

OPERATOR'S MANUAL

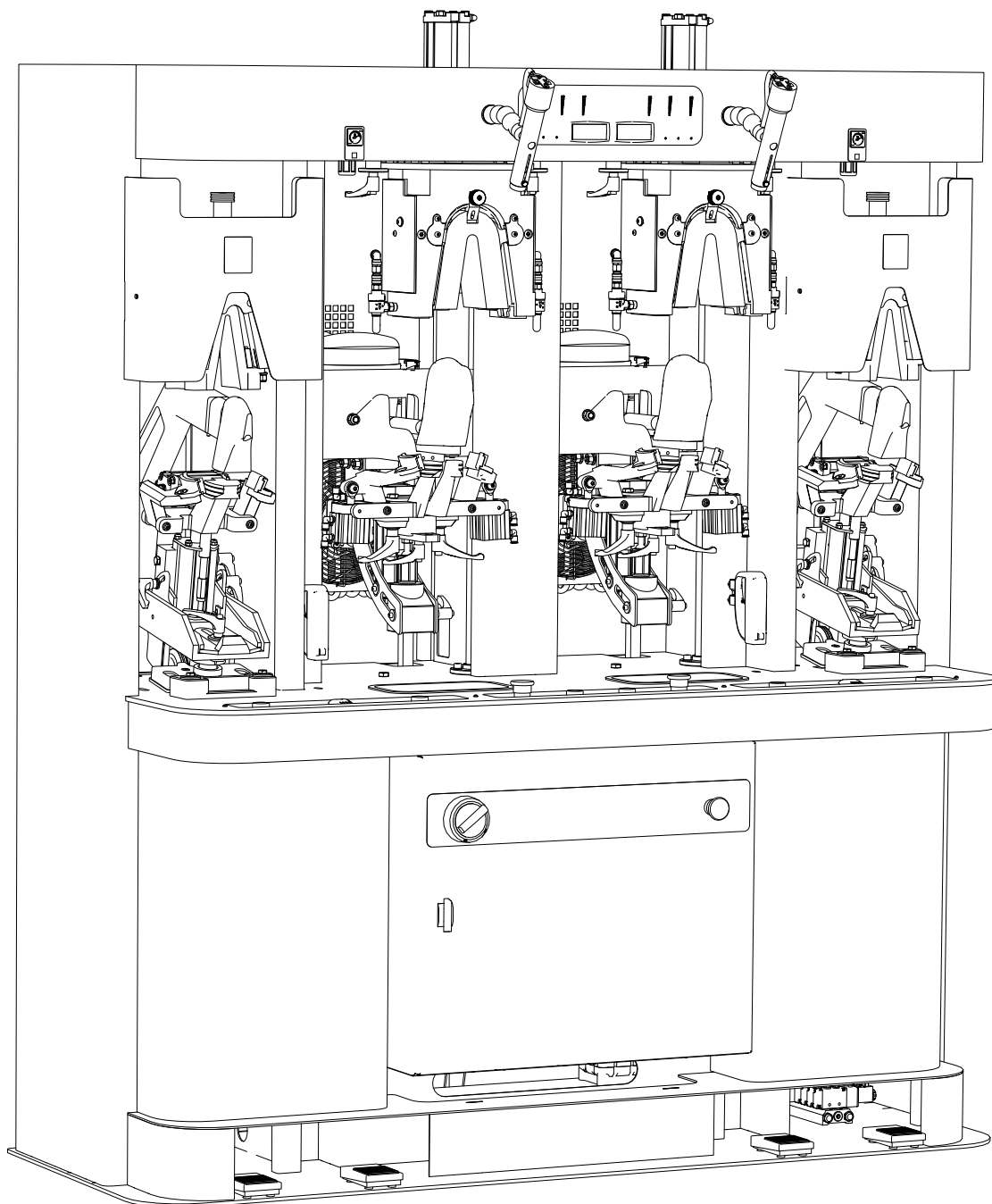


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Introduction

The purpose of this manual is to inform the owner of this machine for its operation, its maintenance and for all the safety regulations.

Please read carefully all the instructions and follow them in order to use the machine properly in the production and avoid any case of injuries.

Our company does not have any responsibility for any changes happened on the machine by the owner, or actions which are different to what this manual refers.

SAFETY REGULATIONS

This machine is intended for professional use only.



WARNING!

Only one operator may work on the machine at a time.



WARNING!

Read and follow carefully all the relative instructions to avoid serious injury.

Only qualified and authorized personnel must use the machine.

- Operators are expressly forbidden to use the machine under the influence of alcohol or drugs capable of affecting physical and mental capacity.
- Keep unauthorized persons away from the work area.
- Make sure that the machine has been installed in compliance with the established legislation and standards.
- Always keep this user manual in a place where it can be readily consulted when working on the machine. Consult it whenever you are in need of information or explanation.
- Do not remove or deface the safety, danger, warning or instruction signs. Replace any missing or illegible Danger, Warning or instructions signs.
- Never use the machine if you notice any damaged electric wires.
- Never install the machine outdoors or in any place with a lot of moisture.



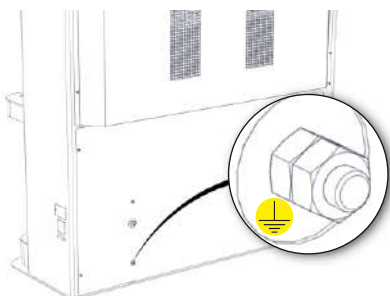
WARNING

Use only original spare parts, which can be supplied by the manufacturer or the local agent. Otherwise, your machine will not be a CE product.



