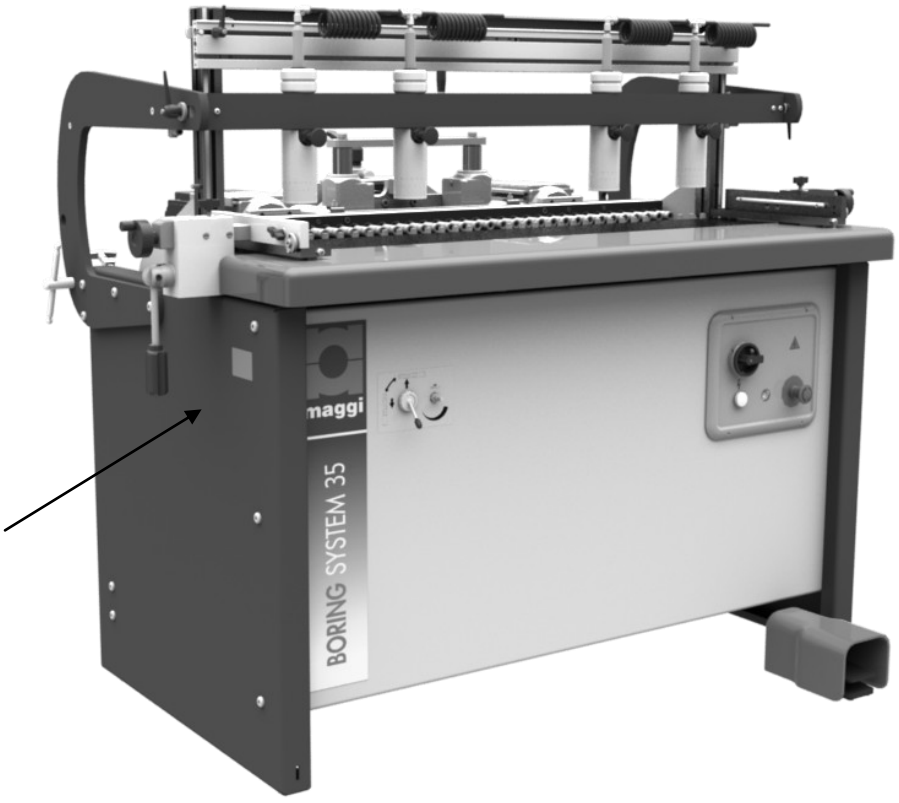
Cod. 36050509



Cod. 36050505



Cod. 36050005



6. INDIVIDUAL PROTECTION DEVICES AND RESIDUAL RISKS

Despite all adopted safety protection devices, following situations may be dangerous:
- fall or throw of wood sliver during working operation
- entangling parts of clothes in moving parts of the machine
- danger of fire
- danger of electrocution
- danger of damage due to noise emission
- danger of damage due to dust emission

To prevent risks during placing, installation, adjustment, use, ordinary and extraordinary maintenance, we strictly recommend to use the following individual protection devices:
- gloves (for example during machine parts handling)
- anti-crushing and anti-sliding shoes
- glasses or face-shields against chip or wood sliver during working or cleaning operation of the machine
- anti-dust masks

Moreover, the clothes must be suited to avoid danger of:
- catching
- dragging
- crushing
- sliding
- abrasion
- contact lenses are prohibited

For further information and recommendation please refer to chapter. OP-

Never leave the machine unattended when connected to the electrical power supply

7. TECHNICAL DATA

Technical feature	**BS 35**
N°. OF SPINDLES	35
INTERAXIS BETWEEN SPINDLES	32 mm
INTERAXIS BETWEEN FIRST AND LAST SPINDLES	1088 mm
MAX. BORING DEPTH	85 mm
MAX DIMENSION OF THE WORKING PIECE	1340 x 3000 mm
HEIGHT OF THE WORKING TABLE	875 mm
DIMENSION OF THE WORKING TABLE	1330 x 410 mm
N° OF CLAMPS	2
STANDARD PNEUMATIC PRESSURE	6 - 8 Bar
STANDARD AIR CONSUMPTION FOR WORKING CYCLE	15 L / Cycle
N° OF MOTORS	2
MOTOR POWER	2 (1,5) HP(KW)
MOTOR r.p.m.	2800 RPM
MACHINE DIMENSIONS (B x L x H)	990x1670x1280 mm
NET WEIGHT	450 Kg

8. INTENDED USE

8.1 MATERIALS

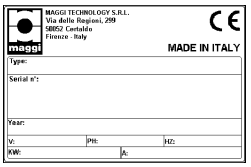
The boring system machine has been designed and built to drill the following materials:
- solid wood
- m.d.f.
- panels of shaving wood, laminated wood, ennobled wood, etc.

The maximum panel thickness is 65 mm and its maximum dimensions are those described at chapter 7.
- Other materials, different from the ones described above, can be machined only after the written approval of the manufacturer. In particular it is not allowed to machine materials having toxic or dangerous substances for operator's health and safety, metals or other materials that can modify the correct working of the machine or cause fire or explosion..
- Any modification is forbidden without the written authorization of the manufacturer.
- It is not allowed to tamper with the safety protection devices.

8.2 IMPROPER USE

Any operation that does not comply with the instructions given herein is to be regarded as improper use.
Moreover:
WE ADVISE YOU NOT TO lay tools against or on the machine for any reason whatsoever during machine installation, use or maintenance.
WE ADVISE YOU NOT TO get on the machine or on any of its parts.

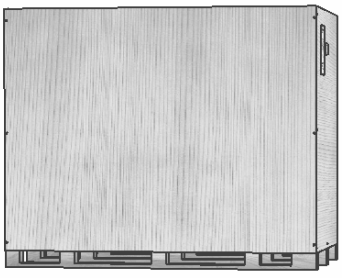
The manufacturer cannot be considered liable for any damage caused to people, animals or property resulting from improper use of the machine.



9. TRANSPORT

The boring machine 35 is packed in a wooden box and/or in cardboard and nylon. It is possible to move it by means of:
- Forklift
- crane
- transpallet

Weight data are written in chapter 8. Before moving the machine verify that the entire surrounding area is free of obstacles. In case of stocking, the machine must be kept in dry places, away from rain, snow or humidity. During all moving operations we recommend to be extremely careful to avoid danger of damage for persons, things and the machine itself.



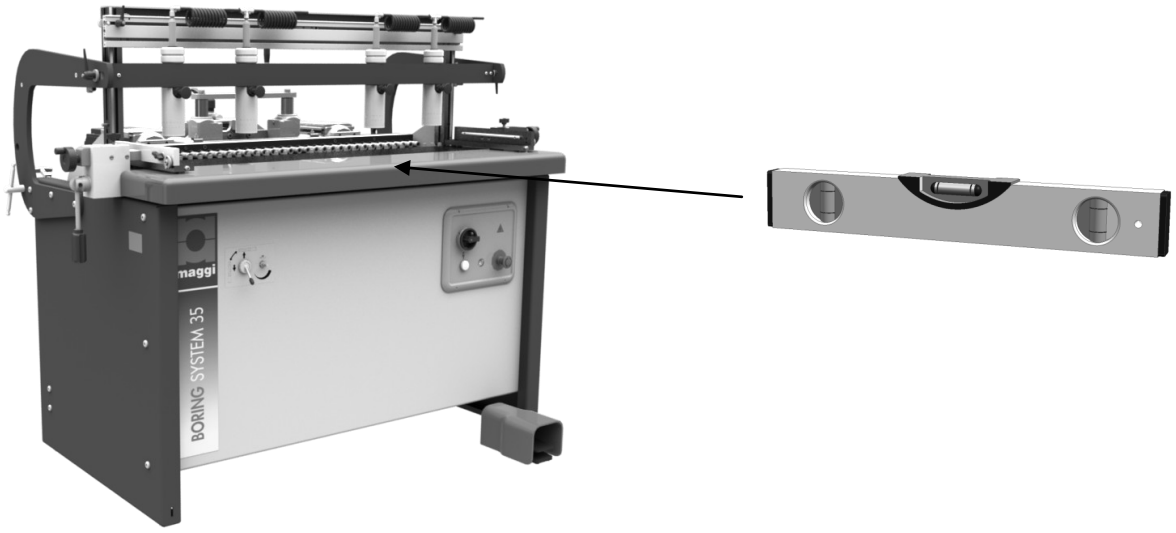
10. INSTALLATION

10.1 PLACING THE MACHINE

The machine must be placed on a stable plain surface, capable to support the weight of the machine itself; any possible difference in height must be in conformity with building rules. When the machine has to be placed on raised plain surface (higher floor) the load-bearing slab must be adequate to the weight of the machine.
Put the machine in the right place, as requested operative requirements, where it is easy to connect it to electrical and pneumatic power supply.
Put the machine in a place where there is enough lighting to see every part of the machine itself.
We suggest also to arrange an exhaust fan nearby the machine to clean it periodically.

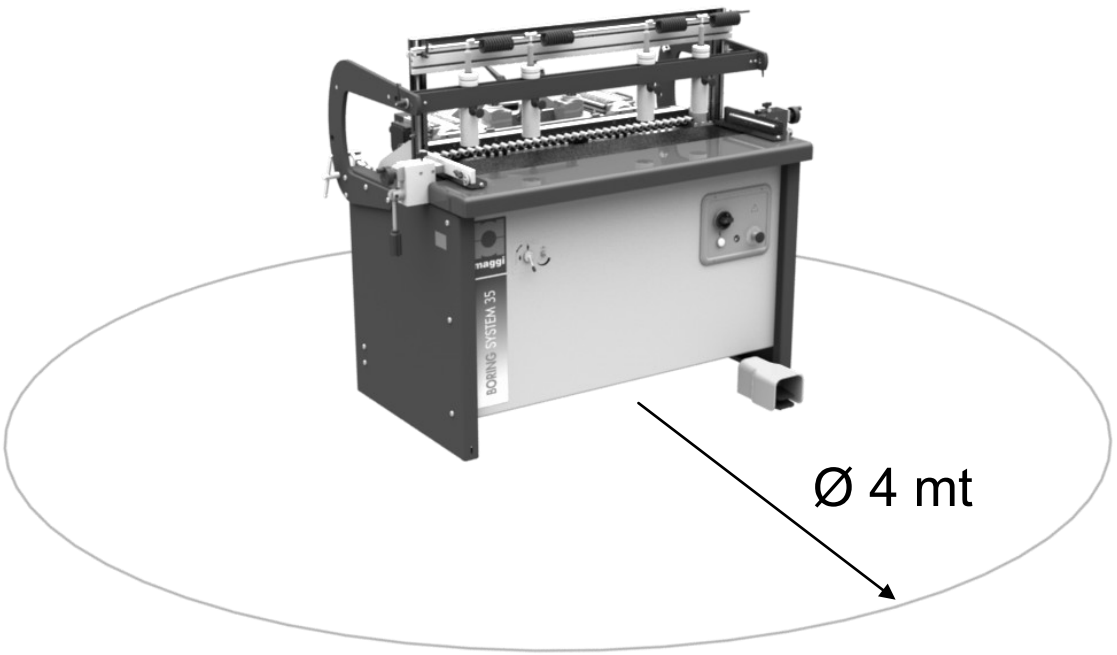
10.2 LEVELLING

Adjust the levelling feet so that the machine is perfectly leaned on the floor, then align the working table of the machine by using a spirit level.
Before going on with levelling, tighten the alignment pins into the threaded holes of the bed frame, remove the protective oil film from planes and every not painted surface, by using petroleum or kerosene only.
Do not use any solvent as gasoline and diesel oil, because they can damage the paint, making it dull, or oxidize other parts.



11. WORKING AREA

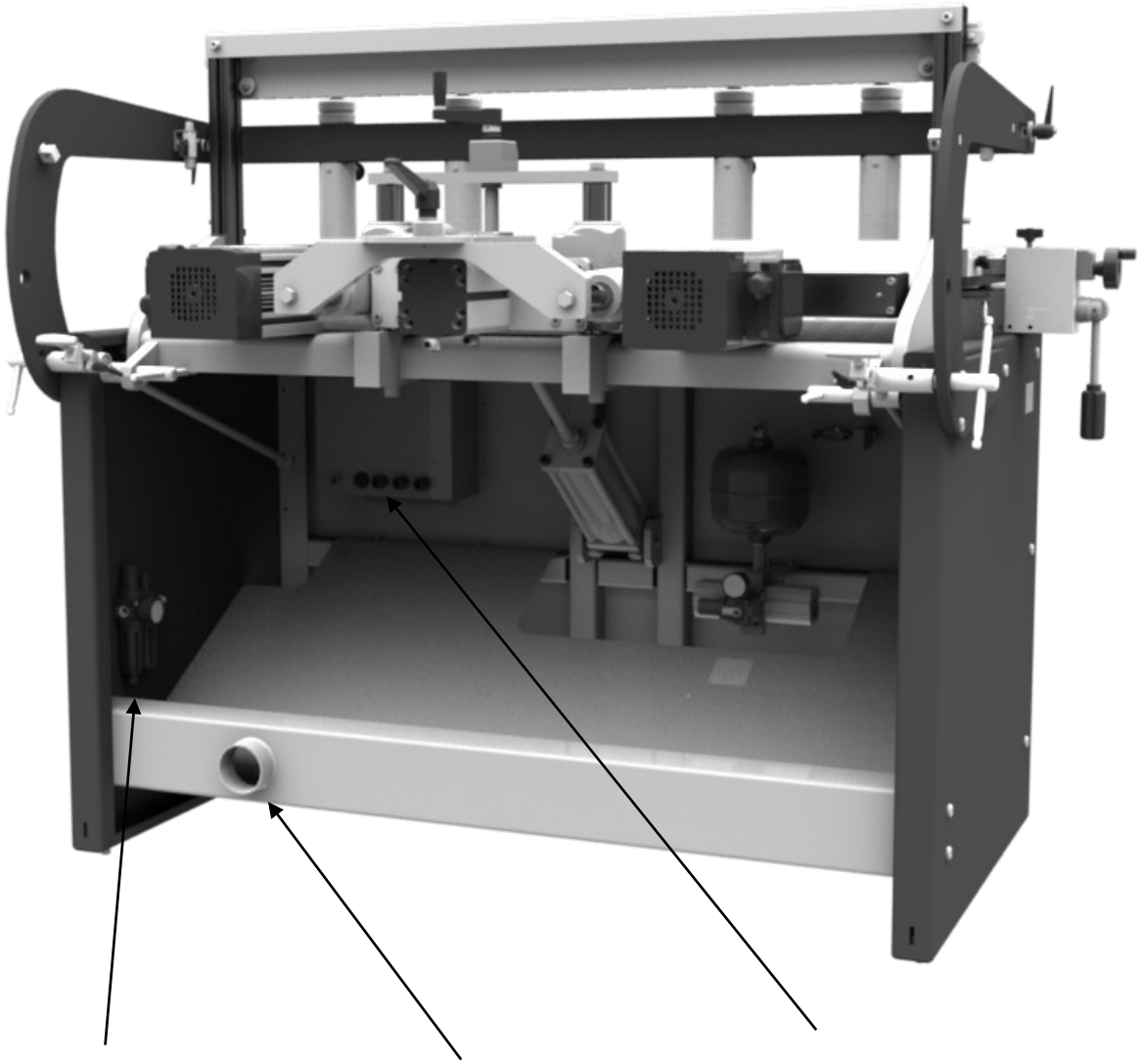
For a correct use of the machine, the following zones must be kept clear.



The next step consists of machine connection to:

- Electric power supply (see chapter 14.1)
- Pneumatic power supply (see chapter 14.2)
- Dust suction system

(attention, we strongly suggest to carefully follow the procedures described on chapter 14)



Pneumatic power supply connection point (1/4” 6 Bar)

Dust suction system connection point (Ø80 mm)

Electric power supply connection point

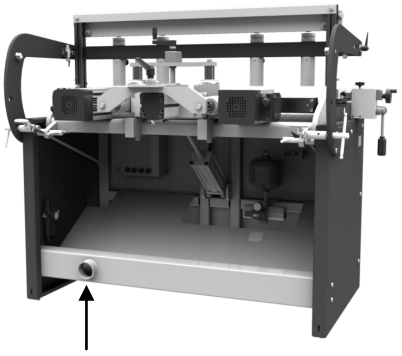
Drilling set-up procedure *please carefully follow the instructions described in chapter 15*

13. ASSEMBLY AND PRELIMINARY PREPARATION FOR SET UP

The machine is delivered partially assembled, so it is necessary to mount all those parts left not assembled for packaging reasons.
The buyer must verify that all the machine parts are safe and not damaged after transportation, before going on with assembling.
In particular we suggest to verify the most delicate parts, as electrical or mechanical components, pneumatic tubing or the safety protection devices of the machine itself.
After assembling, it is necessary to clean all surfaces from protective oil so that the working pieces remain clean during working operations.

SAWDUST REMOVAL

The removal of sawdust and wood scrap, has to be effected in accordance to the current rules of the country where the machine is installed.
We suggest to ask the qualified body of the country where the machine is installed for the rules concerning this removal to know exactly how to behave properly.



ATTENTION: THE MACHINE IS DELIVERED WITHOUT EXHAUST SYSTEM. THE USER HAS TO INSTALL A PROPER EXHAUST FAN DEPENDING ON THE TYPE OF USE, THE MATERIAL AND THE TIMING OF USE OF THE MACHINE. THIS SYSTEM HAS TO KEEP THE DUST CONCENTRACTION BELOW THE VALUE ALLOWED BY THE LAW OF THE COUNTRY WHERE THE MACHINE IS INSTALLED.

14. MACHINE CONNECTION TO EXTERNAL POWER SUPPLY

After machine assembling and installation, connect it with:

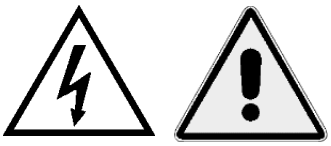
- Electrical power supply
- Pneumatic power supply
- Dust suction system

14.1 CONNECTION TO ELECTRICAL POWER SUPPLY

To gain access to the machine electric system, open the main board door by loosening the screws on the front of it. We recommend not to connect the machine to the electrical power supply until it is not correctly placed in the right place. Before connecting the machine to the electrical power supply, it is necessary to verify that the electrical system corresponds to the following necessary power and safety requirements:

- Grounded equipotential electrical system
- Presence of fuses or protection switches against short circuits on every conducing cable R-S-T, except the grounded one
- The electrical power system must be in conformity with CEI 64.8 (CENELEC HD 384, IEC364-4-41) rules
- Voltage and frequency for the motors are specified on the plates placed on them
- Connect the power supply cable to R-S-T terminals
- Automatic protection devices installed upstream respect to the machine; they have to be coordinated to guarantee the automatic break according to above mentioned rules.

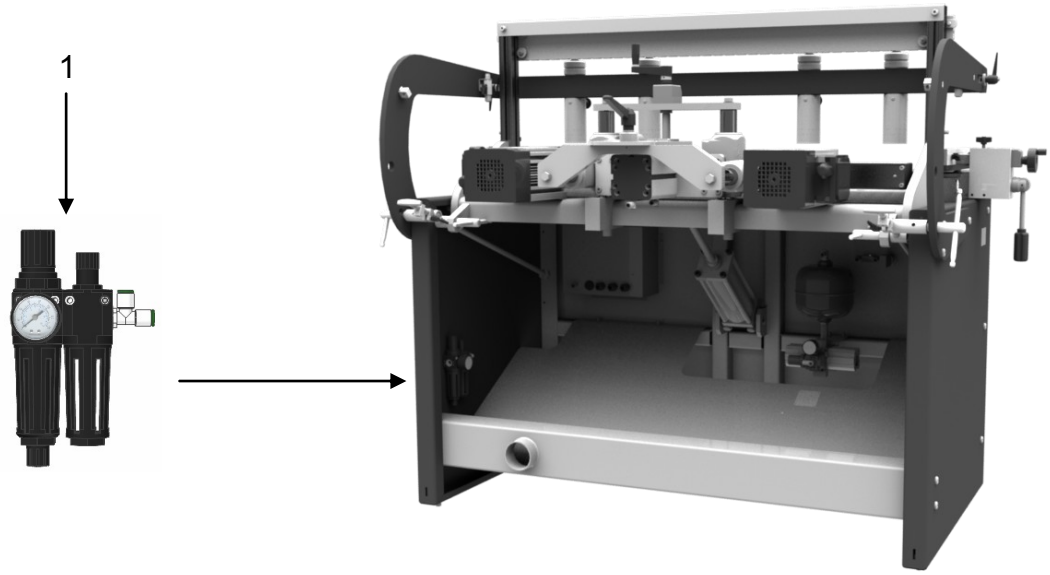
The electrical connection is done by three-phase plug (or single-phase plug, depending on the panel).
The cable for ground connection is yellow-green.
The tolerance of admissible voltage is +/-10%
When voltage is applied to the electrical power supply, check that the spindles rotation direction is the one written in the plate placed on the head (Black=Right; Red=Left).
If the rotation direction does not match the one impressed in the plate, please invert the connection cables to three phase power supply. For any information please see the electrical diagrams included in this manual.



