
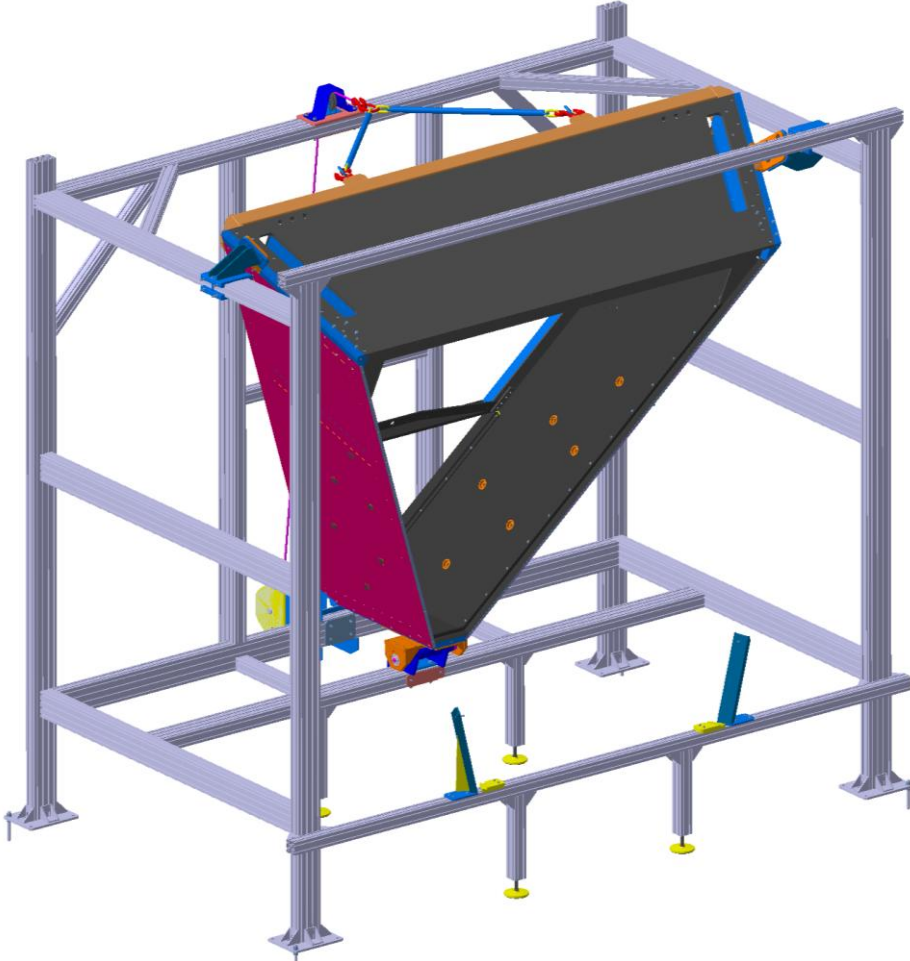




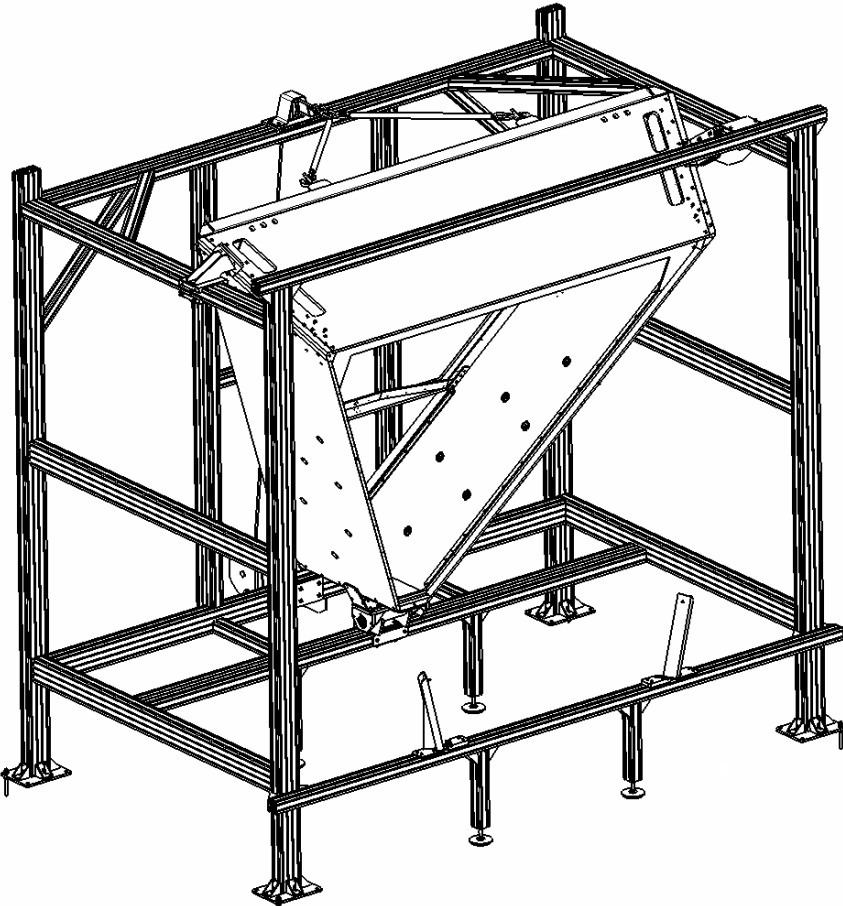


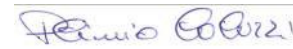

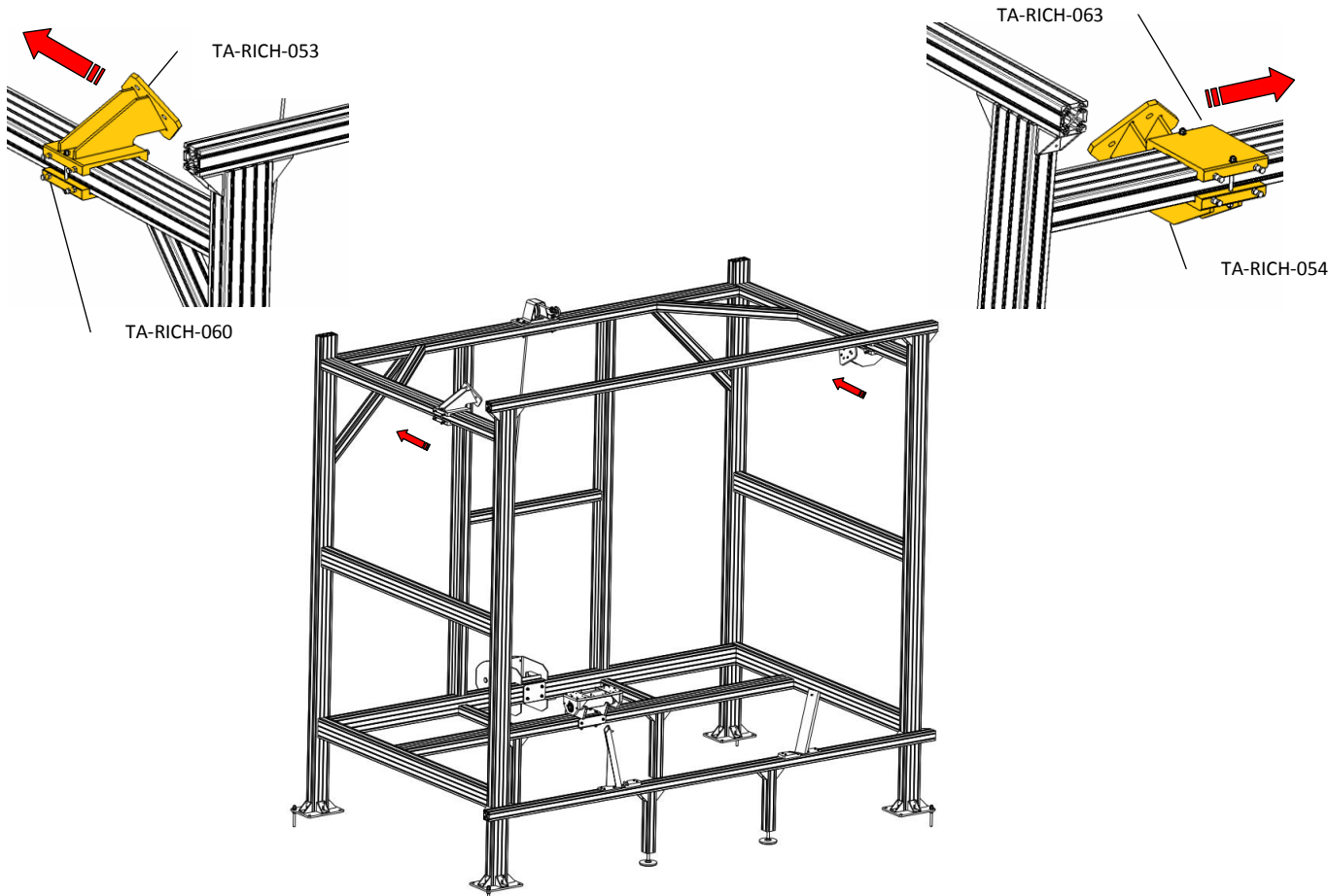






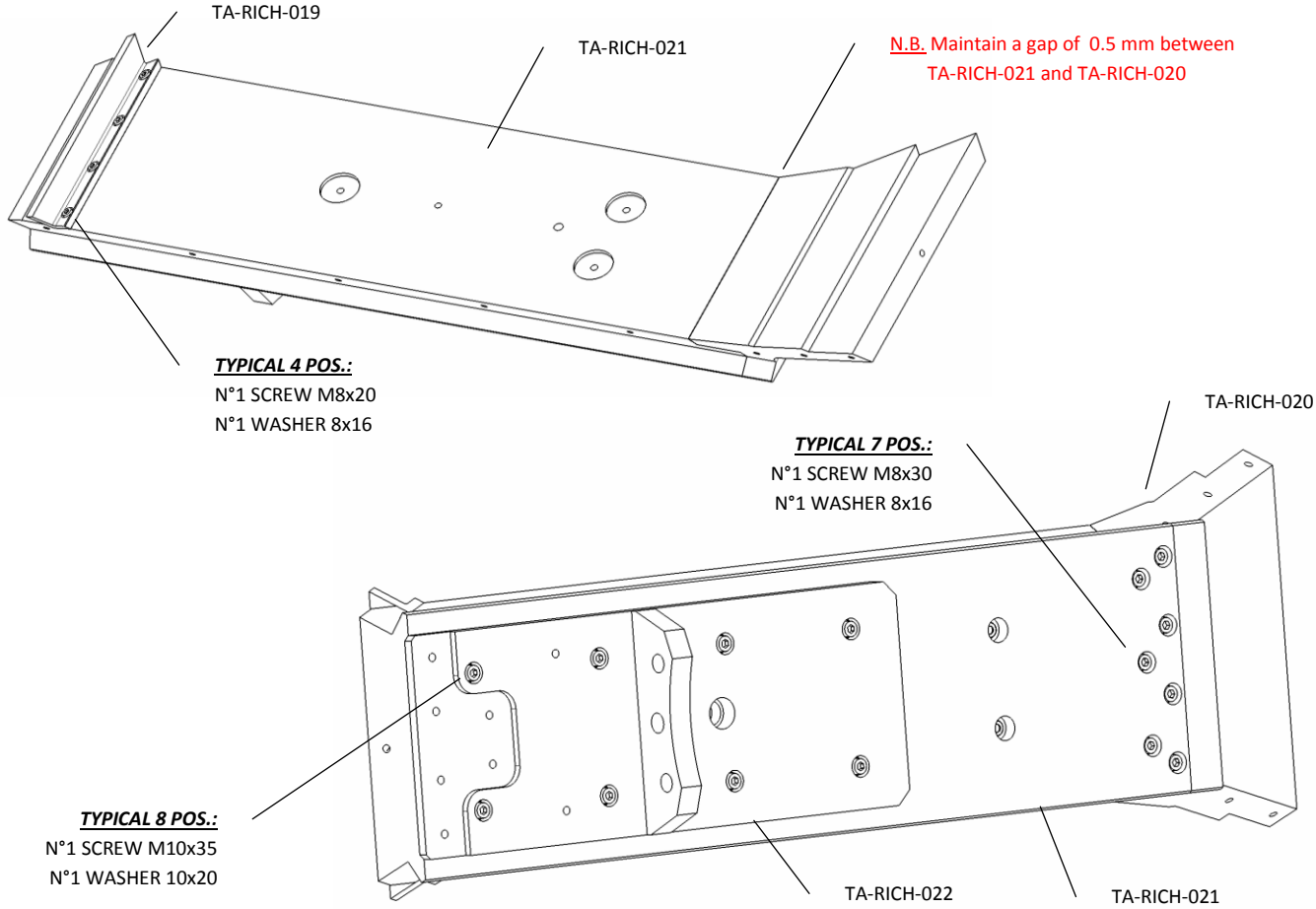


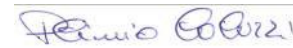
<div></div> <div>Tecnologie Avanzate</div>		Installation & Control Scheme		Mod. 75/95/00
		P/N: TA-RICH-001		DESCRIPTION: Rich CLAS12 Assembly
REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
WORKING CYCLE PHASE	DESCRIPTION AND NOTES		IMAGES	
APPLICABLE DOCUMENTATION: Assembly Structure For RICH Module_August 2016				
TOOL: TA-STR-001 RICH Assembly Structure				
BILL OF P/Ns:				
P/N	Q.ty	P/N	Q.ty	
TA-RICH-002	1	TA-RICH-035	1	
TA-RICH-012	1	TA-RICH-036	1	
TA-RICH-013	1	TA-RICH-037	1	
TA-RICH-019	1	TA-RICH-038	1	
TA-RICH-020	1	TA-RICH-039	1	
TA-RICH-021	1	TA-RICH-045	1	
TA-RICH-022	1	TA-RICH-046	1	
TA-RICH-023	1	TA-RICH-047	4	
TA-RICH-024	1	TA-RICH-078	1	
TA-RICH-025	1	TA-RICH-079	1	
TA-RICH-026	1	TA-RICH-080	1	
TA-RICH-027	1	TA-RICH-083	1	
TA-RICH-028	1	TA-RICH-092	1	
TA-RICH-029	1	TA-RICH-093	1	
TA-RICH-030	1	TA-RICH-094	1	
TA-RICH-031	1	TA-RICH-095	1	
TA-RICH-032	1	TA-RICH-096	1	
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TA-RICH-034	1	TA-RICH-098	1	


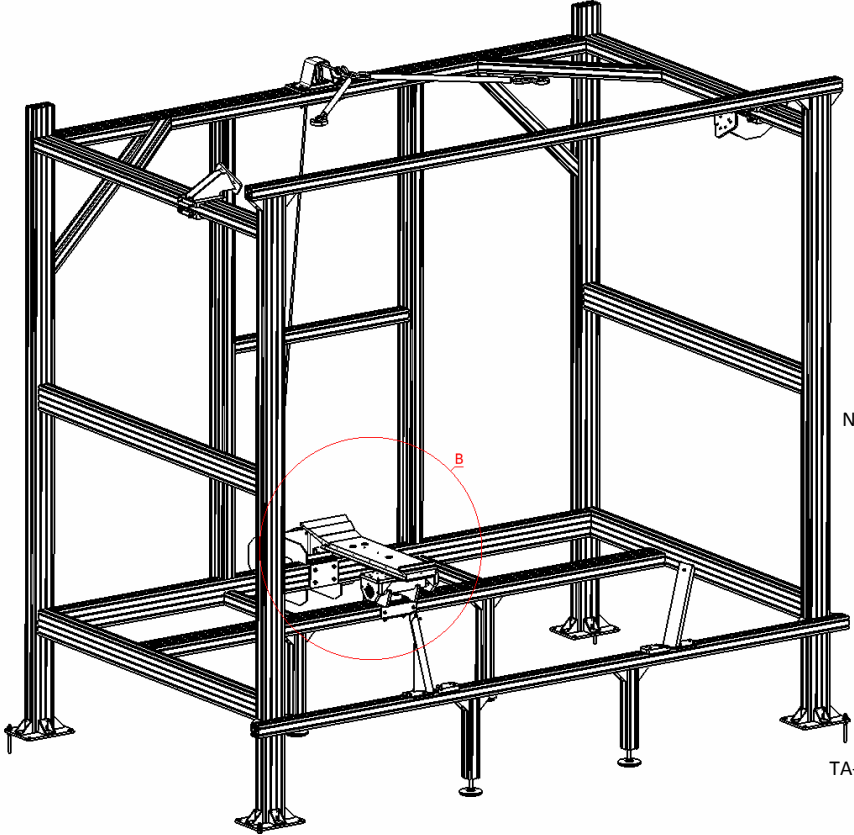
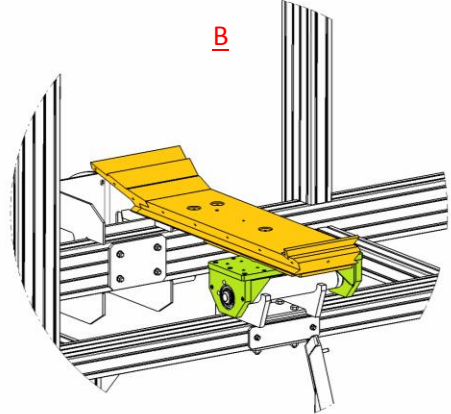
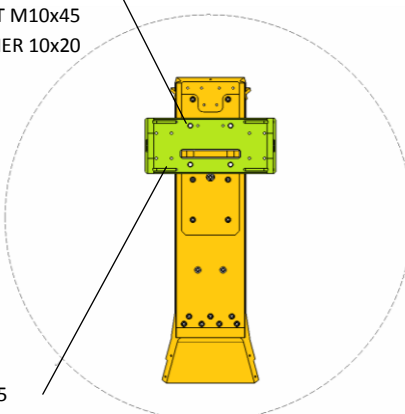
<b>COMPILED BY:</b>	<b>VERIFIED BY:</b>	<b>APPROVED BY:</b>
I. Loi 	M. Pinna 	P. Coluzzi 



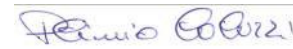
 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00																																															
		P/N: TA-RICH-001	DESCRIPTION: Rich CLAS12 Assembly	SHEET: 2/19																																															
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0	18/10/2016	FIRST EMISSION	N.A.	I. Loi																																															
WORKING CYCLE PHASE	DESCRIPTION AND NOTES		IMAGES																																																
<b>STANDARDS REQUIRED:</b> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">TYPE</th> <th style="text-align: center;">Q.ty</th> </tr> </thead> <tbody> <tr><td>Screw STEEL M5 x 12 ISO 4762</td><td style="text-align: center;">22</td></tr> <tr><td>Screw STEEL M5 x 25 ISO 4017</td><td style="text-align: center;">4</td></tr> <tr><td>Screw STEEL M6 x 16 ISO 4762</td><td style="text-align: center;">16</td></tr> <tr><td>Screw STEEL M8 x 20 ISO 4762</td><td style="text-align: