

2

MANUAL

EDILGRAPPA

**BENDING-STRAIGHTENING TOOL
PR16-32N WITH ADJUSTABLE HEAD
USE AND MAINTENANCE
INSTRUCTIONS**

BENDING-STRAIGHTENING TOOL PR16-32N**AVAILABLE IN THE FOLLOWING VERSIONS:**

1. **SINGLE-PHASE ELECTRIC MOTOR 230 V 50 Hz**

NAME	P/N
BENDING-STRAIGHTENING TOOL PR16-32N WITH ADJUSTABLE HEAD	1.50.02904

CONTENTS

0 DESCRIPTION OF THE MACHINE	5
0.01 MACHINE COMPONENTS.....	5
0.02 SAFETY AND DANGER STICKERS - CE PLATE.....	6
0.03 LIST OF ACCESSORIES INCLUDED IN THE SUPPLY.....	7
1 TECHNICAL FEATURES	7
1.01 HYDRAULIC, MECHANICAL AND ELECTRICAL SPECIFICATIONS	7
2 DELIVERY, COMMISSIONING AND SET-UP	8
2.01 DELIVERY	8
2.02 ELECTRIC MOTOR.....	9
2.02.01 ELECTRICAL CONNECTIONS	9
2.02.02 COMMISSIONING	9
2.03 DOUBLE-ACTING LEVER	9
2.04 EQUIPMENT OPERATION.....	10
2.04.01 HEAD IN STANDARD CONFIGURATION	10
2.04.02 ACCESSORIES AVAILABLE ON REQUEST	11
2.04.03 STARTING	12
2.05 FORESEEN USE AND RESIDUAL RISKS	16
3 ROUTINE MAINTENANCE	17
3.01 CHANGING AND TOPPING UP THE OIL.....	17
3.02 CHECKING SCREWS.....	19
3.03 HYDRAULIC COMPONENTS.....	19
3.03.01 UNSUCCESSFUL OUTWARD STROKE	19
3.03.02 MAX. PRESSURE VALVE INCORRECTLY ADJUSTED	19
3.03.03 MAIN CHECKS ON THE MOTOR	19
3.04 CHECKING TOOLS	20
4 POTENTIAL PROBLEMS AND MEASURES TO BE ADOPTED	22
4.01 GENERAL.....	22
4.02 TROUBLESHOOTING THE MOTOR	22
4.03 TROUBLESHOOTING THE HYDRAULIC COMPONENTS.....	23
5 STORAGE AND RESTARTING	24
5.01 STORAGE	24
5.01.01 ELECTRIC MOTOR.....	24
5.01.02 CYLINDER AND HYDRAULIC COMPONENTS	24
5.02 RESTARTING.....	24
6 MACHINE DISPOSAL	25

A brief legend indicating the most important symbols used in this manual is shown below.



THIS SYMBOL WARNS USERS TO PAY SPECIAL ATTENTION WHEN FOLLOWING THE RELATIVE INSTRUCTIONS. FAILURE TO OBSERVE THESE INSTRUCTIONS CAN CAUSE THE MACHINE TO OPERATE INCORRECTLY.



THIS SYMBOL INDICATES POSSIBLE HAZARDS, TAKE ALL PRECAUTIONS TO PREVENT THESE SITUATIONS FROM OCCURRING.



BEFORE WORKING ON THE MACHINE, CAREFULLY READ ALL THE INSTRUCTIONS, ESPECIALLY THOSE CONTAINED IN BOXES.

- “OPERATOR”:** A person suitably trained and authorised to operate, adjust, clean and transport the machine.
- “MAINTENANCE PERSON”:** A person trained and authorised to perform routine maintenance on the machine and replace certain components.
- “MACHINE”:** The equipment described in this manual.
- “ELECTRIC TOOL”:** Used in the safety precautions, it is a more general definition of the machine in question as it refers to mains-powered electric tools (with cable) or battery-powered electric tools (cordless).

0 DESCRIPTION OF THE MACHINE



CAUTION!! FIRST READ THE MANUAL REGARDING THE GENERAL AND SAFETY REGULATIONS!

0.01 MACHINE COMPONENTS

This machine is fitted with a single-phase alternating current motor.

The equipment comprises:

- a motor,
- a hydraulic pump driven by the motor,
- a rod actuator (piston) driven by the oil pressured by the pump,
- a fixed head with tool.

Figure 1 shows the main parts of the equipment, in particular:

1. cylinder with hydraulic components
2. tool-adjustable head
3. double-acting lever
4. grip with start button
5. electrical connecting cable complete with plug
6. electric motor
7. handle
8. oil cap