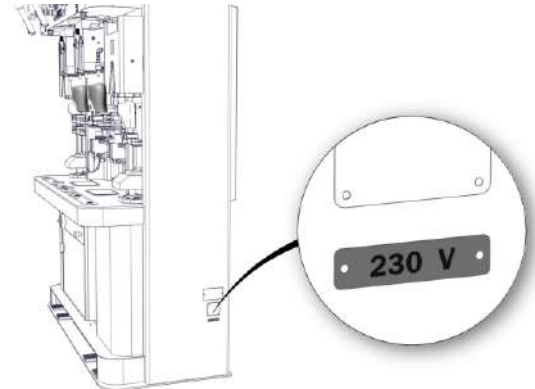
WARNING

The machine frame must be earthed using the outside connection point marked according to the CE norms.



Electric and pneumatic connections

1. Connect the machine (SINGLE PHASE 220V - 50/60Hz).
2. Before plugging in the machine, check that the main supply voltage is the same as that indicated on the label situated on the back side of the machine.

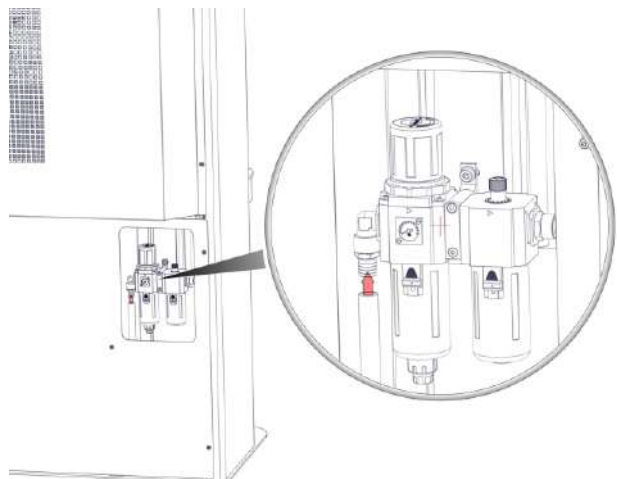


3. Check if the plug and socket have the same technical type. If not, use the suitable adapter after having consulted a certified electrician.

4. To disconnect the machine, turn the main switch off and remove the plug from the outlet.

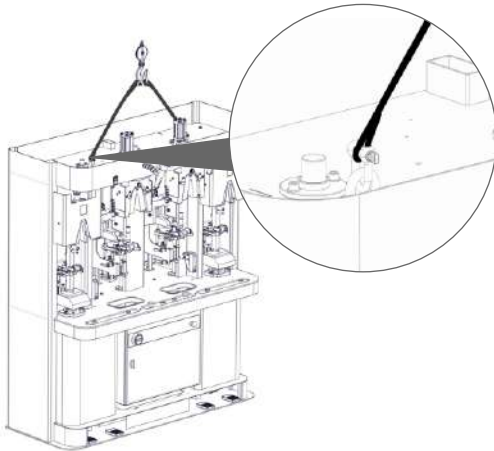


5. Connect the machine to air pressure 6 - 8bar.
6. Connect the proper pneumatic hose. Set the main pressure regulator, which is found, on the back part of the machine to 6 Bar.

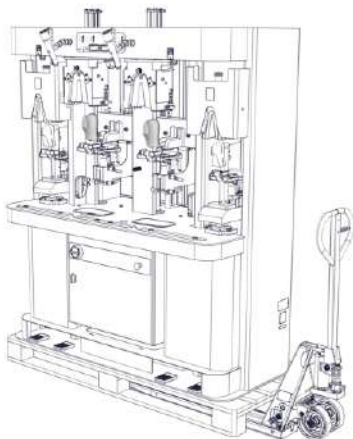


Transportation

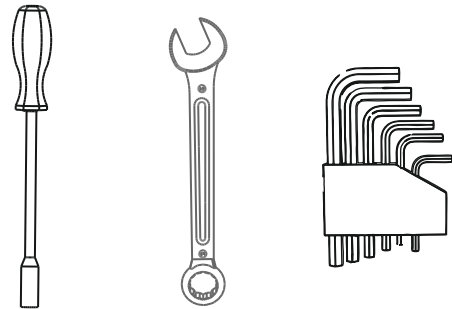
1. Use the clevis's existed on the top of the machine with proper belts to lift the machine.



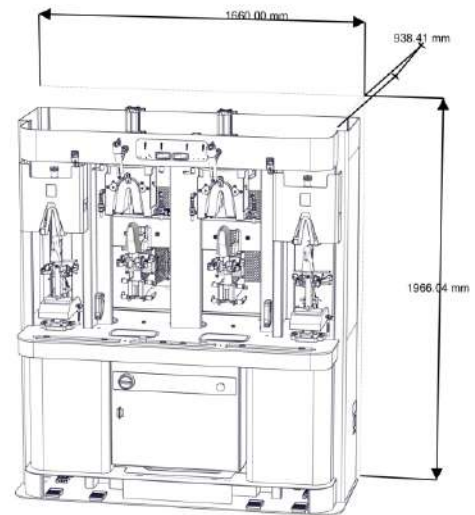
2. Pass the trans-pallet's forks under the pallet as shown in the Figure below.