center;">62</td></tr> <tr><td>Screw STEEL M8 x 25 ISO 4762</td><td style="text-align: center;">10</td></tr> <tr><td>Screw STEEL M8 x 30 ISO 4762</td><td style="text-align: center;">23</td></tr> <tr><td>Screw STEEL M10 x 35 ISO 4762</td><td style="text-align: center;">82</td></tr> <tr><td>Washer STEEL M5 ISO 7089</td><td style="text-align: center;">38</td></tr> <tr><td>Washer STEEL M6 ISO 7089</td><td style="text-align: center;">16</td></tr> <tr><td>Washer STEEL 8 x 16 ISO 7089</td><td style="text-align: center;">115</td></tr> <tr><td>Washer STEEL 10 x 20 ISO 7089</td><td style="text-align: center;">92</td></tr> <tr><td>Washer STEEL M24 ISO 7089</td><td style="text-align: center;">18</td></tr> <tr><td>Washer STEEL 8,8 M28 ISO 7089</td><td style="text-align: center;">8</td></tr> <tr><td>Nut STEEL 8,8 M24 ISO 4032</td><td style="text-align: center;">8</td></tr> <tr><td>NAS1802-6-10</td><td style="text-align: center;">20</td></tr> <tr><td>NAS1802-4-13</td><td style="text-align: center;">12</td></tr> <tr><td>Bolt STEEL M10 x 40 ISO 4014</td><td style="text-align: center;">6</td></tr> <tr><td>Bolt STEEL M10 x 45 ISO 4014</td><td style="text-align: center;">4</td></tr> <tr><td>Bolt STEEL M24 x 60 ISO 4014</td><td style="text-align: center;">2</td></tr> <tr><td>Bolt STEEL 8,8 M24 x 65 ISO 4014</td><td style="text-align: center;">8</td></tr> <tr><td>Screwed Bar M24</td><td style="text-align: center;">2</td></tr> <tr><td>Bolteye M24</td><td style="text-align: center;">2</td></tr> <tr><td>Assembly Lifting Tool</td><td style="text-align: center;">1</td></tr> </tbody> </table>		TYPE	Q.ty	Screw STEEL M5 x 12 ISO 4762	22	Screw STEEL M5 x 25 ISO 4017	4	Screw STEEL M6 x 16 ISO 4762	16	Screw STEEL M8 x 20 ISO 4762	62	Screw STEEL M8 x 25 ISO 4762	10	Screw STEEL M8 x 30 ISO 4762	23	Screw STEEL M10 x 35 ISO 4762	82	Washer STEEL M5 ISO 7089	38	Washer STEEL M6 ISO 7089	16	Washer STEEL 8 x 16 ISO 7089	115	Washer STEEL 10 x 20 ISO 7089	92	Washer STEEL M24 ISO 7089	18	Washer STEEL 8,8 M28 ISO 7089	8	Nut STEEL 8,8 M24 ISO 4032	8	NAS1802-6-10	20	NAS1802-4-13	12	Bolt STEEL M10 x 40 ISO 4014	6	Bolt STEEL M10 x 45 ISO 4014	4	Bolt STEEL M24 x 60 ISO 4014	2	Bolt STEEL 8,8 M24 x 65 ISO 4014	8	Screwed Bar M24	2	Bolteye M24	2	Assembly Lifting Tool	1		
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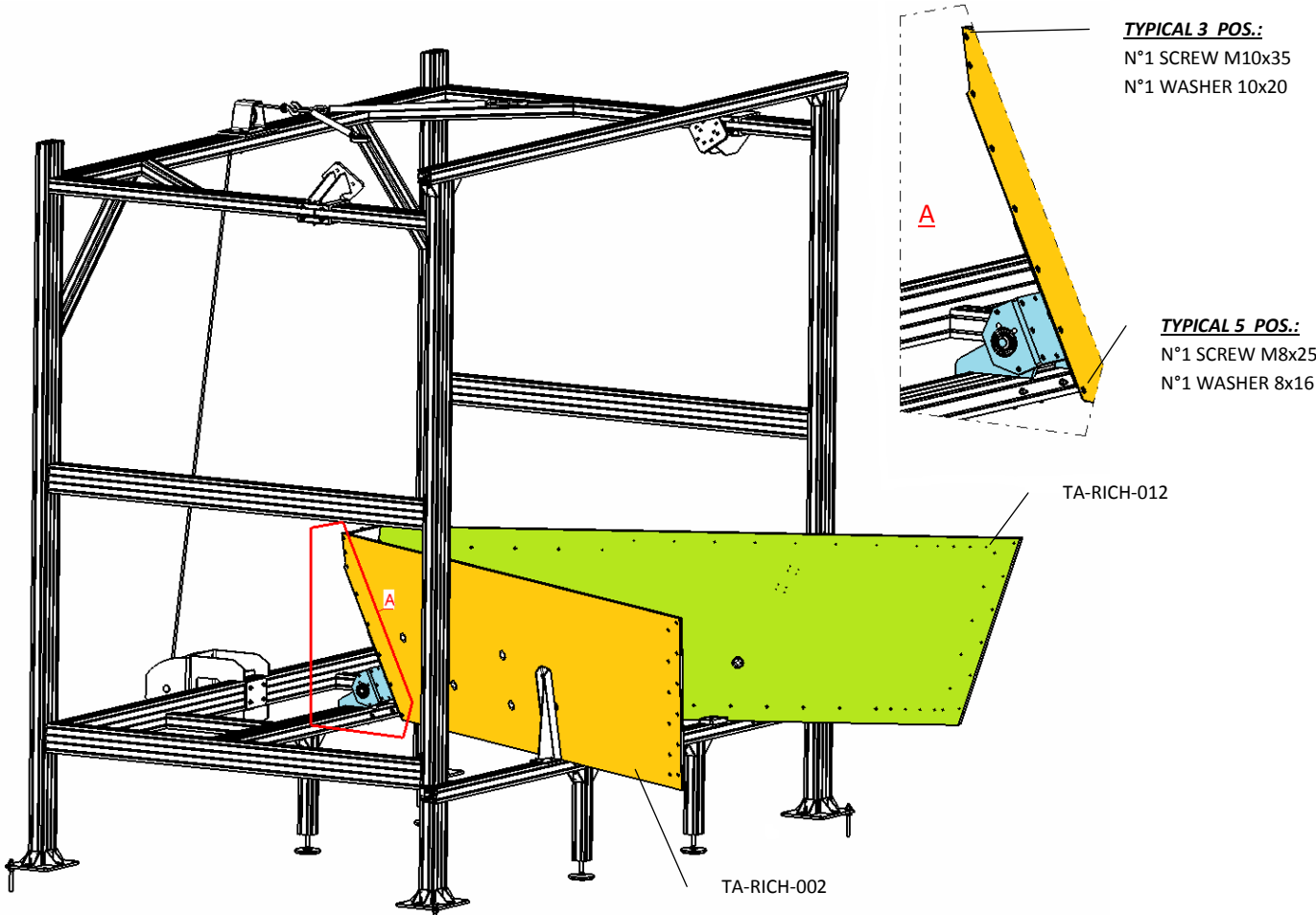
COMPILED BY:	VERIFIED BY:	APPROVED BY:
I. Loi 	M. Pinna 	P. Coluzzi 