Attention: we strongly recommend that the connection to the electrical power supply is done by technical qualified personnel only.

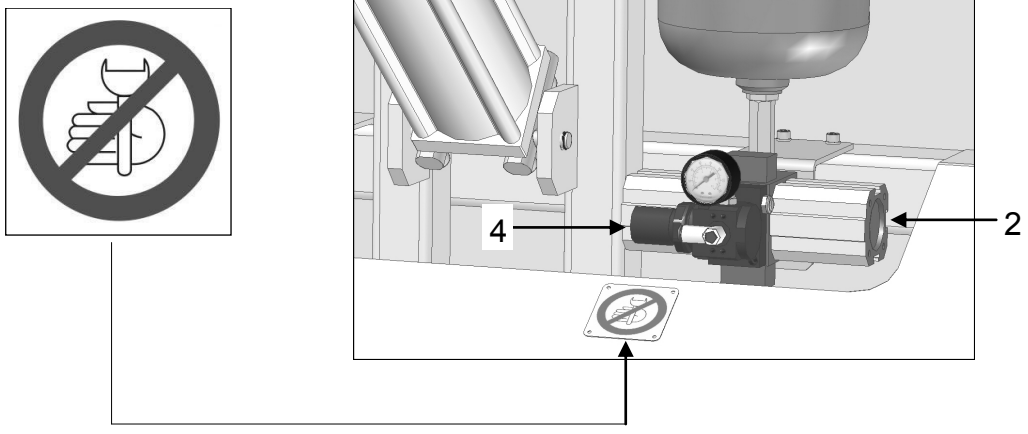
14.2 PNEUMATIC CONNECTION

Connect the Filter regulator unit (1) with the air line through a rubber or nylon hose with a minimum inside diameter of 8 mm.
If the pipe length exceeds 5/6 metres it is advisable to increase the inside diameter to 10 mm, you are also recommended to install a supply shut-off valve on the machine with manual control complete with air relief.
The Filter purifies the air from dust and humidity protecting the valves or seals in the pneumatic cylinders.



The boring machine 35 is equipped with a pressure booster (2).
This component gives a plus line pressure to the pneumatic cylinder (3) for head tipping.
The inlet pressure is set up in the factory at 5,5 Bar throught the pressure regulator (4).

ATTENTION: Do not act for any reason on the pressure regulator (4) to change the pressure value. Any change of this parameter is prohibited without the written approval of the manufacturer.



ANY ADULTERATION OR REMOVAL OF SAFETY PROTECTION DEVICES CAN CAUSE SEVERE DAMAGE. ANY REMOVAL, EXCLUSION OR MODIFICATION OF THESE DEVICES IS STRICTLY FORBIDDEN. YOU MUST VERIFY AND GUARANTEE THE PERFECT RUNNING OF SAFETY DEVICES BY MEANS OF PERIODIC CHECKS. ANY DEFECT OR PROBABLE DRAWBACK MUST BE IMMEDIATELY RESOLVED.

14.3 MACHINE STARTING

The work station and control panel are on the machine electric panel. The operator places the pieces on the work table after adjusting the stops.

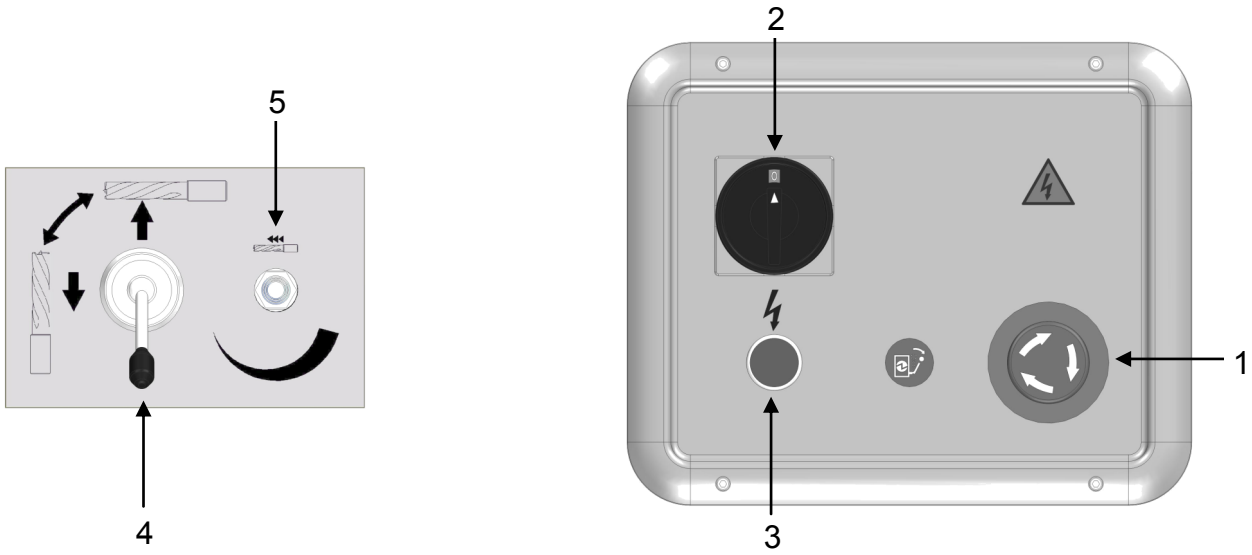
14.4 WORKING CYCLE

After setting the machine, follow the operations described below to start the working cycle:

1) Turn the main switch (2) to ON. The machine is ready to start the working cycle.
2) Operating the pneumatic pedal, the spindles turn and the head starts the working cycle, while the clamps lock the piece in place.
3) If the pedal is released, the head returns to the rest position and the spindles stop.
4) The clamps release the piece when the head returns to the starting position.

Should it be necessary to interrupt the work cycle for any reason, press the emergency button (1).

14.5 CONTROL PANEL



1) EMERGENCY ENGINE STOP BUTTON WITH RETAINER

Pressing this button all the electrical functions of the machine are cut off.
To resume the electrical functions, turn the mushroom button in the direction of the arrows.

2) MAIN SWITCH, ENGINE ENABLE BUTTON

Operating this ensures the presence of electrical energy; it enables the engine for switch on, hence for turning the spindles during the work cycle.

3) ELECTRIC LINE AVAILABILITY WARNING LIGHT ON / OFF

The light on means that current is available; the light off means that electrical current is not available.

4) HEAD POSITIONING AT 0—90°

Pneumatic selector for operating the spindle head rotation mechanism by 0—90°.

5) FEED SPEED ADJUSTMENT

Controls the drill boring feed speed

6) PRESSURE REGULATOR

This is for regulating the compressed air operating pressure keeping it within the above-mentioned limits *(see paragraph 14.2)*

15. CHECK UP AND ADJUSTMENTS

IT IS RECOMMENDED TO DISCONNECT THE ELECTRICAL AND PNEUMATIC POWER SUPPLY BEFORE TAKING ANY INTERVENTION ON THE MACHINE FOR MAINTENANCE OR FOR REPLACING DAMAGED OR WORN PARTS. FOLLOW ALL THE PROCEDURES DESCRIBED BELOW AND THE ADVICE WRITTEN IN CHAPTER 6 OF THIS MANUAL.

15.1 ELECTRICAL INSULATION PROCEDURE

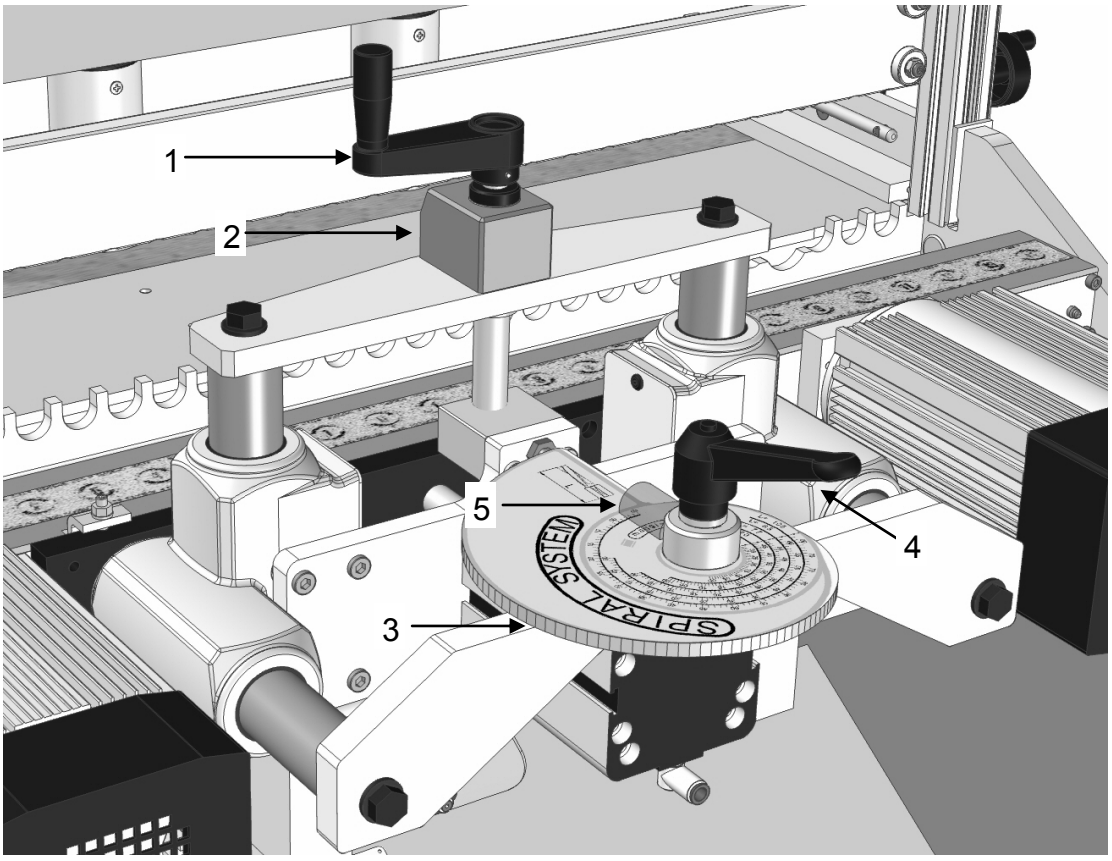
Before starting with any maintenance operation on the machine please follow the following procedure:
1. verify that the machine is in the arranged position for the requested operation. Insulate electric and pneumatic system only after having blocked mechanically the machine in this position.
2. be sure that no any other power source is present, and that no residual power source is able to act.
It is extremely important that this procedure is performed by only one operator and he/she has to notify the machine state by putting on it a well visible tag.

15.2 PRELIMINARY CHECK UP

Check that the working area all around the machine is in order and without any residuals of machined material, as sawdust or wood pieces.
Check that all the safety protection devices are positioned correctly and ready to use.

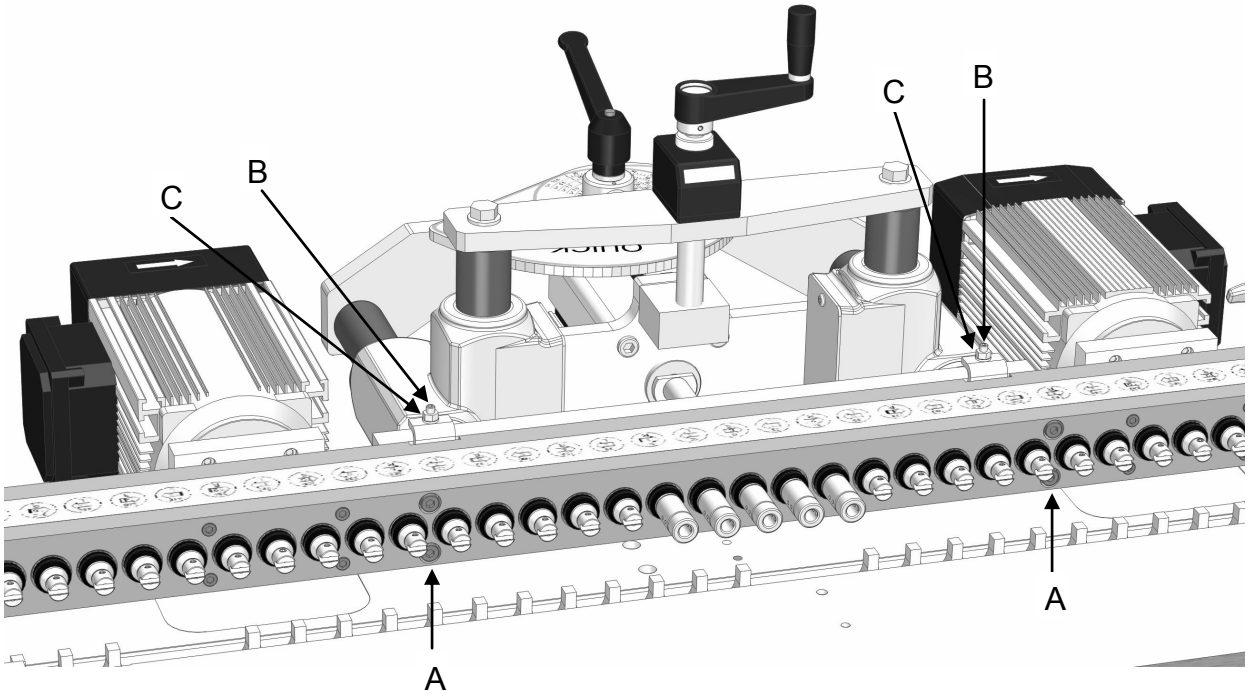
15.3 DRILLING DEPTH AND SPINDLE HEAD ADJUSTMENT

To carry out boring operations, proceed as described below:
1) Insert the suitable drills in the required position on the spindle head
2) Turn the handle (1) to set the required height of the drills from the work table, with the head turned at 0°. The drill height is shown on the digital counter (2) in millimetres. Turn the handle so that the screw is stretched when the required height is reached. The choice of the tool depends on the thickness of the piece to be bored, the position of the hole and the hole diameter.
3) Proceed as follows to adjust the boring depth: once you have found on the depth selection screw (3) the scale referring to the total length of the drill being used, it is possible to set (with no need for calculation) the actual boring depth. Releasing the handle (4) and turning the depth selection screw to the required point, the pointer (5) which also acts as a magnifier, will show the chosen depth. Firmly tighten the handle (4) before starting boring operations.
4) Usually use a scrap piece of wood to test the machine settings before boring a good piece of wood.



HEAD PARALLELISM ADJUSTMENT

- Partially loosen the screws (A) and work alternately on the screws (B) and nuts (C)
- Set the drills parallel to the work table
- Firmly tighten the screws (A)



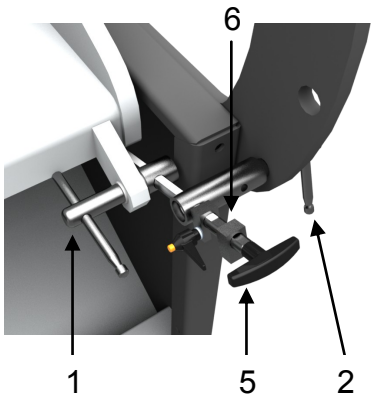
15.4 SPINDLE HEAD HORIZONTAL AND VERTICAL POSITIONING

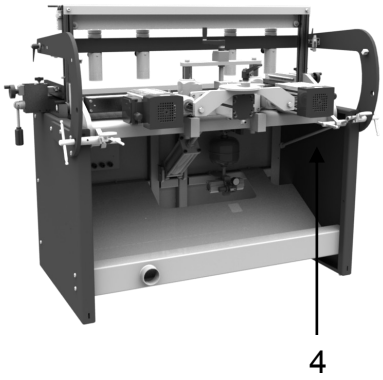
POINT 1 "Caution danger" Carefully follow the whole procedure described below. To position the spindle head at 90° ***(POS. A)*** starting from 0° as shown in the figure, proceed as follows:

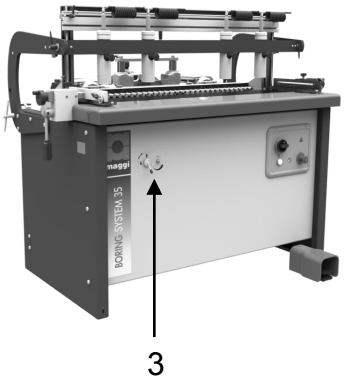
- Release the handles (1 and 2)
- Use the control lever (3), positioned on the front side of the machine, and move it to the lower position.
- Lock the handles (1 and 2) again.

POINT 2 To position the spindle head at 0° starting from 90° ***(POS. A)***, proceed as follows:

- Check that the control lever (3), on the front side of the machine, is also positioned at 90° (lower position)
- Release the handles (1 and 2)
- Use the control lever (3) and move it to the upper position to overturn the head unit
- Lock the handles (1 and 2) again.







SPINDLE HEAD POSITIONING AT AN INTERMEDIATE ANGLE OF 45°

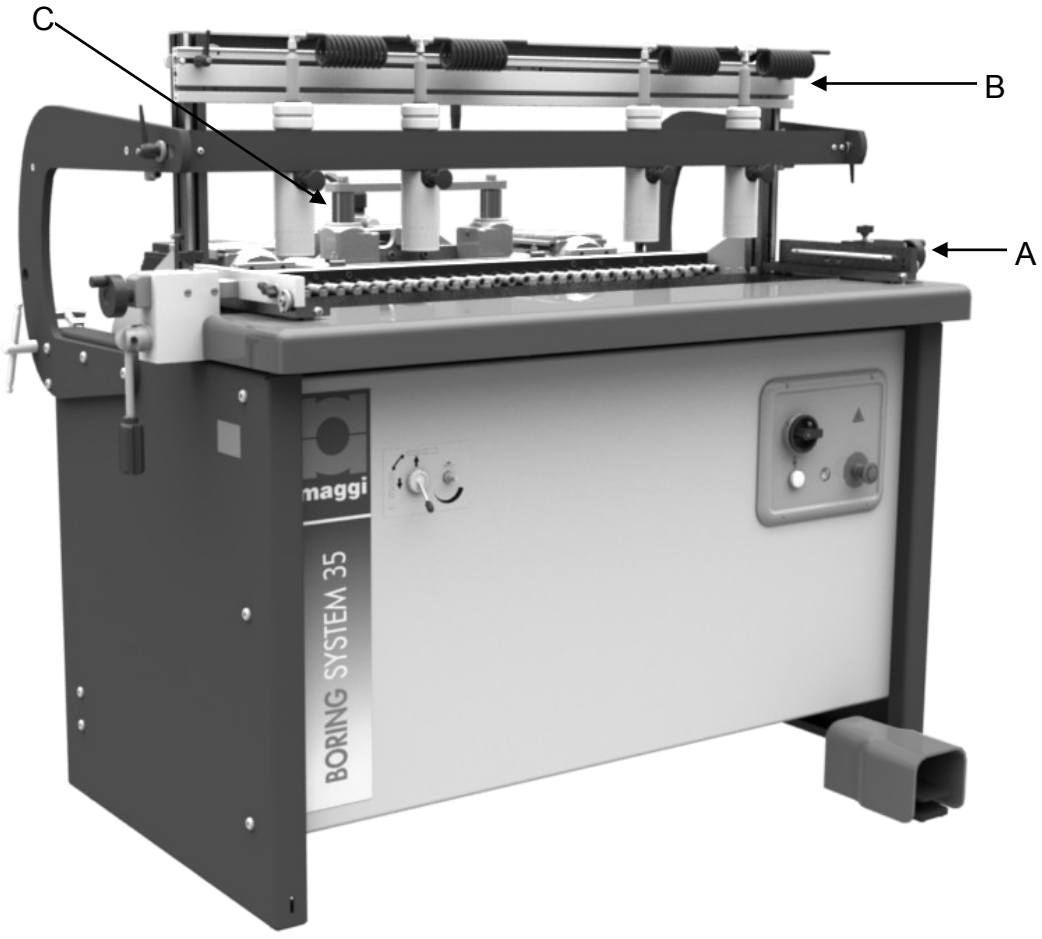
- Please position the head unit at 90°.
- Release the handles (1 and 2) to be able to pull out the graduated fence (4)
- Release the handle (5) and position the stop (6) at the required degrees from 0° to 90° along the graduated fence and then lock again.
- Follow the procedure described at ***Paragraph 15.4 Point 2*** (head positioning at 0°) the unit will stop in the chosen position
- Then lock the handles (1 and 2) again.