Packaging Components



Technical data & Dimensioning



TECHNICAL DATA

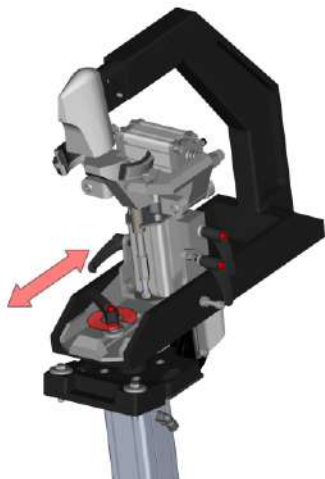
OPERATION	Electro - Pneumatic
PRESSURE	6Bar
CAPACITY	1100 pairs per 8 hours max.
VOLTAGE	230V single phase 50Hz
POWER CONSUMPTION	2500 W
DIMENSIONS (mm)	1660 X 938 X 1986h
WEIGHT	560Kgs

Pincers Adjustments

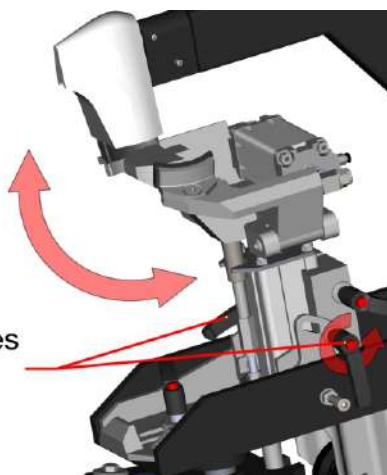
Hot station's pincers adjustments



Loose the handle as shown to move pincers vertically.



Release the handle as shown above, to move pincers horizontally.

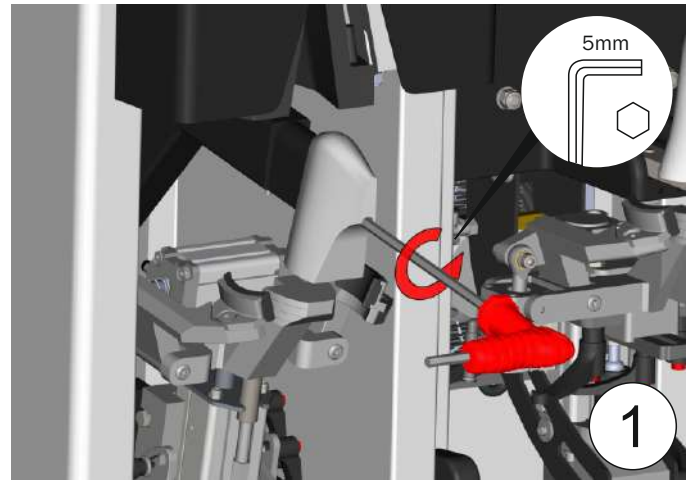


Release both handles
to adjust inclination

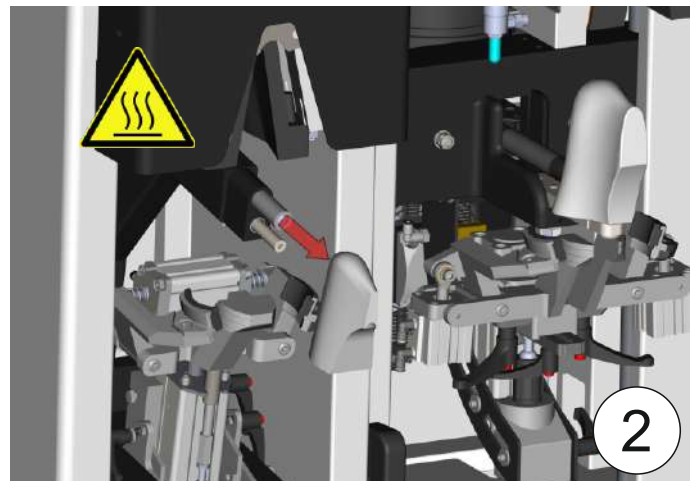
Must be used use it for high heel uppers.

Aluminum Mould replacement

Hot station's aluminum mould replacement

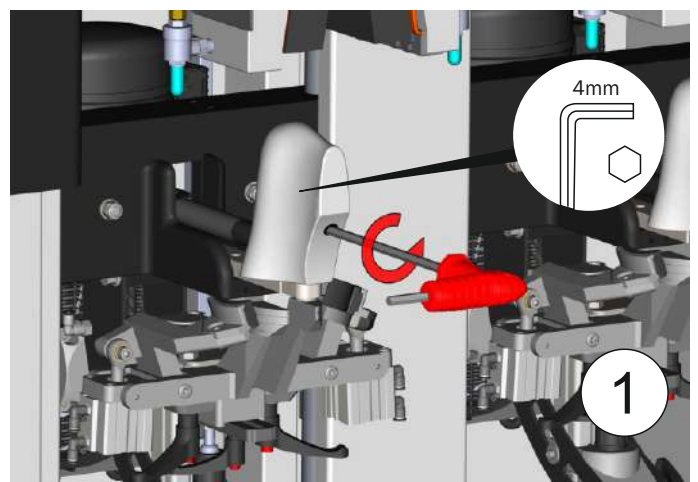


Use a 5mm allen key to loose screw.