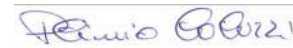
 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 3/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.010</b>	<p>Before beginning the assembly of the RICH CLAS12 module move backward the items:</p> <ul style="list-style-type: none"> <li>• TA-RICH-053;</li> <li>• TA-RICH-054;</li> <li>• TA-RICH-060;</li> <li>• TA-RICH-063</li> </ul> <p>in the way represented in the figure:</p>			
<b>COMPILED BY:</b>		<b>VERIFIED BY:</b>		<b>APPROVED BY:</b>
I. Loi 		M. Pinna 		P. Coluzzi 

 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 4/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.020</b>	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> <li>N° 1 TA-RICH-019</li> <li>N° 1 TA-RICH-020</li> <li>N° 1 TA-RICH-021</li> <li>N° 1 TA-RICH-022</li> <li>N° 4 Screw STEEL M8 x 20 ISO 4762</li> <li>N° 11 Washer STEEL 8 x 16 ISO 7089</li> <li>N° 7 Screw STEEL M8 x 30 ISO 4762</li> <li>N° 8 Screw STEEL M10 x 35 ISO 4762</li> <li>N° 8 Washer STEEL 10 x 20 ISO 7089</li> </ul> <p>Assemble the collected items in the way represented in the figure:</p>	 <p>TA-RICH-019</p> <p>TA-RICH-021</p> <p><b>N.B. Maintain a gap of 0.5 mm between TA-RICH-021 and TA-RICH-020</b></p> <p><b>TYPICAL 4 POS.:</b> N°1 SCREW M8x20 N°1 WASHER 8x16</p> <p><b>TYPICAL 7 POS.:</b> N°1 SCREW M8x30 N°1 WASHER 8x16</p> <p><b>TYPICAL 8 POS.:</b> N°1 SCREW M10x35 N°1 WASHER 10x20</p> <p>TA-RICH-020</p> <p>TA-RICH-022</p> <p>TA-RICH-021</p>		
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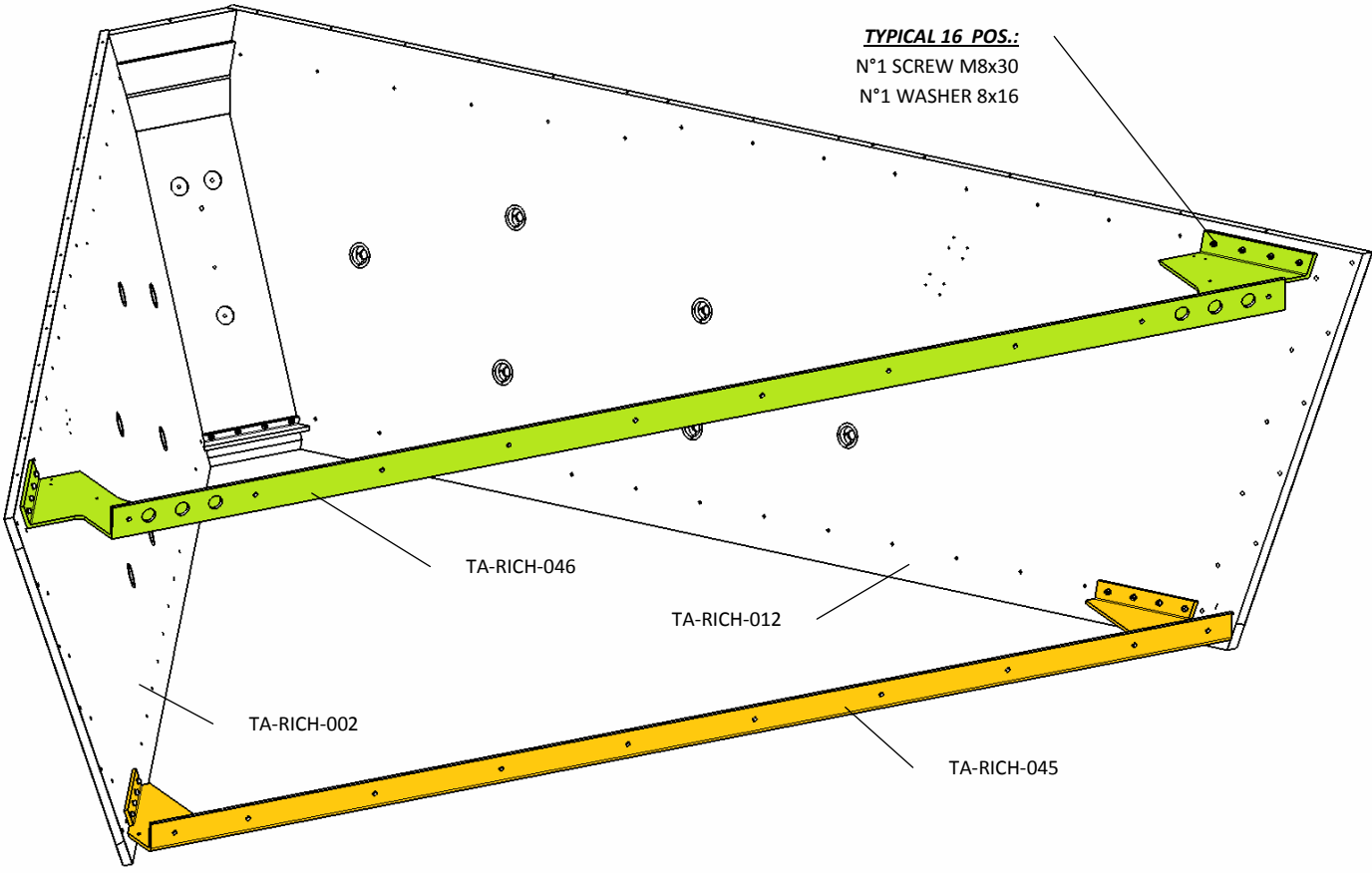
 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 5/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.030</b>  <b>HEAVY OPERATION (80 Kg)</b>	Install the assembled items on TA-RICH-055 by using: <ul style="list-style-type: none"> <li>N° 4 Bolt STEEL M10 x 45 ISO 4014</li> <li>N° 4 Washer STEEL 10 x 20 ISO 7089</li> </ul> in the way represented in the figure:  After that, pull out the locking pins TA-STR-026 from TA-RICH-055.  Turn 65 ° angle the assembly and lock the position obtained through the locking pins, previously removed, in order to make the rotation assembly stable and to continue the assembly, as shown on the side:	  <p><b>TYPICAL 4 POS.:</b>            N°1 BOLT M10x45            N°1 WASHER 10x20</p>  <p>TA-RICH-055</p> <p><b>ASSEMBLY INSTRUCTIONS</b></p>		



