SBW

WELDING TABLE WITH INTEGRATED EXTRACTION WITH CARTRIDGES AND PNEUMATIC CLEANING

ORIGINAL INSTRUCTIONS
0816D001

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CONTENTS

MANUFACTURER DATA

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MACHINE DATA

Machine type: **WELDING TABLE WITH INTEGRATED EXTRACTION WITH CARTRIDGES AND PNEUMATIC CLEANING**

Model **SBW**

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NOTE

For the machine identification data, see the identification sheet attached to this manual.

1. GENERAL

1.1. Purpose and recipients of the Use and Maintenance Manual

The Use and Maintenance Manual must accompany the machine throughout its entire life cycle. Therefore, if the machine is sold to a third party, it must be handed over together with the other accompanying documents to ensure the safety of the operator and user.

This manual provides the necessary instructions for the correct use of the machine and therefore allows the following operations to be performed:

— INSTALLATION
— USE
— ADJUSTMENT
— MAINTENANCE
— DECOMMISSIONING

This applies to both the user and the operator responsible for carrying out the above activities, indicating (where applicable) the required qualification, with reference to paragraph 1.2.

Failure to comply with the instructions contained in this manual will release Secureair® by Gamma Impianti™ S.R.L. from any liability relating to such negligence.

It should also be noted that in the event of:

— improper use of the machine;
— use contrary to specific national regulations;
— lack of maintenance;
— unauthorised modifications or interventions;
— use of non-original or non-specific spare parts;
— failure to follow the instructions;

Secureair® by Gamma Impianti™ S.R.L. shall not be liable for any risks arising from failure to comply with these requirements. The manual shall not be used as a reference if modifications are to be made that alter the configuration of the machine or its intended use. In this case, liability shall remain exclusively for any manufacturing defects.

1.2. Definitions

— User.
— Operator.
— Machine.

— The term "user" refers to a person who, due to their position, is intended to use the machine on a continuous basis.
— The person or persons defined as "Operator" are responsible for installing, operating, adjusting, maintaining, cleaning, repairing or transporting the machine.
— In this manual, the term "machine" refers to the WELDING TABLE WITH INTEGRATED CARTRIDGE EXTRACTION AND PNEUMATIC CLEANING.

The operations mentioned in paragraph 1.1 must be performed by personnel qualified for the specific activity. The level of qualification shall refer to the activities for which the operator is qualified according to the manufacturer's instructions.

NOTE

The definition of qualifications given below refers exclusively to the level of training specific to the machine in question. None of the above definitions concerns, or may concern, contractual qualifications within the customer's company structure.

Qualification 1
Personnel covered by this qualification have no specific training but are authorised to perform simple operations related to the operation of the machine. To this end, they must be trained in the use of the devices on the control panel through initial training and by carefully reading this Use and Maintenance Manual.

Qualification 2
Personnel with specific training in electronically assisted automatic machines, with particular reference to mechanical interventions. This qualification enables them to perform activities related to adjustment and routine and non-routine maintenance in accordance with this Use and Maintenance Manual. Specific training in the operations to be performed on the machine must be achieved through staff training and a thorough reading of this manual.

Qualification 3
Personnel with specific training in electronically assisted automatic machines, responsible for electrical interventions. This qualification enables the performance of installation, adjustment and maintenance interventions. Training in the activities listed above will be achieved through training and thorough reading of this manual.

1.3. Terminology

This manual contains notes that serve to draw the user/operator's attention to a specific procedure or a particular operation.

There are three types of notes:

NOTE: these are warnings to guide and optimise the operator's actions of the operator, or to better highlight particular features of the machine.

WARNING: These are very important warnings that specify actions to be taken/not to be taken, or special precautions to be taken before operating the machine, in order to avoid damaging it.

DANGER: These are very important warnings that specify actions to do/not do, or special precautions to take, before operating the machine, in order to avoid causing harm to people.

2. TECHNICAL SPECIFICATIONS

2.1. Machine versions

The following table shows the versions in which the machine can be supplied, with the different types of power supply available for each version:

MODEL	POWER SUPPLY
SBW 12	— 400V/3PH/50Hz – 400V/3PH+N/50Hz — 220V/1PH/50Hz
SBW 24	— 400V/3PH/50Hz

NOTE

For technical and dimensional differences between the various versions, see the following paragraphs.
The selected benches are those usually kept in stock by Siegmund; other models can be installed subject to confirmation by Secureair® by Gamma Impianti™ S.R.L.

2.2. Siegmund welding tables that can be installed on the machine

The following table shows the versions of Siegmund welding table models with which the machine can be supplied or which can be installed later directly by the customer.

SYSTEM 16				
SIEGMUND CODE	**DESCRIPTION**	**H1 [mm]**	**WEIGHT [kg]**	**MOD**
2-164034.1.X7	Perforated plate X8.7 1200x1200x12 Plasma nitrided	12	131	SBW 12 SBW 24
4-160015.P.T1	Professional 750 welding table 1200x1200x100 Plasma nitrided	100	237	SBW 12
4-160030.P.T1	Professional 750 welding table 2400x1200x100 Plasma nitrided	100	466	SBW 24
4-160015.X7D.T1	Professional Extreme 8.7 welding table 1200x1200x100 Plasma nitrided	100	235	SBW 12
4-160030.X7D.T1	Professional Extreme 8.7 welding table 2400x1200x100 Plasma nitrided	100	462	SBW 24
4-160015.X7PL.T1	Professional Extreme 8.7 PLUS welding table - 1200x1200x150 Plasma nitrided	150	264	SBW 12
4-160030.X7PL.T1	Professional Extreme 8.7 PLUS welding table - 2400x1200x150 Plasma nitrided	150	518	SBW 24

SYSTEM 22				
CODE SIEGMUND	**DESCRIPTION**	**H1 [mm]**	**WEIGHT [kg]**	**MOD**
2-224034.PD	Perforated plate S355J2+N 1200x1200x18. Plasma nitrided Diagonal scale	18	197	SBW 12 SBW 24
4-220015.P.T1	Professional 750 welding table 1200x1200x150. Plasma nitrided	150	365	SBW 12
4-220030.P.T1	Professional 750 welding table 2400x1200x150 Plasma nitrided	150	695	SBW 24
4-220015.XD7.T1	Professional Extreme 8.7 welding table - 1200x1200x150 Plasma nitrided - with holes and diagonal grid	150	357	SBW 12
4-220030.XD7.T1	Professional Extreme 8.7 welding table - 2400x1200x150 Plasma nitrided - with holes and diagonal grid	150	680	SBW 24

SYSTEM 28				
CODE SIEGMUND	**DESCRIPTION**	**H1 [mm]**	**WEIGHT [kg]**	**MOD**
4-281015.XD7.T1	Basic 8.7 welding table - 1200x1200x25 Plasma nitrided - with holes and diagonal grid	25	299	SBW 12 SBW 24
4-281030.XD7.T1	Basic 8.7 welding table - 2400x1200x25 Plasma nitrided - with holes and diagonal grid	25	597	SBW 24
4-280015.P.T1	Professional 750 welding table 1200x1200x200 Plasma nitrided	200	510	SBW 12
4-280030.P.T1	Professional 750 welding table 2400x1200x200 Plasma nitrided	200	952	SBW 24
4-280015.XD7D.T1	Professional Extreme 8.7 welding table - 1200x1200x200 Plasma nitrided - with holes and diagonal grid	200	487	SBW 12
4-280030.XD7D.T1	Professional Extreme 8.7 welding table - 2400x1200x200 Plasma nitrided - with holes and diagonal grid	200	913	SBW 24

2.3. Overall dimensions and weights

Fig.2.1 shows the layout of the machine, with overall dimensions (expressed in mm). For the actual dimensions of the product, including any welding plates and optional extras, please refer to the drawing sent in advance during the order confirmation phase.

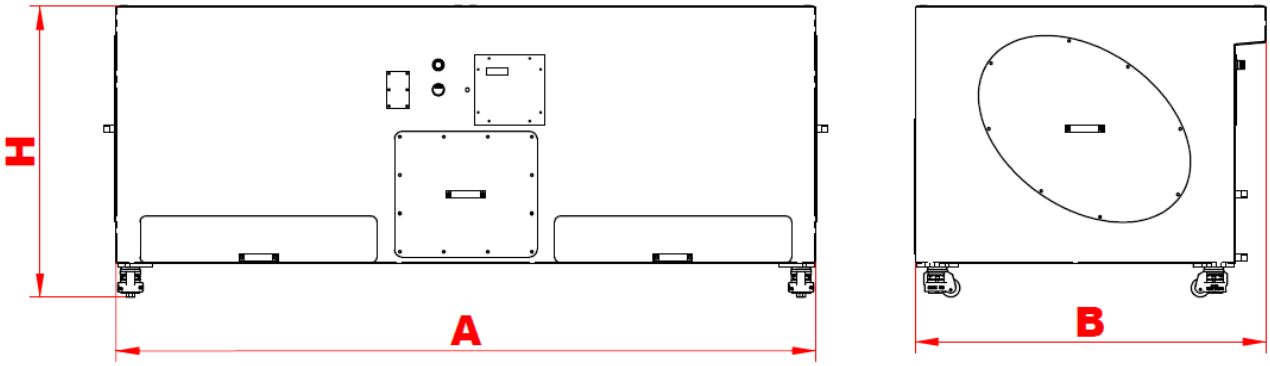


Fig.2.1

MODEL	A (ref.Fig.2.1) [mm]	B (ref.Fig.2.1) [mm]	H (ref.Fig.2.1) [mm]
SBW 12	1,200	1,200	720+102
SBW 24	2,400	1,200	720+102

NOTE

The height of 102 mm refers to the height of the foot with the wheel.

NOTE

The height dimension H1 relating to the installed Siegmund perforated plate must be added to the height dimension H of the bench. See section 2.2.

NOTE

In the presence of accessories such as a rectangular exhaust channel or silencer, the "B" dimension of the benches varies.

NOTE

If accessories such as side panels, rear panel and "casing" are present, the overall height of the bench varies.

2.4. Technical Data

Models with three-phase power supply:

Model	Weigh t* [kg]	Max flow rate [m³/h]	Power [kW]	Voltage three-phase [V]	Current [A]	Maximu m load [kg]	No. Cart	Filter surface area cartridge [m²]	No. Ø3/4" valves	Hepa filter surface area [m²]	Noise [dB(A)]
SBW 12	300	2,000	1.5	400	3.5	1,000	2	30	1	19.4	78
SBW 24	520	4,000	3	400	6.5	2,000	4	60	2	38.8	78

**Weight without welding table*

Models with single-phase power supply:

Model	Weigh t* [kg]	Max flow rate [m³/h]	Power [kW]	Voltage single-phase [V]	Current [A]	Maximu m load [kg]	No. Cart	Filter surface area cartridge [m²]	No. Ø3/4" valves	Hepa filter surface area [m²]	Noise [dB(A)]
SBW 12	300	2,000	1.5	220	9.2	1,000	2	30	1	38.8	78

**Weight without welding plate*

NOTE

The weight of the Siegmund welding plates installed must be added to the weight of the machine. See section 2.2

NOTE

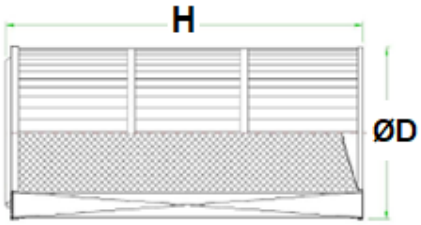
If the bench is equipped with:
- "side panels and rear panel in sheet metal", the weight increases by 50 kg for SBW12 and 70 kg for SBW24
- a "rectangular channel", the weight increases by approximately 35 kg;
- "silencer", the weight increases by approximately 75 kg.

2.5. Filter cartridge data

The machine can be supplied with a different type of cartridge. The characteristics of the cartridges that can be supplied are shown in the following tables.

FILTER FABRIC FILTER FABRIC*	TEFLON-COATED POLYESTER	ANTISTATIC TEFLON-COATED POLYESTER	POLYESTER WITH TEFLON MEMBRANE	ANTISTATIC POLYESTER WITH TEFLON MEMBRANE
No. of pleats	260	260	260	260
Weight [g/m^2]	270	270	290	280
BIA classification	M	M	M	M
Maximum operating temperature continuous	70°C	70°C	70°C	70°C
Height code 600 mm	CAR3250600PO3G-OF	Contact authorised technical office	Contact authorised technical office	Contact authorised technical office

Class of use according to BIA classification	M
Concentration	Dust filtration with AGW values ≥ 0.1 mg/m3
Maximum authorised release	< 0.1%

Model	No. of cartridges	Diameter [mm]	Height H. [mm]	Filtering surface [m^2]	Dimensions
SBW 12	2	325	620	15	
SBW 24	4	325	620	15	

2.6. Metal filter data

The machine can be supplied with different metal filters. The table below shows the characteristics of the filters supplied for the various models.