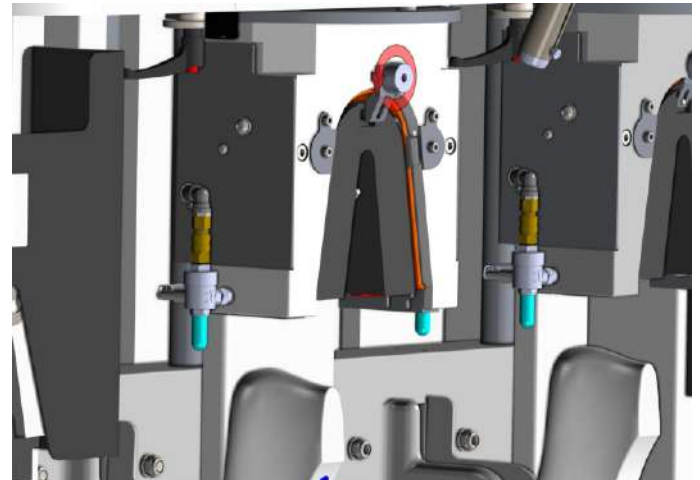
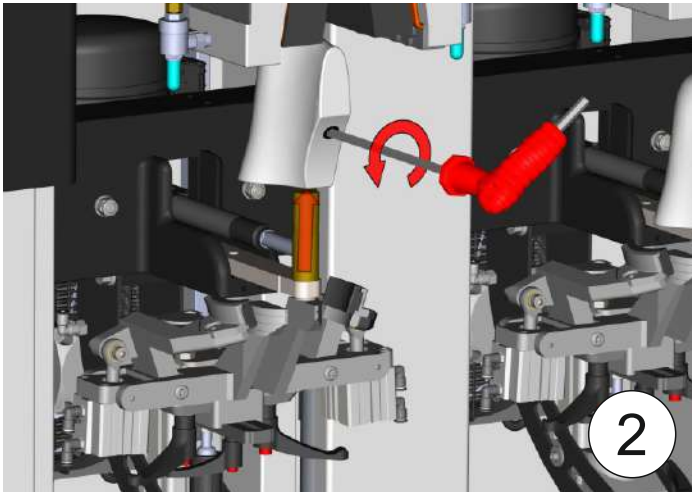
Be careful of the hot surface while removing the last.

Cold station's aluminum mould replacement



Use a 4mm allen key to loose screw.

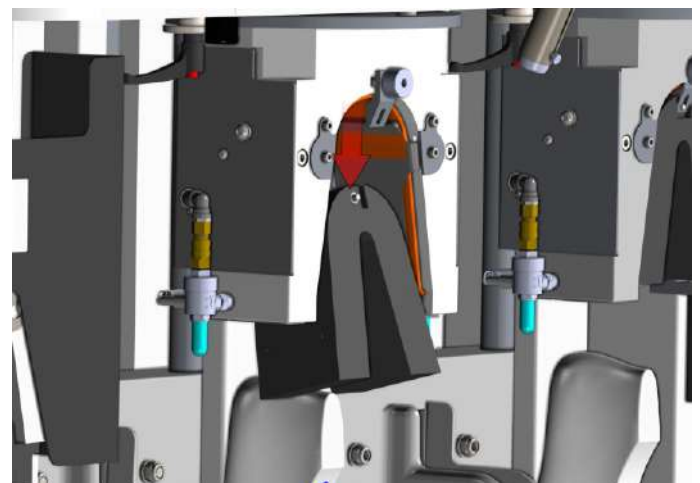
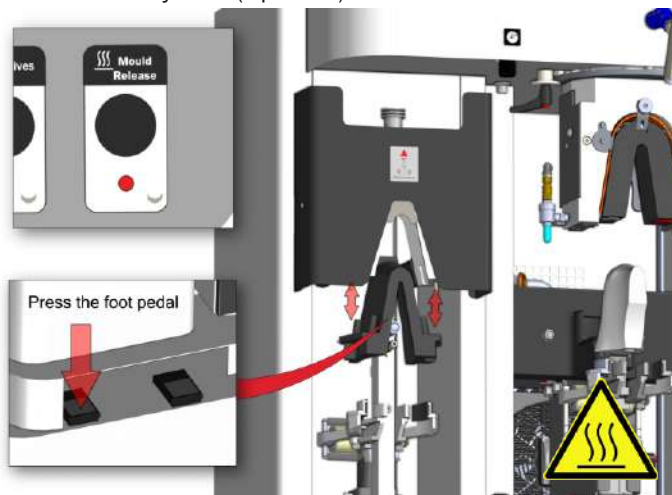
Cold Station P.U Mould Replacement



Loose the nut and pull slightly the mould support plate

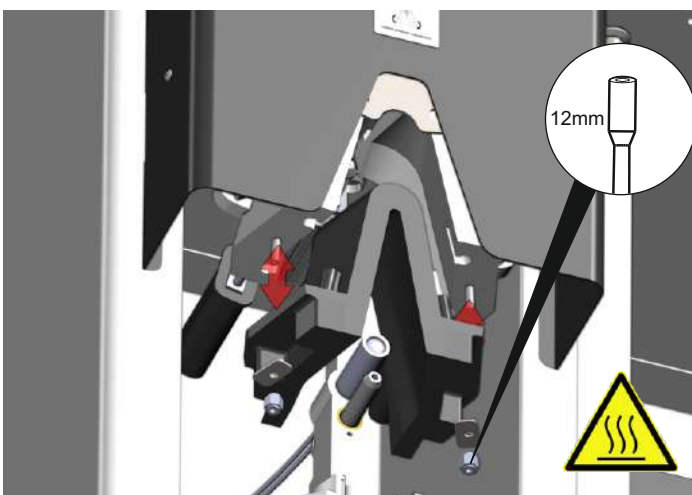
Hot Station's Rubber Mould Replacement

Mould release system (Optional)

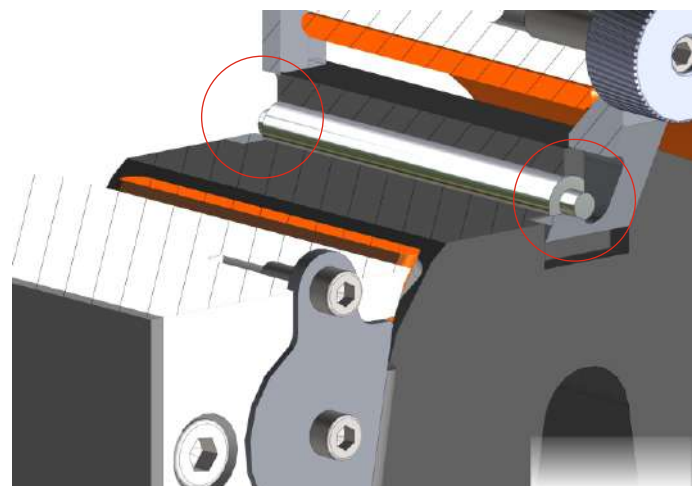


Remove the mould.