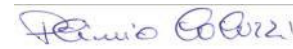
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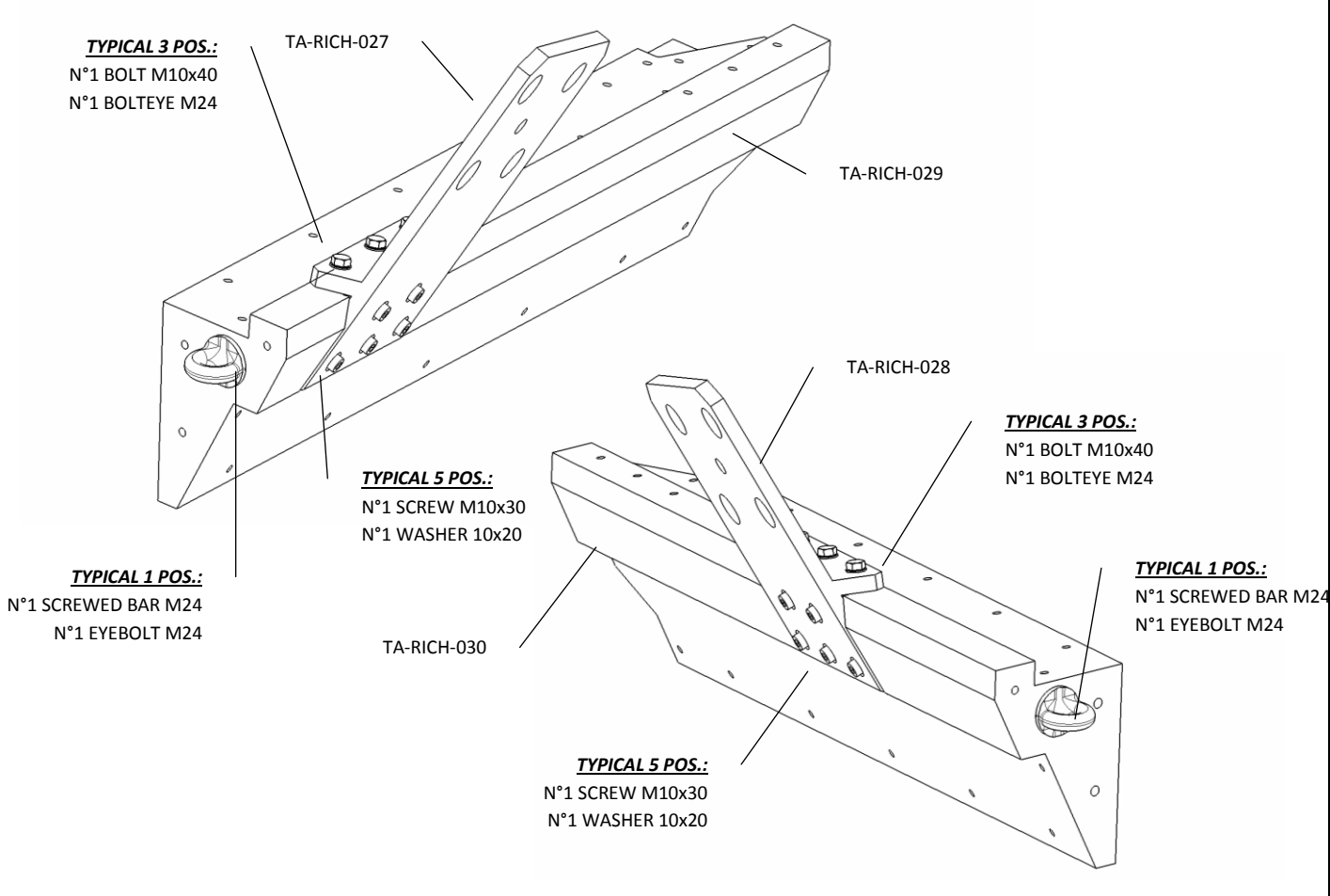
 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 6/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.040</b>  <b>HEAVY OPERATION (130 Kg)</b>	Withdraw the following items: <ul style="list-style-type: none"> <li>N° 1 TA-RICH-002</li> <li>N° 1 TA-RICH-012</li> <li>N° 10 Screw STEEL M8 x 25 ISO 4762</li> <li>N° 10 Washer STEEL 8 x 16 ISO 7089</li> <li>N° 6 Screw STEEL M10 x 35 ISO 4762</li> <li>N° 6 Washer STEEL 10 x 20 ISO 7089</li> </ul> <p>Follow the instruction below and observe the figures:</p>	 <p><b>TYPICAL 3 POS.:</b> N°1 SCREW M10x35 N°1 WASHER 10x20</p> <p><b>TYPICAL 5 POS.:</b> N°1 SCREW M8x25 N°1 WASHER 8x16</p> <p>TA-RICH-012</p> <p>TA-RICH-002</p>		
	<ol style="list-style-type: none"> <li>Take P/N TA-RICH-002 and place on the floor;</li> <li>Position two or more lifting slings around the particular;</li> <li>Take the fork lift and get the harnessed particular as close as possible to the assembled parts;</li> <li>With the support of operators, the forklift and thanks to the installation tools (TA-STR-027, TA-STR-028, TA-STR-029, TA-STR-030), bring TA-RICH-002 in position with TA-RICH-021 in way to allow the assembly;</li> <li>Do the same operations with TA-RICH-012.</li> </ol>			




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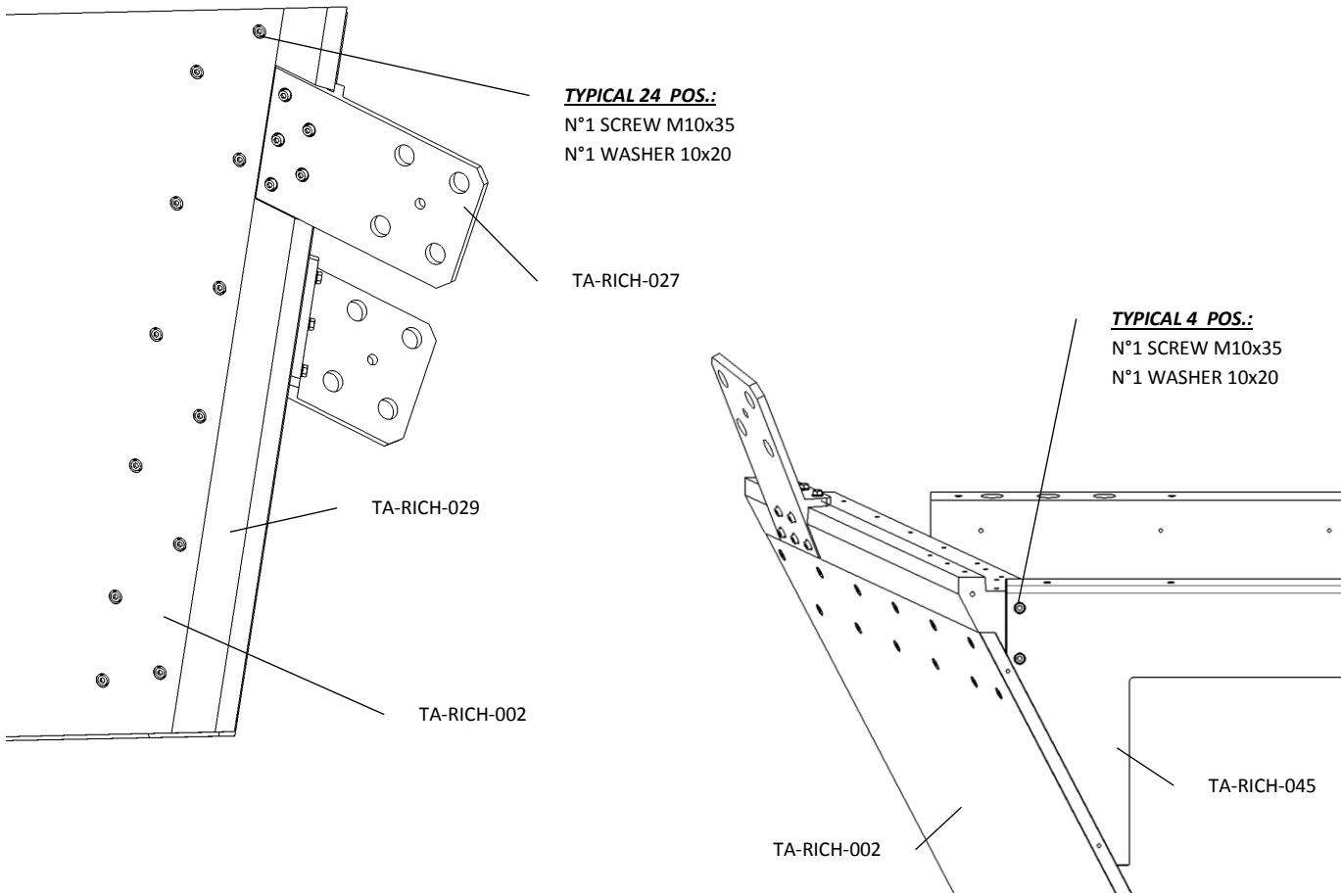



 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 7/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.050</b>	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> <li>N° 1 TA-RICH-045</li> <li>N° 1 TA-RICH-046</li> <li>N° 16 Screw STEEL M8 x 30 ISO 4762</li> <li>N° 16 Washer STEEL 8 x 16 ISO 7089</li> </ul> <p>Assemble the collected items in the way represented in the figure:</p>			


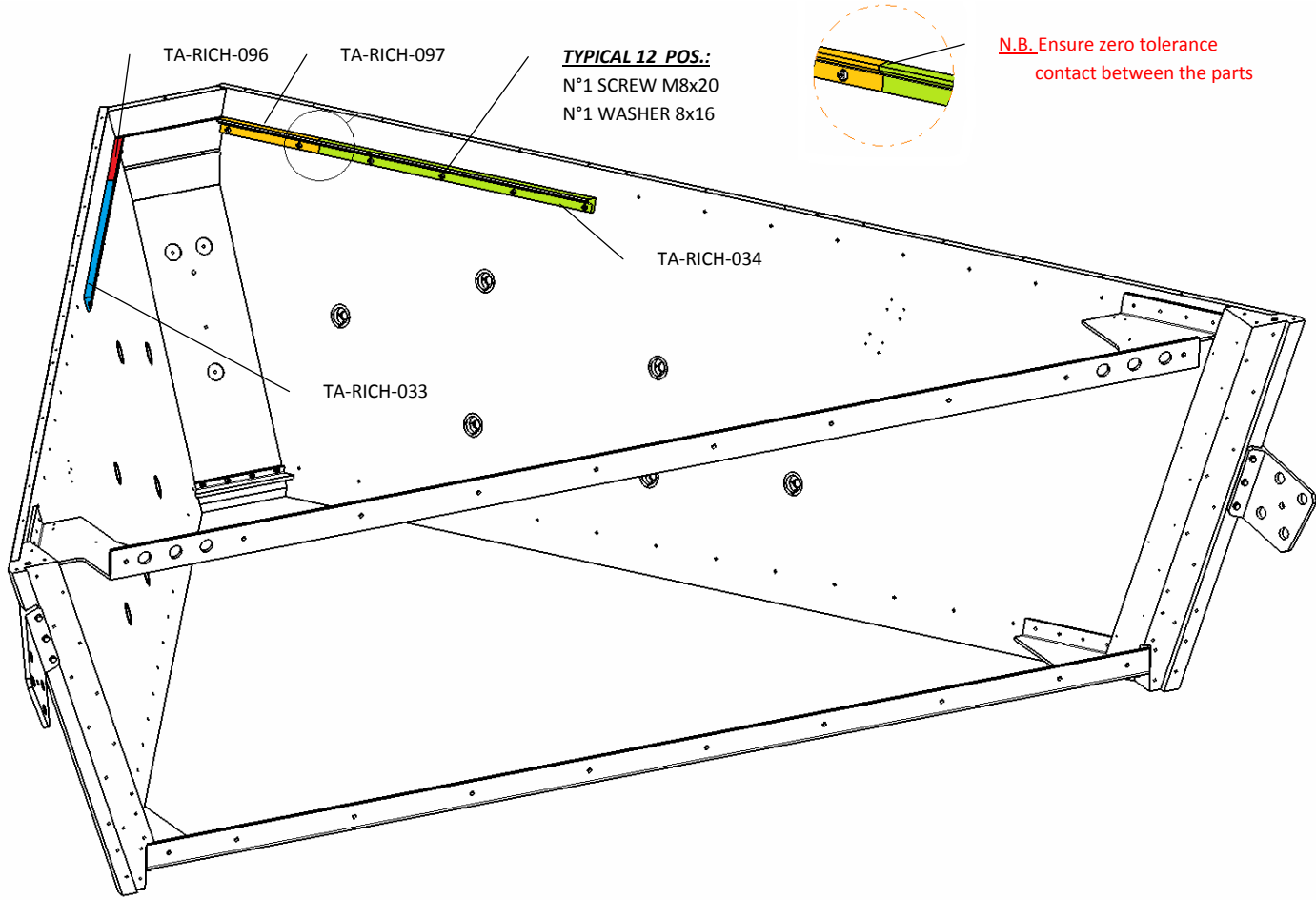
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I. Loi 	M. Pinna 	P. Coluzzi 