15.5 USE OF THE REFERENCE STOP FOR STANDARD 0°-90° MACHINING

STEP 1 - The side squares (A) and back stops (B) are used to position the piece to be machined in the standard working cycle.
With the spindle head at 90° and the spindle holder unit clamped in place:
- Position and lock the side squares at an appropriate distance from the drills to be used
- Position the clamp cylinder (or cylinders) (C) in the area where the piece will be worked
- Place the piece to be bored against the side squares using them as guides to position the piece under the clamps and against the rack.
- Position the stoppers (B) above the work piece, lower the stopper reference block onto the piece and clamp the stopper itself with the corresponding handles.
- The piece is in the right position and it is now possible to start the working cycle pressing the pneumatic pedal to start drill feed with the engine switched on (make sure that the engine button is on). At the same time the clamps will lock the work piece into position.

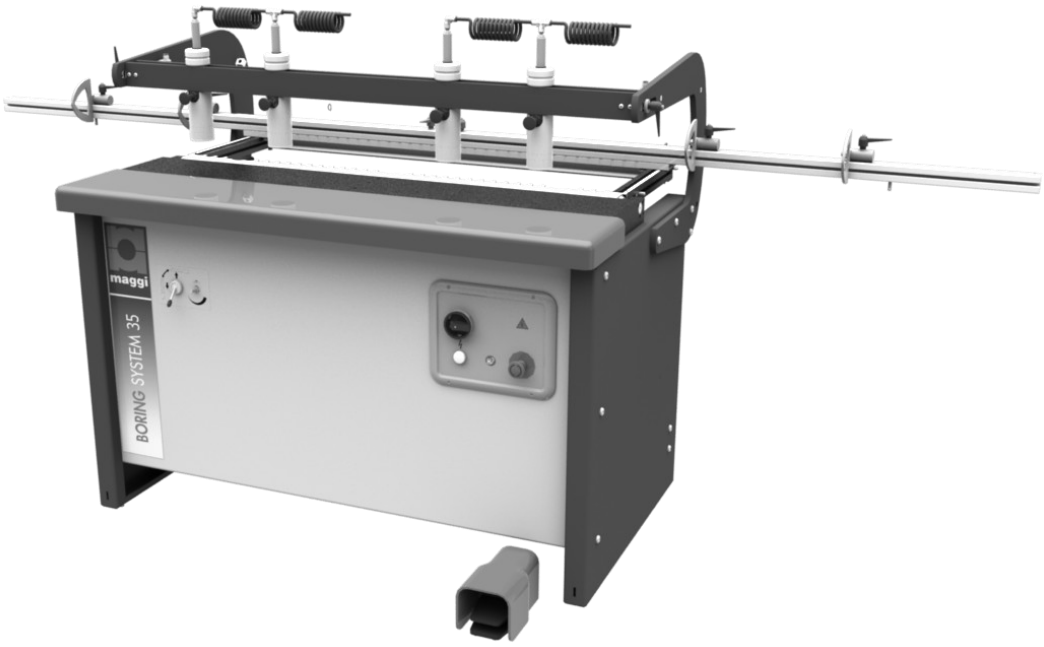
STEP 2 - When the first step is over, release the pneumatic pedal to release the piece and take the bored piece out of the machine. Release the spindle head unit, operating the overturning lever to re-position the spindle head at 90°. Re-position the head and lock it in place, than you can start the second step:
- position the piece, that has to be joined to the one that has just been machined, against the side square under the clamp (or clamps) (C) and against the back stop block.
- Once you are sure the piece has been positioned correctly, press the pedal to lock the clamp, to turn and feed the drills.
- The piece will be released once the pedal is freed, ending the working cycle.

THE TWO PIECES THAT HAVE BEEN OBTAINED ARE NOW READY TO BE JOINED (0°-90°).



15.6 USE OF THE 1,5 + 1,5 MT EXTENSION FENCE *(OPTIONAL)*

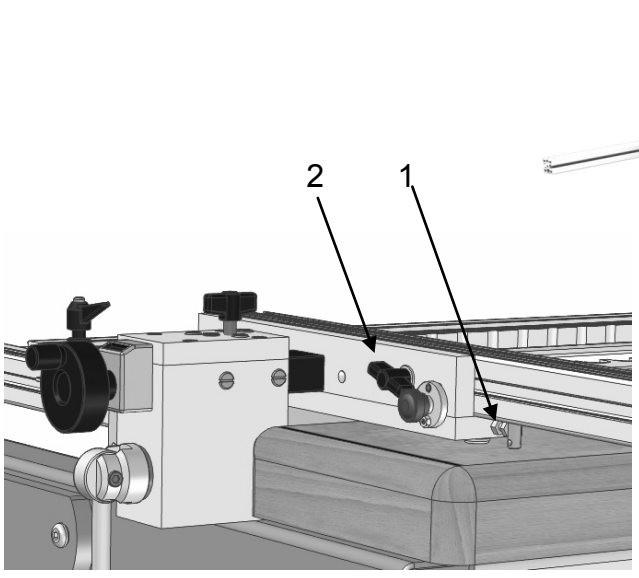
The extension fence is used to make a series of larger holes than the machine can make or to bore large-sized pieces. Use of the extension generally implies complete or partial exclusion of the side squares and positioning the spindle head at 90°. For longitudinal use of the extension, we advise you to exclude the side squares completely, as it is possible to use mobile reference stoppers on the extension itself (the extension is provided with 4 mobile stoppers with positioning screws, stop screw and extension clamping device) for combined positioning of the work piece.

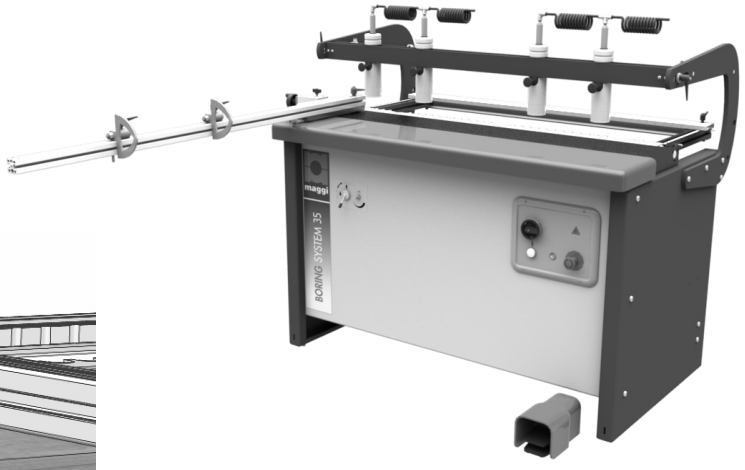


TRANSVERSAL POSITION OF EXTENSION FENCE *(OPTIONAL)*

To use the extension fence transversally you need to fasten it to the side square using the locking knobs provided.
Follow the procedure described below:

- Position the extension on the inner side of the side square, locking it in place with the help of the reference pin (1) on the extension itself.
- Clamp the locking knobs (2) on the side square.
- Once the extension fence has been positioned, it is possible to exclude the other side square if necessary.
- It is now possible to use the mobile stops to co-ordinate the relative positions of the sections to be bored on long pieces.
- Add a suitable support (i.e. a stand) for the fence and for the panel to be bored.



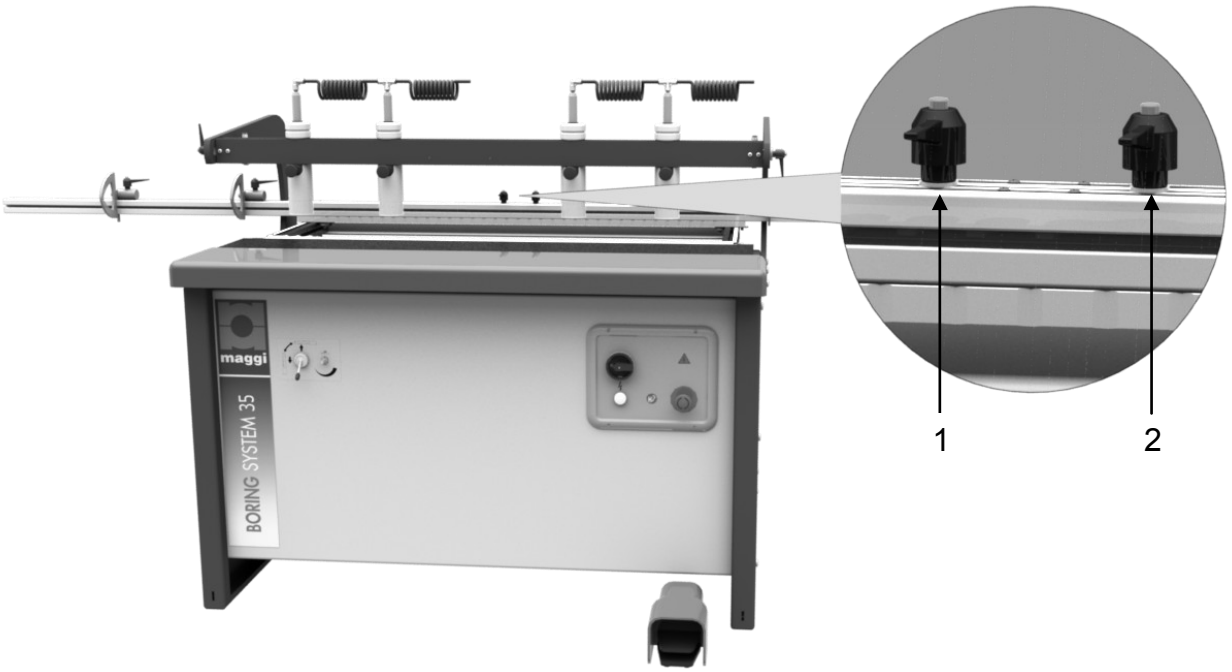


LONGITUDINAL POSITION OF THE EXTENSION FENCE *(OPTIONAL)*

To use the extension fence longitudinally you need to fasten it to the back stop profile using the handles provided.

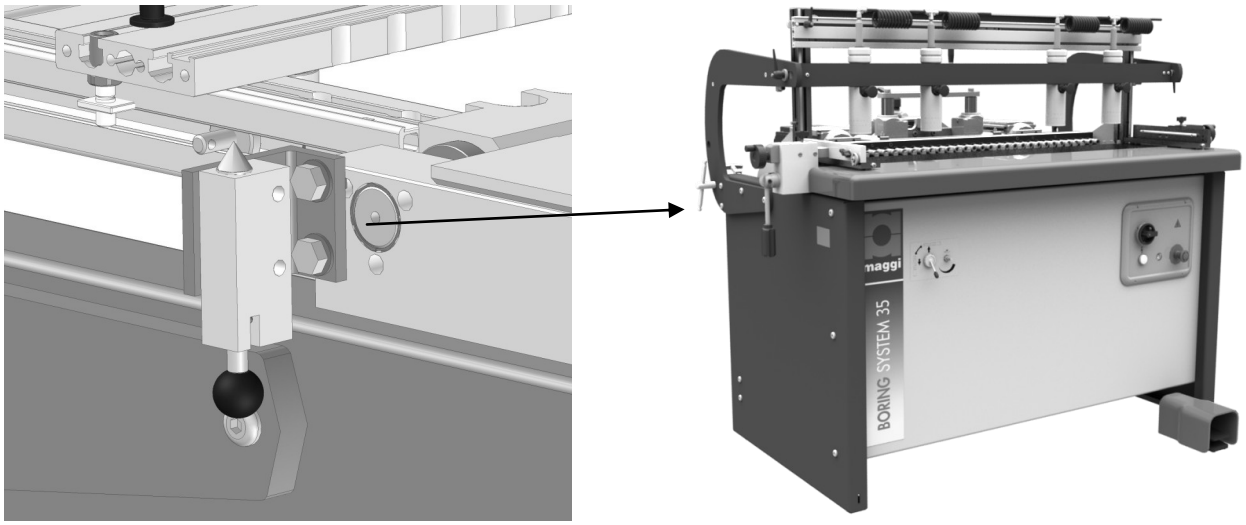
Follow the procedure described below:

- Turn the side squares over to bring them out of the table, making sure they are under the work table.
- Place the extension fence over the back stop profile as illustrated in the figure below.
- Fasten the extension fence to the back stop profile clamping the handle (1) provided with locating pin.
- Finally line up the extension fence to the boring line clamping the other handle (2).
- It is now possible to use the mobile stops to co-ordinate the relative positions of the sections to be bored on long pieces.
- Add a suitable support (i.e. a stand) for the fence and for the panel to be bored.



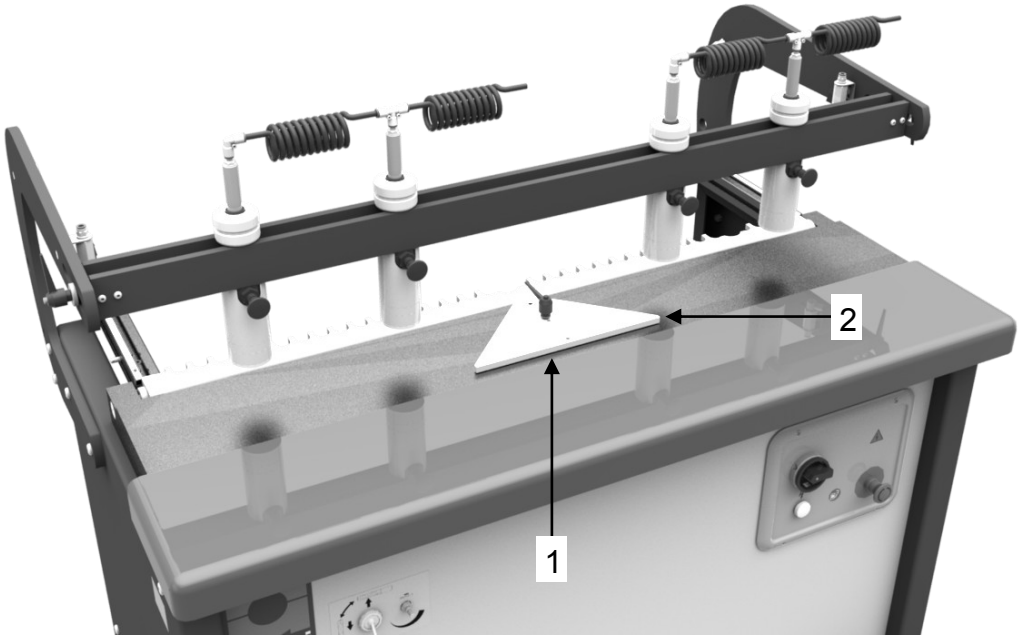
15.7 USE OF THE REFERENCE PIN FOR SETS OF HOLES ON LARGE-SIZED PIECES *(OPTIONAL)*

The use of the extension fence for large-sized pieces can be complicated. Our machines are provided with a reference pin that can be used for the repetition of a set of holes on a large-sized piece, in which the axial distance between the first drill and the last is higher than those obtainable with the boring machine used. The reference pin is aligned with the axis of the drills and it fits into a slot under the machine table when the first set of holes has been bored. To go on boring, the reference pin can be used again by turning the knob to release the spring that allows the reference pin to come out. The reference pin must be inserted in one of the holes that have just been bored to allow repetition of the set of holes.



15.8 USE OF THE TRIANGLE FOR 45° FRAMES *(OPTIONAL)*

The 45° triangle is particularly useful for 45°-45° jointing, mainly used for quickly manufacturing frames. Fasten the triangle (1) on the table in the reference holes and clamp it in the centre hole using the lever (2). This way it is possible to rest the pieces cut at 45° to be bored and coupled with the wooden “dowel” peg. The machine spindle head must be set at 0°. When the position is correct, the clamp is over the piece to be worked; proceed as in a standard working cycle, pressing the pneumatic pedal to start machining and releasing it at the end of the work. Repeat the procedure on both sides of the triangle to obtain two mirrored frame pieces ready to be joined.

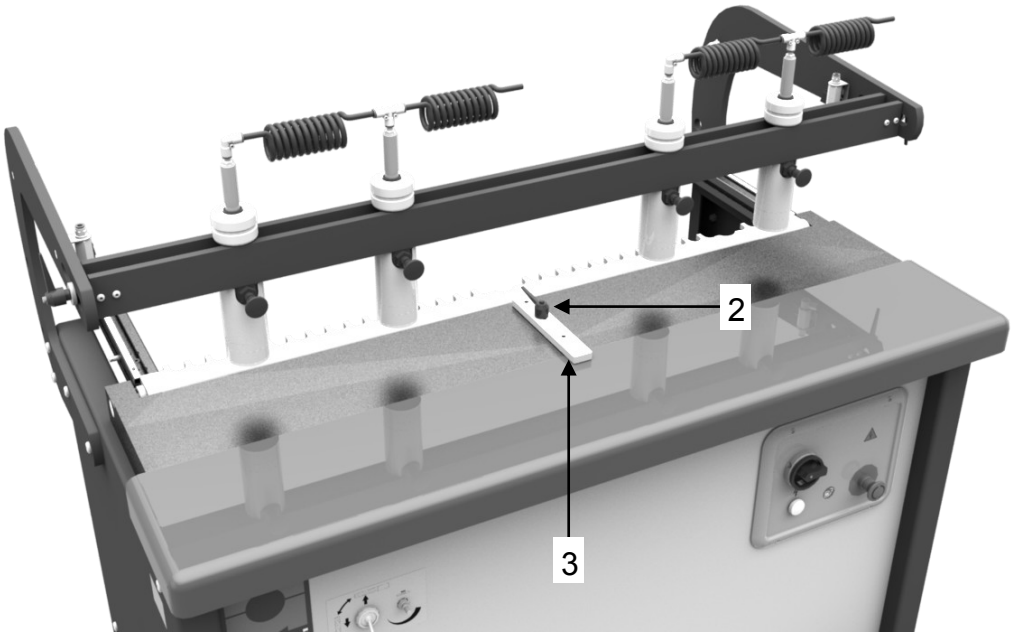


15.9 USE OF THE CENTRAL BAR FOR STRAIGHT 90° FRAMES *(OPTIONAL)*

The central bar is used to join two pieces with sides at a right angle (mainly used for quickly manufacturing straight frames).

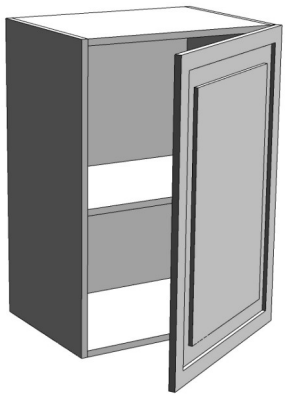
- Fasten the central bar (3) in the special reference holes on the work table and clamp it with the lever (2).
- position the pieces to be worked along the central bar. It is now possible to start boring operations to join frames with wooden “dowel” pegs.