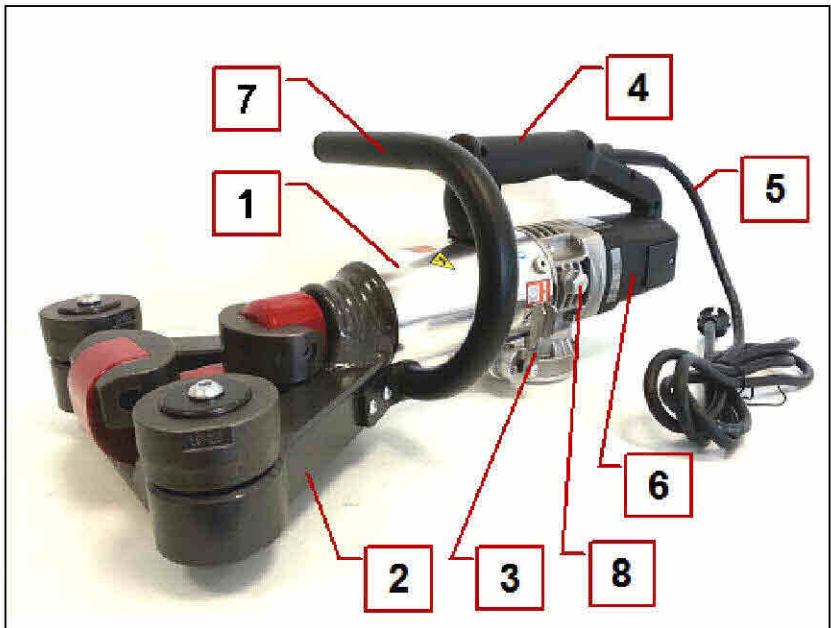
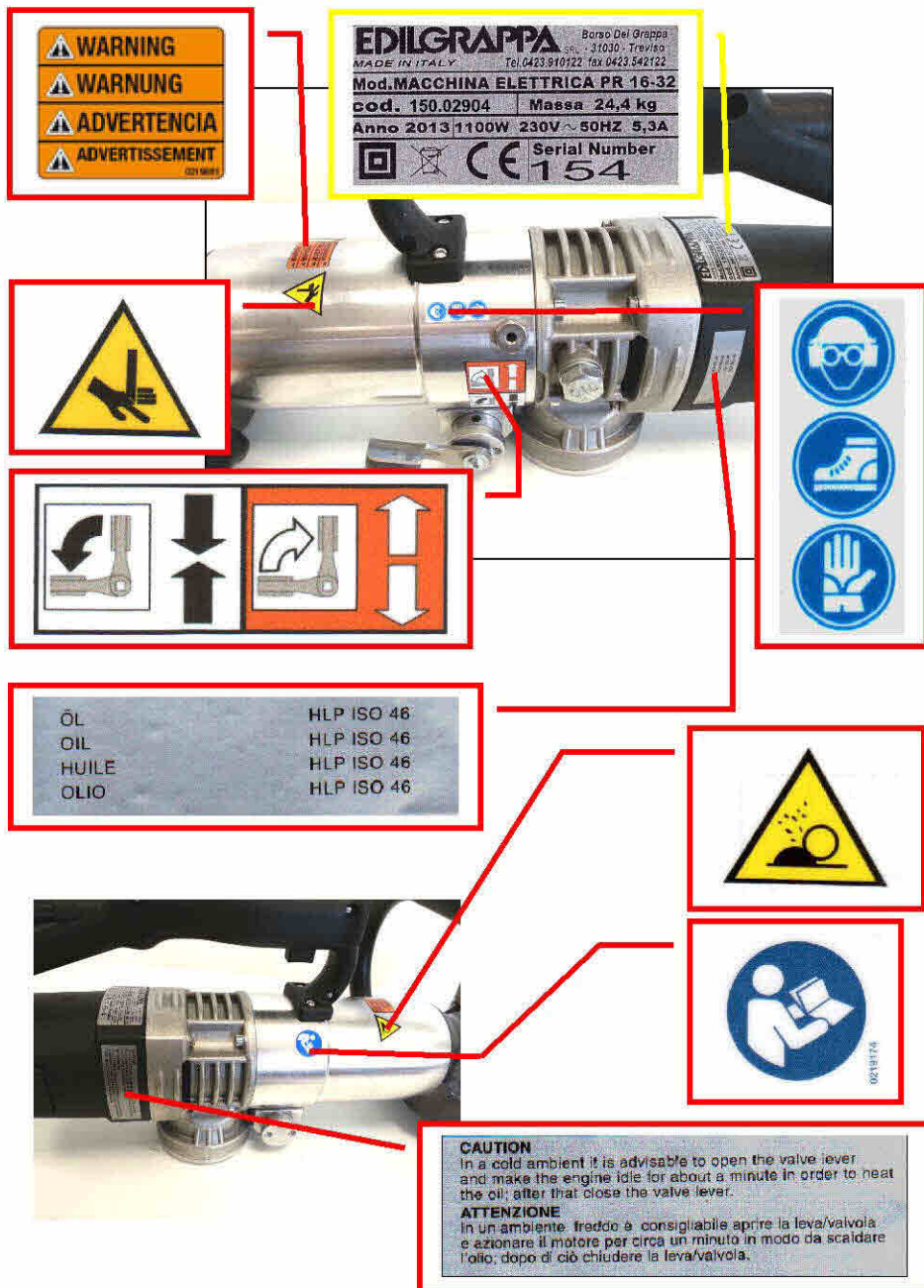


Fig. 1

0.02 SAFETY AND DANGER STICKERS - CE PLATE

Position of plate and safety and danger stickers on the machine:





Observe the warnings on the plates and stickers. Failure to do so could lead to injury or death. Make sure the plates and stickers are attached and legible. If not, apply them or request the maker for replacements.

0.03 LIST OF ACCESSORIES INCLUDED IN THE SUPPLY

- Case
- General safety rules, Use and maintenance instructions
- Declaration of conformity
- Warranty certificate
- Simple repair key, if appropriate

1 TECHNICAL FEATURES

1.01 HYDRAULIC, MECHANICAL AND ELECTRICAL SPECIFICATIONS

Maximum bending size and characteristics of material [mm and daN/mm ²]	Ø 32 mm / R = 75 daN/mm ²
Maximum output force from rod [t]	24.8
Maximum operating pressure [bar]	550
Dimensions: Length X Width X Height [mm]	601 x 300 x 229
Bending angle	180° to 80° (depending on the diameter and hardness of the material)
Weight [kg]	26.4
Guaranteed no-load LwA sound level (CEI EN 60745-1 and CEI EN 60745-2-8) [dB]	98
No-load operator Lpa (CEI EN 60745-1 and CEI EN 60745-2-8) [dB]	87
Vibrations when bending Ø 32 mm rod (CEI EN 60745-1 and EN ISO 5349)	4.01 m/s ²
Input voltage [V]	230
Frequency [Hz]	50
Electrical power [W]	1100
Input current [A]	5.3
Insulation class	II
RPM	10000

2 DELIVERY, COMMISSIONING AND SET-UP

2.01 DELIVERY

The machine is normally shipped and delivered inside a special hard case, well secured and in a stable position (see adjacent figure). All materials shipped are checked prior to delivery.