Metal mesh	
Efficiency class (CEN EN779)	G2
EFFICIENCY GROUP EN ISO 16890:2016	GROUP ISO ePM10 50% (ePM1 8% - ePM2.5 17% - ePM10 53%)
Average gravimetric efficiency (sp.23mm)	70
Max operating temperature	200°C
Relative humidity	100

Model	No. of metal filters	Dimensions [mm]
SBW 12	1	678x600x23
SBW 24	2 2	490x592x23 287x592x23

2.7. HEPA H13 filter data

The machine can be supplied with different HEPA absolute filters. The table below shows the characteristics of the filters supplied for the various models.

HEPA absolute filter	
Filter class (EN1822)	H13
MMPS efficiency	99.95
Max operating temperature	70°C
Relative humidity	90

Model	No. of HEPA absolute filters	Dimensions [mm	Filtering surface area [m^2]
SBW 12	1	610x610x150	18.4
SBW 24	2	610x610x150	36.8

2.8. Intended use

The machine is designed and built for the extraction and filtration of dry dust and fumes resulting from industrial processes of various origins. The system must not be used if the dust contains a high degree of moisture or in operating conditions other than those specified during design.
This machine is to be used only and exclusively when the product being treated cannot cause an explosion.

DANGER

The machine must not be used in environments where, during normal operation, an ATEX atmosphere exists or could occur, even for short periods.

DANGER

In the event of improper use, or if the type of processing for which the machine is intended is not specified, Secureair® by Gamma Impianti™ S.R.L. declines all responsibility in the event of malfunctions or accidents.

WARNING

If the processing operations may cause the formation of incandescent particles or cause fires, it is advisable to take additional measures to detect the presence of any sparks and flames or to use suitable alternative devices to reduce or eliminate the risk of fire.

2.9. Workable products

Dry powders and fumes from industrial processes of various origins, excluding those containing a high degree of moisture. This machine is to be used only and exclusively in cases where the product being processed cannot cause an explosion.

DANGER

The machine must not be used in environments where, during normal operation, an ATEX atmosphere exists or could occur, even for short periods.

WARNING

The use of products other than those specified may cause various malfunctions of the system that are not attributable to it, as the technical limits have not been respected. In this case, Secureair® by Gamma Impianti™ S.R.L. declines all responsibility in the event of any malfunctions or accidents.

2.10. Optional

If requested at the time of quotation, SBW benches can be supplied with a wide range of optional extras listed below.

2.10.1. ATEX motor

The installation of an ATEX-certified electric motor is recommended if the possibility of an explosion cannot be completely ruled out.
However, the installation of this device is not sufficient for the treatment of potentially explosive dusts or to allow the bench to be installed in ATEX-certified areas. The fan as a whole is not ATEX certified.

2.10.2. Bend and silenced rectangular canal

The bench can be equipped with a 1000 mm long rectangular channel and a corresponding rectangular bend to direct the ejection upwards.
The channel is lined internally with sound-absorbing material that reduces noise by approximately 4 dB(A) (noise levels are greatly influenced by the workplace and the final position of the device).
The installation of the bend and channel increases the width beyond that of the bench itself.
A connection for a drain pipe can be attached to the end of the bench.

2.10.3. Bend and Rectangular Silencer

The bench can be equipped with a rectangular exhaust elbow to which a rectangular silencer is attached, reducing noise by approximately 8÷10 dB(A) (noise is greatly influenced by the workplace and the final position of the device).

2.10.4. Hepa H13 filter on discharge

The SBW bench can be equipped with an H13 efficiency filter in the exhaust, inserted in a special space at the rear of the bench, which allows the air to be returned to the working environment (where required by current regulations).
The installation of the outlet filter results in a reduction in flow rate of approximately 15% compared to the nominal flow rate.
The installation of the elbow and duct increases the width beyond that of the bench itself.

H13* absolute filter according to EN1822	
Fireproof and water-repellent glass microfibre paper filter media	
MMPS efficiency	>99.95%
MERV	13
Max operating temperature	70°C
Relative humidity	100
Fire resistance (DIN53438)	Class F1

Model	**No. Absolute filters**	**Dimensions [mm]**
SBW 12	1	610x610x150
SBW 24	2	610x610x150

*Please note that the H13 exhaust filter reduces the flow rate indicated in paragraph 2.4 by approximately 15%.

2.10.5. Non-EXTRACTION enclosure

The workbench enclosure consists of a sheet metal structure that completely covers the work surface on three sides and also at the top. The structure confines the dust generated during work carried out on the workbench in order to maximise collection.
The enclosure can be integrated with the ceiling light to ensure better visibility inside.
The installation of this superstructure increases the overall height of the bench.

2.10.6. Non-extraction metal sheet side panels and rear panel

The non-extraction side and rear panels delimit the work surface to reduce material dispersion and thus increase collection. The panels are fixed to the bench using special Siegmund clamping pins.

2.10.7. Central partition

The bench can be supplied with a partition panel installed in the centre of the bench to create two separate work areas. The partition is secured to the welding surface using special Siegmund clamping pins.

3. INSTALLATION

3.1. Transport

The machine must be transported properly packaged, with stretch nylon wrapping or another suitable system, to protect it from dust and atmospheric agents.

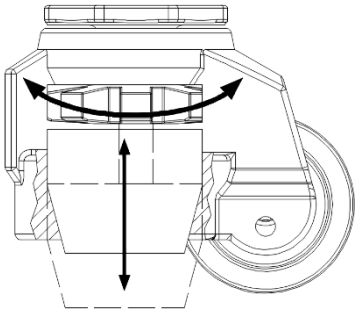
3.1. Storage conditions

If stored indoors, the machine is designed to withstand environments with the following characteristics:

- Temperature between --5°C °C and +50°C °C.
- Relative humidity < 80% (without condensation)

3.2. Lifting and handling

Lifting and handling must be carried out using suitable equipment. In particular, we recommend handling on the ground (after unpacking the items), using forklift trucks with long forks or a crane or overhead travelling crane system, with appropriate slinging accessories.



Handling on the ground must only be carried out after disconnecting the power supply cables, the machine's pneumatic supply pipes and any pipes or elements connected to the bench drain.

The bench is equipped with multifunction levelling castors. These castors are versatile and are the ideal choice for equipment that needs to be mobile but, once positioned, must be completely stable and fixed.

The castors are equipped with a manual ring nut which, when rotated, allows the foot to be raised/lowered to stabilise the bench on the ground.

WARNING

It is strictly forbidden to lift and move the parts that make up the machine if it is still connected, as there is a risk of damaging the electrical cables and/or the pneumatic system pipes.

DANGER

Before lifting, check that the lifting device is suitable for lifting the weight of the individual part.

DANGER

During movement, take the utmost care to avoid impacts, jolts or accelerations that could cause the load to fall. Ensure that the area affected by the movement

is free of obstacles and that there are no other users nearby who could be in danger.

3.3. Space required for use and maintenance

It is advisable to leave a free space of at least 1.5 m in front of the machine and around its entire perimeter (except for the side where it connects to the other machines that make up the line) for the operator to stand and to open the panels. The above-mentioned free spaces are also necessary for the passage of personnel involved in use, repairs, inspection and maintenance operations.

3.4. Permitted environmental conditions

The machine is designed to operate in industrial environments. Therefore, the environmental parameters taken as a reference are as follows:

- Temperature between +5°C 40°C
- Humidity < 80% (without condensation)

The machine is not intended for use in environments with characteristics other than those mentioned above.

WARNING

Use of the machine in environments or situations not specified above will release Secureair® by Gamma Impianti™ S.R.L. from any liability arising from such use. It is therefore recommended that you request Secureair® by Gamma Impianti™ S.R.L.'s consent for use in environments with different conditions.

3.5. Positioning

The machine must be installed in accordance with the instructions given in the paragraphs of the following chapter.

Once positioned, it must be levelled using the adjustable feet; then connect the machine to the power supply and the external pneumatic supply.

3.6. External power supply connection

The machine requires an external power supply and an external pneumatic supply to operate.

3.6.1. Power supply

The installation requirements for the power supply are described below:

- power supply voltage (depending on the version purchased):
  400 V ± 10% three-phase + earth
  220 V ± 10% single-phase + earth
- frequency: 50 Hz ± 1%.

The isolation function is performed by the plug socket through which the machine is connected to the power supply.
The earth circuit must be connected correctly inside the electrical panel, using the appropriate terminal and a cable of suitable cross-section.

All electrical connections must be made by personnel with Qualification 3.

NOTES

A three-pole residual current device with adequate sensitivity to losses must be installed on the input power line, upstream of the machine.

3.6.2. Pneumatic power supply

The system receives a pneumatic supply line from the outside. The requirements are described below:

- Minimum supply pressure of 6 bar
- Line equipped with shut-off valve
- Filtered and dried air
- Hose suitable for pressure and connection used

Connect the compressed air supply hose to the ¼" female connector on the rear wall of the EXTRACTION bench. Use a ¼" male connector for the connection.

Use the pressure regulator to set the supply pressure of the cleaning system tank to 4 bar.

Model	Tank capacity [l]	Compressed air consumption [l] with tank under pressure [bar] per shot				
		4	4.5	5	5.5	6
SBW 12	12	48	54	60	66	72
SBW 24	12	48	54	60	66	72

4. FUNCTIONAL DESCRIPTION

4.1. General description

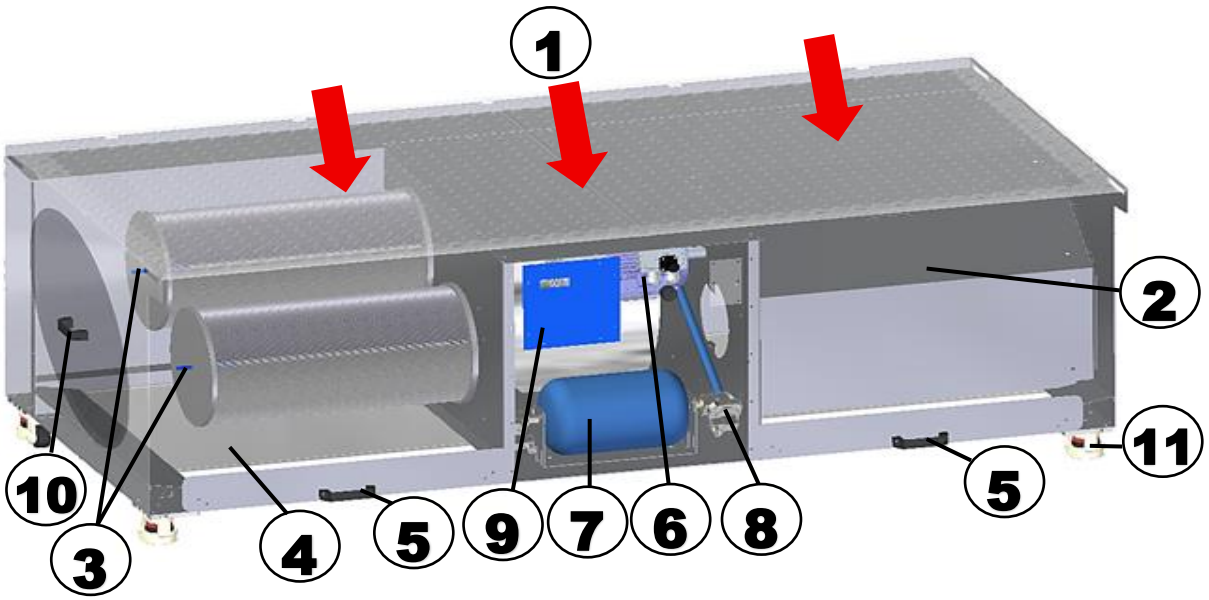
The machine is designed and built for theand filtration of dry dust and fumes resulting from industrial processes of various origins. The system must not be used if the dust contains a high degree of moisture or in operating conditions other than those specified during design. This machine is to be used only and exclusively when the product being treated cannot cause an explosion.