The position is correct when the spindle head is at 0° and the clamp is over the piece to be bored. Proceed as in a standard working cycle, pressing the pneumatic pedal to start machining and releasing it at the end of the work. Repeat the procedure on both sides of the triangle to obtain two mirrored frame pieces ready to be joined.

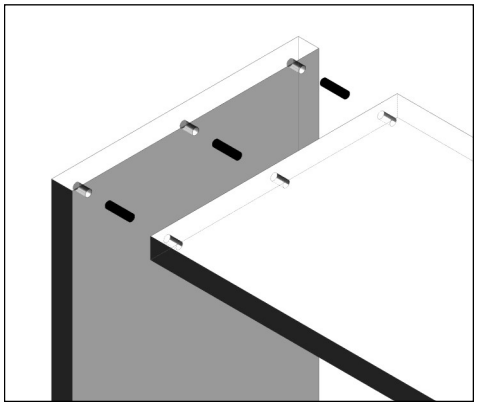


16. WORKING EXAMPLES

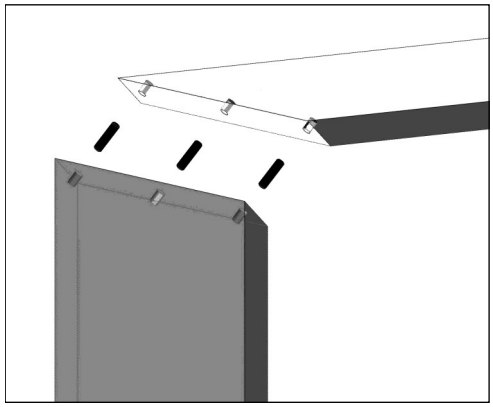
PANEL MATING EXAMPLES



Assembling parts

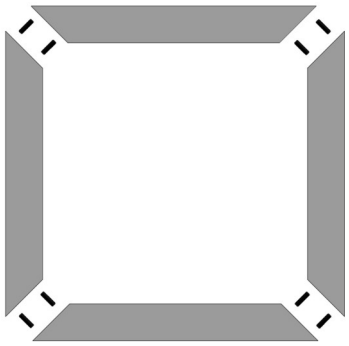


Mating parts (at 0°)



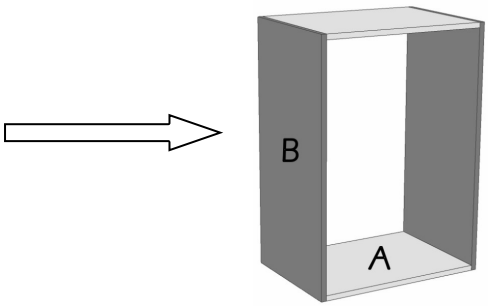
Mating parts (between 0° and 90°)

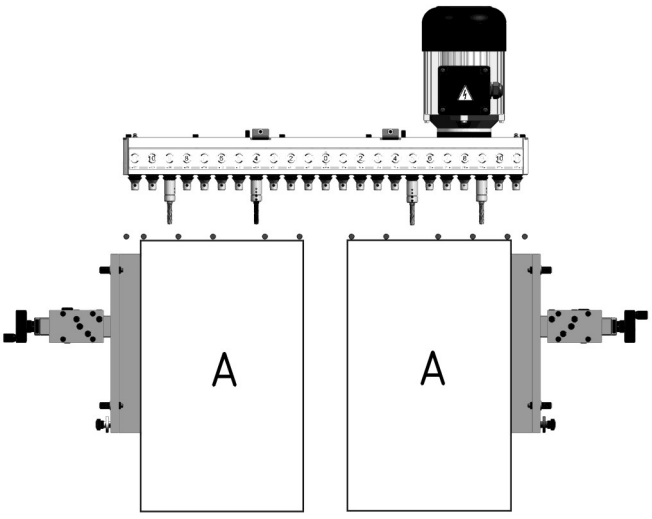
FRAME MATING EXAMPLE AT 0° AND AT 45°



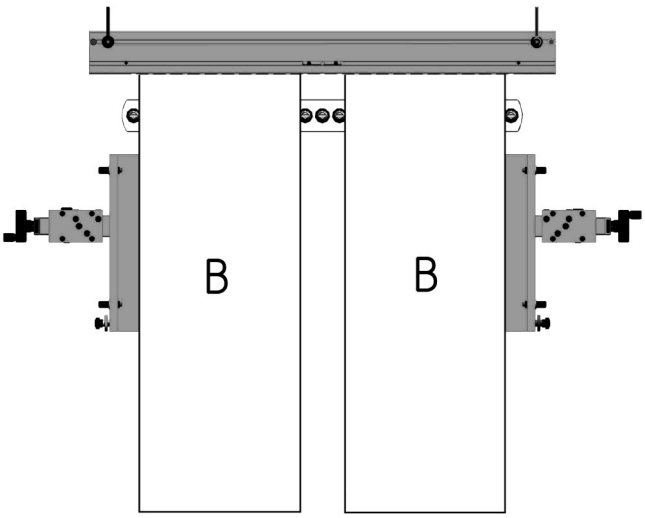
SIMULTANEOUS MIRROR DRILLING EXAMPLES

Reference assembling



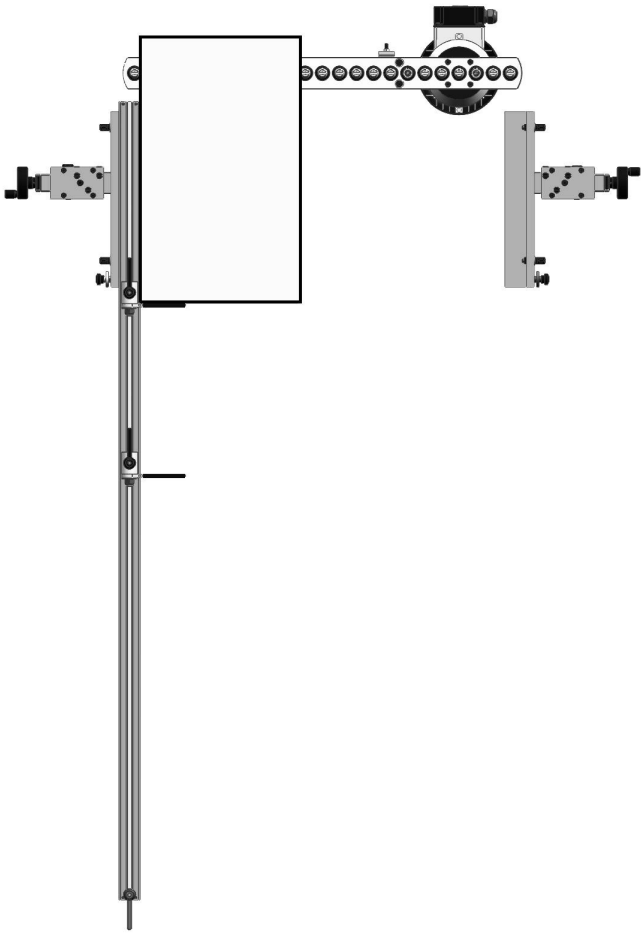


Simultaneous mirror drilling of two panels (drilling head at 0°)

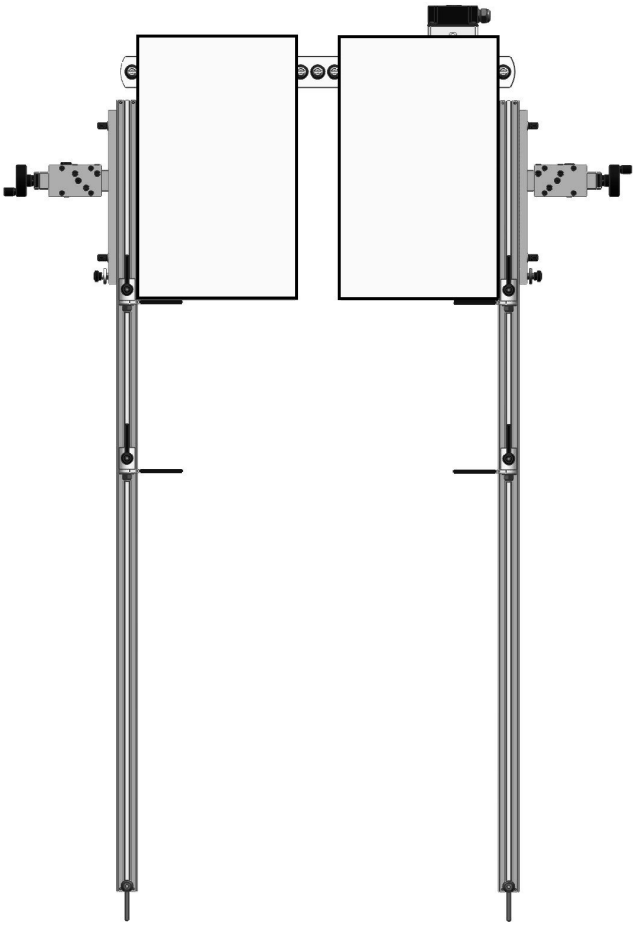


Simultaneous drilling of two side panels (drilling head at 90°)

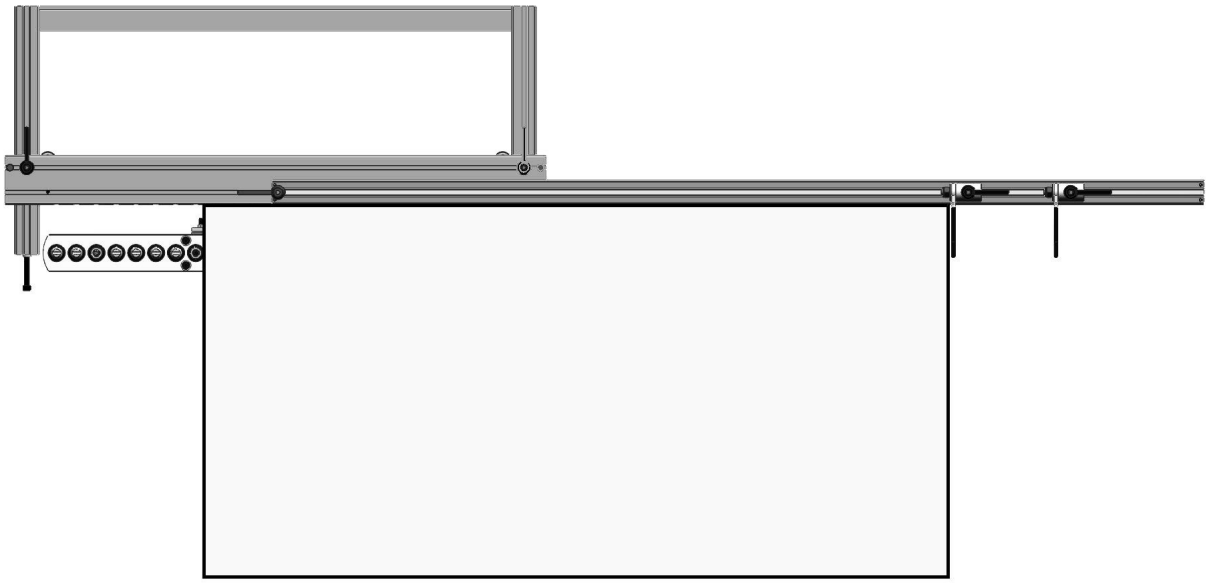
DRILLING EXAMPLES WITH REFERENCE FENCES



Transverse positioning of the fence, equipped with reference stops, to drill transverse holes on side panels for the insertion of support panels

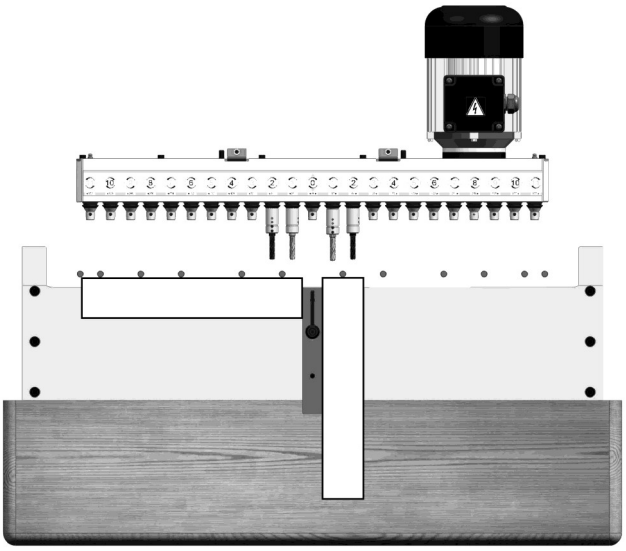


Transverse positioning of two fences, equipped with reference stops, to drill simultaneously transverse holes on side panels for the insertion of support panels

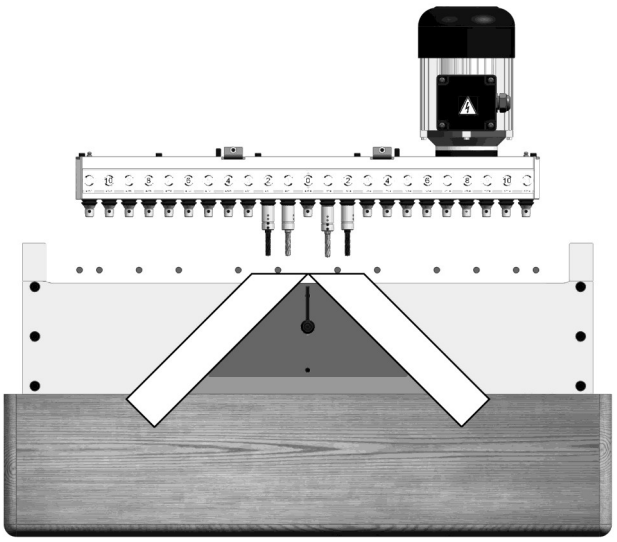


Longitudinal positioning of the 1500mm fence, equipped with two reference stops, to drill line holes on large panels. The long fence can be used both on left and right side with high accuracy. The 1500+1500 mm long fence, equipped with four reference stops, is particularly suitable to drill line holes on very large panels: thanks to its dimension, it ensures a fast and complete positioning.

DRILLING EXAMPLES USING FRAME FENCE

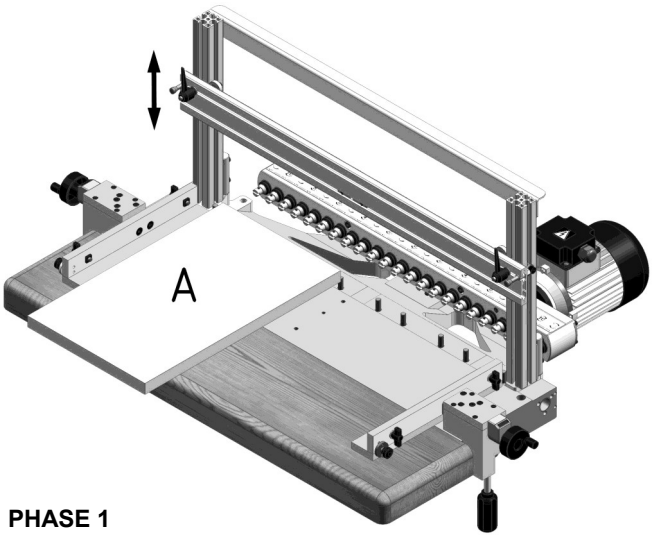


Example of the use of the standard dimension fence to drill simultaneously two frames at 0° - 90°

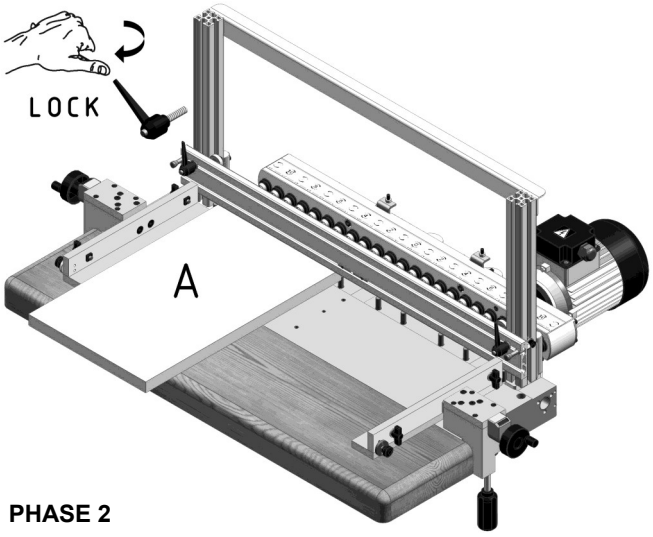


Example of the use of the triangular fence to drill simultaneously two frames to be joined at 45° - 45°