Upon receipt, check the machine for any damage (breakages or major denting) caused during transport. If so, it is necessary to immediately inform the shipping company and to write on the Delivery note the "Accepted subject to checking" clause.



In the event of damage, send a written complaint to the forwarder within 8 days of receipt.

Promptly inform Edilgrappa s.r.l. if major damage, caused during transport, is found upon receipt, or if any parts are missing.



It is also necessary to check the delivered materials against the detailed shipping list.

The machine can be moved easily both when it is inside its special rigid case, using the upper handle, and by gripping its upper or lower handle.



Loads must be moved in compliance with current occupational safety regulations.

After use, put the machine back into its case or place it on a stable surface, making sure this can withstand its weight.

2.02 ELECTRIC MOTOR

2.02.01 ELECTRICAL CONNECTIONS



THE USER SYSTEM AND THE RESPECTIVE CONNECTIONS MUST BE MADE IN STRICT OBSERVANCE OF THE REGULATIONS IN FORCE, BY COMPETENT PERSONNEL QUALIFIED TO DO THE JOB.



BEFORE CONNECTING THE APPLIANCE BY MEANS OF THE PLUG SOCKETS, TURN THE MAIN SWITCH TO OPEN POSITION "O".

2.02.02 COMMISSIONING

These machines do not need any adjustment or particular precautions before commissioning.

The only controls to perform concern:

- Machine integrity:
make sure that nothing happened during transport that could damage the insulation or mechanical parts.
- Completeness of supply:
check that all the supplied accessories are fitted.
- Oil level:
check the oil level and top up if necessary as per the instructions in Para 3.01.



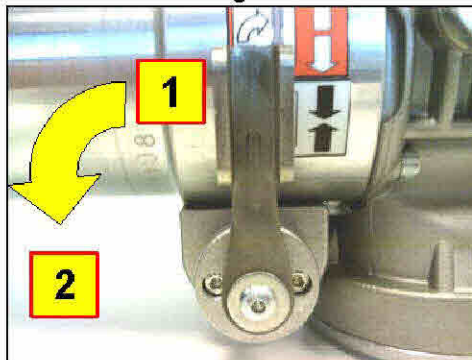
IMPORTANT: Before loosening the oil cap carefully read the instructions in Para 3.01.

2.03 DOUBLE-ACTING LEVER

The double-acting lever has two positions (see fig. 2)

- Position 1 (open): The piston returns to its original position.
- Position 2 (close): The piston performs its outward stroke (bending-straightening phase).

Fig. 2



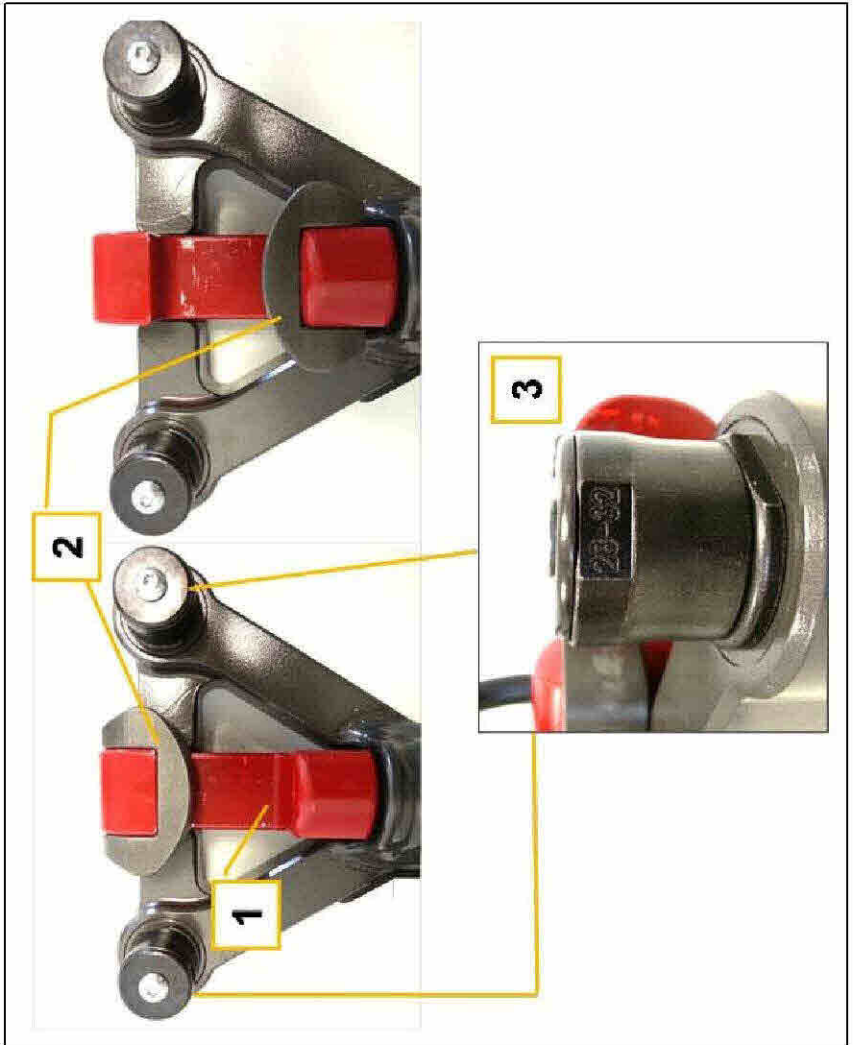
2.04 EQUIPMENT OPERATION

2.04.01 HEAD IN STANDARD CONFIGURATION

In its standard configuration, the tool head is supplied as shown in fig. 2A.
In particular, the following can be seen:

1. Cam support;
2. Cam, applicable for both push bending and pull bending;
3. Bending rollers (standard version: for bending - straightening from Ø28mm to Ø32mm).