 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 8/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.060</b>  <b>HEAVY OPERATION (60 Kg)</b>	Withdraw the following items: <ul style="list-style-type: none"> <li>N° 1 TA-RICH-027</li> <li>N° 1 TA-RICH-028</li> <li>N° 1 TA-RICH-029</li> <li>N° 1 TA-RICH-030</li> <li>N° 6 Bolt STEEL M10 x 40 ISO 4014</li> <li>N° 44 Washer STEEL 10 x 20 ISO 7089</li> <li>N° 38 Screw STEEL M10 x 35 ISO 4762</li> <li>N° 2 Screwed Bar M24</li> <li>N° 2 Bolteye M24</li> </ul> <p>Firstly, assemble TA-RICH-027 with TA-RICH-029 and TA-RICH-028 with TA-RICH-030, than install the M24 Screwed Bars and the eyebolts on them as shown:</p>	 <p><b>TYPICAL 3 POS.:</b> N°1 BOLT M10x40 N°1 BOLTEYE M24</p> <p><b>TYPICAL 1 POS.:</b> N°1 SCREWED BAR M24 N°1 EYEBOLT M24</p> <p><b>TYPICAL 5 POS.:</b> N°1 SCREW M10x30 N°1 WASHER 10x20</p> <p><b>TYPICAL 3 POS.:</b> N°1 BOLT M10x40 N°1 BOLTEYE M24</p> <p><b>TYPICAL 1 POS.:</b> N°1 SCREWED BAR M24 N°1 EYEBOLT M24</p> <p><b>TYPICAL 5 POS.:</b> N°1 SCREW M10x30 N°1 WASHER 10x20</p>		


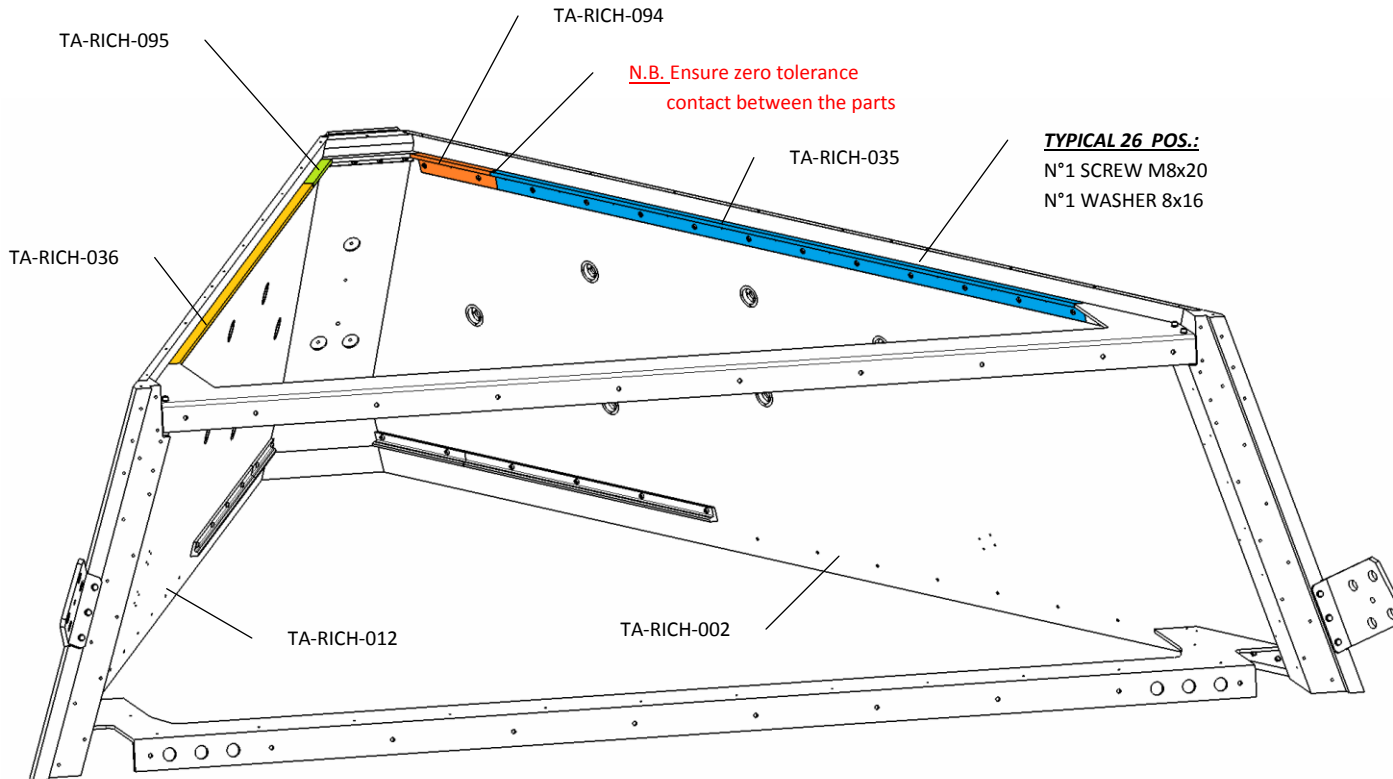
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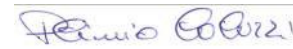



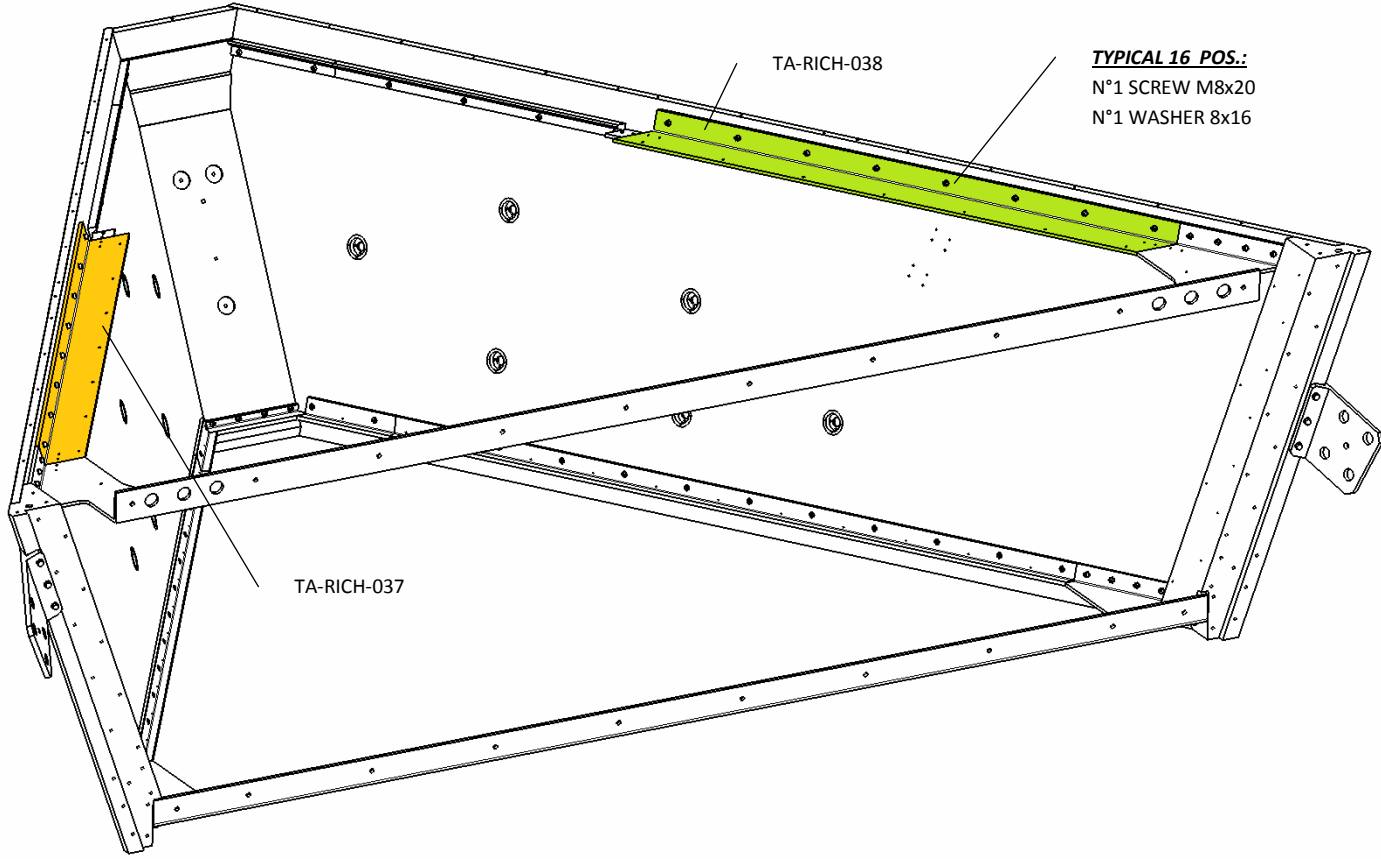
 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 9/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>HEAVY OPERATION (60 Kg)</b>	<p>Assemble the parts with TA-RICH-002 and TA-RICH-012 following the instruction below and observing the figures:</p> <ol style="list-style-type: none"> <li>1) Take TA-RICH-029 and place on the floor;</li> <li>2) Tie a ribbon in the eyebolt and lift using forklift;</li> <li>3) Bring the part next to TA-RICH-002 until you have the surface in abutment with the panel;</li> <li>4) With the support of operators and of the forklift turn TA-RICH-029 until you have each hole perfectly aligned;</li> <li>5) Fix both particulars with the screws previously taken;</li> <li>6) Do the same between TA-RICH-030 and TA-RICH-012;</li> <li>7) Remove Eyebolts and Screwed Bars from TA-RICH-029 and TA-RICH-030.</li> </ol>			
<b>COMPILED BY:</b>		<b>VERIFIED BY:</b>		<b>APPROVED BY:</b>
I. Loi 		M. Pinna 		P. Coluzzi 




 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 10/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.070</b>	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> <li>N° 1 TA-RICH-033</li> <li>N° 1 TA-RICH-034</li> <li>N° 1 TA-RICH-096</li> <li>N° 1 TA-RICH-097</li> <li>N° 12 Screw STEEL M8 x 20 ISO 4762</li> <li>N° 12 Washer STEEL 8 x 16 ISO 7089</li> </ul> <p>Assemble the collected items in the way represented in the figure:</p>	 <p><b>TYPICAL 12 POS.:</b>  N°1 SCREW M8x20  N°1 WASHER 8x16</p> <p><b>N.B. Ensure zero tolerance contact between the parts</b></p>		