Standard mould change

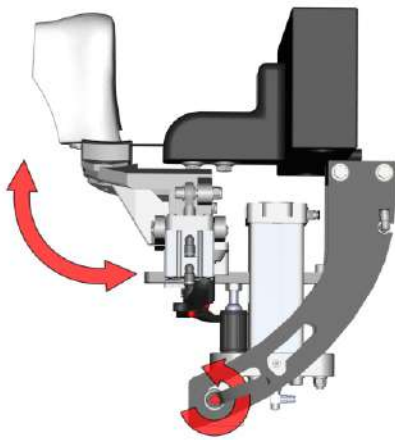


Use a 12mm wrench or nut to remove the mould

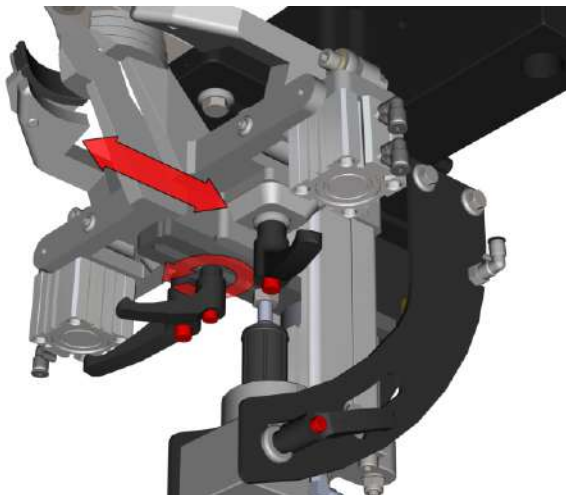


Important: During placement ensure that the pin is will be firmly placed between the two metal plates.

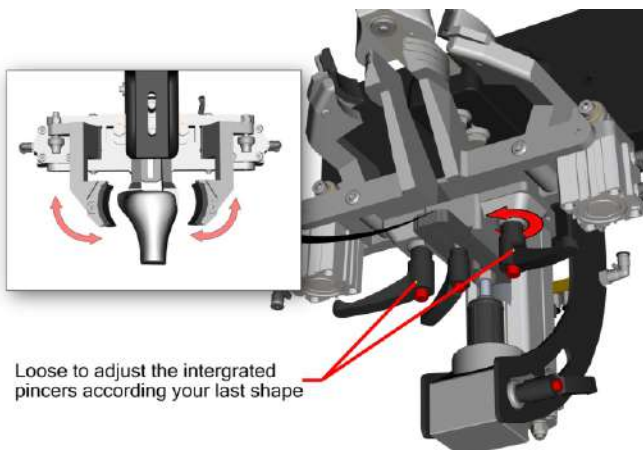
Cold's station pincers adjustments



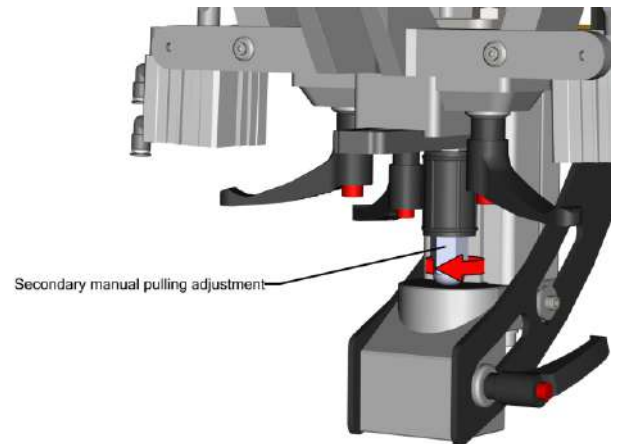
Loose the handle as shown above, and change inclination.



Release the handle as shown above, and move pincers inside-out.



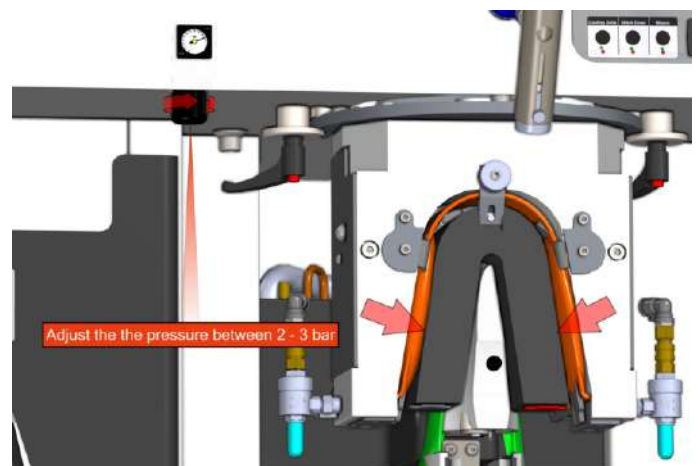
Loose to adjust the integrated pincers according your last shape



Manual pulling adjustment available also.