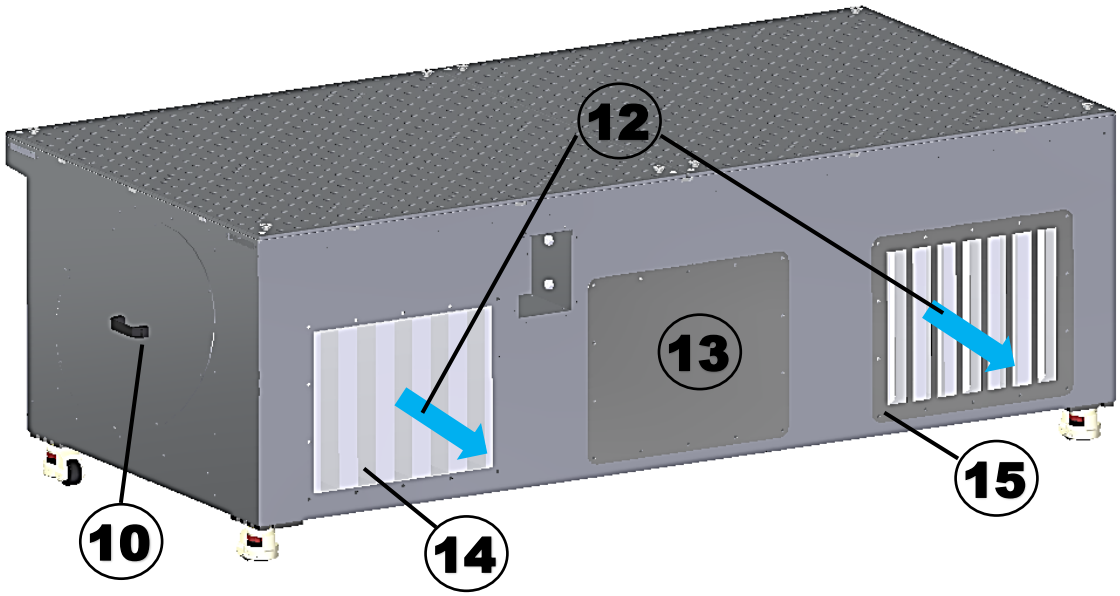
DANGER

The machine must not be used in environments where, during normal operation, an ATEX atmosphere exists or could occur, even for short periods.

4.2. Identification of functional groups

Fig.4.1 on this page and the next page shows the layout of the main functional groups that make up the machine. Each of the identified groups performs its own function within the work cycle described in the following paragraph.
The figure is accompanied by a legend.
A detailed description of the controls is provided in Chapter 5, as part of the system operating instructions, while the location of the safety devices is shown in Chapter 6.





1	Polluted air intake	**6.**	Extractor fan	**11.**	Multifunction levelling castors
2.	Cartridge cover	**7.**	Compressed air tank	**12.**	Filtered air outlet
3.	Filter cartridges	**8.**	Pneumatic cleaning valve	**13.**	Outlet closure panel for ducting
4.	Metal mesh filter	**9.**	Touch screen control display	**14.**	Absolute filter at outlet (accessory)
5.	Slag collection drawers	**10.**	Cartridge replacement door	**15.**	Absolute filter housing (accessory)

Fig.4.1

4.3. Functional description

The SBW extraction bench consists of an extraction unit, a filter unit and an air evacuation section.

The air flow to be purified is conveyed to the filter thanks to the vacuum generated inside the bench by an extractor fan integrated into the structure.

The double-EXTRACTION fan is made of carbon steel and has a squirrel cage impeller made of galvanised sheet metal. The latter is subjected to careful static and dynamic balancing to eliminate vibrations, ensuring a longer life for the motor ball bearings.
The fan is equipped with an electric motor with belt drive.

The polluted air enters (1,Fig.4.1) from the support surface.

The filtering section separates and collects the fine dust present in the air to be purified. It consists of flat metal mesh filters (4), a series of filter cartridges (3) installed inside the structure and secured with screws to the support surface to facilitate disassembly, replacement and maintenance, and compact H13 absolute filters located at the rear of the bench.

Once it has passed through the filter section, the purified air flow passes through the extractor fan (6) and is expelled from the structure through the rear openings (15), which can be equipped with HEPA absolute filters (14) on request.

The pollutant waste is deposited in removable collection drawers (5), located at the bottom of the front wall of the extractor bench and equipped with a special handle.

The pneumatic cartridge cleaning system is located in the central part of the modular structure. Before being fed into the tank, the supply air must be suitably filtered and dehumidified to ensure optimal operation.

The cartridges are cleaned by a jet of compressed air blown directly into them. The system consists of a tested and certified steel tank (7) and diaphragm valves (8) rigidly fixed to the tank.

The cleaning jet is controlled by a touch screen display (9) on the front of the bench.

4.4. Electrical and pneumatic diagrams

The systems fitted to the machine are electrical and pneumatic, and attached to this manual (1, 2 and 3), so that the operator can receive comprehensive training according to their qualification, are all the diagrams relating to the systems in question.

5. INSTRUCTIONS FOR USE

5.1. General

The system interfaces with the user via the control devices located on the machine. Qualification 1 is required for workers who are responsible for using the system during the normal work cycle.
The isolation function is performed by the plug socket through which the machine is connected to the power supply.

5.2. Control and monitoring devices on the machine

Fig.5.1 shows the control devices located on the machine; the controls are described in the associated table.

Fig.5.1

REF. (FIG.5.1)	DESCRIPTION
1	Rotation direction indicator, necessary for checking the correct rotation direction of the motor.
2	Pressure regulator
3	Pressure gauge
4	Touch screen control display (see5.2.1)

5.2.1. Touch screen programming terminal (HMI)

The display on the machine is supplied with factory settings suitable for the product on which it is installed.
By accessing specific functions, it is possible to modify certain parameters; in any case, it is possible to return to the initial settings by selecting "restore factory settings".
The bench is equipped with a multifunction touch screen display complete with ON, OFF and MENU buttons.

When switched on, the main page of the display appears:

The following buttons are available on the operating screen of the display:

	**ON button to switch on the fan**
	**OFF button to switch off the fan**
	**MENU button to open the menu.**

In addition, the following data can be displayed:

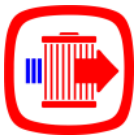
Clogging [Pa]:	Indicates the current clogging status of the filters by providing ΔP in Pascal.
Cleaning with economiser	Indicates the operating mode of the pneumatic cleaning of the cartridges.
Cleaning start [Pa]:	Indicates the ΔP value at which pneumatic cleaning begins.
End of cleaning [Pa]:	Indicates the ΔP value at which pneumatic cleaning ends.
Next valve:	Indicates the time remaining until the pneumatic cleaning valve opens.

Pressing the '  ' button opens another drop-down menu displaying the functions that can be interacted with.
Depending on the machine on which the display is installed, some of these items may not be available.
The arrows shown on the display are used to change the screen displayed.

List of functions:

Timer settings	Function to be used if "Cleaning with Timer" is set in "Operation Selection". Time interval (seconds) between valve openings for cleaning. Use the + and – keys to adjust the value.
Economiser settings	Function to be used if "Cleaning with Economiser" is set in "Operation Selection". Time interval (seconds) between valve openings for cleaning. Use the + and – keys to adjust the value. Pressure value (Pa) at the start of cleaning. Use the + and – keys to adjust the value. Pressure value (Pa) at the end of cleaning. Use the + and – keys to adjust the value.
Clogging settings	Hours until maintenance. Press the reset key to reset the working hours counter.
	Filter check (Pa). Use the + and – keys to adjust the value
	Filter change (Pa). Use the + and – keys to adjust the value
Post-cleaning settings Automatic cleaning when the fan is switched off	Function to be used if "Post Cleaning" has been selected in "Operation Selection" Time interval (seconds) between valve opening for cleaning when the fan is switched off. Use the + and – keys to adjust the value. Number of cartridge cleaning cycles in post cleaning. Use the + and – keys to adjust the value.
Zero Pa calibration	To be used with the extractor switched off and with new filters. Selecting this item displays the "OK" button. Pressing it resets the pressure reading value.
Operation selection	In this field, you can select the pneumatic cleaning method: ○ "Programme without cleaning". The pneumatic cleaning system is deactivated. It is not possible to set post-cleaning. ○ "Cleaning with Timer". The pneumatic cleaning system is controlled by a timer. ○ "Cleaning with economiser". The pneumatic cleaning system is managed by filter clogging pressure values. ○ "Cleaning Deactivated". The pneumatic cleaning system is deactivated. Post-cleaning can be set. ○ "Post-cleaning". Ticking the box activates the post-cleaning function (cleaning when the fan is switched off).
Language	By selecting this item, you can choose the language of the text.
Restore factory settings	Selecting this item displays two buttons for choosing factory reset.
Technical Settings	Not applicable.
Firmware version	Displays the firmware version.

Finally, the display shows the following control indicators:

	Check the filters. Check the integrity of the filters and their cleanliness. Remove any dust accumulation with a vacuum cleaner, taking care not to damage the fabric.	Cartridges
	Change the filters. Replace the filters.	Cartridges
	Overall filter check, from the structure to the filters. Check the integrity of the filters in the machine and their fastenings. Reset the maintenance hour counter.	Bench
	Motor failure. Tripped differential switch or blown fuse. The reasons could be as follows: - Burnt-out electric motor; - Power surge at the bench input; - Fan rotating in reverse. Action: - Disconnect the bench from the power supply; - Unscrew the display panel (fig. 5.1 - 4) from the structure; - Gently pull out the display, taking care not to strain the cables, and reset the residual current device; - Screw the display panel back onto the structure (we recommend screwing only four bolts at the corners); - Connect the bench to the power supply. - Turn on the machine using the start button, leave it on for a few seconds and check, through the appropriate window, that the direction of rotation of the electric motor or electric fan matches that indicated by the arrow on the appropriate display; If it is rotating in the opposite direction, reverse two power phases and try again. If the differential switch trips as soon as you press ON, the electric motor of the fan may have burned out (short circuit).	Motor

5.3. Description of operating mode

The system operates automatically. The machine performs its work in a continuous cycle when started by the operator using the appropriate button on the machine.

5.4. Operating procedures

This section describes the operating procedures for using the system.

5.4.1. Start-up and preliminary checks

Switch on the system, following the steps described below:

- check that the pneumatic power supply is correctly connected;
- check that the machine is correctly connected to the power supply using the appropriate plug;
- check that the ejection line is correctly connected.

CAUTION

Carefully check that the EXTRACTION points connected to the machine are open, free of foreign objects and unable to suck up anything not intended for the machine. Improper use may cause damage to the purifier and will also result in the immediate termination of the warranty.

5.4.2. Start-up procedure

After performing the machine start-up procedures and preliminary checks, it is necessary to:

- Press the ' 

' button to turn on the fan.

DANGER

It is strictly forbidden to start the machine with one or more cartridges removed.

NOTES

When starting the machine, check the direction of rotation of the fan (see par. 5.4.5.)

5.4.3. Procedure for use

The factory settings of the bench are set to the "Economiser" function for cleaning the cartridges.

When the set cleaning start value is reached, the pneumatic cartridge cleaning system is activated until the cleaning end value is reached.
At the end of the process, a post-cleaning cycle will be performed to clean the cartridges with the fan turned off.

NOTES

It is important to ensure that the workbench is supplied with electricity and compressed air at the end of the processing cycles to ensure post-cleaning.

WARNING

Failure to perform the cleaning cycles will cause premature deterioration of the cartridges' filtering capacity, resulting in an increase in maintenance operations.

5.4.4. Shutdown procedures

During automatic mode operation, the system can be shut down in several ways, as described below.

STOPPING DURING OPERATION

Press the " 

" button to switch off the fan.

END OF WORK SHIFT

To shut down at the end of the work shift, with the machine already stopped, unplug the power cord from the power outlet.

NOTES

Do not disconnect the bench from the power supply until post-cleaning (if set) is complete.

5.4.5. Check direction of rotation

To perform the following check, proceed as described below:

1. Switch on the machine using the start button and check, via the appropriate window (1,Fig.5.1), that the direction of rotation of the electric motor or electric fan matches that indicated by the arrow on the appropriate display;
2. Switch off the machine using the stop button;
3. If rotation is in the opposite direction, reverse two power phases and try again.

6. SAFETY INFORMATION

6.1. General information

The machine has been designed and manufactured in accordance with European Directives, with reference to harmonised safety standards. Where possible, hazards have been eliminated during the design phase. For those that could not be eliminated, fixed and/or interlocked guards have been installed in accordance with regulatory requirements. Qualified personnel working on the machine must always comply with the requirements of this manual and the instructions received. Should situations arise due to unexpected and/or unforeseeable use, it is advisable to contact the Secureair® by Gamma Impianti™ S.R.L. Service Department before proceeding with any further activity.