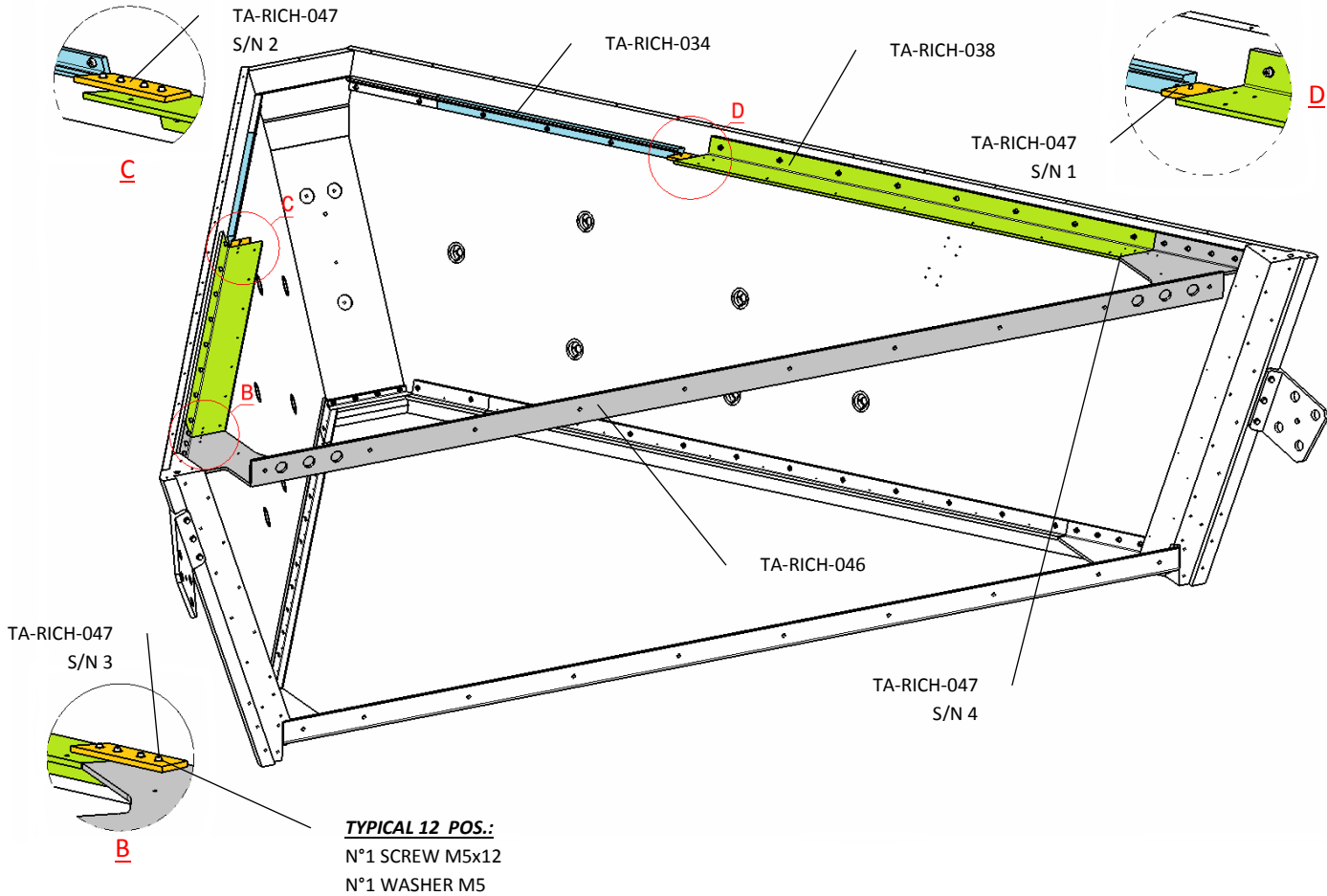


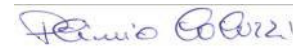
<b>COMPILED BY:</b>	<b>VERIFIED BY:</b>	<b>APPROVED BY:</b>
I. Loi 	M. Pinna 	P. Coluzzi 


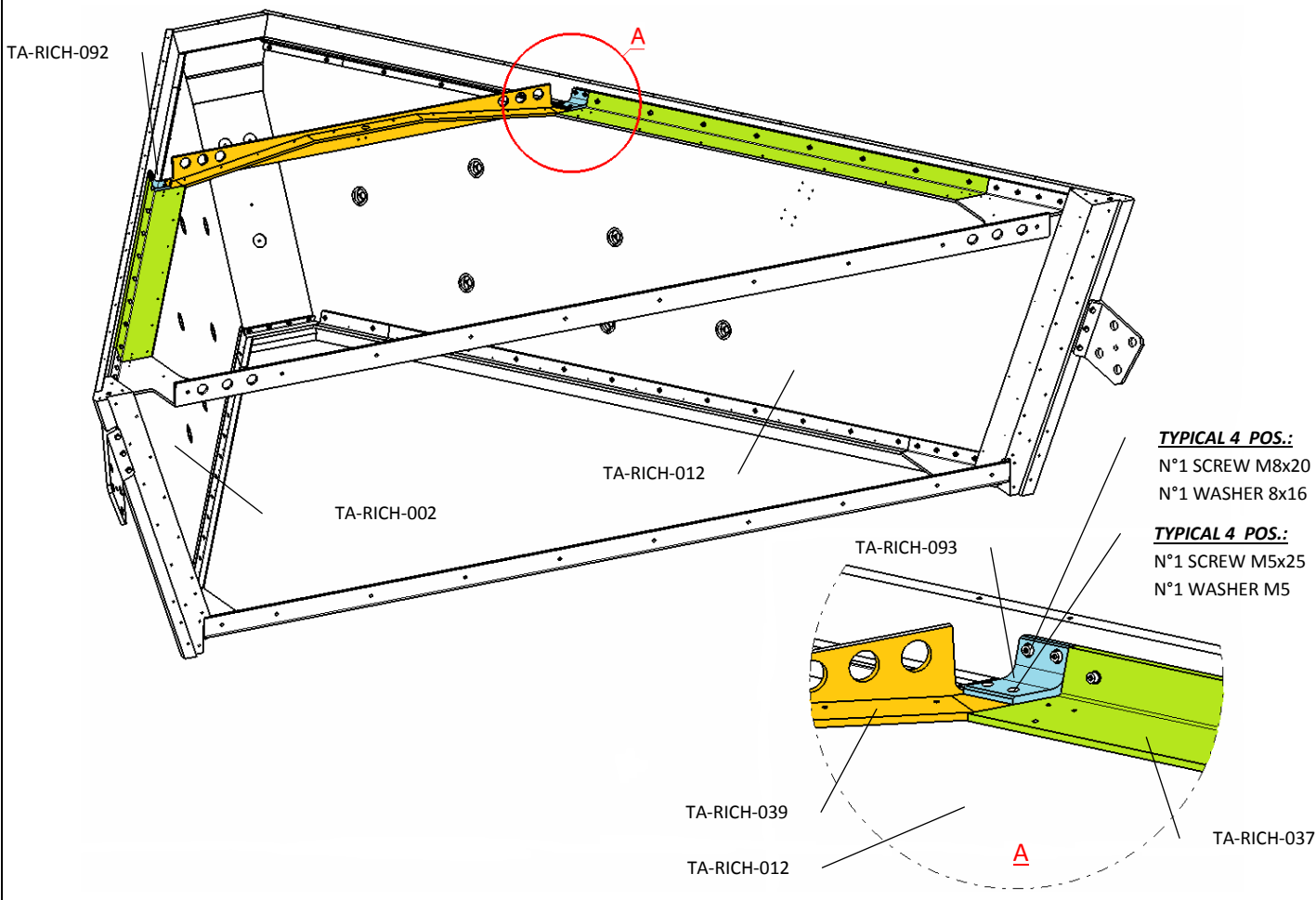


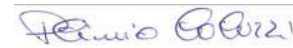
 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 11/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.080</b>	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> <li>N° 1 TA-RICH-035</li> <li>N° 1 TA-RICH-036</li> <li>N° 1 TA-RICH-094</li> <li>N° 1 TA-RICH-095</li> <li>N° 26 Screw STEEL M8 x 20 ISO 4762</li> <li>N° 26 Washer STEEL 8 x 16 ISO 7089</li> </ul> <p>On the opposite side of that shown in the OP.070, assemble the collected items in the way represented in the figure:</p>			

<b>COMPILED BY:</b>	<b>VERIFIED BY:</b>	<b>APPROVED BY:</b>
I. Loi 	M. Pinna 	P. Coluzzi 


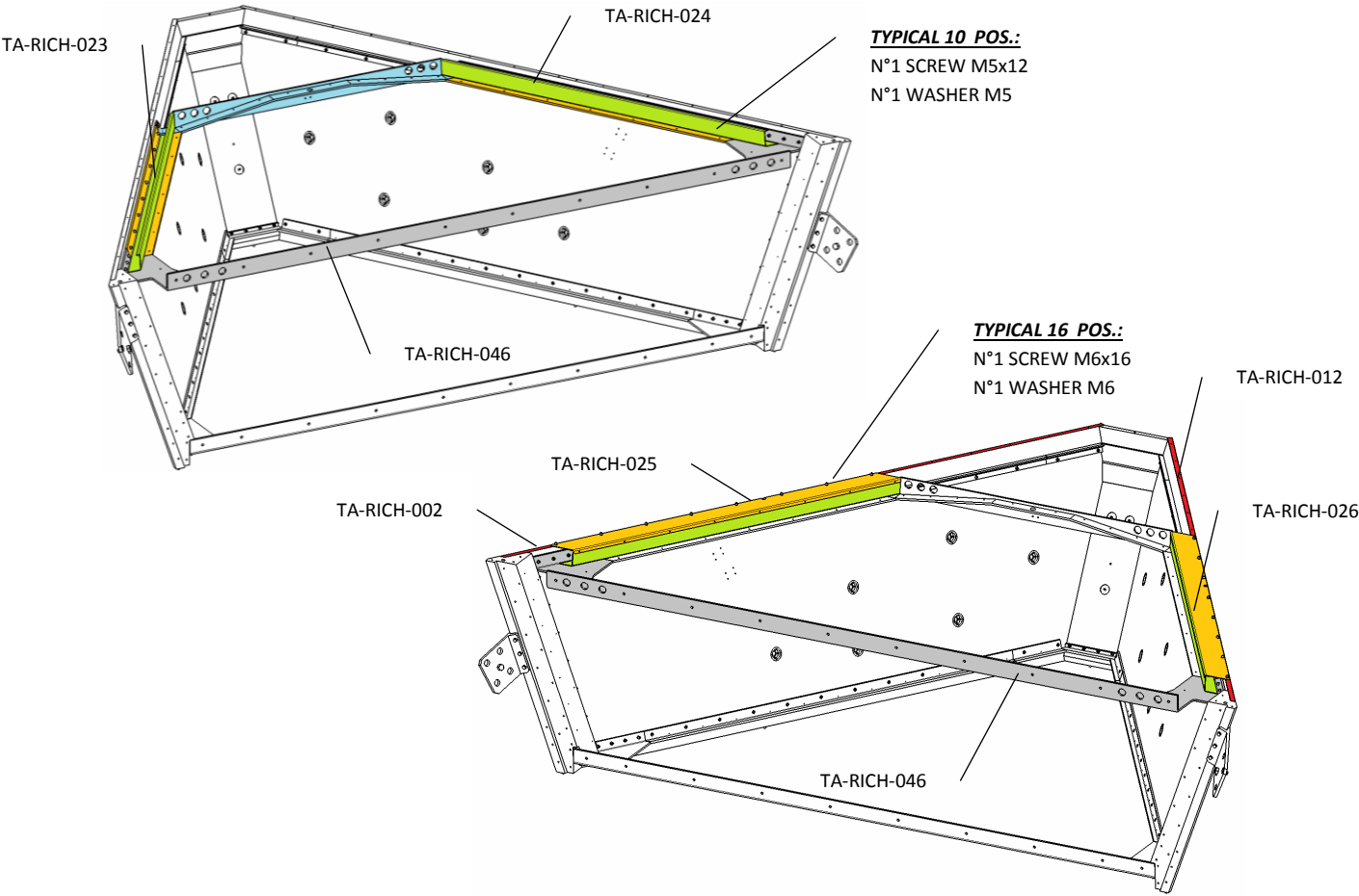


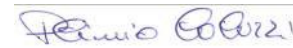
 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 12/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.090</b>	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> <li>N° 1 TA-RICH-037</li> <li>N° 1 TA-RICH-038</li> <li>N° 16 Screw STEEL M8 x 20 ISO 4762</li> <li>N° 16 Washer STEEL 8 x 16 ISO 7089</li> </ul> <p>Assemble the collected items in the way represented in the figure:</p>			