Fig. 2A

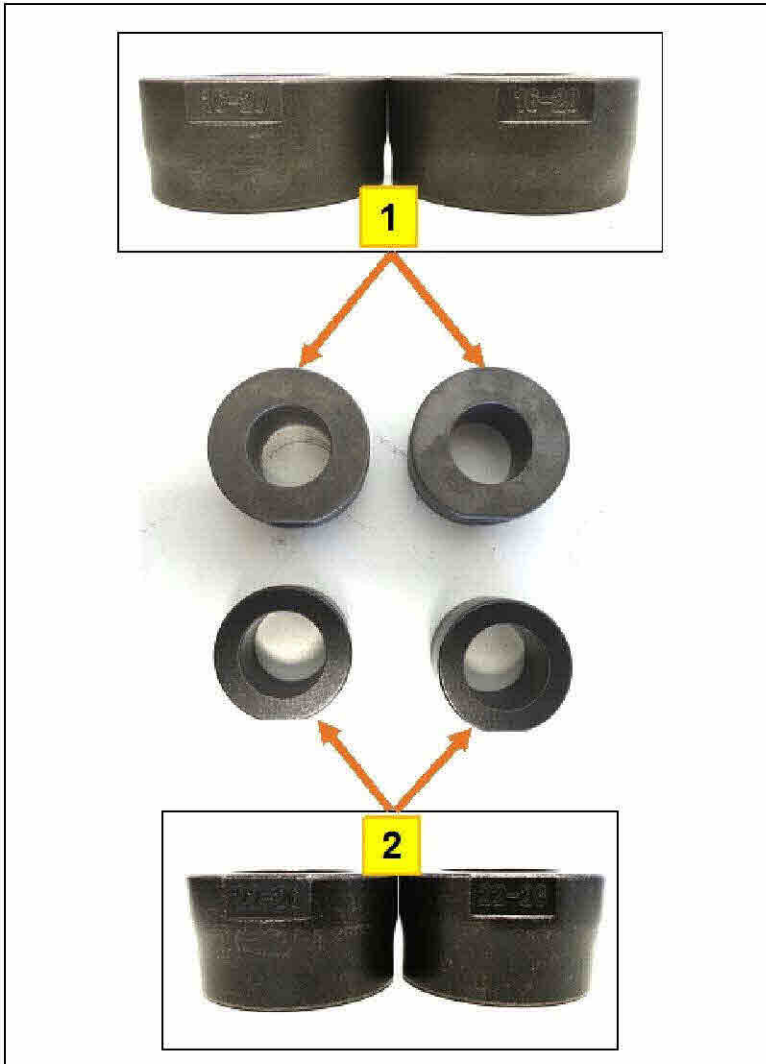


2.04.02 ACCESSORIES AVAILABLE ON REQUEST

The following accessories are available on request (see fig.2B):

- Bending rollers for bending - straightening from $\varnothing 16\text{mm}$ to $\varnothing 20\text{mm}$ (see ref.1 in fig. 2B);
- Bending rollers for bending - straightening from $\varnothing 22\text{mm}$ to $\varnothing 26\text{mm}$ (see ref.2 in fig. 2B)

Fig. 2B



2.04.03 STARTING

Insert the plug in a suitable power socket and follow the instructions below, depending on the kind of machine involved.



Make sure the characteristics of the work piece are compatible with the contents of the technical specifications table.



***IMPORTANT:** When processing hard and fragile materials (not included among the functions of this tool) metal elements (steel splinters and the like) may be projected from the work piece and accelerate to considerable speeds.*

This situation has been described in the machine instructions manual in order to allow the operator to take the precautions required to avoid this potentially hazardous situation, by wearing a helmet, goggles and suitable protective clothing.



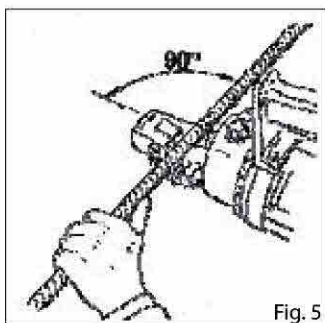
Make sure the workpiece lies at right angles with respect to the axis of the equipment (fig. 3A).



***IMPORTANT:** If the machine is moved towards the workpiece, hold it still with both hands and maintain a fixed position.*



If the machine lies on a surface, keep one hand on the grip and hold the workpiece with the other (fig. 5 by way of example)