DANGER

The use of control devices in a manner that does not comply with the provisions of chapter 5 or their replacement with non-original components or components that do not comply with regulatory requirements will release Secureair® by Gamma Impianti™ S.R.L. from any liability regarding their operation.

DANGER

The introduction of new control devices must be authorised by Secureair® by Gamma Impianti™ S.R.L.. in order to ensure that they do not create dangerous situations for the operator or user.

6.2. Protective devices

All machine movements are separated by protective panels:

— fixed guards: fixed guards are all guards fixed to the machine by means of screws, locks or other fastening systems, for which a tool is required for opening and removal.

DANGER

It is strictly forbidden to replace the guards with non-original parts. It is also forbidden to tamper with the guards or to work with the guards removed. Secureair® by Gamma Impianti™ S.R.L. declines all responsibility for damage caused by alterations to the safety systems.

6.3. Safety devices

The machine is equipped with two types of stop devices:

1) Normal stop, using the ON/OFF  button. This command stops the machine as

described in chapter 5 and maintains power to the actuators.

2) End-of-shift stop (category 0 - EN 60204-1), represented by the plug socket.

The choice of stop mode must follow the criteria set out in chapter 5 regarding the machine's control devices.

NOTES

Given the simplicity of the machine, the plug socket is also used as an emergency stop.

DANGER

The use of control devices that do not comply with the provisions of chapter 5 or their replacement with non-original components or components that do not comply with regulatory requirements will Secureair® by Gamma Impianti™ S.R.L. from any liability regarding their operation.

DANGER

The introduction of new control devices must be authorised by Secureair® by Gamma Impianti™ S.R.L. in order to ensure that they do not create dangerous situations for the operator or user.

6.4. Personal protective equipment

With regard to operations strictly related to the operation of the machine, the operator is not required to use personal protective equipment, with the exception of a mask during filter cleaning operations.

6.5. Residual risks

The purpose of this section is to highlight the residual risks associated with the activities described in this manual concerning the operation and maintenance of the machine.
The situations that present residual risks for the operator are as follows:

- there may be a risk of contact with live parts inside the electrical panel, even when the machine is stopped, due to possible electrostatic charges; for this reason, the maintenance technician MUST wait at least 1 minute after the power supply has been interrupted before accessing the electrical panel;
- there may be a risk of inhaling dust that is potentially harmful to the operator's health (depending on the type of fumes extracted) during filter cleaning operations; the use of a suitable mask is required (the choice of mask is the responsibility of the user, based on the products being processed);
- there may be a risk of fire caused by dust in the drawers. Clean the collection drawers thoroughly at the end of each work shift and/or when the fan is switched off.

DANGER

Responsibility for incorrect use, whether foreseeable or unforeseeable, shall lie solely with the operators who performed the operations, excluding Secureair® by Gamma Impianti™ S.R.L.

6.5.1. Pictograms on the machine

This section lists the meanings of the pictograms on the machine. Their use provides quick and clear information necessary for the correct and safe use of the machine.

	Check the filters.		Danger: Electrical voltage.
	Change the filters.		Caution: machine with automatic start-up.
	Maintenance required.		General hazard
	Engine failure.		Fire hazard
	No entry.		Danger: read instruction manual.
	Do not disconnect the power supply.		Hand protection.
	No smoking or use of naked flames.		Wearing a protective mask is mandatory during maintenance operations, filter replacement and drawer emptying.

7. ADJUSTMENTS AND FORMAT CHANGES

7.1. General information

The WELDING TABLE WITH INTEGRATED CARTRIDGE EXTRACTION AND PNEUMATIC CLEANING is designed and manufactured for the extraction and filtration of dry dust and fumes from various industrial processes. The system must not be used if the dust contains a high degree of moisture or in operating conditions other than those specified during design.
No format change operations are provided for.

8. MAINTENANCE INSTRUCTIONS

8.1. General information

This chapter aims to illustrate the maintenance operations to be carried out on the machine. Maintenance operations are divided into two types: routine and extraordinary.
Routine maintenance refers to all operations necessary to keep the machine in perfect working order, which can be scheduled on a time basis. Extraordinary maintenance refers to all operations that may be necessary to restore the normal functioning of the machine following breakdowns and/or malfunctions. The operator authorised to perform the activities described below must have Qualification 2. For each operation, a single qualified operator is required, who must work with the machine disconnected from the power supply.

8.2. Preliminary safety information

Below are some safety recommendations for maintenance operations, which must be strictly followed by the operator.

DANGER

Before any maintenance work, the machine must be disconnected from the power supply.

DANGER

Before carrying out any maintenance inside the electrical panel, disconnect the machine from the power supply and wait at least 1 minute before proceeding, so that any residual energy inside the circuits can dissipate.

DANGER

All maintenance work must be carried out by qualified personnel who have carefully read the information in this manual so that they are aware of the specific residual risks associated with the machine.

8.3. Routine maintenance

Keeping the machine in perfect working order requires carrying out the maintenance operations scheduled by the manufacturer based on the expected operating hours of the machine. Compliance with the maintenance schedule below reduces the possibility of breakdowns, malfunctions, or failures. The scheduled maintenance operations are illustrated in the table below, which describes the type of operation, the frequency with which it must be carried out and the paragraph where the relevant procedure is described.

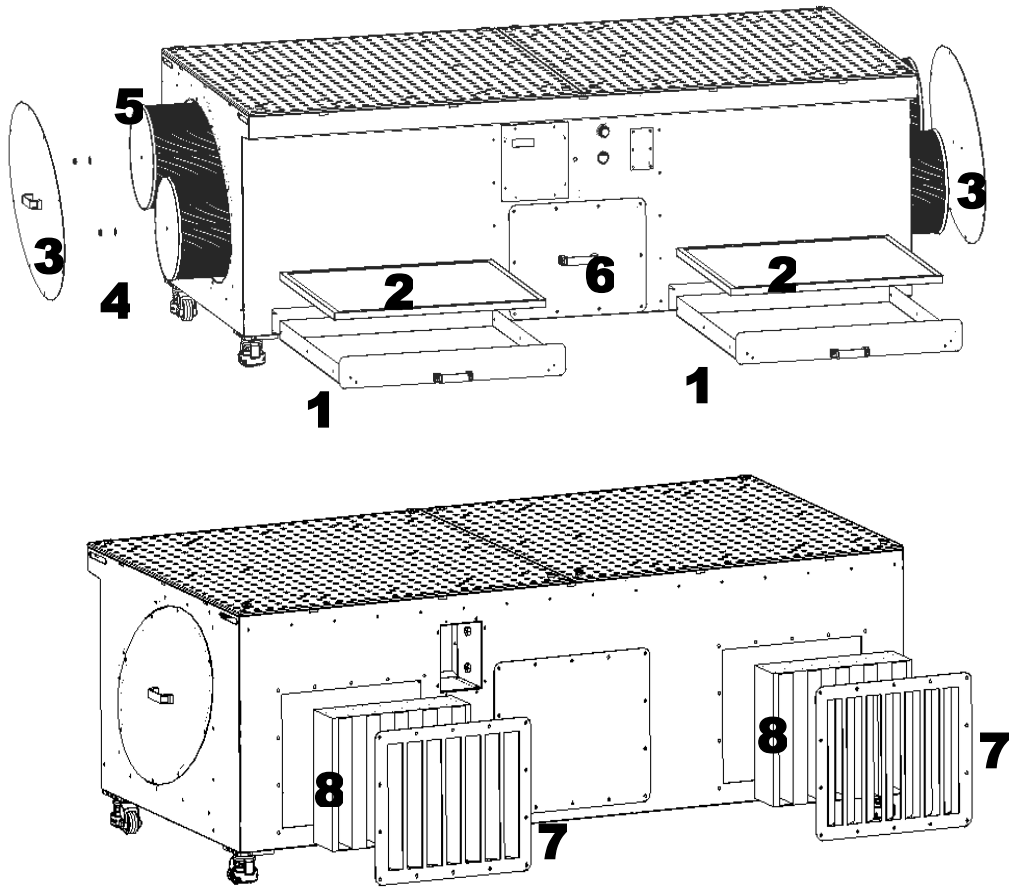


Fig.8.1

Frequency	Description of intervention	Paragraph
Daily	— Machine cleaning.	8.3.1
Every work shift and/or when the fan is switched off	— Empty waste collection drawers and clean pre-filters (1-2,Fig.8.1).	-
See specific paragraph	— Check, replace filter elements and perform periodic maintenance (5-8,Fig.8.1).	8.3.2
Monthly	— Check tightness of screws and bearings on shaft (6).	-
Quarterly	— Belt tensioning (6).	8.3.4
Half-yearly	— Lubrication of bearings (6).	8.3.3

CAUTION

After installation, the fan unit must be monitored for at least two hours after it starts operating. Ensure that there are no vibrations or abnormal noises and that the voltage and current consumption values are correct and in any case do not exceed the values indicated on the motor nameplate. If necessary, retighten the belts to compensate for initial elongation.

WARNING

Failure to perform maintenance or failure to perform it within the above-mentioned time frames, as well as the use of non-original spare parts, may have serious consequences on the life and functionality of the machine. In such cases, the Manufacturer shall not be liable for any damage to the machine.

8.3.1. Machine cleaning

Thoroughly clean the entire exterior of the machine and the work area using a vacuum cleaner or soft, dry cloths or cloths slightly dampened with alcohol or a mild, non-foaming detergent solution.

CAUTION

For cleaning the outside of the machine, use only alcohol or non-foaming detergents that are not aggressive on plastic and painted parts.

Thoroughly clean the entire area inside the guards, removing dust and any residues.

8.3.2. Checking, replacing filter elements and periodic maintenance

The control display provides information on the status of the filter elements.

DANGER

When cleaning the filters, it is mandatory to wear a suitable mask (the choice of mask is the responsibility of the user, based on the products being treated).

CAUTION

Before checking and replacing the filters, perform a complete post-cleaning cycle.
Periodic maintenance must be carried out according to the following table