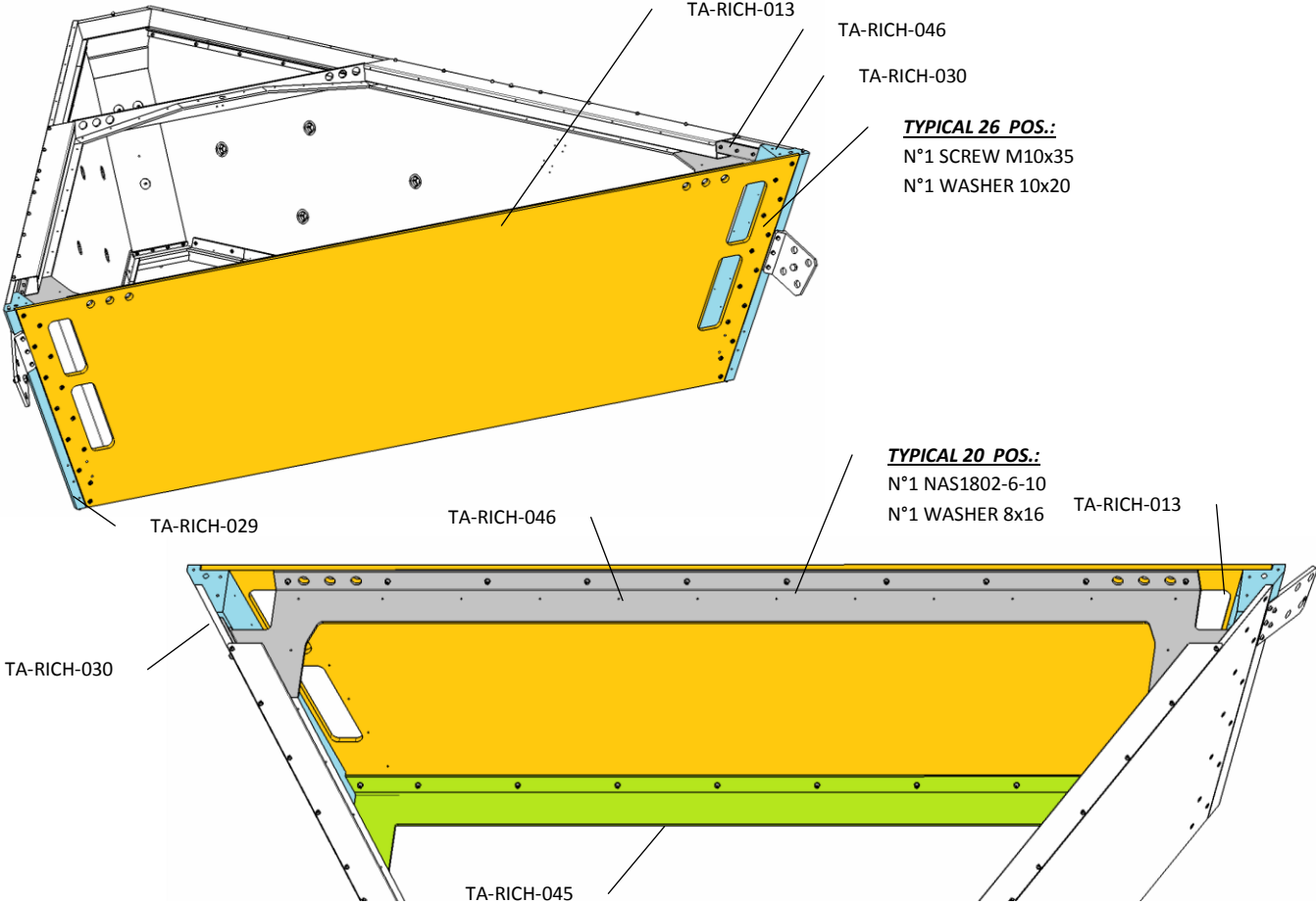
<b>COMPILED BY:</b>	<b>VERIFIED BY:</b>	<b>APPROVED BY:</b>
I. Loi 	M. Pinna 	P. Coluzzi 




 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 13/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.100</b>	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> <li>N° 1 TA-RICH-047 S/N 1</li> <li>N° 1 TA-RICH-047 S/N 2</li> <li>N° 1 TA-RICH-047 S/N 3</li> <li>N° 1 TA-RICH-047 S/N 4</li> <li>N° 12 Screw STEEL M5 x 12 ISO 4762</li> <li>N° 12 Washer STEEL M5 ISO 7089</li> </ul> <p>Assemble the collected items so as to be positioned internally to the RICH case, as represented in the figure:</p>	 <p><b>TYPICAL 12 POS.:</b> N°1 SCREW M5x12 N°1 WASHER M5</p>		
<b>COMPILED BY:</b>		<b>VERIFIED BY:</b>		<b>APPROVED BY:</b>
I. Loi 		M. Pinna 		P. Coluzzi 


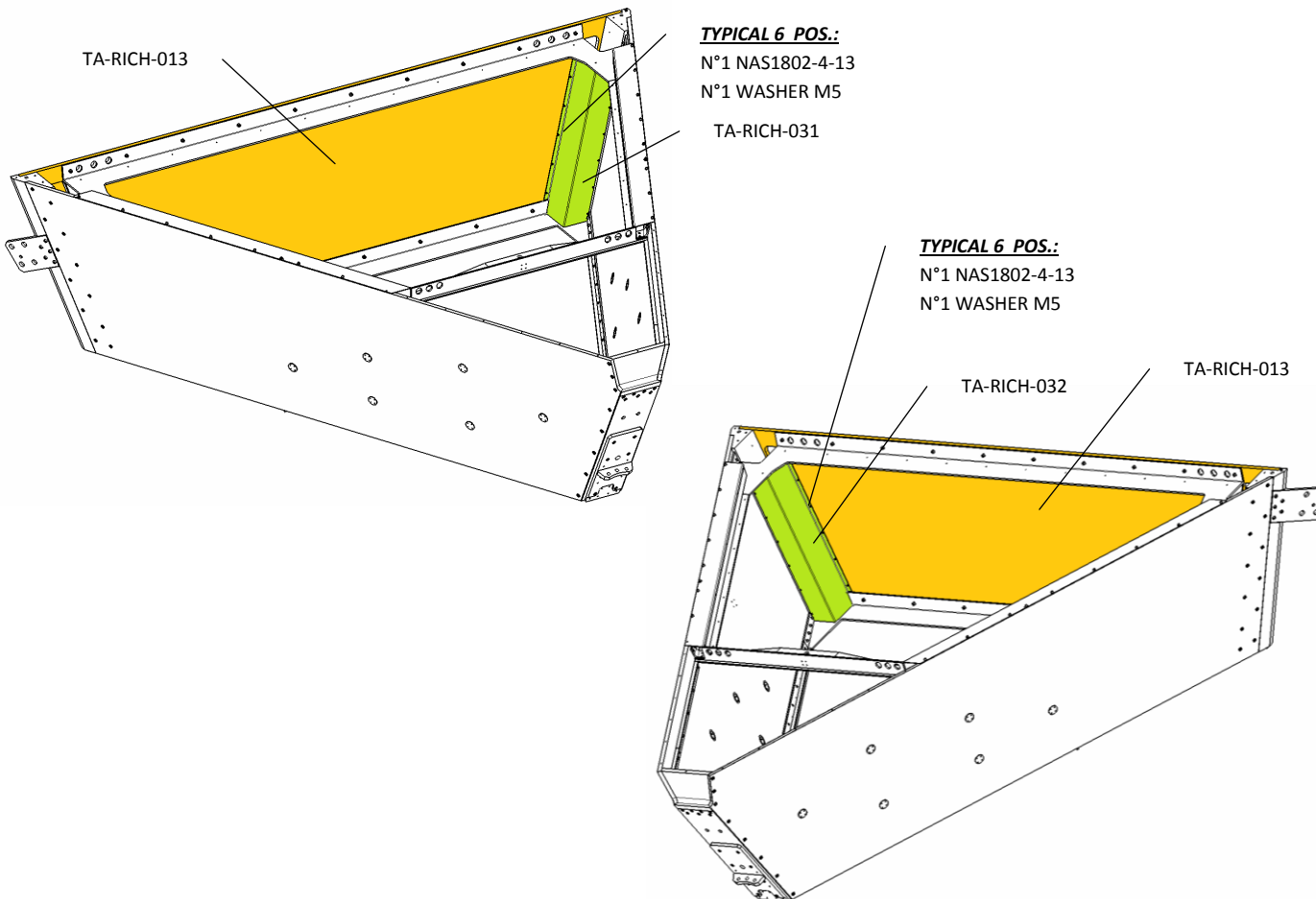
 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 14/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.110</b>	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> <li>N° 1 TA-RICH-092</li> <li>N° 1 TA-RICH-093</li> <li>N° 1 TA-RICH-039</li> <li>N° 4 Screw STEEL M8 x 20 ISO 4762</li> <li>N° 4 Washer STEEL 8 x 16 ISO 7089</li> <li>N° 4 Screw STEEL M5 x 25 ISO 4762</li> <li>N° 4 Washer STEEL M5 ISO 7089</li> </ul> <p>Observing the figure, follow the instructions:</p> <ol style="list-style-type: none"> <li>Place the TA-RICH-039 on TA-RICH-047s;</li> <li>Place TA-RICH-092 and TA-RICH-093 on TA-RICH-039 and assemble them with TA-RICH-047s using Screw M5x25;</li> <li>Assemble TA-RICH-092 on TA-RICH-002 using Screw M8x20;</li> <li>Assemble TA-RICH-093 on TA-RICH-012 using Screw M8x20.</li> </ol>	 <p>TA-RICH-092</p> <p>TA-RICH-002</p> <p>TA-RICH-012</p> <p>TA-RICH-093</p> <p>TA-RICH-039</p> <p>TA-RICH-012</p> <p>TA-RICH-037</p> <p><b>TYPICAL 4 POS.:</b> N°1 SCREW M8x20 N°1 WASHER 8x16</p> <p><b>TYPICAL 4 POS.:</b> N°1 SCREW M5x25 N°1 WASHER M5</p>		
<b>COMPILED BY:</b>		<b>VERIFIED BY:</b>		<b>APPROVED BY:</b>
I. Loi 		M. Pinna 		P. Coluzzi 