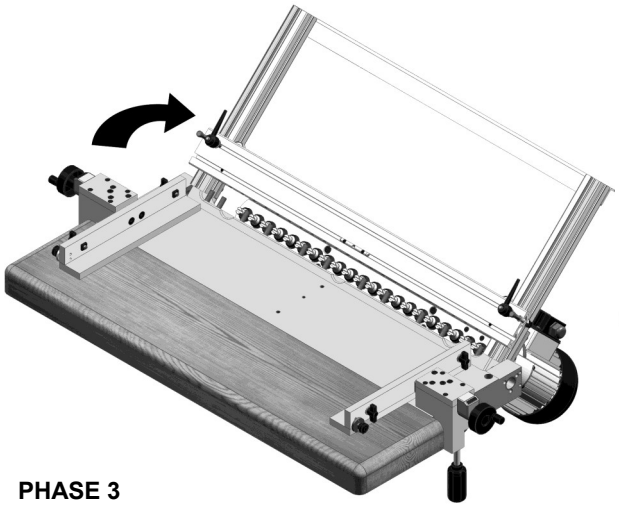
EXAMPLES OF AUTOMATIC MATING OF VERTICALLY AND HORIZONTALLY DRILLED PANELS



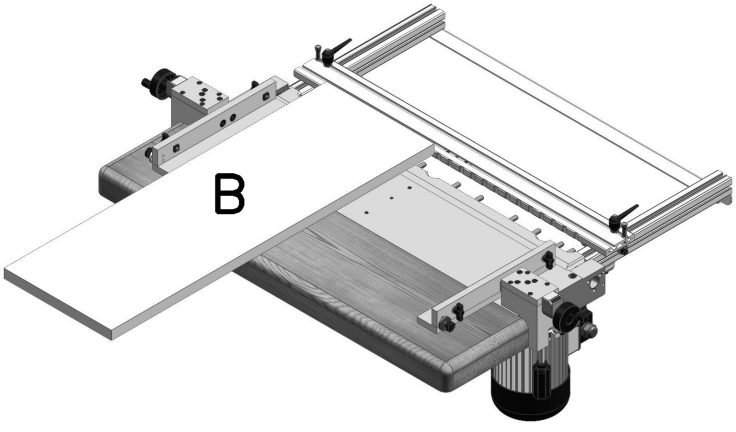
PHASE 1



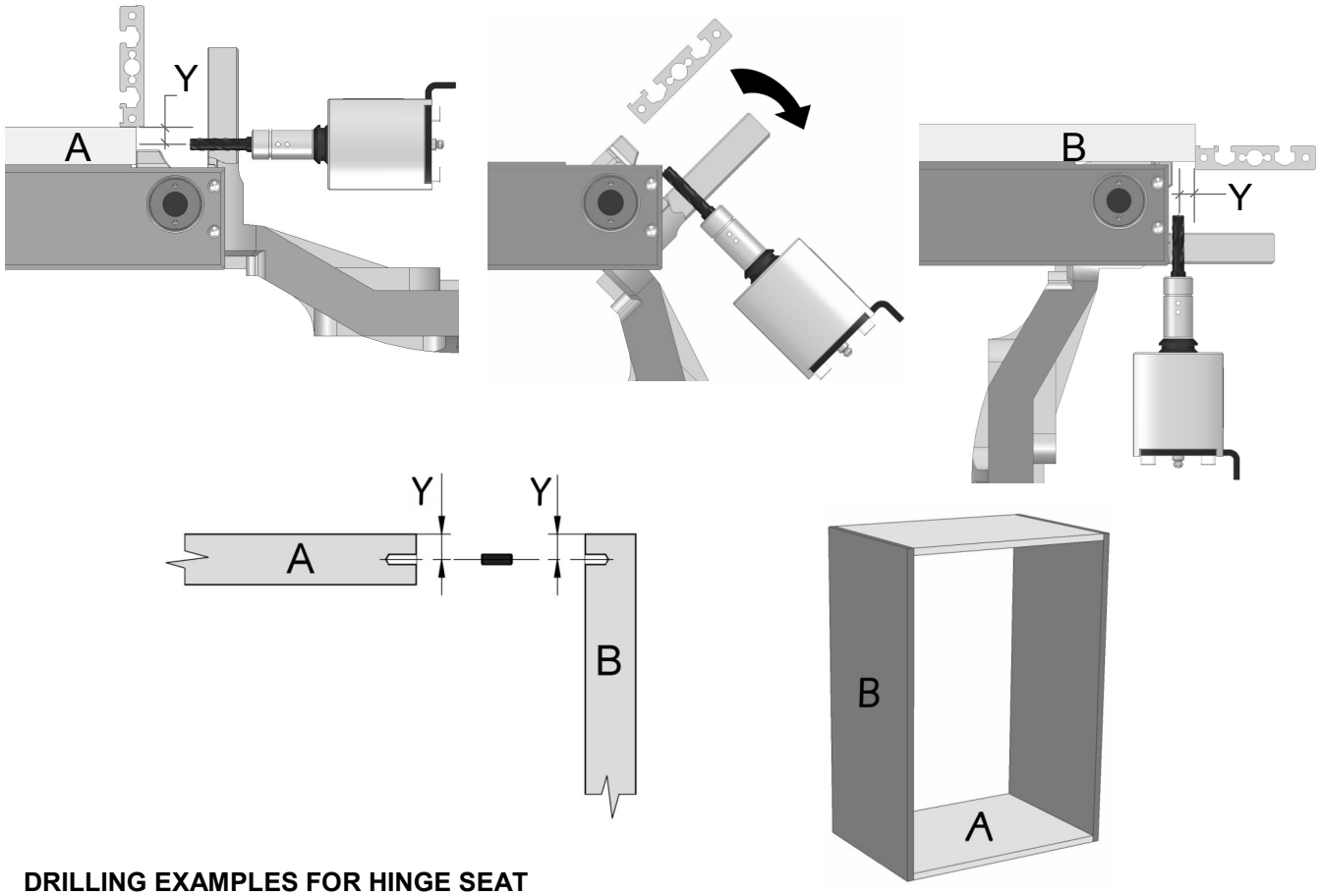
PHASE 2



PHASE 3



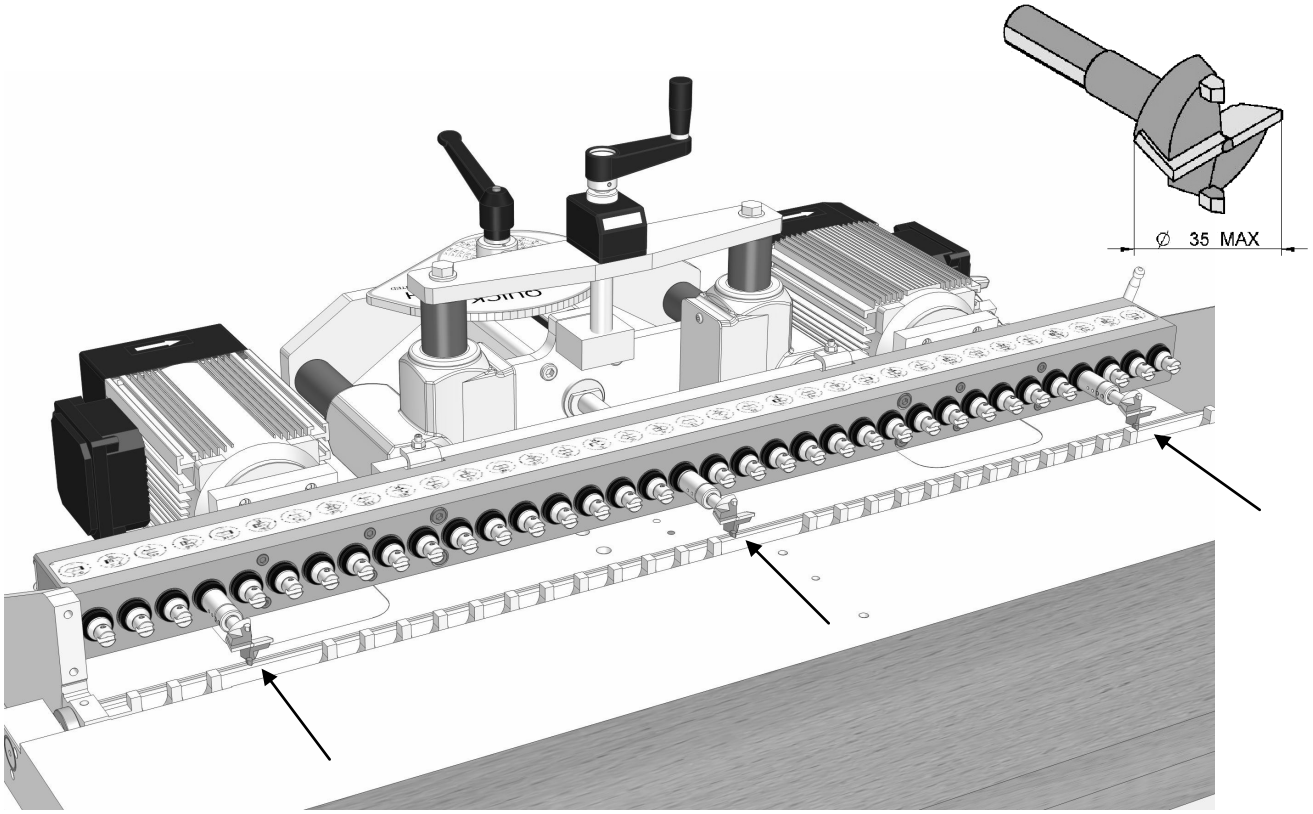
PHASE 4



DRILLING EXAMPLES FOR HINGE SEAT

It is possible to drill holes using 35mm O.D. tools max. *(if you want to use a 40mm O.D. tool you must follow carefully the procedure described below)*

ATTENTION !!! The 35mm O.D. tool has to be mounted only on the spindles corresponding to three right positions of the rack (see the three arrows on the right side of the figure below), besides the head group has to be positioned in the “0 0 0 0,0” vertical position, as depicted in the figure below.



It is possibile to drill holes larger than 40mm O.D. if you position the head from the rack at a distance of the tool O.D. + 10mm. At this distance you can use large tools in any spindle of the head.
ATTENTION !!! You must verify that the tool is above the rack.

17. MAINTENANCE

17.1 ORDINARY MAINTENANCE

AN ADEQUATE MAINTENANCE IS A CRUCIAL FACTOR FOR A LONGER LIFE OF THE MACHINE, AND TO OBTAIN OPTIMAL WORKING CONDITION OF THE MACHINE ITSELF. ALL THE MAINTENANCE OPERATIONS MUST BE DONE WITH THE MACHINE TURNED OFF. WEAR ALWAYS PROTECTIVE GLOVES AND FACE-SHIELD

WARNING - DANGER OF SLIDING!
During cleaning of working area, be careful to working residuals and liquids left over the floor all around the machine: they can be dangerous for sliding of the operator.

17.2 CLEANING OF THE MACHINE (DAILY)

The machine and working area must be kept clean from working scraps and anything that could hamper the working cycle or access to the machine itself. The machine must be cleaned every day. Make sure that no material not needed by the machine can gather on it preventing safe operation and causing danger to the operator during the normal working cycle .

17.3 CLEANING OF THE GUIDES (WEEKLY)

Sliding guides and bars must be kept clean from working residuals: they can obstacle correct machine movements and damage machine efficiency. Do not use detergents or lubricants.

ELECTRICAL CABLES CHECK
Check the condition of the electric cables. Make sure there are no signs of wear, scrapes, etc.

17.4 EXTRAORDINARY MAINTENANCE

MAINTENANCE

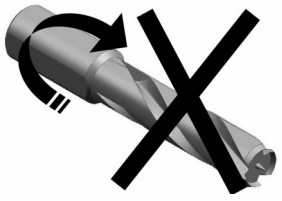
- Check electric system safety
- Check the clamping of the various mechanical components.
- Check the lubricant oil level in the filter unit and top up if necessary.
- Make sure the machine is lubricated regularly.
- Check air pressure value: the pneumatic power supply must give air at a pressure value of 6 bar
- Check sludge: sludge and air impurity deposit into the transparent cup of air treatment group

18. COMMON FAILURES: REASONS AND REMEDIES

Some failure causes can be eliminated directly by the operator, other by qualified personnel only.

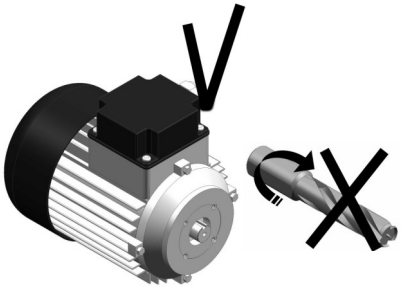
ATTENTION:
BEFORE MAKING ANY INTERVENTION IT IS OBLIGATORY TO FOLLOW CAREFULLY THE INSULATION PROCEDURE

18.1 DRILLS DO NOT WORK



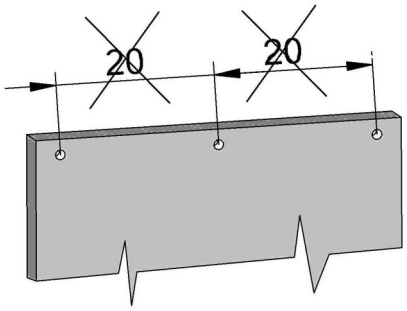
PROBABLE REASON	ACTION
A - the motor does not work B - the motor is out of service	- push the motor start push button - release the emergency push button and/or check fuse - check air pressure value (to turn on the pressure sensor) - replace the motor

18.2 THE MOTOR WORKS BUT THE DRILLS DOES NOT



PROBABLE REASON	ACTION
A - possible failure of: - gears and/ or keys - drive joint	- replace them or call technical service

18.3 THE HOLE IS NOT ACCURATE



PROBABLE REASON
A - unproper drill locking
B - drill wear
C - working piece unproperly blocked

ACTION
- check locking. Call Service if the locking is good
- replace or call Service
- check clamp units, their seals and working air pressure value

19. ANOMALIES DURING ORDINARY WORKING PHASES

19.1 BURN-TRACES DUE TO DRILLS
This problem might appear when the piece is positioned incorrectly or owing to drill wear or if the drills turn in the opposite direction.

19.2 DRILLED PIECES ARE NOT PARALLEL TO THE REFERENCE BAR
This might be due to incorrect parallelism of the drills in relation to the reference stop. Check the heads in relation to the stop and the parallelism of the line of drills of head 1 with head 2.

19.3 DIFFICOLTY IN TURNING THE HEAD
If the boring unit fails to reach or finds it difficult to reach other positions, check the hinge and rod of the overturning piston

19.4 THE WORKING PIECE IS NOT BLOCKED BY THE SAFETY CLAMP
If the clamps are not clamping properly, check the air pressure and connection pipes.
To solve these problems we suggest you contact Maggi Engineering Post-Sale Service, or your local dealer.

20. NOISE EMISSION

Noise emission according to correct working of machine and balancing and grinding of tools, is variable and depends on working material, drill diameter and depth drill. The operator permanence expected time is variable during 8 hours a day. Some other factors may determinate the exposure level; the surroundings and other noise sources, and other close machines.
We suggest to inform the operators about risks caused by a prolonged exposure to noise, providing them with suitable individual protection devices. The acoustic pressure level, collected in the operator place through class 1 integrative noise meter, is 76.1 dB(A).
This measure was done according to ISO3745 rules with usual working values of speed and air pressure, drilling a shaving wood PVC covered panel. The measure was executed at 1.5 m from ground, in front of the machine, in the operator position.
Moreover the following reference measures were collected with the same procedure:
Acoustic pressure level in Atm. dB(A): 78.3
Acoustic pressure power dB(A): 93.3

21. DUST EMISSION

The following results are obtained from the determination of dust emission in 1 hour of continuous work, drilling a fir PVC covered panel 20 mm thick. Dust emission turned out 13,9 mg/N cu.m at 1,5 m from ground in front of the machine in the operator position.

22. PUTTING THE MACHINE OUT OF SERVICE

When machine has to be put out of service, please carefully follow our instructions in order to safeguard the safety of people and of environment. Firstly execute the insulation procedure, then dismantle the drills and put them into a suitable packaging box. Dismantle electric, hydraulic and pneumatic components so that you can re-use them after a check or a revision. Empty out completely from oil the hydraulic power unit, avoiding scrupulously to disperse the oil in the environment. Dismantle metal components grouping them for materials. Call a specialized company to rescue and eliminate solid and liquid materials.

23. TERMS OF GUARANTEE

The guarantee provided with this certificate is valid for the period of one year from the date of purchase. Consequently, during such guarantee period, the manufacturer undertakes to replace any parts found to be faulty because of manufacturing defects. Only carriage expenses will be on the customer's account. The guarantee is void if the machine has been used improperly or damaged during transport.

24. GUARANTEE CERTIFICATE

The machine has been built according to technological and safety criteria and has been checked in our factory before being forwarded.

MAGGI guarantees machine working and quality in agreement with law rules, for a period of 12 months. Improper use and incorrect maintenance, not following the rules contained in this manual, as well as adjustments or modifications not approved by the manufacturer, cancel all the terms of guarantee. The conditions of guarantee about the correct working of the machine are strictly connected to the respect of all the indications described in the

USE AND MAINTENANCE MANUAL

The free replacement of any parts found to be faulty is done only after having checked that the machine had been properly used.

Claims and guarantee interventions request are accepted only against presentation of the machine number engraved into the identification plate.

Upon receipt of the machine carefully check that packaging is safe and not damaged. Except for different agreement, the manufacturer is not responsible for any damages done during transport.

In case of evident damages on packaging, we suggest to contact immediately the carriers. Our firm will be available to give the necessary support.

NOTES

COUPON TO BE FORWARDED TO THE MANUFACTURER

GUARANTEE AND LOOK-OVER COUPON

Model..……..Serial number……...

Name……..

Address……..

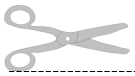
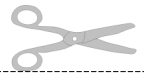
ZIP Code……...City……

Date of purchase…… Dealer……...

Owner's signature

……..

The purchaser states to accept all the terms of guarantee and to have checked the machine to work well

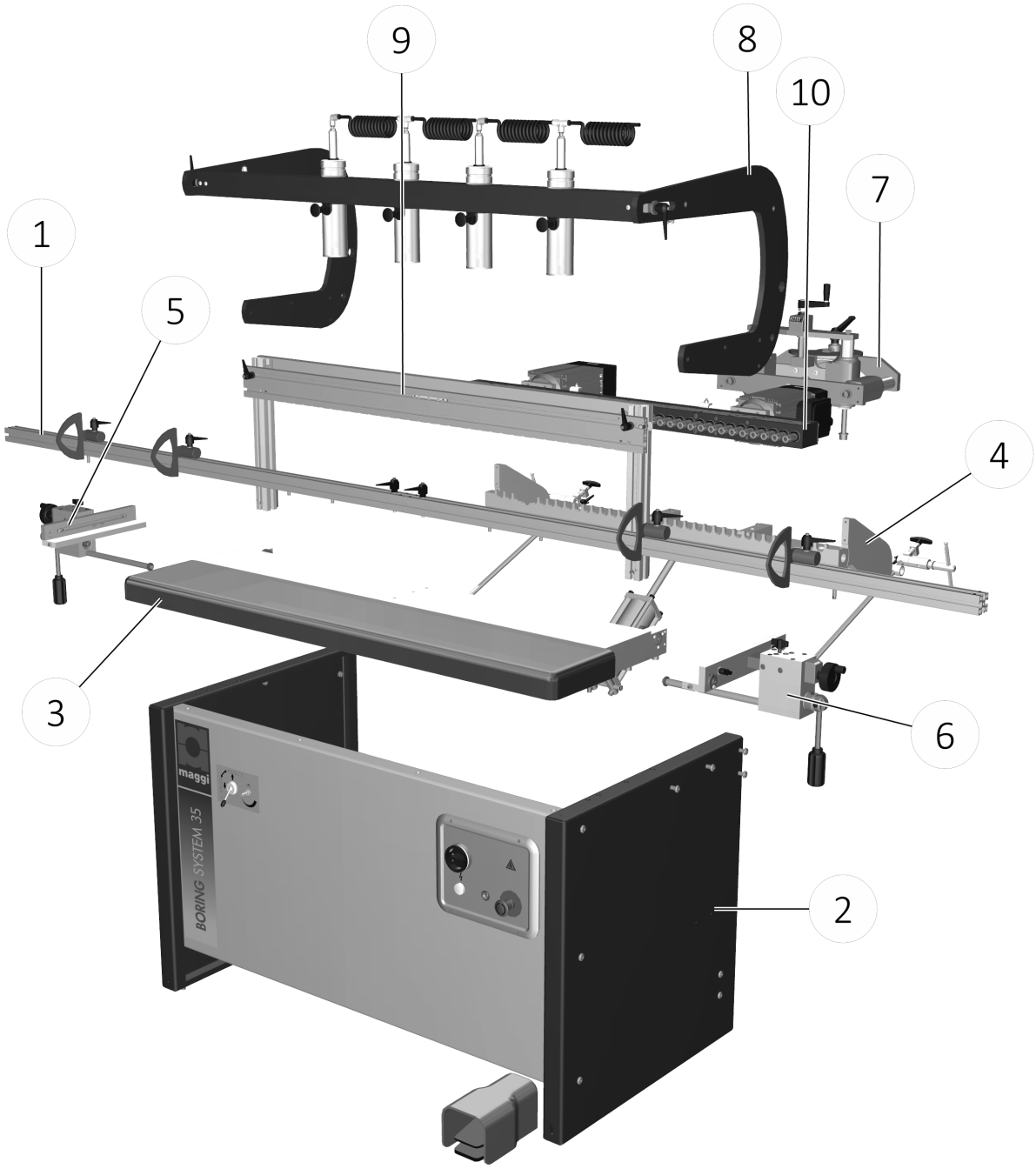



Ship to:

MAGGI TECHNOLOGY srl
Vendita ed Assistenza Tecnica
Via delle Regioni n°299
50052 CERTALDO (Fi)
ITALIA