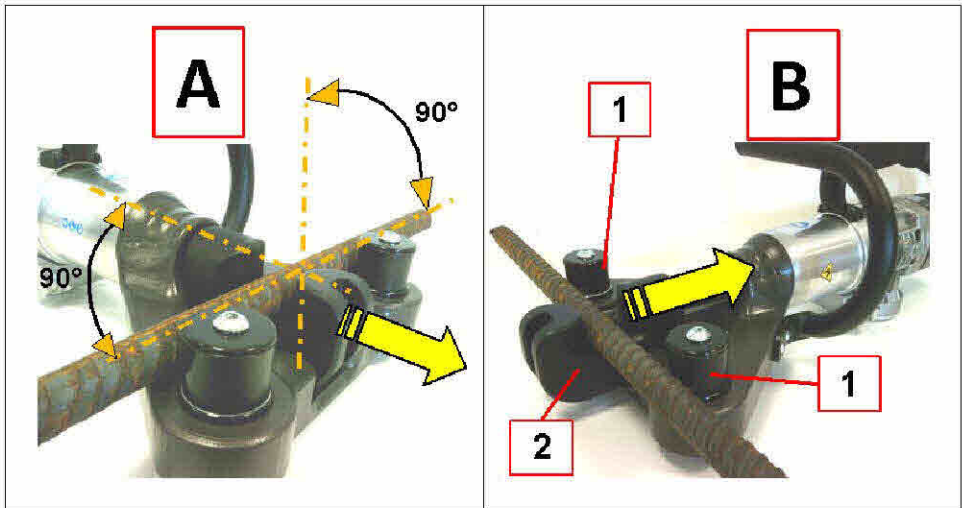
2.04.04 BENDING OR STRAIGHTENING

This type of machine can bend-straighten in both directions of travel (refs. A and B in fig. 3A). The hook die (ref. 2 in fig. 3A) can work when both pushed and pulled. More force is generated when pushing the tool (ref. A in fig. 3A) than when pulling it.

- Position the rod that it lies firmly on the base of the head and on the rollers (ref. 1 in fig. 3A) and perpendicular to the longitudinal axis of the machine (fig. 3A).
- After correctly positioned the work piece as indicated in fig. 3A, move the double-acting lever to " open " or " close " as required;
- press the start button and hold it down until the bending or straightening operation has been completed;
- Once bending or straightening have been completed, move the piston slightly in the opposite direction from that required (always with the help of the double-acting lever and the start button) in order to release the material and remove it from the head.

The following picture (fig. 3A) is only an example

Fig. 3A



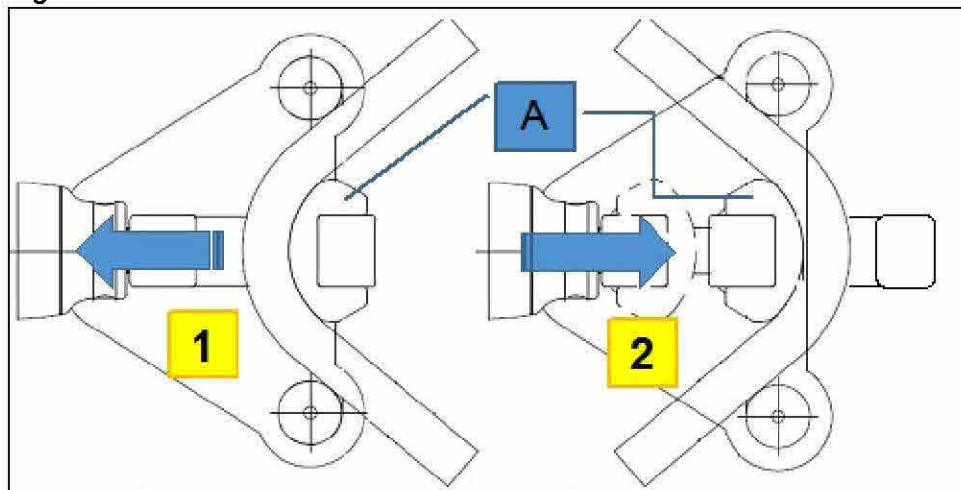
The following simplified diagram shows how bending and straightening operations must be performed.

See Fig. 2C and Fig. 2D.

PUSH AND PULL BENDING WITH THE CAM ASSEMBLED:

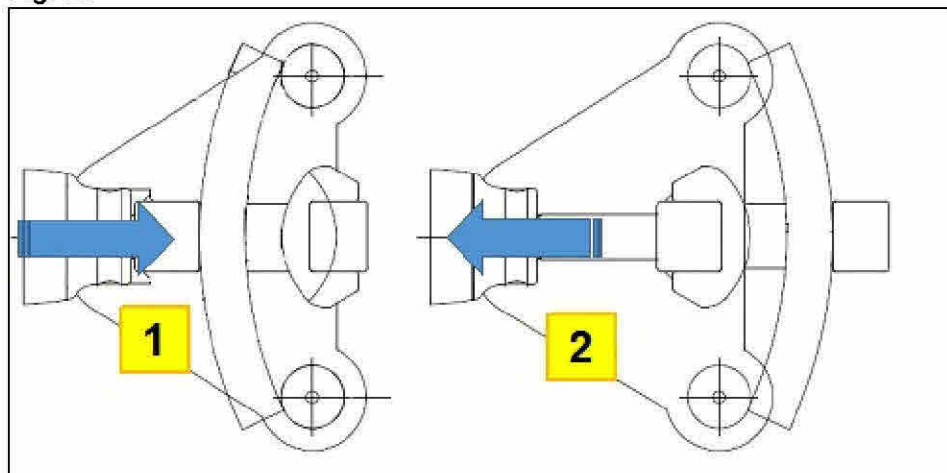
Assemble the cam as described in fig. 2C (see also para 3.04), according to the bending method to be performed (see Ref. A in fig.2C).

1. Pull bending
2. Push bending

Fig. 2C**PUSH AND PULL STRAIGHTENING WITHOUT CAM:**

See fig. 2D

1. Push straightening
2. Pull straightening

Fig. 2D

2.04.05 ADJUSTING THE HEAD

The head of this machine can be freely adjusted (rotated by 180°) to help the operator during positioning and subsequent processing.

To adjust the head, simply turn the handle (ref. 1 in fig. 2E), as indicated by the arrows.

Fig. 2E





Adjusting the head with the tool disconnected and not working. Hold the grip (ref. 1 in fig. 2E) and handle (ref. 4 in fig. 1) firmly, without touching the on/off button, and move the head to the required position.