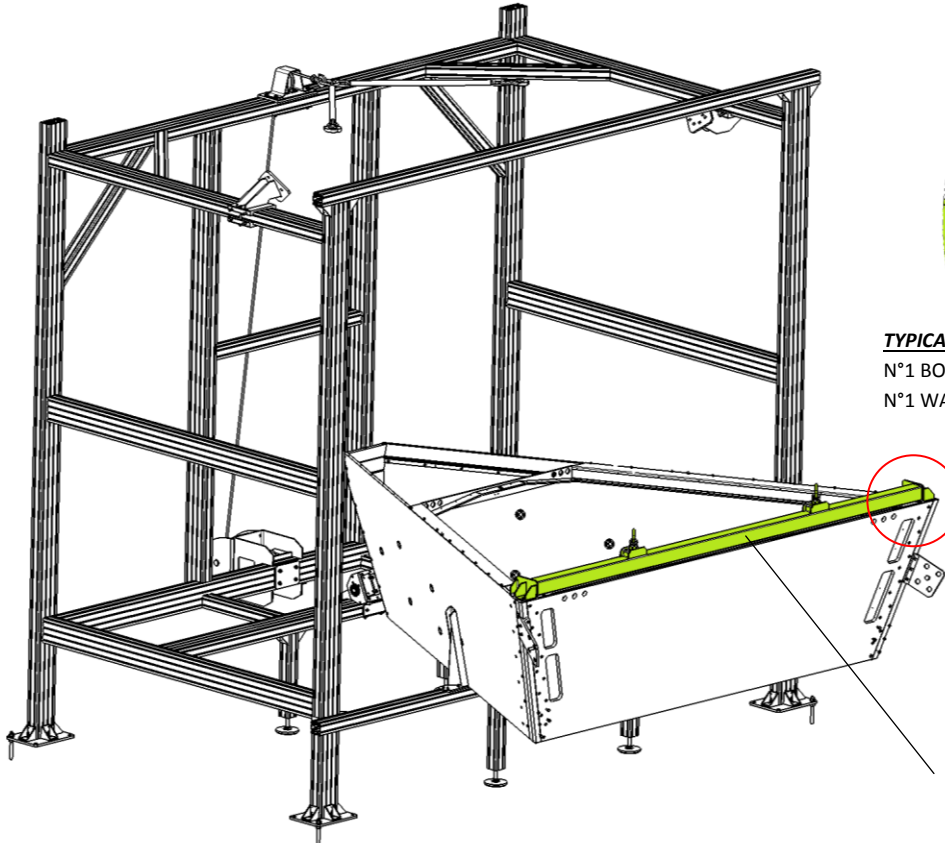




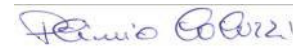
 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 15/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.120</b>	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> <li>N° 1 TA-RICH-023</li> <li>N° 1 TA-RICH-024</li> <li>N° 1 TA-RICH-025</li> <li>N° 1 TA-RICH-026</li> <li>N° 10 Screw STEEL M5 x 12 ISO 4762</li> <li>N° 10 Washer STEEL M5 ISO 7089</li> <li>N° 16 Screw STEEL M6 x 16 ISO 4762</li> <li>N° 16 Washer STEEL M6 ISO 7089</li> </ul> <p>Observing the figure, follow the instructions:</p> <p>1) Place TA-RICH-023 and TA-RICH-024 on TA-RICH-037 and TA-RICH-038 and fix with Screw M5x12;</p> <p>2) Place TA-RICH-025 and TA-RICH-026 and assemble on TA-RICH-002 and TA-RICH-012 them with Screw M6x16.</p>	 <p><b>TYPICAL 10 POS.:</b> N°1 SCREW M5x12 N°1 WASHER M5</p> <p><b>TYPICAL 16 POS.:</b> N°1 SCREW M6x16 N°1 WASHER M6</p>		
<b>COMPILED BY:</b>		<b>VERIFIED BY:</b>		<b>APPROVED BY:</b>
I. Loi 		M. Pinna 		P. Coluzzi 


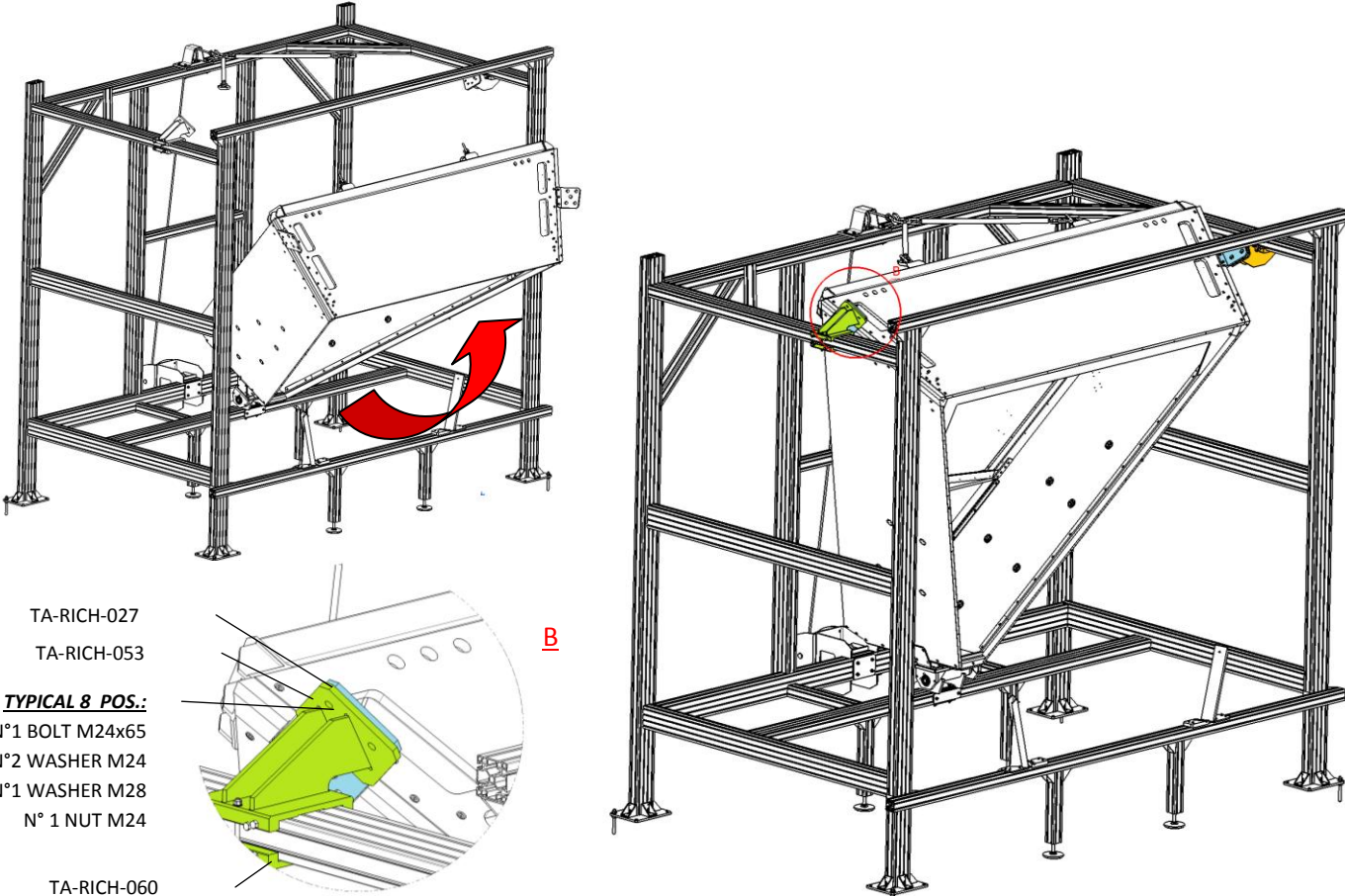
 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 16/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.130</b>  <b>HEAVY OPERATION (80 Kg)</b>	Withdraw the following items: <ul style="list-style-type: none"> <li>N° 1 TA-RICH-013</li> <li>N° 20 Screw NAS1802-6-10</li> <li>N° 20 Washer STEEL 8x16 ISO 7089</li> <li>N° 26 Screw STEEL M10 x 35 ISO 4762</li> <li>N° 26 Washer STEEL 10 x 20 ISO 7089</li> </ul>	 <p><b>TYPICAL 26 POS.:</b> N°1 SCREW M10x35 N°1 WASHER 10x20</p> <p><b>TYPICAL 20 POS.:</b> N°1 NAS1802-6-10 N°1 WASHER 8x16</p>		
	Follow the instruction below and observe the figures: <ol style="list-style-type: none"> <li>Take P/N TA-RICH-013 and place on the floor;</li> <li>Position two or more lifting slings around the particular;</li> <li>Take the fork lift and get the harnessed particular as close as possible to the assembled parts;</li> <li>With the support of operators and of the forklift, bring TA-RICH-013 in position with TA-RICH-029 and TA-RICH-030 in way to allow the assembly, and fix it with Screw M10x35;</li> <li>Complete the assembly fixing TA-RICH-045 and TA-RICH-046 to TA-RICH-013 by NAS1802-6-10.</li> </ol>			



<b>COMPILED BY:</b>	<b>VERIFIED BY:</b>	<b>APPROVED BY:</b>
I. Loi 	M. Pinna 	P. Coluzzi 

 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		P/N: TA-RICH-001	DESCRIPTION: Rich CLAS12 Assembly	SHEET: 17/19
REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES		
OP.140	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> <li>N° 1 TA-RICH-031</li> <li>N° 1 TA-RICH-032</li> <li>N° 12 Screw NAS1802-4-13</li> <li>N° 12 Washer STEEL M5 ISO 7089</li> </ul> <p>Assemble the collected items in the way represented in the figure:</p>	 <p><b>TYPICAL 6 POS.:</b> N°1 NAS1802-4-13 N°1 WASHER M5</p> <p>TA-RICH-031</p> <p><b>TYPICAL 6 POS.:</b> N°1 NAS1802-4-13 N°1 WASHER M5</p> <p>TA-RICH-032</p> <p>TA-RICH-013</p>		
COMPILED BY:		VERIFIED BY:		APPROVED BY:
I. Loi		M. Pinna		P. Coluzzi

 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 18/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.150</b>  <b>HEAVY OPERATION (100 Kg)</b>	Withdraw the following items: <ul style="list-style-type: none"> <li>N° 1 Assembly Lifting Tool</li> <li>N° 2 Bolt STEEL M24x60 ISO 4018</li> <li>N° 2 Washer STEEL M24 ISO 7089</li> <li>N° 4 Bolt STEEL M10 x 35 ISO 4014</li> <li>N° 4 Washer STEEL 10 x 20 ISO 7089</li> </ul>	 <p>TA-RICH-030</p> <p>TA-RICH-046</p> <p>ASSEMBLY LIFTING TOOL</p> <p><b>TYPICAL 4 POS.:</b> N°1 BOLT M10x35 N°1 WASHER 10x20</p> <p><b>TYPICAL 2 POS.:</b> N°1 BOLT M24x60 N°1 WASHER M24</p>		
	Assemble the collected items in the way represented in the figure:			

<b>COMPILED BY:</b>	<b>VERIFIED BY:</b>	<b>APPROVED BY:</b>
I. Loi 	M. Pinna 	P. Coluzzi 

 <b>Tecnologie Avanzate</b>		<b>Installation &amp; Control Scheme</b>		Mod. 75/95/00
		<b>P/N: TA-RICH-001</b>	<b>DESCRIPTION: Rich CLAS12 Assembly</b>	SHEET: 19/19
<b>REV.</b>	<b>DATE</b>	<b>REVIEW'S REASON</b>	<b>MODIFIED PHASES</b>	<b>SIGNATURE</b>
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
<b>WORKING CYCLE PHASE</b>	<b>DESCRIPTION AND NOTES</b>	<b>IMAGES</b>		
<b>OP.160</b>  <b>HEAVY OPERATION (700 Kg)</b>	Withdraw the following items: <ul style="list-style-type: none"> <li>N° 8 Bolt STEEL 8,8 M24 x 65 ISO 4014</li> <li>N° 8 Washer STEEL 8,8 M28 ISO 7089</li> <li>N° 16 Washer STEEL M24 ISO 7089</li> <li>N° 8 Nut STEEL 8,8 M24 ISO 4032</li> </ul> <p>Follow the instruction below and observe the figures:</p> <ol style="list-style-type: none"> <li>Fix the hooks to Assembly Lifting Tool's eyebolts;</li> <li>Using Tackle System Assy lift up the RICH CLASS12 Assembly unless the Inner Plate TA-RICH-021 is parallel with the floor;</li> <li>Move forward Stirrup Supports TA-RICH-053, TA-RICH-054, TA-RICH-060, TA-RICH-063 until intercepting Connection Stirrups TA-RICH-027, TA-RICH-028;</li> <li>Using the item collected, fix the RICH CLASS12 Assembly with the Structure through the Stirrups Supports.</li> </ol> <p><b>N.B.</b> During the lifting, make sure that the movement is continuous and constant.</p> <p><b>N.B.</b> Ensure proper cable winding during lifting.</p>	 <p>TA-RICH-027 TA-RICH-053</p> <p><b>TYPICAL 8 POS.:</b>  N°1 BOLT M24x65  N°2 WASHER M24  N°1 WASHER M28  N° 1 NUT M24</p> <p>TA-RICH-060</p> <p><b>B</b></p>		

<b>COMPILED BY:</b>	<b>VERIFIED BY:</b>	<b>APPROVED BY:</b>
I. Loi 	M. Pinna 	P. Coluzzi 