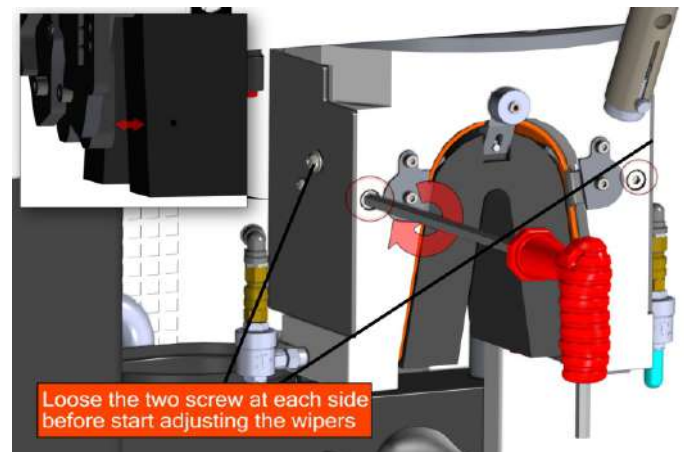
Extra adjustments

Cushion pressure adjustments (1 - 2,5 bar)



Adjust the the pressure between 2 - 3 bar

Wipers adjustments

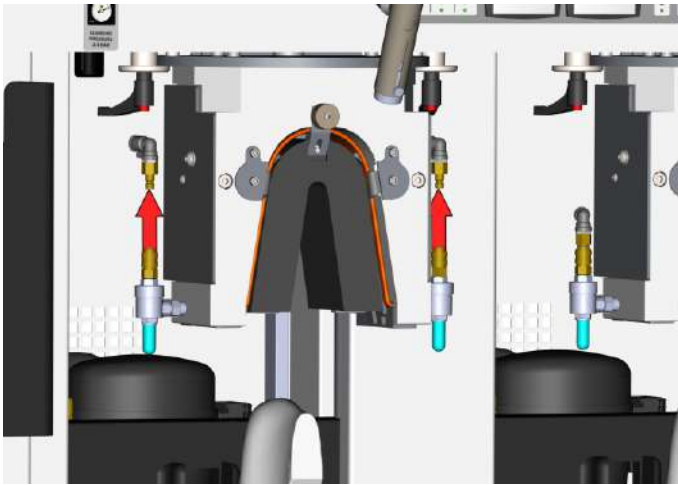


Loose the two screw at each side before start adjusting the wipers

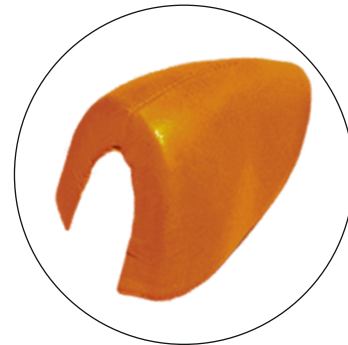
Adjust the wipers by using a 6mm allen key as shown in the picture. Do not forget to loose the side mounted screws.

Cushion Rotation

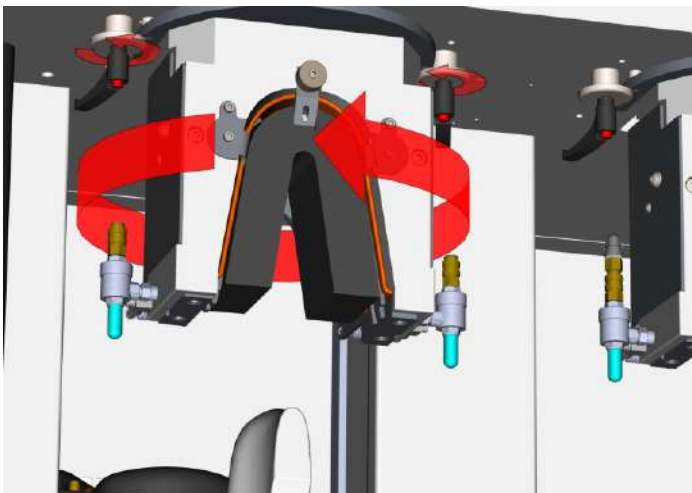
When the cushion is rotated the machine can perform the below procedures



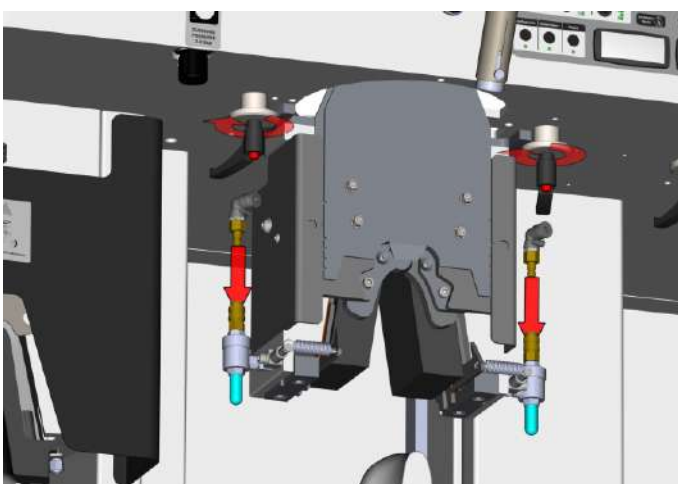
Unplug the side couplings.



Mini - counter flanging



Loose the handles, and rotate the head 180°.