2.05 FORESEEN USE AND RESIDUAL RISKS

The machine may only be used for bending or straightening. The maximum diameter of the material is 32 mm and its unit tensile strength must not be greater than 750 N/mm². Do not use the machine for bending other elements that are not specified above.

The machine may only be used if powered by an electrical system compliant with legislation and current law (suitably connected to an earth system and protected from current surges and short circuits).

Any use other than that expressly indicated shall be considered as improper and therefore not permitted.

Edilgrappa S.r.l. declines all liability for any improper use of the machine and for any modification or change made to it.

Operators must observe the instructions in this manual in order to minimise the risk of accidents. In particular, they must pay attention when working in conditions that could cause:

- Possible burns from overheated metal parts;
- Injury due to incorrect positioning or inadequate lifting or moving;
- Injury caused by splinters discharged from the work piece.

People remaining in the vicinities of the machine while it is working are subject to the following risks:

- flying debris (dangerous objects, etc...);

Hand/arm vibration. Standard applied: EN ISO 5349

The mechanical vibrations transmitted to the hands and arms generate a risk to the health and safety of workers, especially as concerns vascular, osteoarticular, neurological and muscular ailments.

The Employer is responsible for assessing the risk generated by mechanical vibrations, pursuant to Directive 2002/44/EC.

Operating temperature	-40° + +50° C
Bending Ø and max. unit tensile stress	Ø 16 ÷ Ø 32 mm STEEL R=750 N/mm ²



- ***It is strictly forbidden to use the machine for purposes other than those indicated in this installation and maintenance manual.***
- ***It is forbidden to use the machine in areas subject to the risk of explosion.***

3 ROUTINE MAINTENANCE



1. *All maintenance, inspection and cleaning operations must be performed with the power supply disconnected and the machine cool (see the person responsible in the maintenance schedule);*



2. *Maintenance operations must be performed in a suitable place according to current safety regulations;*
3. *Before any maintenance intervention, thoroughly clean the machine (see Paragraph 5.01);*
4. *Wear suitable personal protective equipment while performing maintenance work.*



AFTER MAINTENANCE WORK, MAKE SURE THE GUARDS ARE PUT BACK INTO THEIR CORRECT PLACE.

Periodic maintenance schedule

<i>Frequency</i>	<i>Operation</i>	<i>Method</i>	<i>Person in charge</i>
EVERY 8 HOURS	• CHECKING THE INTEGRITY OF THE MACHINE	Visual	Operator
EVERY 1600 HOURS	• CHANGE THE OIL	Para 3.01	Maintenance person
EVERY 8 HOURS	• CHECK THE TIGHTNESS OF NUTS AND BOLTS	Para 3.02	Operator



In case of doubts during the maintenance interventions, to order spare parts or for complex maintenance work, contact your authorised retailer.

3.01 CHANGING AND TOPPING UP THE OIL

The oil change or top up must be performed so as to prevent impurities from contaminating the oil or entering the tank. Impurities in the oil can irreversibly damage the hydraulic parts.



**ALWAYS MAKE SURE THE OIL CONTAINS NO IMPURITIES
DO NOT USE DIRTY TOOLS
DO NOT WORK IN DUSTY AREAS**

CHANGING THE OIL:



**USING A SUITABLE DISPENSER, PREPARE THE CORRECT QUANTITY OF OIL (0.6 l) TO POUR INTO THE TANK.
LEAKING OIL CAN CAUSE SHORT CIRCUITS, FIRE AND EXPLOSIONS.**

1. Place the machine horizontally in a stable position on a work surface with the magnetic cap facing upwards. Place a basin under the machine to catch any oil leaks;
2. Unscrew the magnetic cap (see part. 8 para 0.01) and remove any residues with the piston in its retracted position;

3. Totally drain the oil tank using a suitable extraction system (used oil extraction pump) so that no oil can leak into the machine;
4. Slowly pour in the correct quantity of oil (0.6 l) using suitable equipment (e.g. a funnel as shown in fig. 4). Only use new or clean recommended oil (as indicated on the next page);
5. Fill up to the upper rim of the hole;
6. Put back the oil cap and tighten slightly;
7. Perform some piston strokes to vent the large air bubbles;
8. Move the piston to its maximum extension and rapidly start and stop the motor several times (before the piston automatically retracts);
9. Complete filling;
10. Put the oil cap on and tighten.



Fig. 4

TOPPING UP THE OIL:



Before unscrewing the magnetic cap to check the oil level, make sure the piston is fully extended and, if necessary, pull it out. If this is not done the oil may leak, air bubbles may form and/or the oil level may be incorrectly measured, thus causing the machine to operate incorrectly.

Only after completing the above operations, proceed as shown below:

1. Place the machine horizontally in a stable position on a work surface with the filling hole facing upwards. Place a basin under the machine to catch any oil leaks;
2. Unscrew the magnetic cap (see part. 8 para 0.01) and remove any residues;
3. Check the amount of missing oil;
4. Slowly top up to the upper rim of the hole with recommended new and clean oil using suitable equipment (e.g.: a funnel as indicated in fig. 4);
5. Put the oil cap on and tighten.

Maximum quantity:	0.6 l.
Type of hydraulic oil:	ESSO NUTO H46 or approved equivalents HLP46 according to DIN 51 524 MIL-H 17672 C



When demolishing the machine or parts of it (oil, plastic, etc.) observe the regulations in force in the country in which this operation is performed.

3.02 CHECKING SCREWS

Periodically, or every day in the event of frequent or prolonged work, make sure that all the screws are perfectly tight.



FAILURE TO TIGHTEN LOCKING SCREWS CAN CAUSE SERIOUS DAMAGE.

3.03 HYDRAULIC COMPONENTS

3.03.01 UNSUCCESSFUL OUTWARD STROKE

If it is not possible to perform another outward stroke, make sure the double-acting lever is correctly positioned (see para 2.03).