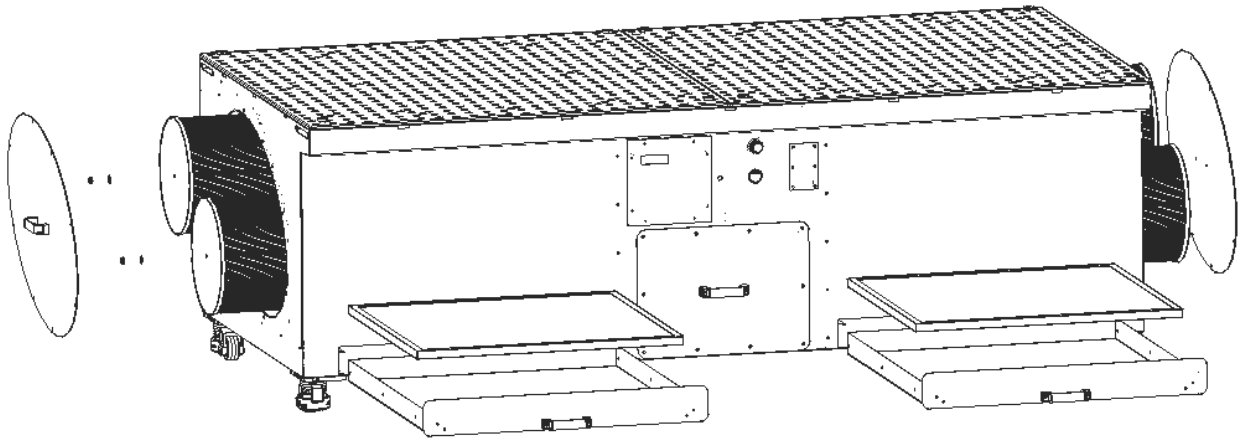
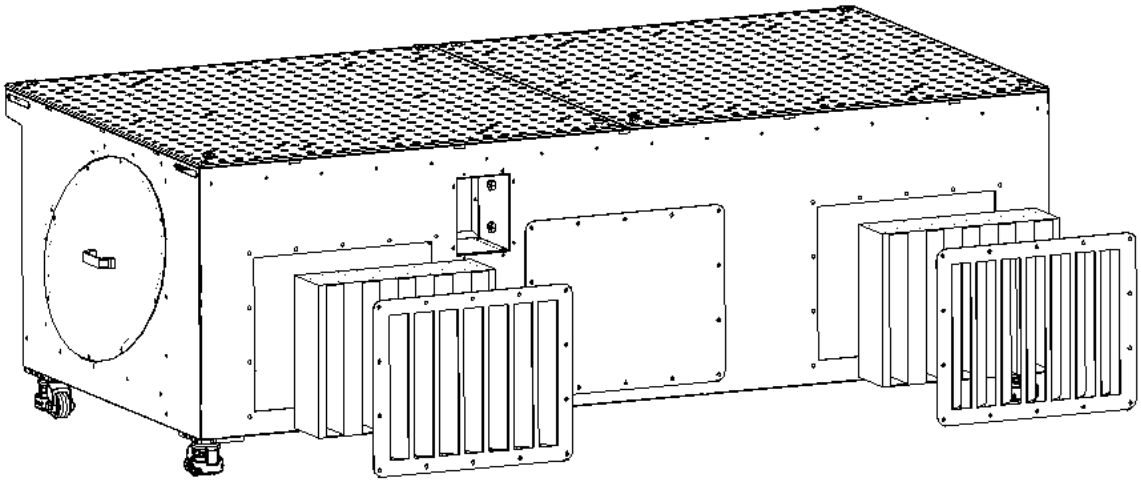
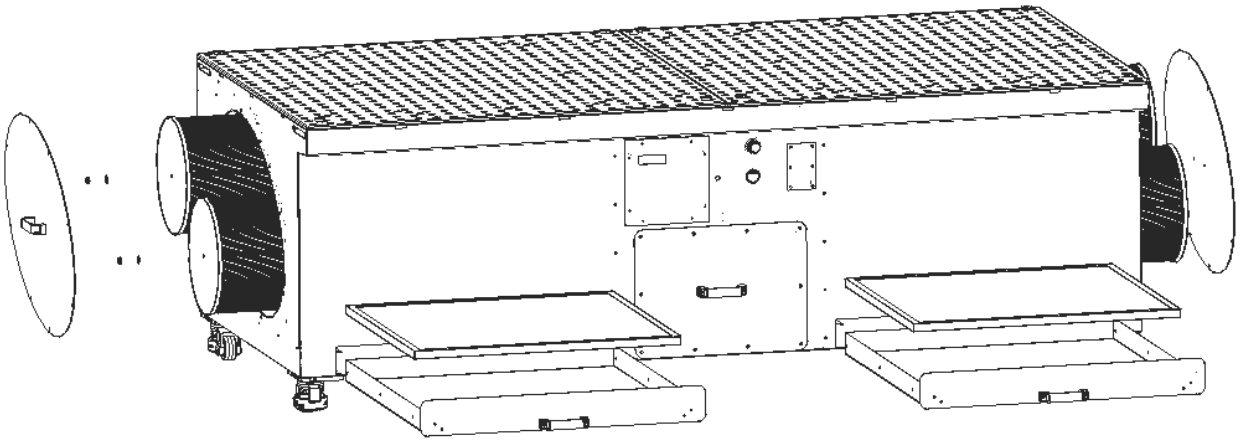
Period [hours]	Type of operation	Element
8	With the fan switched off but the compressed air supply open, perform post-cleaning cycles.	Cartridges
80	Cleaning of metal filters. Pull out the drawers (1,  	Metal mesh

Fig.8.2) and remove the metal pre-filter (2,



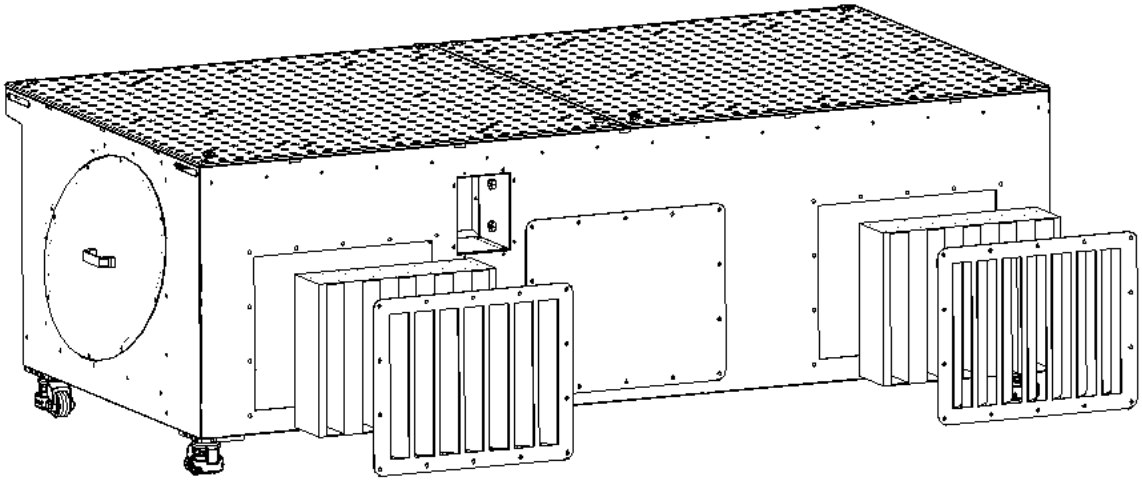
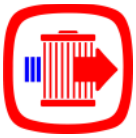


Fig.8.2). Check that they are intact and, if damaged, replace the filters; otherwise, clean the pre-filters by blowing them with compressed air. Place the pre-filters in the drawer and reinsert the drawers into the bench.

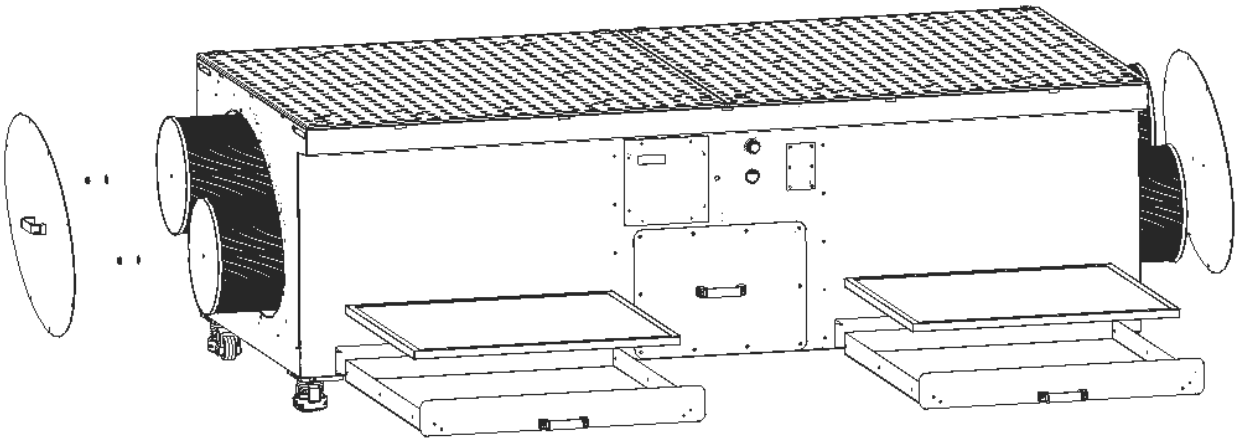
When performing maintenance on filter elements, check that no images indicating filter control or clogging appear on the display:

	Check the filters. Check the integrity of the filters and their cleanliness. Remove any dust accumulation with a vacuum cleaner, taking care not to damage the fabric.	Cartridges
	Change the filters. Replace the filters	Cartridges
	Overall check of the filter, from the structure to the filters. Check the integrity of the filters in the machine and how they are secured. Check the lubrication of the fan bearings and the tension of the drive belt.	Bench

	Reset the maintenance hour counter.	

To replace the filter cartridges correctly, proceed as follows:

- Disconnect the pneumatic supply;
- Perform pneumatic cleaning strokes to empty the compressed air tank;
- Disconnect the machine from the power supply;
- Pull out the drawers (1,



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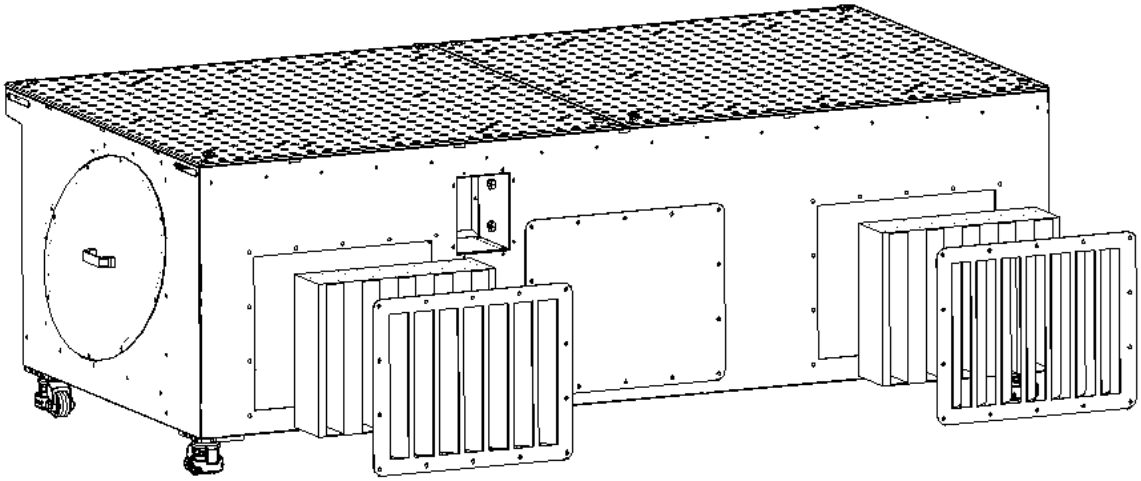


-
- Fig.8.2) and remove the metal pre-filter (2);
- Check the integrity of the metal pre-filters and, if damaged, replace the filters or clean them by blowing with compressed air;
- Unscrew the side doors to access the cartridges (3);
- Unscrew and remove the nut and washer (4) screwed onto the pin that protrudes centrally from the bottom of the cartridge (5) and pull the cartridge (5) outwards;

To change HEPA filters, if required:

- Unscrew the rear doors (7) to access the absolute flat filters (8).
- Remove the absolute flat filters (8).

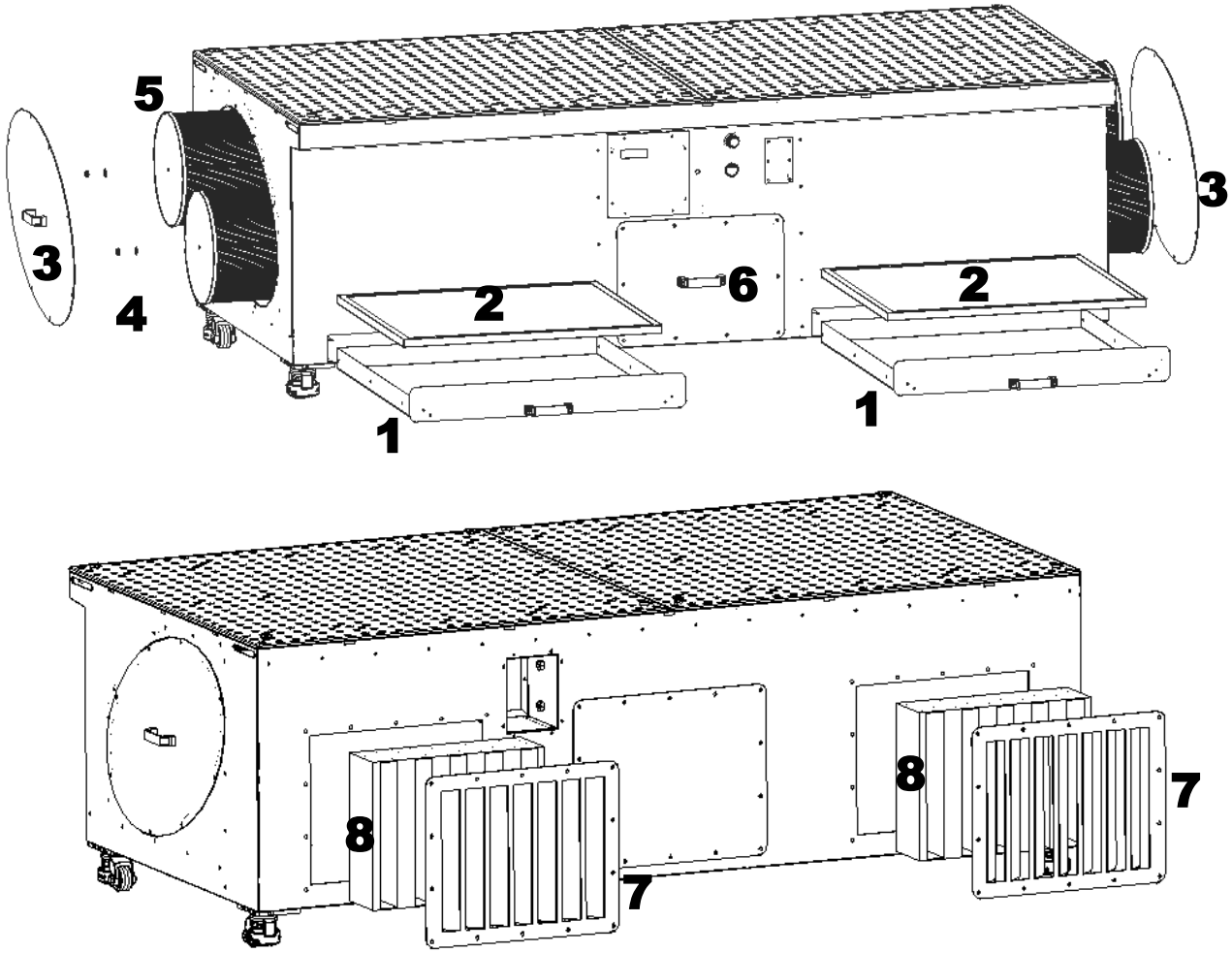


Fig.8.2

WARNING

The type of cartridges must comply with the characteristics specified for the specific version of the machine. The use of cartridges with different characteristics may result in hazards not attributable to the machine. Secureair® by Gamma Impianti™ S.R.L. shall not be liable for damage caused to persons, property or the machine itself in this event.