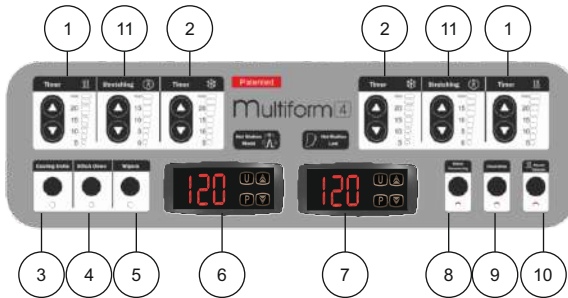
Tight the handles, and plug the couplings.



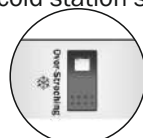
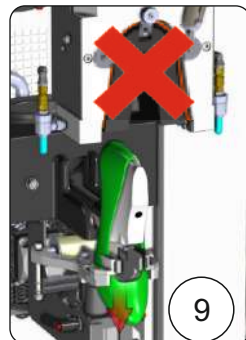
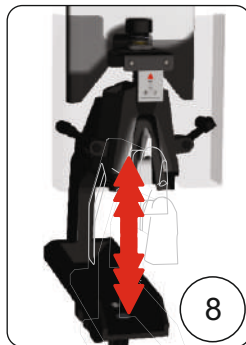
Mocassin Flanging
(On demand)

Panel Adjustments

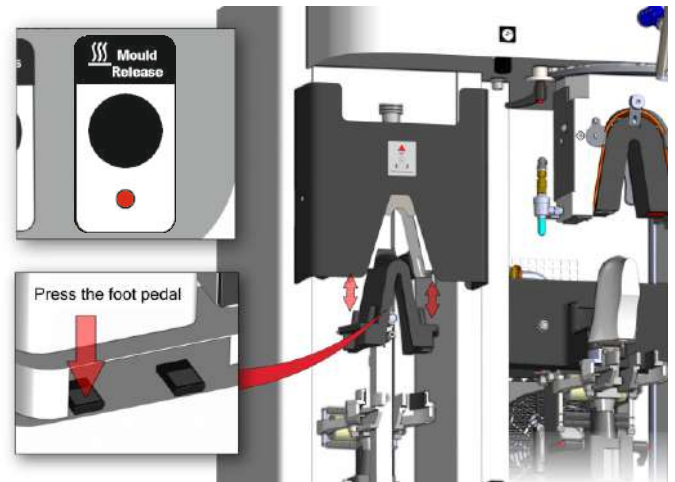
Warning: when opening the general switch of the machine, wait for the indications on the display panel, to stop blinking.



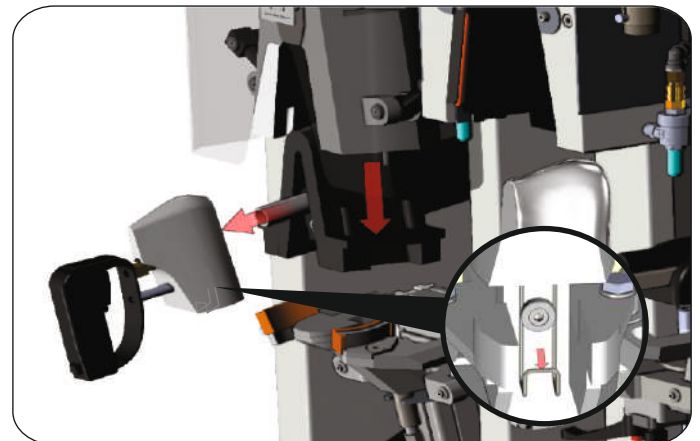
1. Adjust the cycle time of the hot station
2. Adjust the cycle time of the cold station
3. Cooling unit on/off
4. Press to execute the stitch down procedure. The optional stitch down attachment must be installed on the machine.
5. Activate / deactivate the wipers. Activate the wipers in order to succeed flanging in the back-part of the shoe upper.
6. Controls the temperature of silicon rubber in both hot stations. Range from 130 °C to 170 °C.
7. Controls temperature for aluminum (teflon coated) lasts in both hot stations. Range from 80 °C to 150 °C.
8. Stitch Hammering (optional): When activated creates a “hammering simulation” at the end of the hot station's cycle in order to better open the back seem of the upper. Ideal for ladies uppers.
9. Decoratives: When activated the cold station cushions are deactivated in order to avoid decoratives breaking. The upper remain pulled on the cold station pincers until the end of operation cycle.
10. Mould release (optional): Activate / deactivate the auto mould release system of the hot station. See the procedure below.
11. Stretching: adjusts electronically the cold station's pincers pulling. Avoid the repetitive pulling of the upper by pressing the pedal and as soon as you press once use the over-stretching button to add extra pulling when necessary.



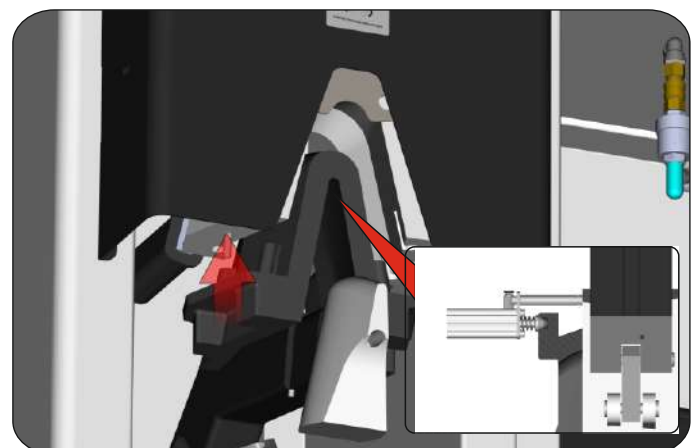
Mould release (optional)



Press the pedal while you have activated the mould release function on the panel.