3.03.02 MAX. PRESSURE VALVE INCORRECTLY ADJUSTED

In case of a pressure drop for a reason that cannot be directly identified, have a maintenance person or the maker check the maximum pressure valve is clean and calibrated.

3.03.03 MAIN CHECKS ON THE MOTOR

- Keep the motor surfaces clean, especially the fins on the head
- Keep the motor cooling slits clean and unobstructed
- Check the brushes for wear: replace them with authentic spare parts when their length is less than 5mm.

3.04 CHECKING TOOLS

The use of worn tools decreases the potential of the machine and can needlessly overheat the motor.

REPLACE AS SOON AS YOU NOTICE THEY ARE WORN.

REPLACING TOOLS:

Disconnect the tool, place it horizontally on a stable worktop and proceed as follows:

BENDING ROLLER:

1. Fully return the piston to position 1 (open) using the double-acting lever, see para 2.03;
2. Remove the lock screw (see ref. 1 in fig. 5A);
3. Remove the washer (see ref. 2 in fig. 5A);
4. Remove the bending roller (ref. 3 in fig. 5A) as indicated by the arrow (fig. 5A);
5. Mount the new bending roller;
6. Put back the washer;
7. Fully tighten the lock screw.



ALWAYS REPLACE BOTH BENDING ROLLERS. NEVER REPLACE JUST ONE.

The following picture (Fig. 5A) is only an example

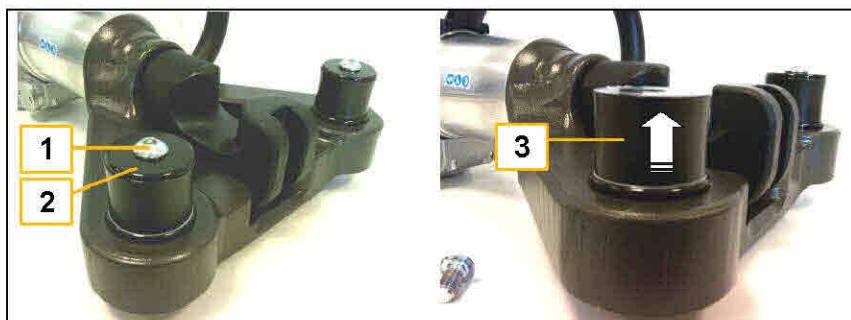


Fig. 5A

CAM SUPPORT:

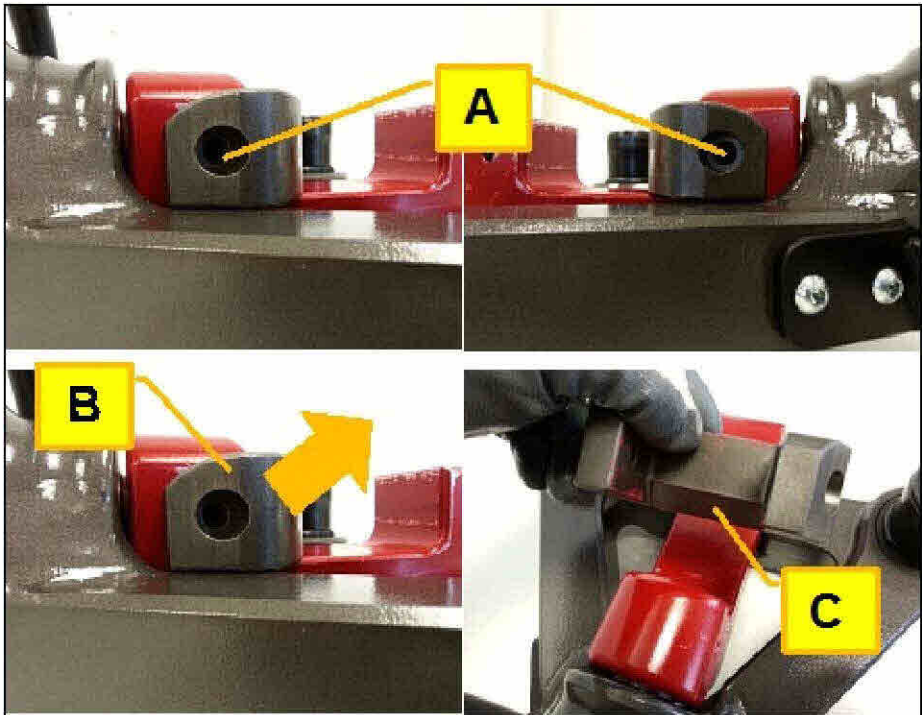
The cam support is made from material with a high mechanical resistance and heat treated to assure a long lifetime whilst considerably reducing the need to replace it.

To replace the cam support, contact the manufacturer.

CAM:

- Loosen the lock screws (see ref. A fig. 5B);
- Remove the die (see ref. B in fig. 5B) as indicated by the arrow;
- Mount the new cam making sure that the bevel (see ref. C in fig. 5B) is facing downwards, that is, towards the surface of the cam support housing.

Fig. 5B



4 POTENTIAL PROBLEMS AND MEASURES TO BE ADOPTED

4.01 GENERAL

Faults can be divided into three sections:

1. faults on the motor
2. faults on the head
3. faults not closely connected with the machine



ALL OPERATIONS MUST BE PERFORMED BY QUALIFIED PEOPLE IN OBSERVANCE OF SAFETY REGULATIONS.



WORK ON THE MACHINE DURING THE WARRANTY PERIOD MUST BE PERFORMED AT THE MAKER'S FACILITY.



Remedies marked with the letter R require the assistance of the Authorised dealer. The remedies marked by the letter M require the intervention of the Maintenance man. Remedies marked with the letter O can be performed by the Operator.