To install new filter cartridges correctly, proceed as follows:

- Insert the filter cartridge (5) into the side compartment, taking care to insert the threaded pin correctly into the central hole on the bottom of the cartridge, pushing it until it is fully inserted;
- Check that the cartridge is correctly positioned in relation to the fixing surface and the threaded pin;
- Insert the washer and tighten the locking nut (4) of the cartridges;

— Screw on the side doors for access to the cartridges (3);

To insert new HEPA filters, if required:
— Insert flat absolute filters (8).
— Screw on the rear doors (7).
— Fit the pre-filters (2) in the drawers after cleaning or replacing them thoroughly and reinsert the drawers (1) into the bench;
— Reconnect the machine to the power supply;
— The machine is ready to restart.

8.3.3. Lubrication of bearings

Maintenance work must be carried out by personnel with Qualification 2 or 3. In any case, this work must be carried out with the machine disconnected from all power sources.
All work on the bearings must be carried out using suitable tools.
Access the motor by removing the welding plate (1,Fig.8.3) and unscrewing the fixed guard (2,Fig.8.3). Lubricate the bearings with general-purpose grease for this type of component.

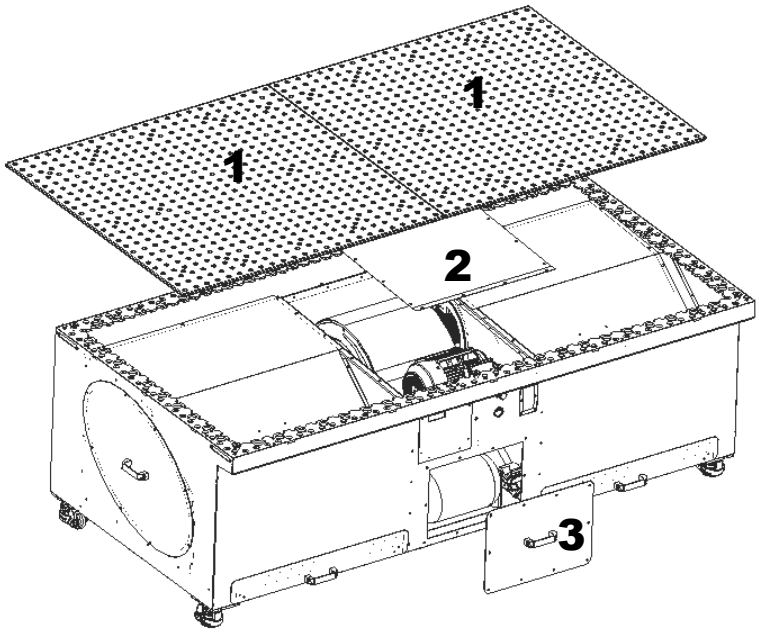


Fig.8.3

8.3.4. Belt tensioning

Maintenance work must be carried out by personnel with Qualification 2 or 3. In any case, this work must be carried out with the machine disconnected from all power sources.

The belt tension can be checked by removing the front cover (3,Fig.8.3).
Access the motor by removing the worktop (1,Fig.8.3), unscrewing the fixed guard (4) and proceeding as follows:

- Check that the belts are correctly tensioned and in good condition; replace them if they are frayed.
- Check that the pulley grooves are clean.

Problems caused by insufficient belt tension:

- Belt slippage resulting in rapid wear due to the belt rubbing against the pulley grooves
- Noise due to rubbing.
- Increased vibrations.
- Abnormal loads on components.

Problems caused by excessive belt tension:

- Excessive loads on bearings and on the fan and motor shaft, resulting in a reduction in their useful life.
- Increased vibrations.
- Abnormal loads on components.

8.4. Defects and failures

There is a wide range of faults that can occur during the operation of the machine or its components. The most common faults are discussed below, indicating their probable causes and related corrective actions.
If, despite the suggested actions, the anomaly persists, we recommend contacting Secureair® by Gamma Impianti™ S.R.L., indicating the defect and the operating conditions of the machine. For troubleshooting and eliminating defects, see the table below.

Fault	Causes	Solution
Machine shuts down	No power supply	Check the connection to the power supply
	Power failure due to tripped circuit breaker or blown fuse.	Reset the circuit breaker. Replace the fuse. If the problem persists, contact the technical department
	Disconnected cable	Contact the authorised technical department.
Insufficient EXTRACTION	Exhaust grille blocked	Remove the obstruction
	Clogged pre-filters or filters	Check the cleanliness and integrity of the pre-filters.
		Check the cleaning system is working properly. Replace filters
		Check that the material being vacuumed is the type for which the filter was designed
	Vacuum cleaner running in the wrong direction	Check (see section5.4.5)
	Exhaust line blocked.	Remove the obstruction
The motor does not start	Electrical panel not powered	Power the electrical panel
	Internal cable to electrical panel disconnected.	Contact authorised technical office
	Motor burnt out.	Contact authorised technical office

The panel is powered but the extractor fan is not working	Internal cable to electrical panel disconnected	Contact an authorised technical office
	Burnt-out electric motor	Contact authorised technical office
The display shows  **Motor failure**	Electric motor burned out	Contact authorised technical office
	Differential switch tripped or fuse blown. Power surge at the bench input	Disconnect the bench from the power supply; Unscrew the display panel (fig. 5.1 - 4) from the structure; Gently pull out the display, taking care not to strain the cables, and reset the residual current device or replace the fuse; Screw the display panel back onto the structure (we recommend screwing only four bolts at the corners); Connect the bench to the power supply. Switch on the machine using the start button and check.
	Fan rotating in reverse (400V version only).	Disconnect the bench from the power supply; Unscrew the display panel (fig. 5.1 - 4) from the structure; Gently pull out the display, taking care not to strain the cables, and reset the residual current device; Reverse two power supply phases Screw the display panel back onto the structure (we recommend screwing only four bolts at the corners); Connect the bench to the power supply. Switch on the machine using the start button and check.
Cleaning system not working	No pneumatic power supply	Connect compressed air regulated to 4 bar
	Compressed air is 'wet'	Insert filter and compressed air dryer
Increased fan vibration or noise	Belt not tensioned	Adjust or replace the belt
	Belt misaligned	Realign the pulleys and adjust the belt
	Damaged bearings	Replace the bearings
	Miscellaneous	Contact authorised technical office
Dust or slag coming out of the exhaust	Damaged filters	Replace filters
	EXTRACTION capacity not adequate for the pollutant	Contact an authorised technical office

8.5. Extraordinary maintenance

Extraordinary or unscheduled maintenance includes all operations aimed at replacing faulty components. If replacing or procuring a component proves difficult, please contact the Secureair® by Gamma Impianti™ S.R.L. Customer Service Department for information.

WARNING

The use of non-original or non-specific spare parts may result in hazards not attributable to the machine, as it alters its original configuration. Secureair® by Gamma Impianti™ S.R.L. shall not be liable for damage caused to persons, property or the machine itself in this event.

Extraordinary maintenance must be carried out by personnel with Qualification 2 or 3. In any case, such maintenance must be carried out with the machine disconnected from all power sources.

9. DISMANTLING AND DISPOSAL

9.1. Removal of connections and preparation for handling

Before moving the machine, the following operations must be carried out:

- disconnect the external power cables from the machine;
- disconnect the external pneumatic supply hose from the machine;
- disconnect elements attached to the air ejection section of the bench.

Packaging (see chapter 3) is required if long-distance transport is involved that could pose a risk to the integrity of the machine.

The machine can be lifted using the procedures described in chapter 3 of the manual. Detailed instructions on the procedures to be followed for handling are provided in chapter 3.

9.2. Disposal of the machine

The machine must be decommissioned by disposing of it as waste characterised by mechanical components made of steel, aluminium and copper alloys and electrical and electronic components that require disposal through specialised companies, in accordance with the provisions in force in the user's country.

It is recommended that materials be sorted to facilitate storage or recovery processes.

Rubber components must be disposed of separately from the above, in accordance with the regulations in force in the user's country; the same applies to all electronic components (PC, keyboard, mouse, monitor, etc.).

10. ATTACHMENTS

10.1. List of attachments

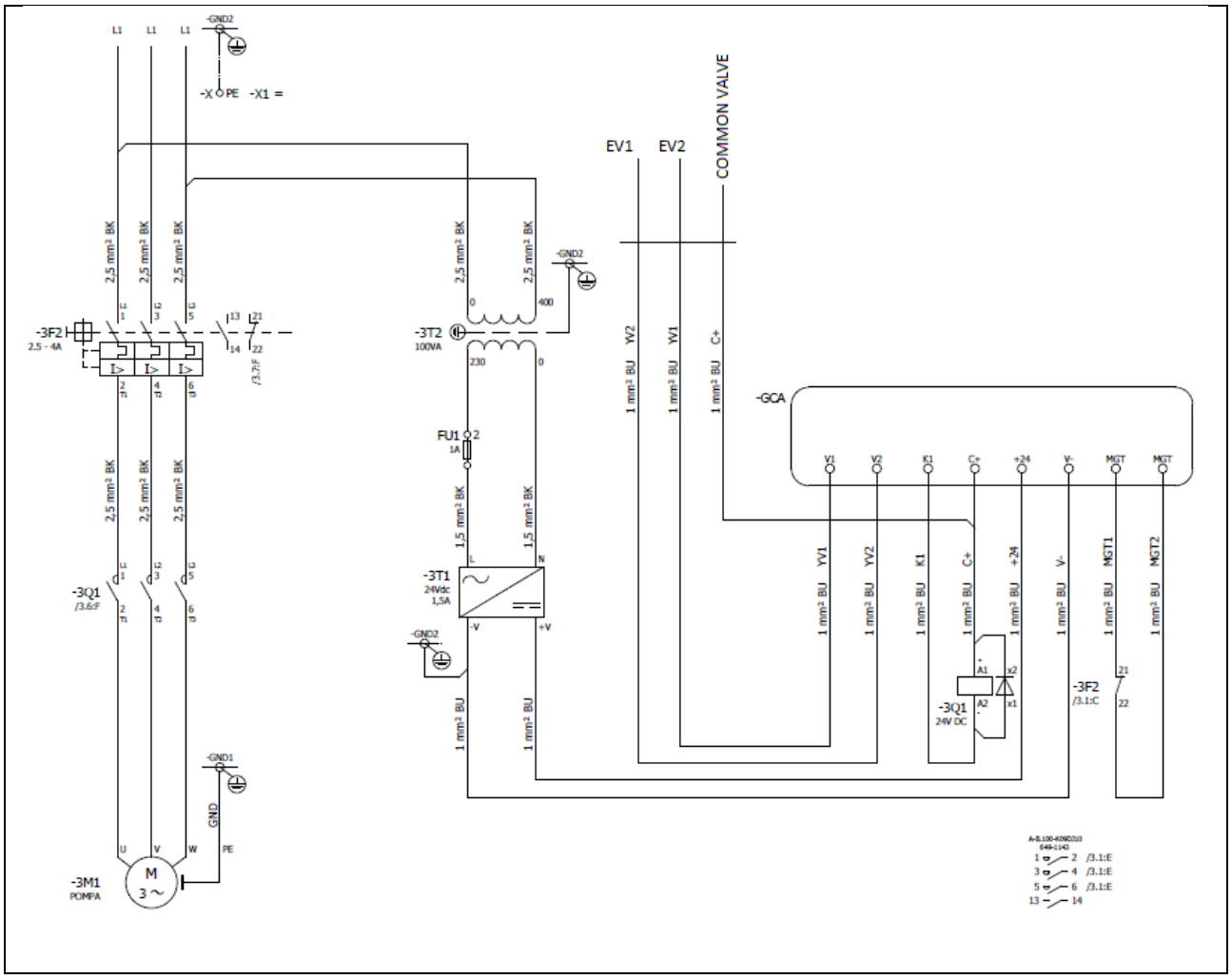
The User and Maintenance Manual for the PNEUMATIC CLEANING CARTRIDGE EXTRACTION BENCH is supplemented by attachments that are shown separately due to the customisations made.