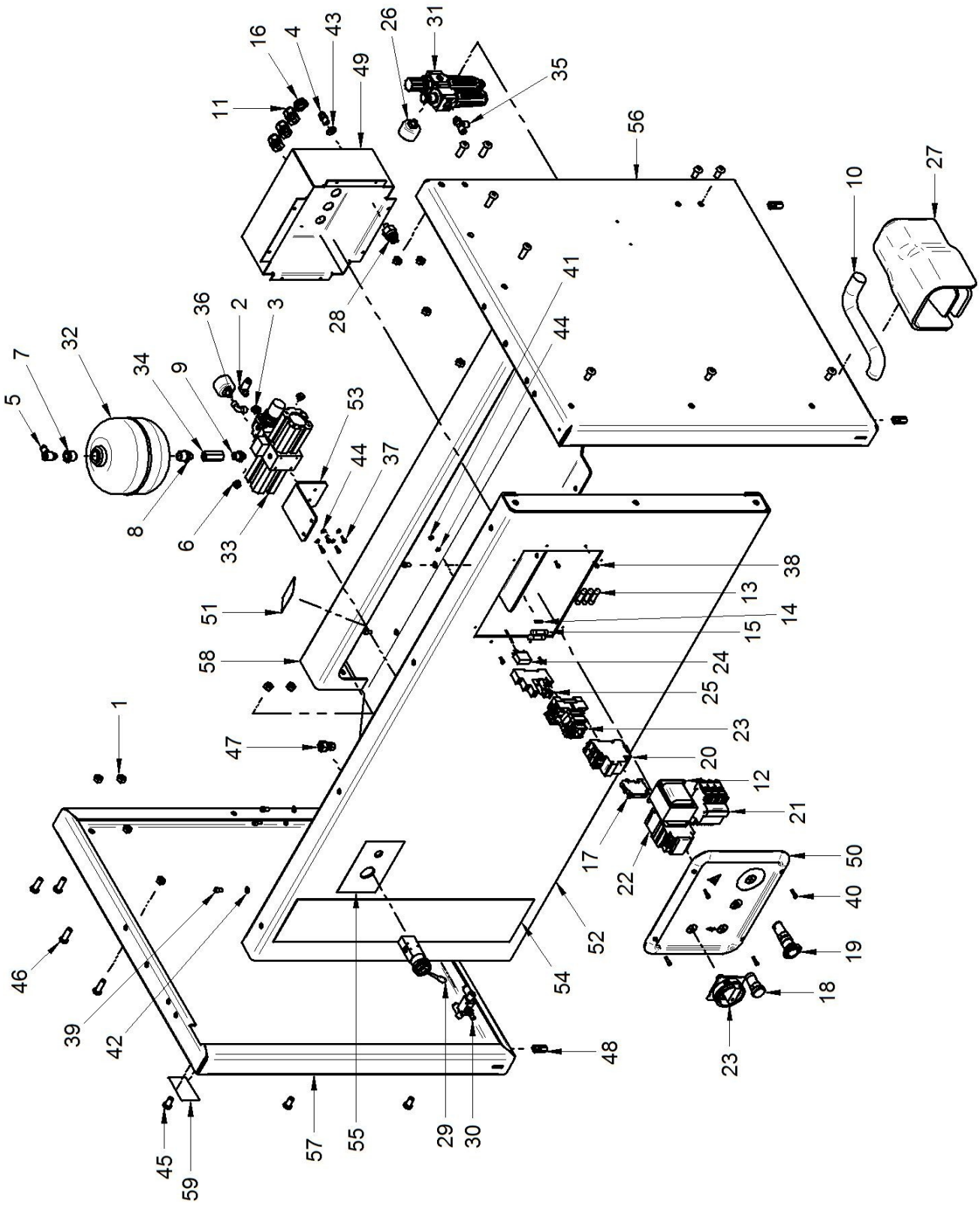
25. SPARE PARTS CATALOGUE

POS.	CODE	DENOMINATION GROUP	REFERENCE SHEET
1	26054810	1,5 +1,5 Mt EXTENSION FENCE + N° 4 ROTARY STOPS UNIT	SHEET. 11
2	26302001	FRAME UNIT	SHEET. 1
3	26367101	TABLE UNIT	SHEET. 2
4	26367201	RACK UNIT	SHEET. 3
5	26367300	LH SQUARE UNIT	SHEET. 4
6	26367301	RH SQUARE UNIT	SHEET. 5
7	26367401	SPINDLE HEAD UNIT	SHEET. 6
8	26367501	CLAMPING UNIT	SHEET. 7
#	26054502	CLAMP UNIT *(CLAMPING UNIT SUBGROUP)*	SHEET. 8
9	26367600	BACK STOP UNIT	SHEET. 9
10	26367700	HEAD UNIT	SHEET. 10
#	26050801	SWIVEL STOP UNIT *(EXTENSION FENCE SUBGROUP)*	SHEET. 12
#	#	PNEUMATIC SYSTEM	SHEET. 13-14
#	#	ELECTRIC SYSTEM	SHEET. 15



26302001 FRAME UNIT

SHEET 1



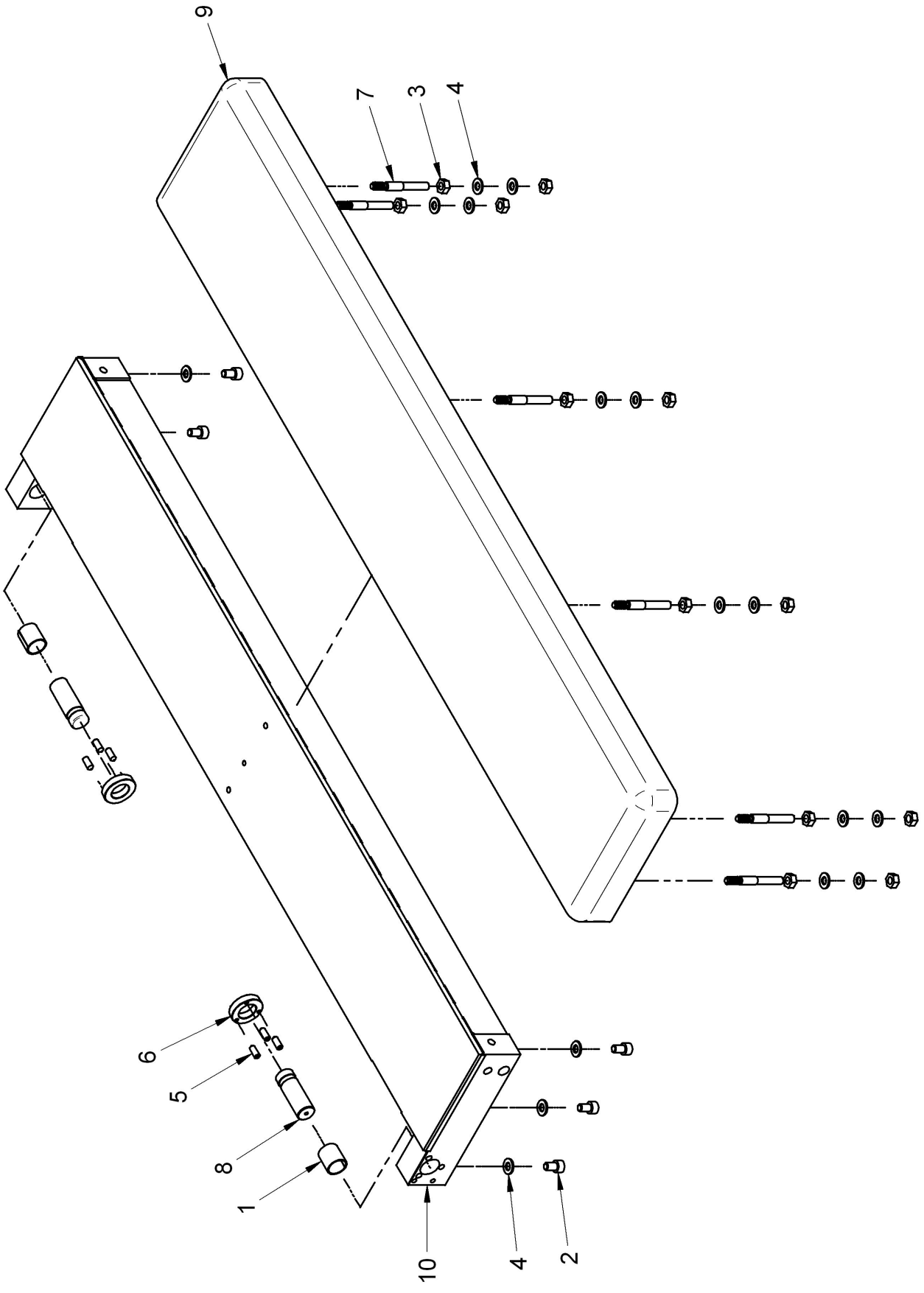
26302001 FRAME UNIT

POS.	COD./CODE	Q. TA'/Q. TY
1	00000151	18
2	00001105	1
3	00001106	1
4	00001107	1
5	00001108	1
6	00001109	2
7	00001116	1
8	00001117	1
9	00001119	1
10	00001124	1
11	00001188	3
12	00005032	1
13	00005072	3
14	00005074	1
15	00005083	2
16	00005086	1
17	00005087	1
18	00005320	1
19	00005330	1
20	00005341	1
21	00005342	1
22	00005365	1
23	00005370	1
24	00005452	1
25	00005621	1
26	00015219	2
27	00015220	1
28	00015221	1
29	00015223	1

POS.	COD./CODE	Q. TA'/Q. TY
30	00015229	1
31	00015233	1
32	00015239	1
33	00015240	1
34	00015241	1
35	00015651	1
36	00015652	1
37	00018290	4
38	00018300	4
39	00018333	5
40	00018380	4
41	00018499	3
42	00018520	5
43	00018522	1
44	00018531	8
45	00018601	10
46	00018602	8
47	28500009	1
48	28500011	3
49	36054033	1
50	36054034	1
51	36300100	1
52	36302001	1
53	36354015	1
54	36354023	1
55	36354031	1
56	36354082	1
57	36354084	1
58	36367008	1
59	40000030	1

26367101 TABLE UNIT

SHEET 2

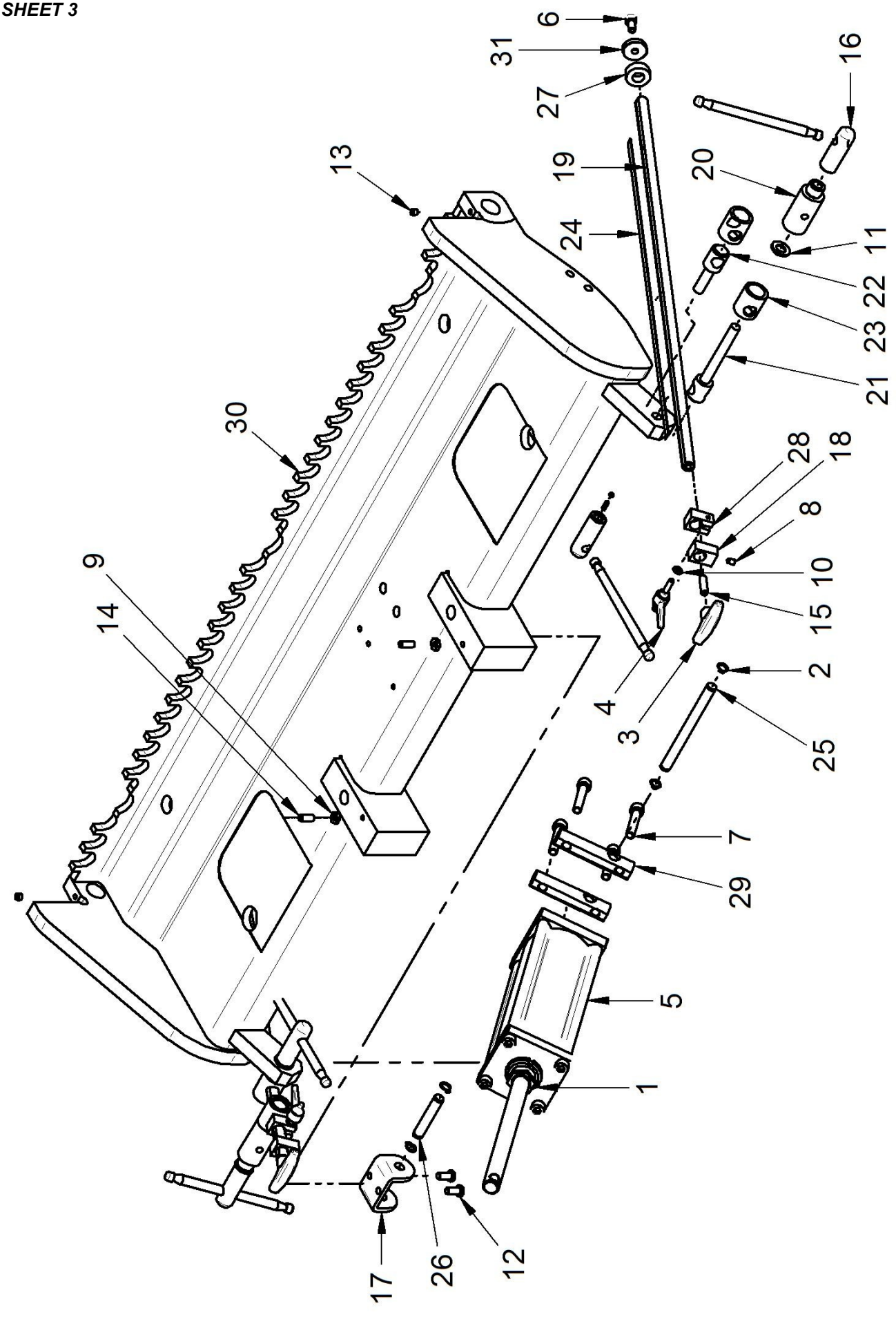


26367101 TABLE UNIT

POS.	COD./CODE	Q.TA'/Q.TY
1	00005045	2
2	00018364	6
3	00018503	12
4	00018522	18
5	00150909	6
6	36001016	2
7	36001127	6
8	36222125	2
9	36301018	1
10	36354017	1

26367201 RACK UNIT

SHEET 3

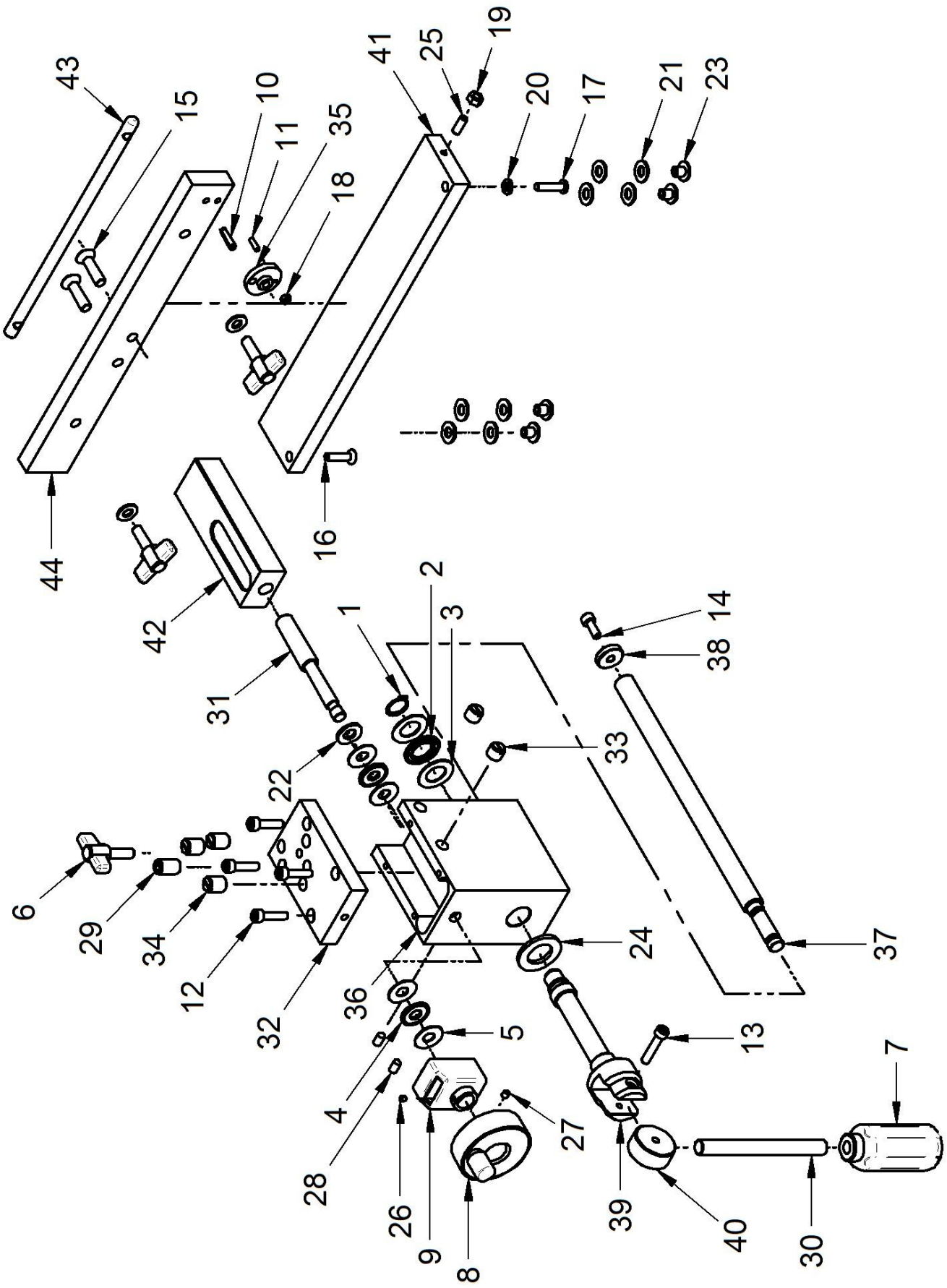


26367201 RACK UNIT

POS.	COD./CODE	Q.TA'/Q.TY
1	00000169	1
2	00003305	4
3	00003904	2
4	00003920	2
5	00015205	1
6	00018307	2
7	00018330	4
8	00018450	2
9	00018502	2
10	00018520	2
11	00018523	4
12	00018608	2
13	00150802	2
14	00150808	2
15	00150812	2
16	33201009	4
17	36000002	1
18	36000010	2
19	36000011	2
20	36000012	2
21	36000013	2
22	36000014	2
23	36000015	4
24	36000098	2
25	36000105	1
26	36000106	1
27	36000120	2
28	36001010	2
29	36001108	2
30	36322005	1
31	49900051	2

26367300 LH SQUARE UNIT

SHEET 4

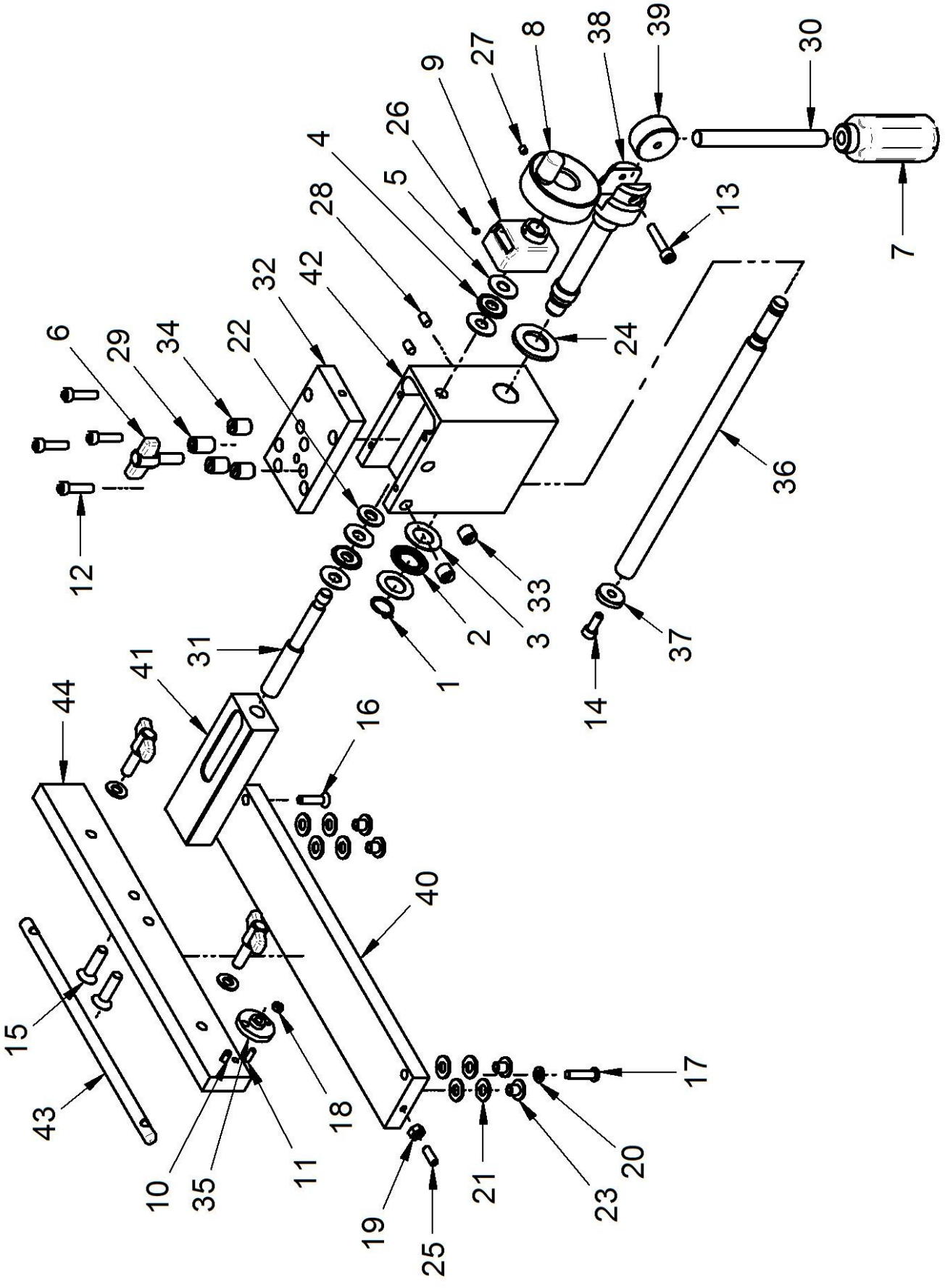


26367300 LH SQUARE UNIT

POS.	COD./CODE	Q.TA'/Q.TY
1	00003304	1
2	00003455	1
3	00003456	2
4	00003460	2
5	00003461	4
6	00003911	3
7	00003940	1
8	00003962	1
9	00003961	1
10	00004307	1
11	00018291	1
12	00018304	4
13	00018318	1
14	00018325	1
15	00018424	2
16	00018460	1
17	00018461	1
18	00018499	1
19	00018500	1
20	00018520	1
21	00018521	10
22	00018522	1
23	00018552	4
24	00018590	1
25	00100609	1
26	00120400	1
27	00130501	1
28	00140605	2
29	00171216	1
30	36000037	1
31	36000123	1
32	36050308	1
33	36050310	2
34	36050311	3
35	36050316	1
36	36054301	1
37	36054302	1
38	36054303	1
39	36054304	1
40	36054305	1
41	36054307	1
42	36054308	1
43	36054311	1
44	36354306	1