4.02 TROUBLESHOOTING THE MOTOR

FAULT	POSSIBLE REASON	POSSIBLE REMEDY	PERFORMED BY
MOTOR DOES NOT START	Broken power cable	Replace cable with one having the same specifications	M
	Faulty plug	Replace	M
	Stator windings	Replace	R
	Rotor windings	Replace	R
	Switch	Replace	R
	No electric power	Check the line and the cable protections	M
ELECTRIC MOTOR OVERHEATED	Worn brushes	Replace	R
	Worn manifold	Replace or overhaul	R
	Insufficient power supply	Check the line, the protections of the electric panel and the tightness of the connection terminals	M
	Partial fault of the stator windings	Replace	R
	Partial fault of the rotor windings	Replace	R
	Windings dirty	Clean	M
	Ventilation slits obstructed	Clean	O
	Fan broken	Replace	R
	Motor supports worn	Replace	R
Mechanical faults on the head	Overhaul	R	

FAULT	POSSIBLE REASON	POSSIBLE REMEDY	PERFORMED BY
ELECTROMAGNETIC DISTURBANCES IN LINE	Fault in anti- disturbance filter	Replace	R
	Manifold worn	Replace	R
	Brushes worn	Replace	R

4.03 TROUBLESHOOTING THE HYDRAULIC COMPONENTS

FAULT	POSSIBLE REASON	POSSIBLE REMEDY	PERFORMED BY
OUTWARD STROKE DOES NOT BEGIN			
	Return spring broken (if present)	Replace	O
	Max. pressure valve dirty	Consult the Maker	/
	Double-acting valve broken	Repair	M
	Oil tank empty	Fill	O
MOTOR DOES NOT STOP	Switch contacts stuck	Replace	M
OUTWARD STROKE INCOMPLETE	No oil	Top up	O
OUTWARD STROKE DISCONTINUOUS	Air bubbles in the hydraulic circuit	Vent	O
	Max. pressure valve open due to built-up dirt	Consult the Maker	/
	Pump faulty or dirty	Replace	M
	Piston gasket faulty	Replace	M
	Pump O-ring	Replace	M
RETURN STROKE INCOMPLETE	Dirt between piston rod and tool	Move the piston to its end- of-stroke position and clean	O
	Return spring broken (if present)	Replace	O
NO FORCE	Oil hydraulic pump faulty	Replace	M
	Dirt on oil hydraulic pump valve	Replace	M
	Max. pressure valve open	Replace	M
	Piston gasket worn	Replace	M
	Pump O-ring broken	Replace	M
OIL LEAKS FROM TANK COVER	Membrane faulty	Replace	O

5 STORAGE AND RESTARTING

5.01 STORAGE

In case of long periods of inactivity, proceed as follows:

5.01.01 ELECTRIC MOTOR

- Clean all the internal electrical parts (rotor, stator, cooling circuit) with compressed air



DO NOT USE CONDUCTIVE OR FLAMMABLE LIQUIDS TO CLEAN INTERNAL ELECTRICAL PARTS

- To clean the outside of the machine, if necessary, use a cloth dampened in soapy water and then dry thoroughly
- Check the following are in good condition:
 - insulation
 - power cable
 - switches
 - plug
 - brushes and manifold
 - clean the stator, rotor, cooling circuit and fan with compressed air

5.01.02 CYLINDER AND HYDRAULIC COMPONENTS

Before performing these operations, see the relative instructions in Chap. 3

- Check the hydraulic oil and top up or, if necessary, replace.
- Clean the magnetic cap and check the membrane.
- Check for any oil leaks.
- Tighten the screws.

Store the equipment in a clean and dry place accessible only to authorised personnel.

5.02 RESTARTING

Before performing these operations, see the relative instructions in Chap. 3

- Check the oil tank is full and top up if necessary
- Remove any traces of oil remaining after topping up or applied to protect metal parts from the grip and other parts that can be gripped.

ELECTRIC MOTOR

- Ensure that the power cable, the plug and the machine body have not been damaged.
- Start the machine a few times and make sure no operating faults occur.



ELIMINATE ANY FAULTS BEFORE STARTING WORK.

6 MACHINE DISPOSAL

When disposing of the machine, the various materials must be separated.

The tool comprises the following groups of materials:

- ferrous materials
- copper
- plastic
- aluminium alloys

Observe current legislation when sorting, storing, recycling or disposing of these materials.

Only for EC countries:



This electric tool is marked with the following recycling symbol. Consistently with Directive 2002/96/EC on waste electrical and electronic equipment (WEEE), at the end of its useful lifetime, this product must be disposed of separately in suitable collection areas and not together with normal domestic waste. A benefit for the environment to help everyone.

EDILGRAPPA

S.r.l.

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authorised to draw up
the technical brief:**Giacomo Rorato
Via Callesello, 4
31030 Borso Del Grappa (TV)**General name:**

Portable motor-driven tool

Function:Bending-straightening rods with maximum \varnothing of: 32 mm**Type:**

Bending-straightening tool

Model:**PR16-32N adjustable head****Trade name:****Bending-straightening machine PR16-32N with
adjustable head****Serial n°:**

Year of construction:

DECLARES THAT THE ABOVE-MENTIONED EQUIPMENT IS COMPLIANT WITH THE FOLLOWING
DIRECTIVES:

Machinery Directive

2006/42/EC (Proc. Annex VIII)

EMC Directive

2004/108/EC

Low Voltage Directive

2006/95/EC

RoHS Directive

2011/65/EC

WEEE Directive

2002/96/EC

Place: Borso Del Grappa TV

Date.....

Signature
PAOLO MAZZARO
(legal representative)

EDILGRAPPA Srl
**MACHINES AND EQUIPMENT FOR THE BUILDING TRADE, INDUSTRY
AND RESCUE**

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