The list below shows the list of attachments:

- annex 1 and 2: electrical diagrams;
- annex 3: pneumatic diagrams;
- annex 4: spare parts;
- annex 5: Siegmund welding table assembly instructions
- declaration of conformity;

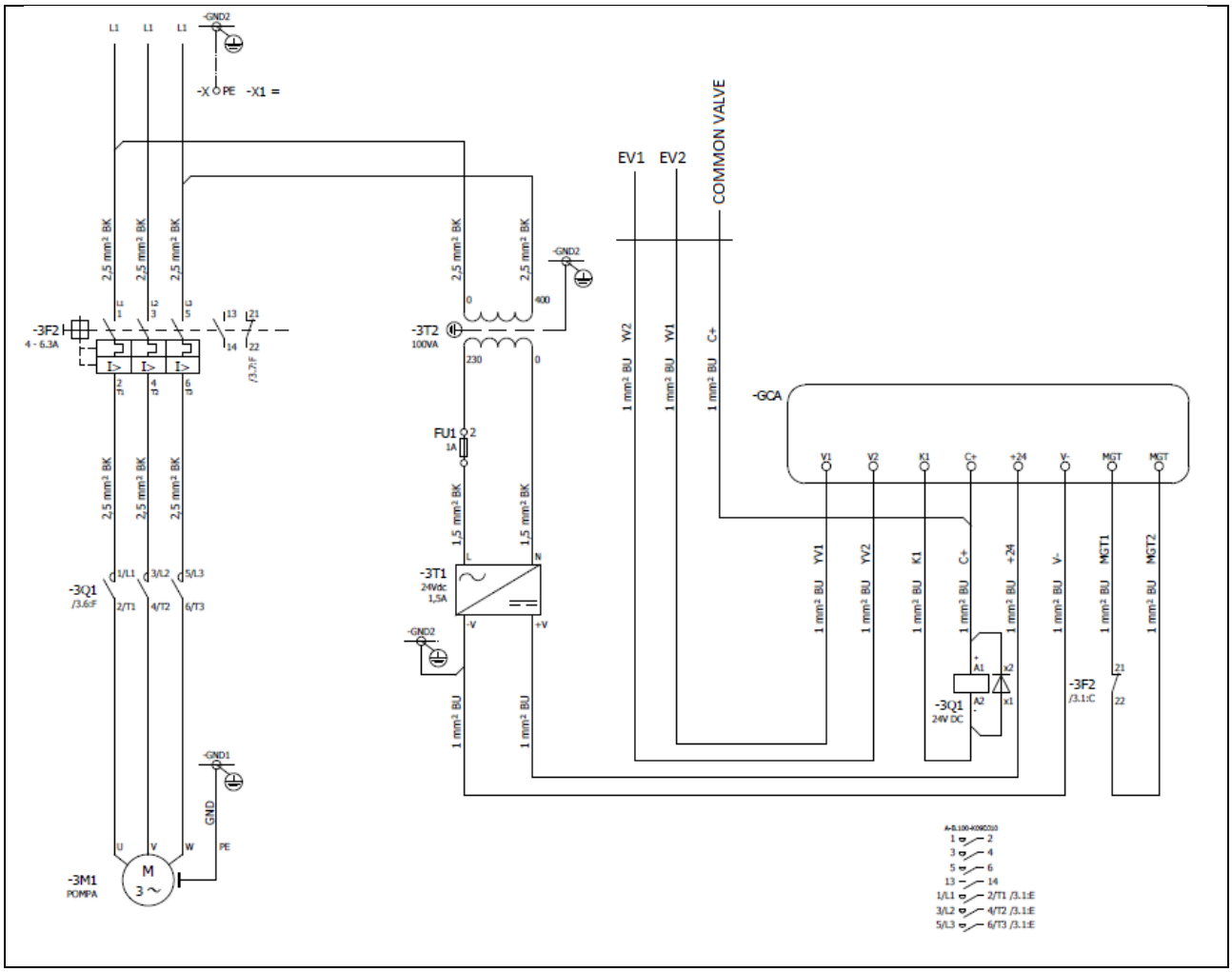
Annex 1 – SBW 12 electrical diagram

1.5kW electrical panel – IEC 81346-2 standard – Drawing No. 811255_0 dated 26/07/2022



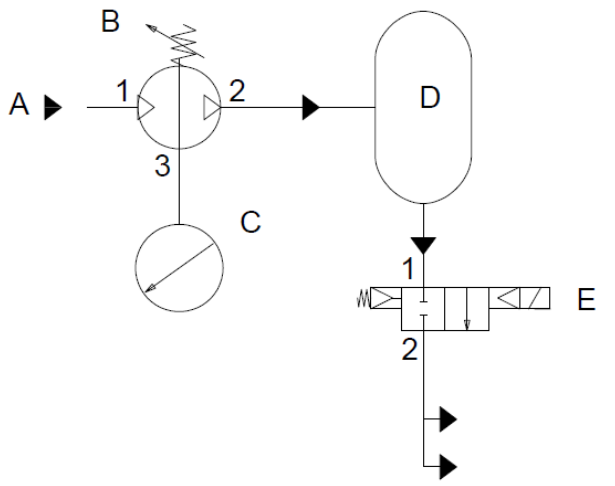
Annex 2 – SBW 24 wiring diagram

3kW electrical panel – IEC 81346-2 standard – Drawing no. 811256_0 dated 26/07/2022



Annex 3 – Pneumatic diagram

DBW 12 pneumatic diagram



Key

A= 1/4” female air inlet wall bushing

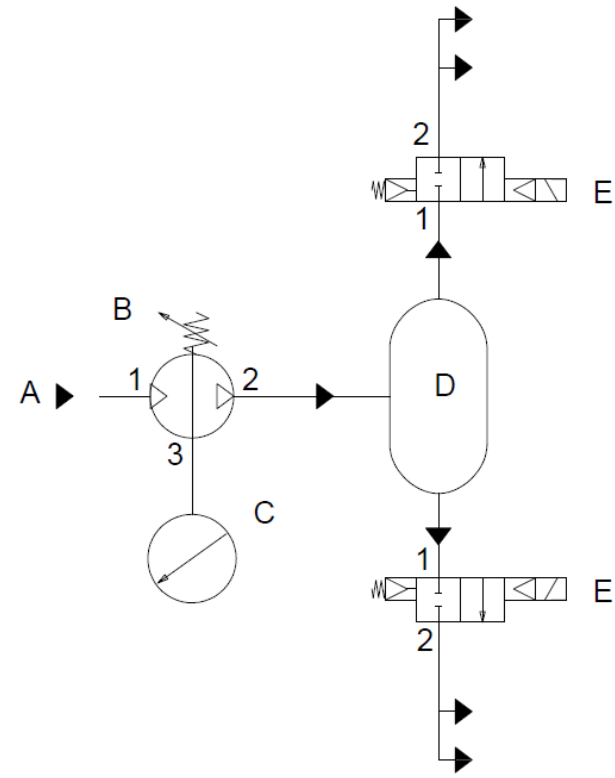
B= 1/4” pressure regulator

C= DN40 1/8” pressure gauge

D= 7-litre tank

E= 3/4" 24VDC diaphragm solenoid valve

SBW 24 pneumatic diagram



Key

A= 1/4” female air inlet wall bushing

B= 1/4" pressure regulator

C= DN40 1/8" pressure gauge

D= 7-litre tank

E= 3/4" 24VDC diaphragm solenoid valve

Annex 4 – SBW bench spare parts

	Aspirator	
Model	**Description**	**Code**
SBW 12 **SBW 24**	AT 15/11 EXTRACTOR WITH FRAME, WITHOUT MOTOR OR TRANSMISSION	AT1511.00000000000ST-00

	Electric motor	
Mod	**Description**	**Code**
SBW 12	THREE-PHASE MOTOR 1.5 KW 230/400V 50HZ- 4 POLES - B3	MOT.T0154PB3ST-00
	SINGLE-PHASE MOTOR 1.5 KW 220V 50HZ- 4 POLES - B3	MOT.M0154PB3ST-00
SBW 24	THREE-PHASE MOTOR 3 KW 230/400V 50 HZ - 4 POLES - B3	MOT.T0304PB3ST-00

	Display (control panel)	
Mod.	**Description**	**Code**
SBW 12	THREE-PHASE DISPLAY 1.1/1.5 KW	ELE.DIS015T-00
	SINGLE-PHASE DISPLAY 1.1-1.5 KW 220V	ELE.DIS011M-00
SBW 24	THREE-PHASE DISPLAY 2.2/3 KW	ELE.DIS030T-00

Cleaning		
Mod.	**Description**	**Code**
SBW 12	No. 1 ¾" VDC solenoid valves	SER.VTF3/4P-00
	No. 1 D.22 blower tube for BC	AC.RIL.B22-01
	Compressed air tank	SER.T12LV00.0-00
SBW 24	No. 2 ¾" VDC solenoid valves	SER.VTF3/4P-00
	No. 2 D.22 blower pipe for BC	AC.RIL.B22-01
	Compressed air tank	SER.T12LV00.0-00

Metal filter		
Mod.	**Description**	**Code**
SBW 12	No. 1 metal filter 678 x 600 x 23 mm	FILPMM23SP0678X0600-00
SBW 24	No. 2 metal filter 490 x 592 x 23 mm No.2 metal filter 287 x 592 x 23 mm	FILPMM23SP0490X0592-00 FILPMM23SP0287X0592-00

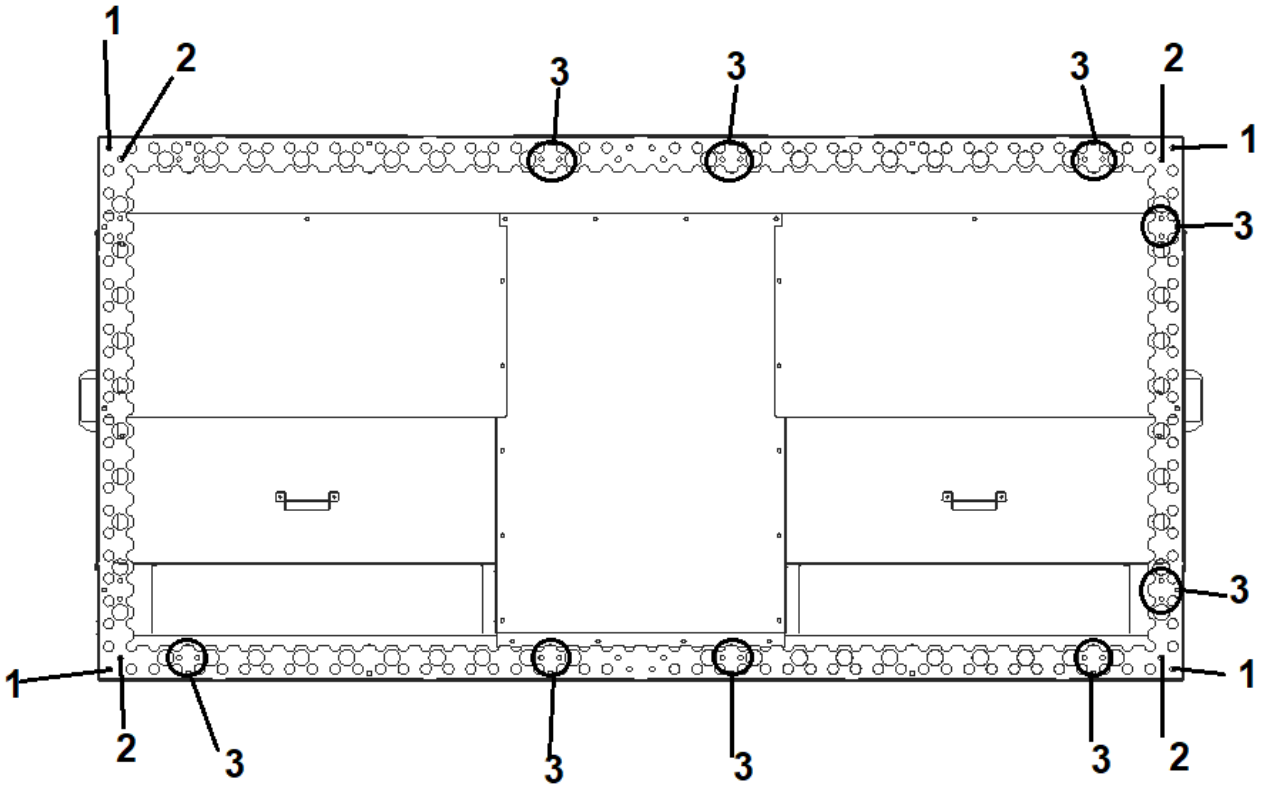
Cartridges		
Mod.	**Description**	**Code**
SBW 12	No. 2 cartridges Ø325 mm, h.600 mm	Based on the fabric chosen Page 14
SBW 24	No. 4 cartridges Ø325 mm, h.1000 mm	Depending on the fabric chosen Page 14