26367300 RH SQUARE UNIT

SHEET 5

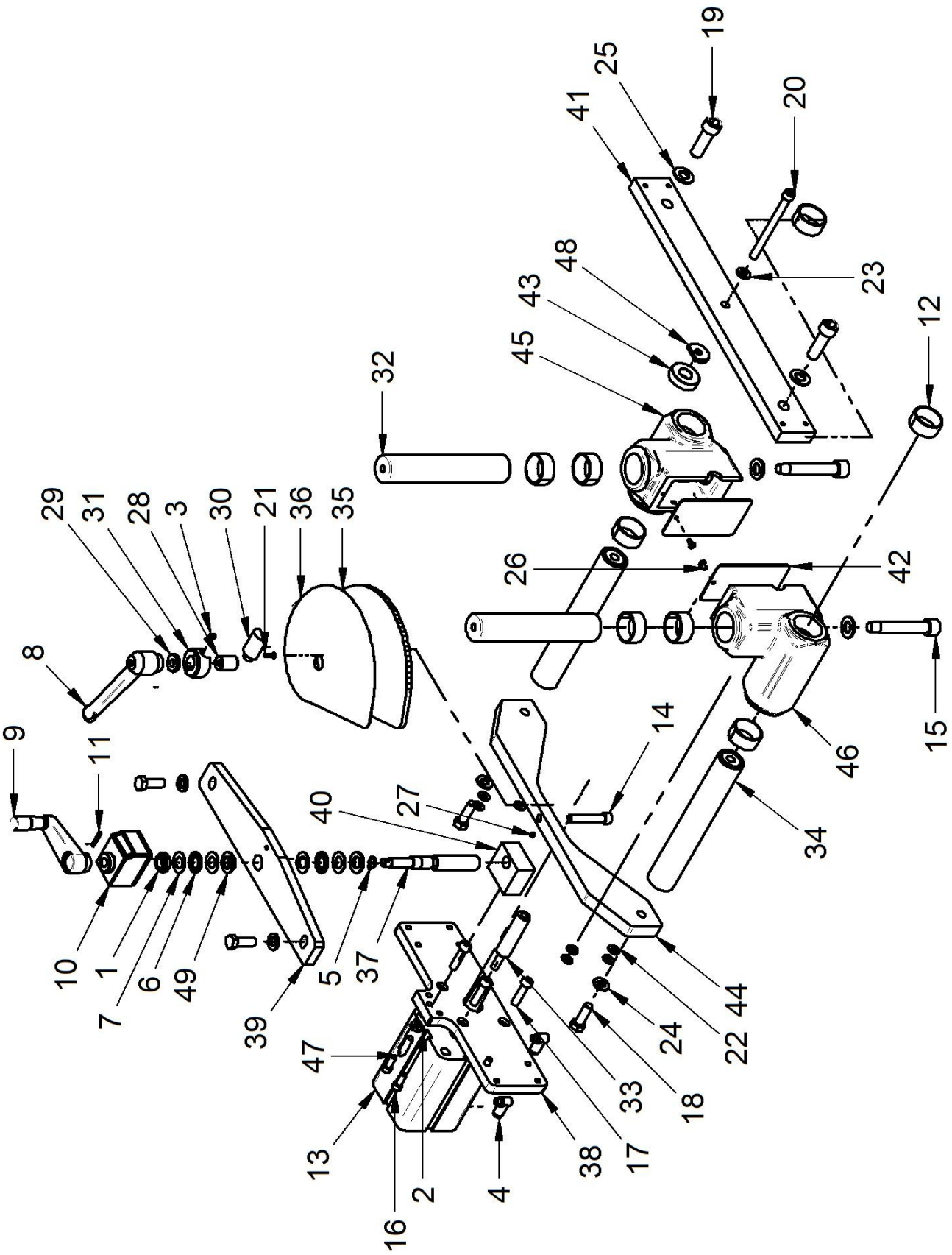


26367300 RH SQUARE UNIT

POS.	COD./CODE	Q.TA'/Q.TY
1	00003304	1
2	00003455	1
3	00003456	2
4	00003460	2
5	00003461	4
6	00003911	3
7	00003940	1
8	00003962	1
9	00003961	1
10	00004307	1
11	00018291	1
12	00018304	4
13	00018318	1
14	00018325	1
15	00018424	2
16	00018460	1
17	00018461	1
18	00018499	1
19	00018500	1
20	00018520	1
21	00018521	10
22	00018522	1
23	00018552	4
24	00018590	1
25	00100609	1
26	00120400	1
27	00130501	1
28	00140605	2
29	00171216	1
30	36000037	1
31	36000123	1
32	36050307	1
33	36050310	2
34	36050311	3
35	36050316	1
36	36054302	1
37	36054303	1
38	36054304	1
39	36054305	1
40	36054307	1
41	36054308	1
42	36054309	1
43	36054311	1
44	36354320	1

26367401 SPINDLE HEAD UNIT

SHEET 6



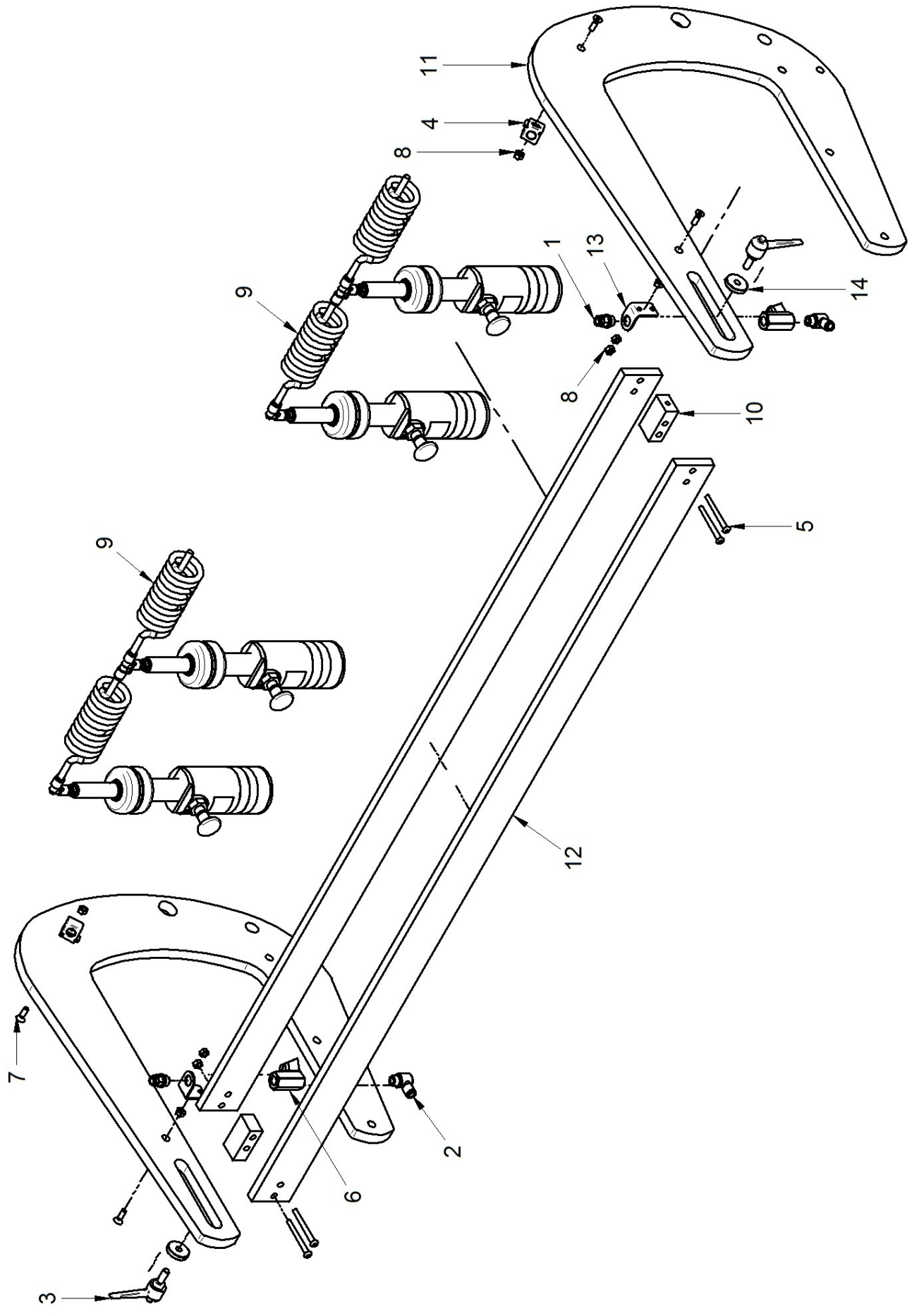
26367401 SPINDLE HEAD UNIT

POS.	COD./CODE	Q.TA'/Q.TY
1	00000168	1
2	00000180	1
3	00000213	1
4	00001105	2
5	00003303	1
6	00003455	2
7	00003456	4
8	00003934	1
9	00003942	1
10	00003960	1
11	00004380	1
12	00005047	8
13	00015206	1
14	00018312	1
15	00018315	2
16	00018322	10
17	00018332	4
18	00018403	4
19	00018409	2
20	00018411	1
21	00018419	1
22	00018521	8
23	00018522	1
24	00018523	4
25	00018524	5
26	00018558	2
27	00130501	1
28	36000042	1
29	36000043	1
30	36000044	1
31	36000045	1
32	36000048	2
33	36000111	1
34	36050403	2
35	36000046	1
36	36000097	1
37	36300018	1
38	36322009	1
39	36322010	1

POS.	COD./CODE	Q.TA'/Q.TY
40	36322011	1
41	36322012	1
42	36322013	2
43	36322015	1
44	36322047	1
45	36322109	1
46	36322110	1
47	36322124	1
48	36354401	1
49	41600004	1

26367501 CLAMPING UNIT

SHEET 7

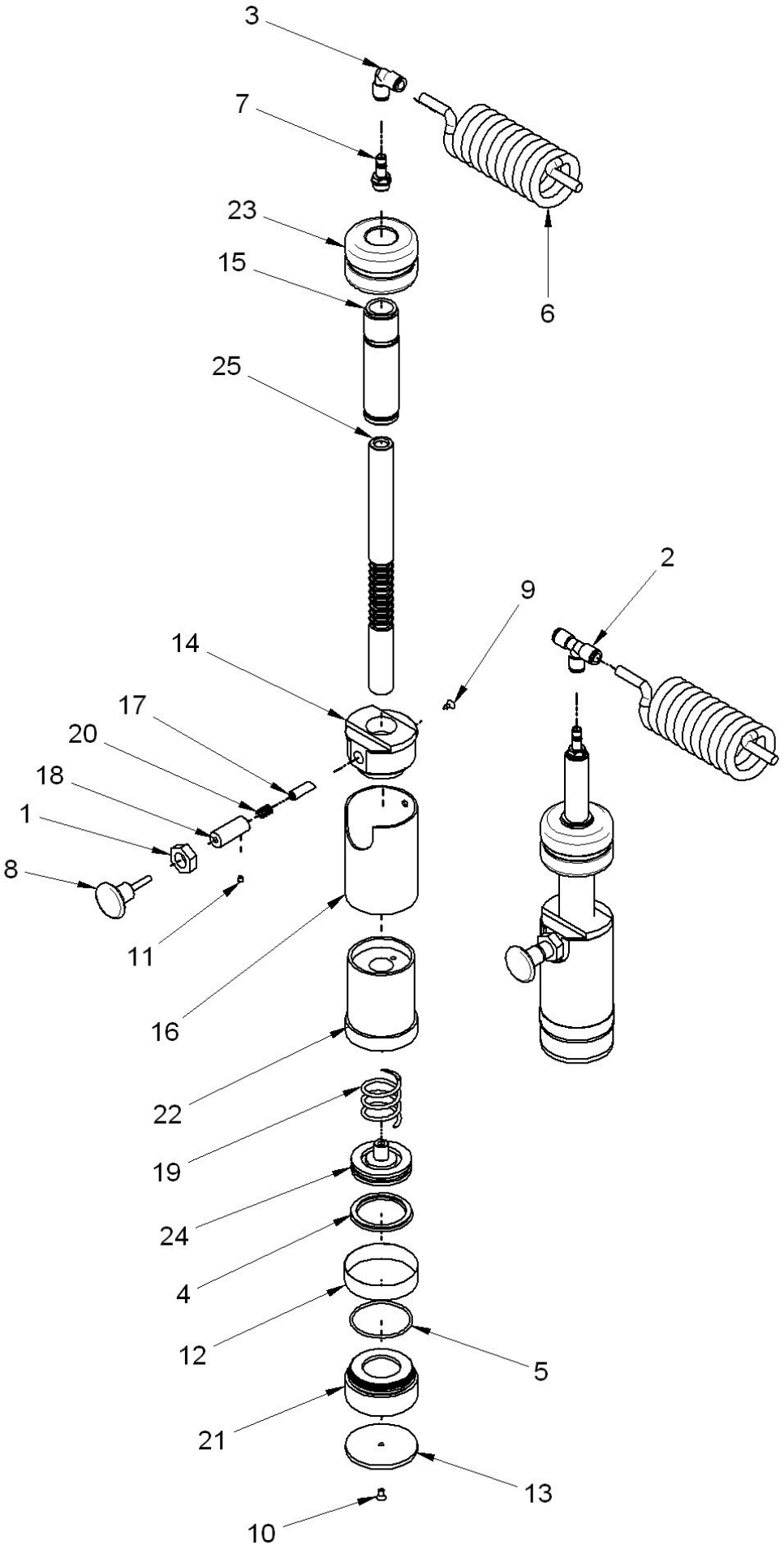


26367501 CLAMPING UNIT

POS.	COD./CODE	Q. TA'/Q. TY
1	00001013	2
2	00001108	2
3	00004022	2
4	00005041	2
5	00009083	4
6	00015226	2
7	00018429	4
8	00018500	8
9	26054502	2
10	36000091	2
11	36000102	2
12	36300041	2
13	39900045	2
14	49900051	2

26054502 CLAMP UNIT *(CLAMPING UNIT SUBGROUP)*

SHEET 8

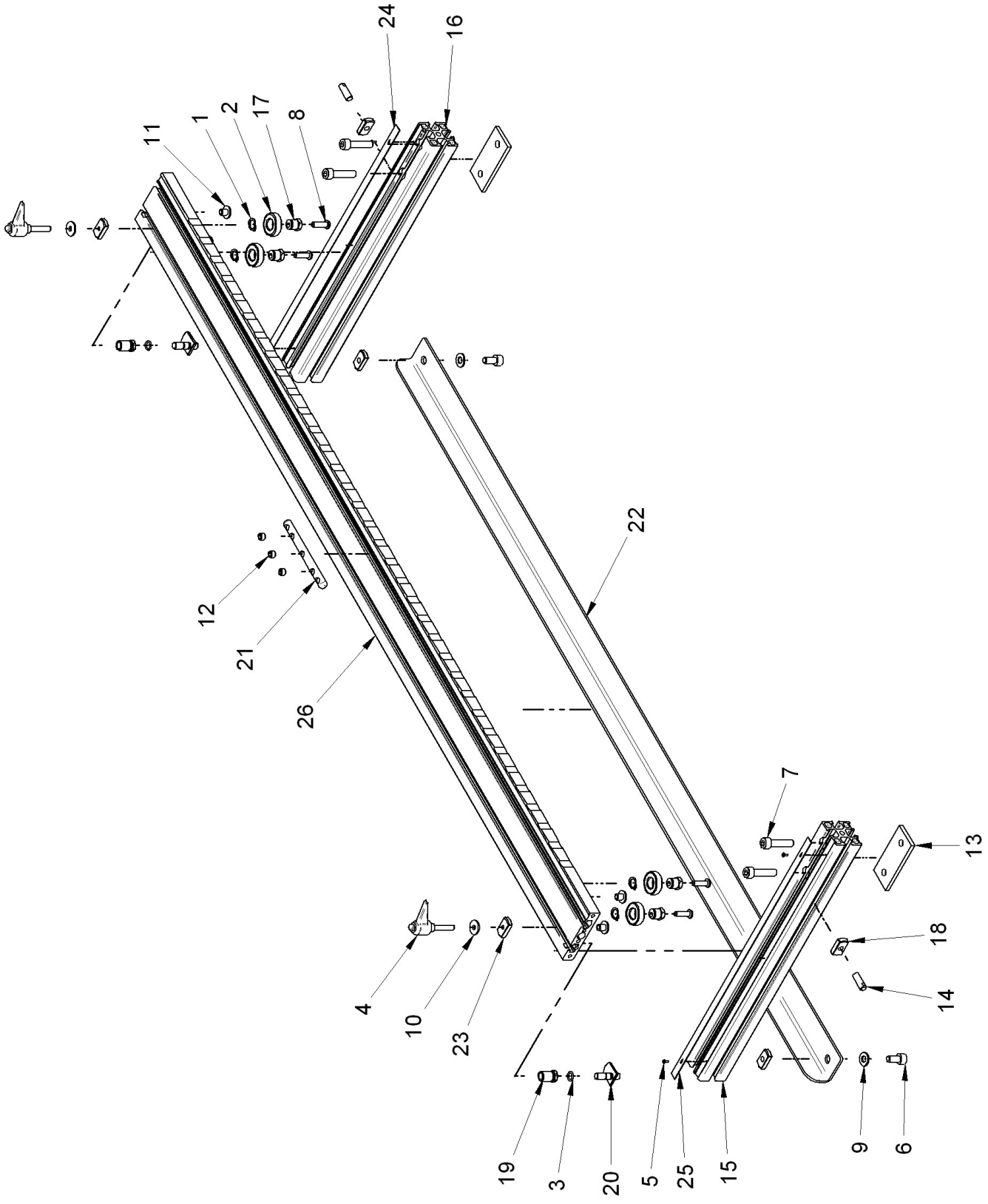


26054502 CLAMP UNIT *(CLAMPING UNIT SUBGROUP)*

POS.	COD./CODE	Q.TA'/Q.TY
1	00000118	2
2	00001102	1
3	00001110	1
4	00001120	2
5	00001121	2
6	00001128	2
7	00001250	2
8	00003120	2
9	00005103	2
10	00018439	2
11	00120404	2
12	#	#
13	49900095	2
14	49901088	2
15	49901089	2
16	49970042	2
17	49970047	2
18	49970048	2
19	49970053	2
20	49970146	2
21	49971051	2
22	49972040	2
23	49972045	2
24	49972052	2
25	49981043	2