Transmission ratio		
Mod.	**Description**	**Code**
SBW 24	BC15 PLUS transmission ratio kit consisting of bushings, pulleys and transmission belt	TR.KIT.BC15PLUS-00
SBW 24	BC30 PLUS transmission ratio kit consisting of bushings, pulleys and transmission belt	TR.KIT.BC30PLUS-00

Siegmund welding plan
Read paragraph 2.2 of this manual

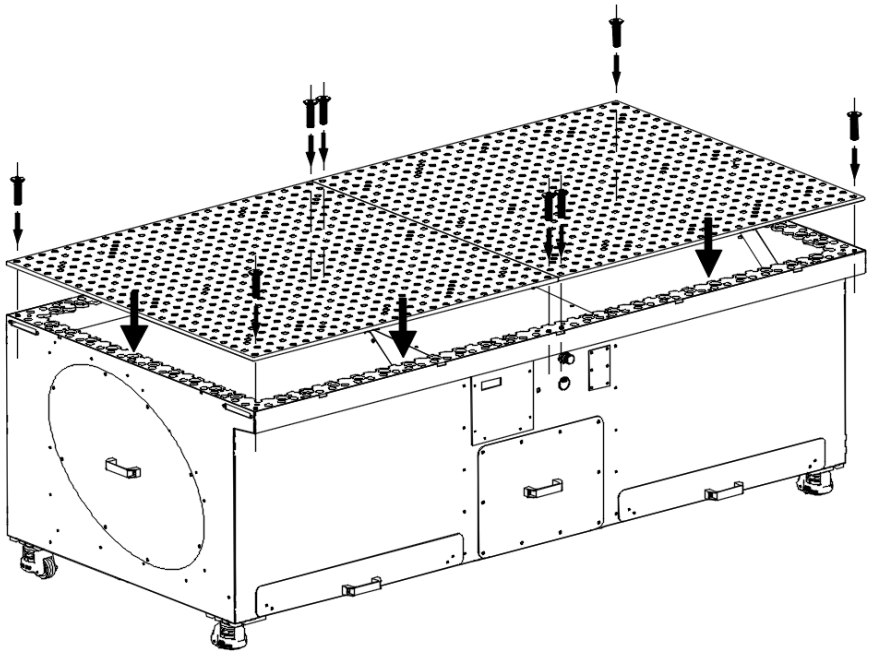
Annex 5 – Siegmund welding table assembly instructions if not ordered from Secureair®

The bench top has a welding table support plate with various holes.
With reference to the image below, the numerical references correspond to the fixing holes depending on the type of welding table to be installed.
1 – System 16 welding plate
2 – System 22 and System 28 welding plate without flange
3 – System 16, System 22 and System 28 welding plate without flange



Welding tables without flange

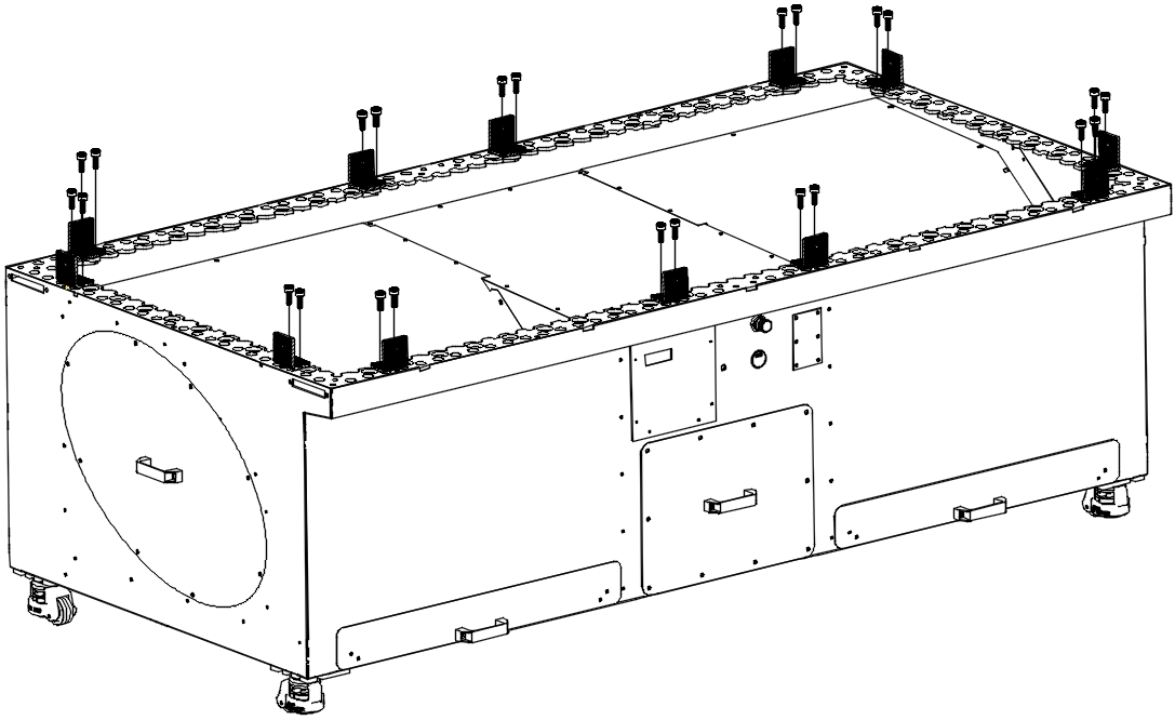
Position the welding plate on top of the bench, moving it using the appropriate lifting equipment and lifting eyes (not included).
Centre the holes in the top at the four corners with the holes on the support plate on the bench.
Screw the plate in place using the screws supplied with the bench, according to the holes in the welding plate.



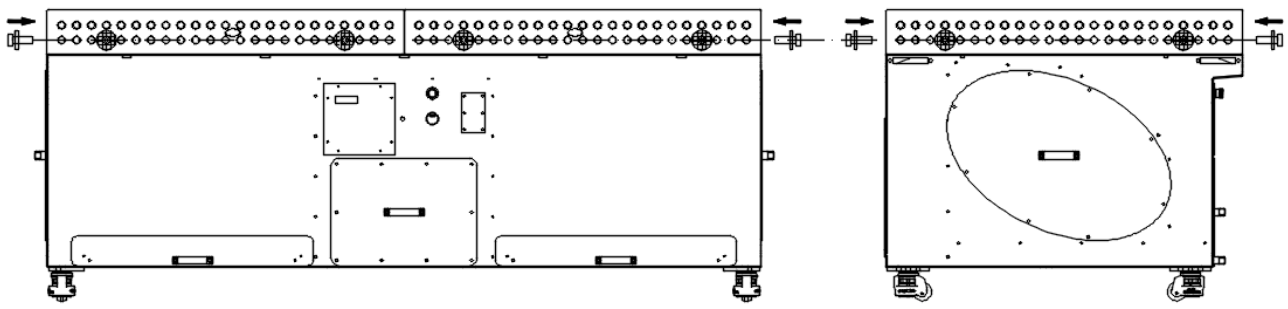
SYSTEM 16				
CODE SIEGMUND	**DESCRIPTION**	**H1 [mm]**	**WEIGHT [kg]**	**MOD**
2-164034.1.X7	Perforated plate X8.7 1200x1200x12 Plasma nitrided	12	131	SBW 12
SYSTEM 22				
SIEGMUND CODE	**DESCRIPTION**	**H1 [mm]**	**WEIGHT [kg]**	**MOD**
2-224034.PD	Perforated plate S355J2+N 1200x1200x18. Plasma nitrided Diagonal scale	18	197	SBW 12
SYSTEM 28				
SIEGMUND CODE	**DESCRIPTION**	**H1 [mm]**	**WEIGHT [kg]**	**MOD**
4-281015.XD7.T1	Basic 8.7 welding table - 1200x1200x25 Plasma nitrided - with holes and diagonal grid	25	299	SBW 12
4-281030.XD7.T1	Basic 8.7 welding table - 2400x1200x25 Plasma nitrided - with holes and diagonal grid	25	597	SBW 12

Welding table with sides

Screw the L-brackets supplied with the bench to secure the welding table with flange. The brackets to be used must be chosen according to the type of welding table to be installed.



Position the welding table with its sides facing upwards on the workbench, moving it using appropriate lifting equipment and lifting eyes (not included). Centre the holes on the sides of the table with the holes in the brackets previously screwed onto the workbench.
Screw the top in place using the appropriate screws and washers supplied with the bench, according to the holes in the welding top.



SYSTEM 16				
CODE SIEGMUND	**DESCRIPTION**	**H1 [mm]**	**WEIGHT [kg]**	**MOD**
4-160015.P.T1	Professional 750 welding table 1200x1200x100 Plasma nitrided	100	237	SBW 12
4-160030.P.T1	Professional 750 welding table 2400x1200x100 Plasma nitrided	100	466	SBW 24
4-160015.X7D.T1	Professional Extreme 8.7 welding table 1200x1200x100 Plasma nitrided	100	235	SBW 12
4-160030.X7D.T1	Professional Extreme 8.7 welding table 2400x1200x100 Plasma nitrided	100	462	SBW 24
4-160015.X7PL.T1	Professional Extreme 8.7 PLUS welding table - 1200x1200x150 Plasma nitrided	150	264	SBW 12
4-160030.X7PL.T1	Professional Extreme 8.7 PLUS welding table - 2400x1200x150 Plasma nitrided	150	518	SBW 24
SYSTEM 22				
CODE SIEGMUND	**DESCRIPTION**	**H1 [mm]**	**WEIGHT [kg]**	**MOD**
4-220015.P.T1	Professional 750 welding table 1200x1200x150. Plasma nitrided	150	365	SBW 12
4-220030.P.T1	Professional 750 welding table 2400x1200x150 Plasma nitrided	150	695	SBW 24
4-220015.XD7.T1	Professional Extreme 8.7 welding table - 1200x1200x150 Plasma nitrided - with holes and diagonal grid	150	357	SBW 12
4-220030.XD7.T1	Professional Extreme 8.7 welding table - 2400x1200x150 Plasma nitrided - with holes and diagonal grid	150	680	SBW 24
SYSTEM 28				
CODE SIEGMUND	**DESCRIPTION**	**H1 [mm]**	**WEIGHT [kg]**	**MOD**
4-280015.P.T1	Professional 750 welding table 1200x1200x200 Plasma nitrided	200	510	SBW 12
4-280030.P.T1	Professional 750 welding table 2400x1200x200 Plasma nitrided	200	952	SBW 24
4-280015.XD7D.T1	Professional Extreme 8.7 welding table - 1200x1200x200 Plasma nitrided - with holes and diagonal grid	200	487	SBW 12
4-280030.XD7D.T1	Professional Extreme 8.7 welding table - 2400x1200x200 Plasma nitrided - with holes and diagonal grid	200	913	SBW 24