26367600 BACK STOP UNIT

SHEET 9

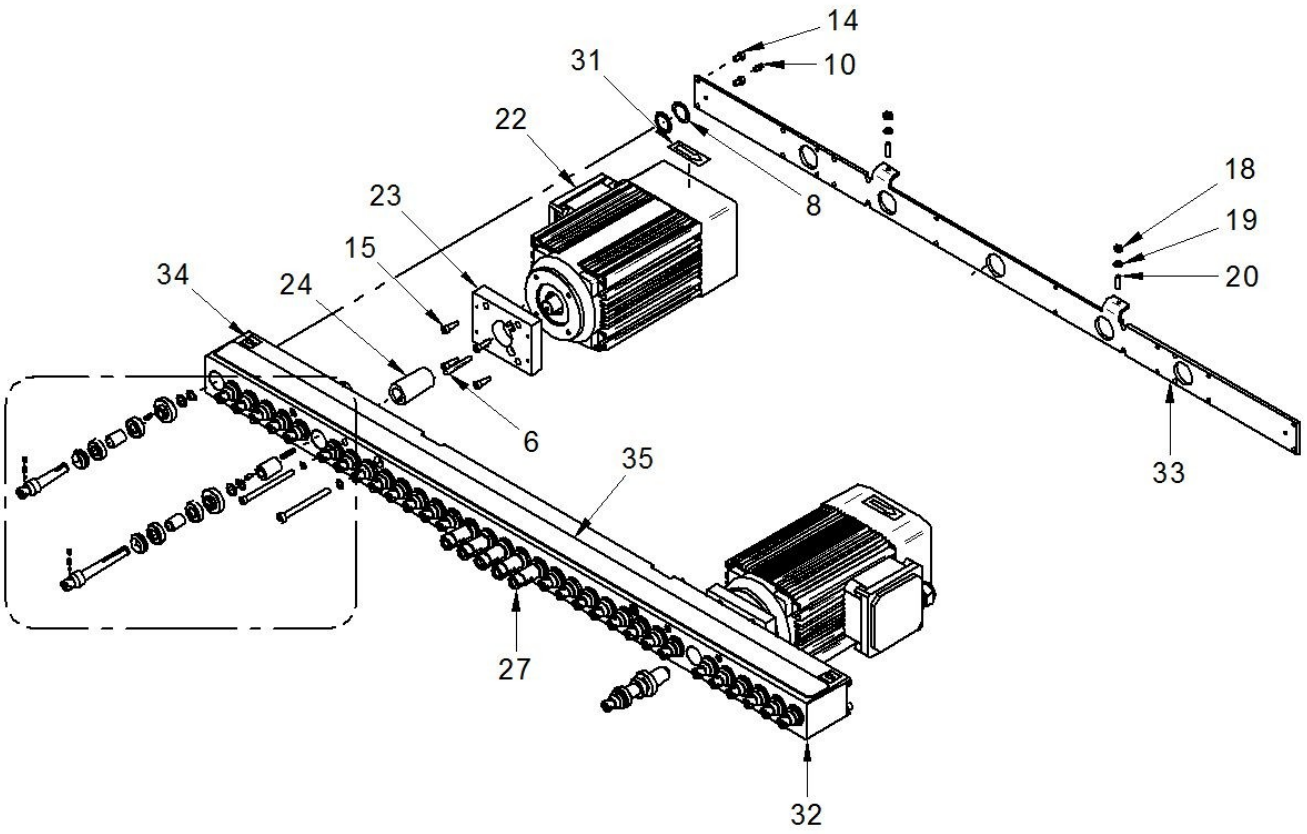


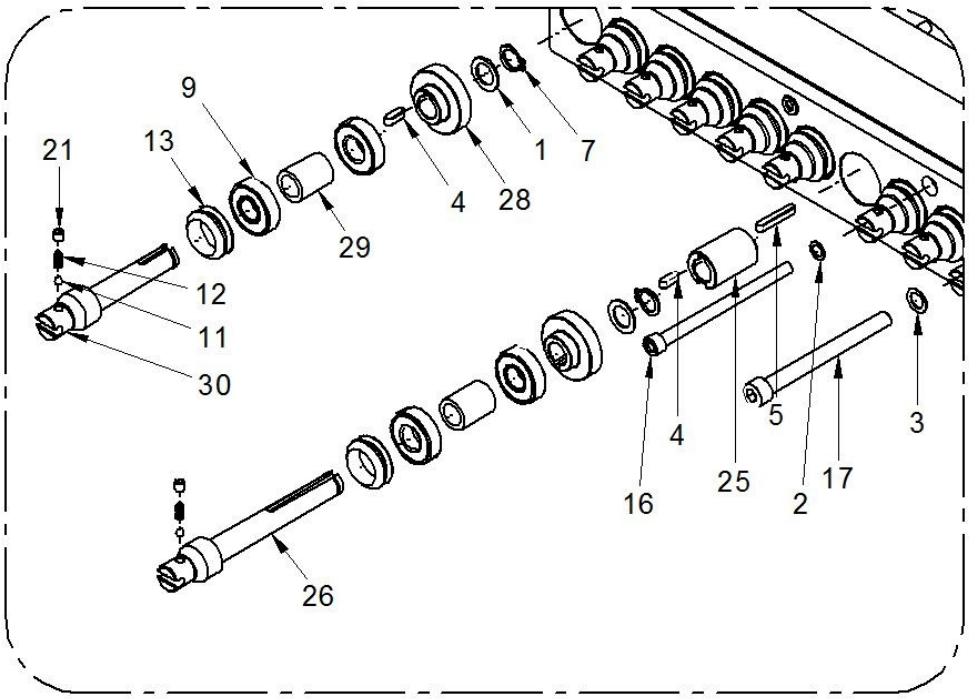
26367600 BACK STOP UNIT

POS.	COD./CODE	Q.TA'/Q.TY
1	00003305	4
2	00003424	4
3	00003520	2
4	00004044	2
5	00005127	4
6	00018307	2
7	00018327	4
8	00018431	4
9	00018521	2
10	00018526	2
11	00018552	4
12	00150802	3
13	36000153	2
14	36001078	2
15	36002065	1
16	36002066	1
17	36050608	4
18	36050801	4
19	36054601	2
20	36054602	2
21	36204812	1
22	36350607	1
23	36800228	2
24	46050613	1
25	46050614	1
26	46350603	1

26367700 HEAD UNIT

SHEET 10



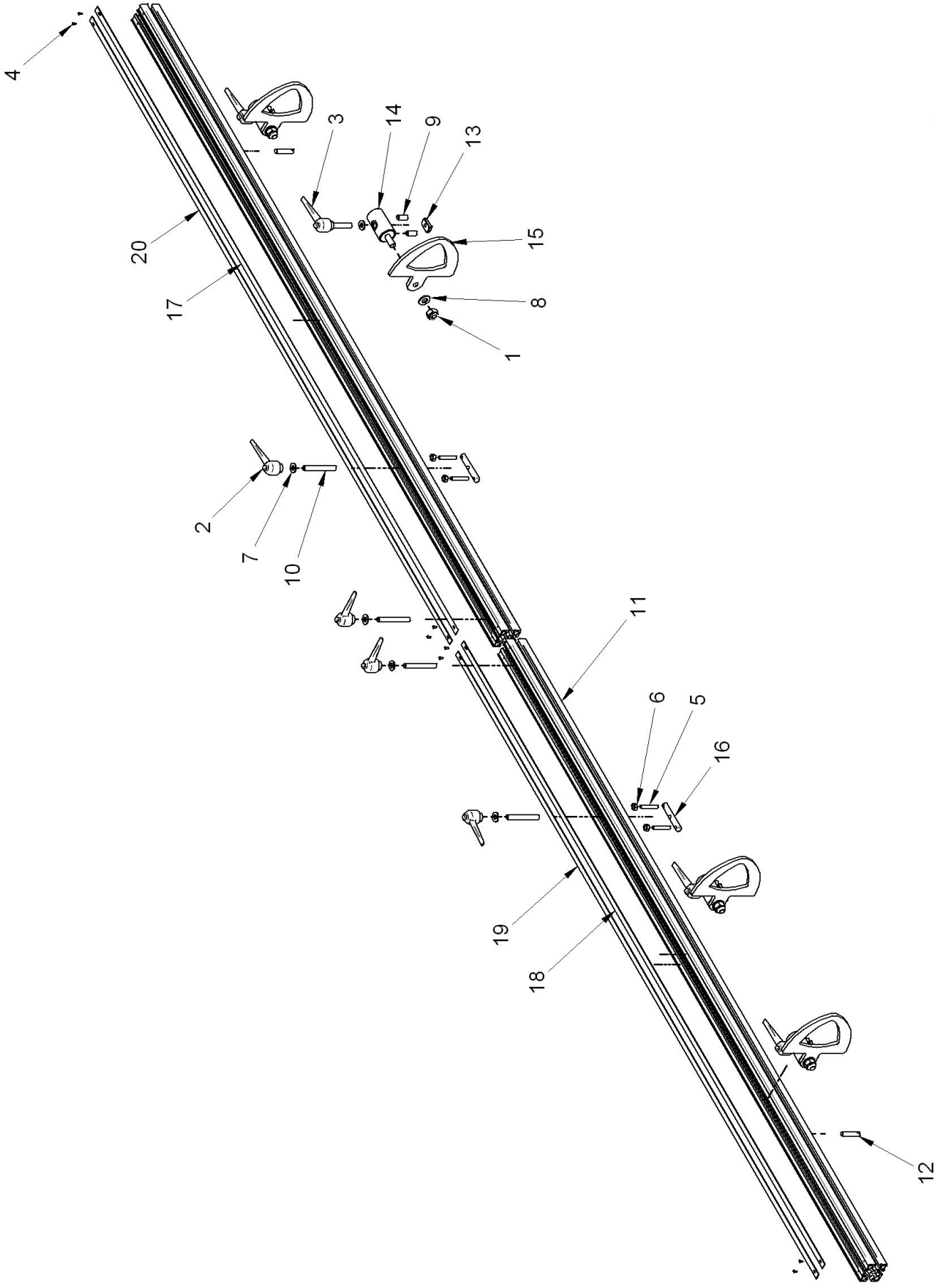


26367700 HEAD UNIT

POS.	COD./CODE	Q.TA'/Q.TY
1	00000037	35
2	00000041	8
3	00000042	4
4	00000211	35
5	00000212	2
6	00000222	2
7	00003305	35
8	00003337	70
9	00003424	70
10	00003703	2
11	00004103	35
12	00005025	35
13	00005097	35
14	00018302	12
15	00018303	8
16	00018305	8
17	00018316	4
18	00018500	2
19	00018520	2
20	00100614	2
21	00130501	35
22	26000001	2
23	36000055	2
24	36000056	2
25	36000057	2
26	36000059	2
27	36000061	5
28	36000062	35
29	36000063	35
30	36001060	33
31	36054020	2
32	36300054	1
33	36322058	1
34	36367710	2
35	36300095	1

26054810 1,5 +1,5 Mt EXTENSION FENCE + N° 4 ROTARY STOPS UNIT

SHEET 11

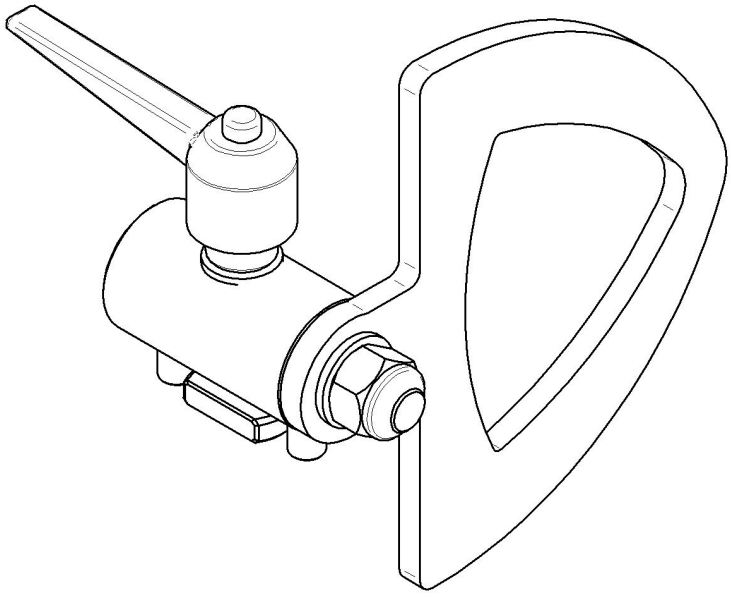


26054810 1,5 +1,5 Mt EXTENSION FENCE + N° 4 ROTARY STOPS UNIT

POS.	COD./CODE	Q.TA'/Q.TY
1	00000150	4
2	00003921	4
3	00004020	4
4	00005102	8
5	00018456	4
6	00018500	4
7	00018521	8
8	00018522	4
9	00150808	8
10	36000079	4
11	36001176	2
12	36003078	2
13	36050801	4
14	36050802	4
15	36051803	4
16	36054612	2
17	36054805	1
18	36054806	1
19	36054807	1
20	36054808	1

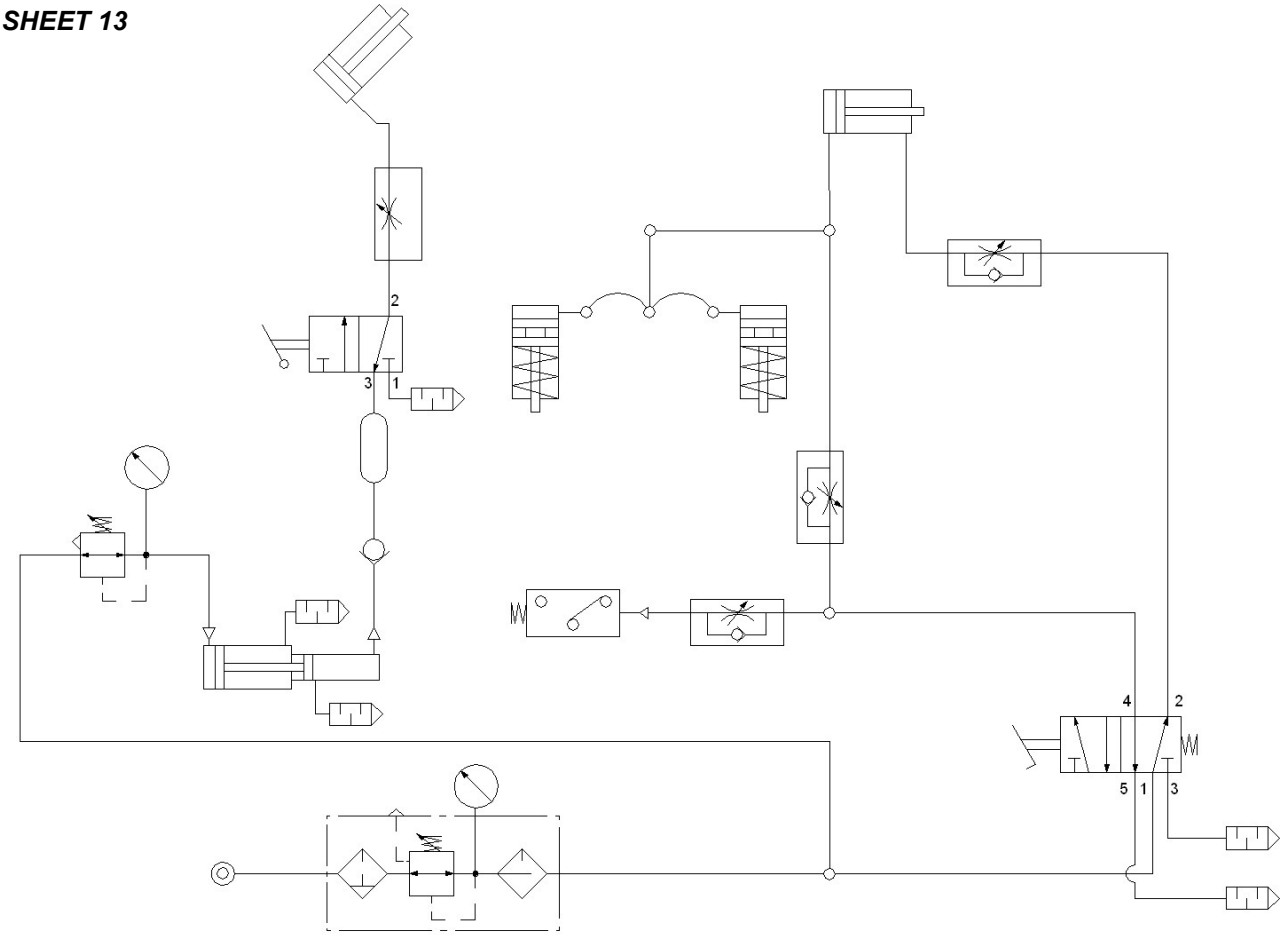
SHEET 12

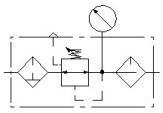
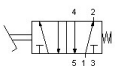
26050801 SWIVEL STOP UNIT *(EXTENSION FENCE SUBGROUP)*

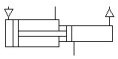


PNEUMATIC SYSTEM

SHEET 13



SIMBOLO/SIMBOL	DESCRIZIONE/DESCRIPTION
	FILTRO RIDUTTORE + LUBRIFICATORE FILTER PRESSURE REGULATOR + LUBRICATOR *G1/4 20U 0-8 BAR*
	MANOMETRO PRESSURE GAUGE *G1/8 Ø40*
	PRESSOSTATO 250V PRESSURE SWITCH *PME 10A G1/8 T4 48V*
	PEDALE CON PROTEZIONE MOLLA PEDAL PROTECTION SPRING *G1/8*
	SILENZIATORE *SILENCER* *G1/8*
	REGOLATORE DI FLUSSO UNIDIREZIONALE FLOW CONTROL VALVE UNIDIRECTIONAL *G1/8*
	CILINDRO A DOPPIO EFFETTO STELO SEMPLICE CYLINDER DOUBLE ACTING VERSION, SIMPLE PISTON ROD *G1/8*
	CILINDRO A SEMPLICE EFFETTO RITORNO A MOLLA CYLINDER SINGLE ACTING VERSION WITH FRONT SPRING *G1/4*
	VALVOLA AD AZIONAMENTO MANUALE *3 VIE NORMALMENTE CHIUSA* MANUAL VALVE *3 WAYS NORM. CLOSED* *G1/8*
	CILINDRO A SEMPLICE EFFETTO STELO SEMPLICE CYLINDER SINGLE ACTING VERSION, SIMPLE PISTON ROD *G1/8*
	REGOLATORE DI FLUSSO BIDIREZIONALE FLOW CONTROL VALVE BIDIRECTIONAL *G1/8*

SIMBOLO/SIMBOL	DESCRIZIONE/DESCRIPTION
	MOLTIPLICATORE DI PRESSIONE PRESSURE BOOSTER *G1/8*
	RIDUTTORE DI PRESSIONE PRESSURE REGULATOR *G1/8*
	VALVOLA UNIDIREZIONALE SENZA MOLLA UNIDIRECTIONAL VALVE WITHOUT SPRING *G1/8*
	SERBATOIO TANK *G1/2*

27. SPARE PARTS REQUEST

ATTENTION! FILL IN DETAILS THIS FORM

Customer …….. Address …….. ……..	Date …… Telephone number …….. Fax ……..

MACHINE TYPE	SERIAL NUMBER	DELIVERY DATE	
GROUP CODE	**CODE**	**PART NAME**	**QUANTITY**

NOTE

……

……

……

N.B.: Please attach a copy of each table where the requested part is.

Page intentionally left blank

Page intentionally left blank

Maggi Technology S.r.l.
Via delle Regioni, 299 50052 Certaldo (Fi) Italia

Tel. +39 0571 63541 Fax. +39 0571 664275
E mail: service@maggi-technology.com

ACIMALL