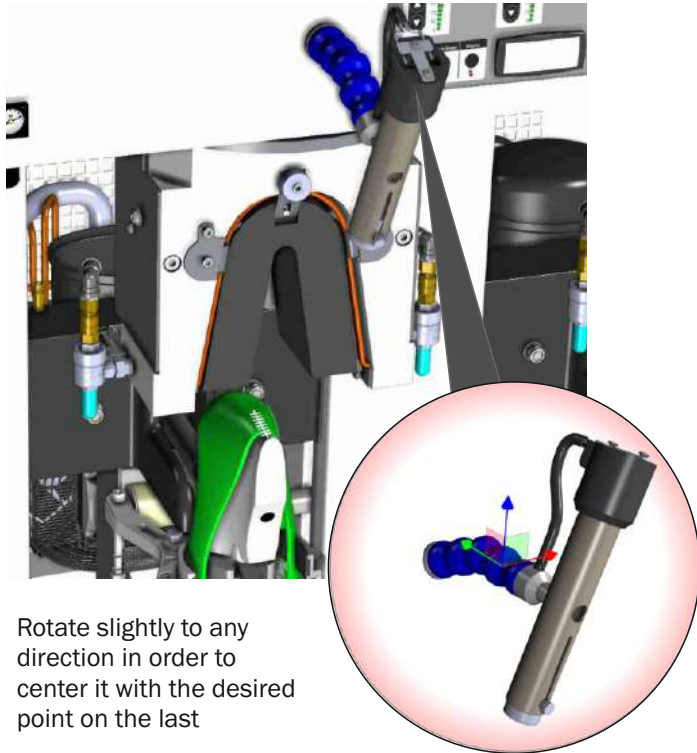


Use the special air gun as shown in the picture while in the same time pull the special wire of the last.



During mould placement ensure that the pin will get in the hole as shown

Projector adjustments

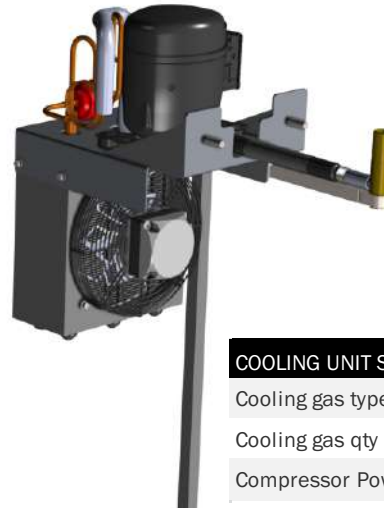


Rotate slightly to any direction in order to center it with the desired point on the last

Maintenance of cooling unit

Clean the condenser (radiator) of the cooling unit once per month by using pressure.

Each cooling unit is provided with a two (2) years operation warranty, with the appropriate maintenance. Warranty does not cover damage caused by misuse and/or lack of maintenance.



COOLING UNIT SPECIFICATIONS

Cooling gas type	R404A
Cooling gas qty	330gr
Compressor Power	1 1/4 Hp

Lubrication

Keep the FRL (air-filter-regulator & lubricator) always filled with oil. We note that with 8 hours of work per day, the lubricator oil is consumed within 20-25 days approximately. If this does not occur, adjust the oil flow using the adjuster on upper part of lubricator. We recommend the use of pneumatic oil.

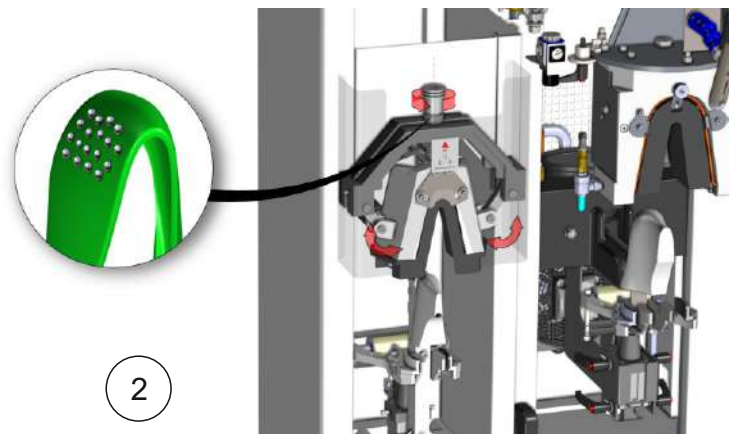
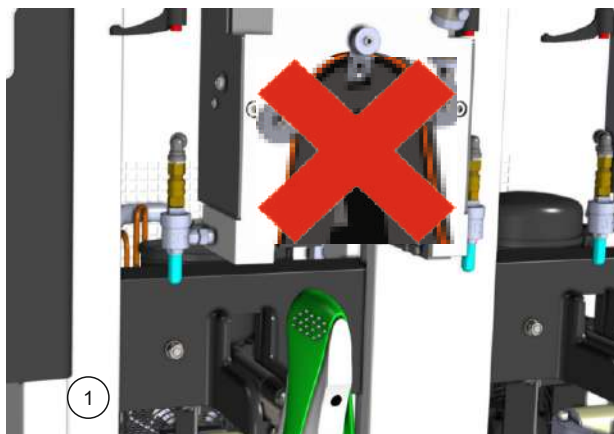
Once per week lubricate all moving parts of the machine.



Lateral pressure adjustments

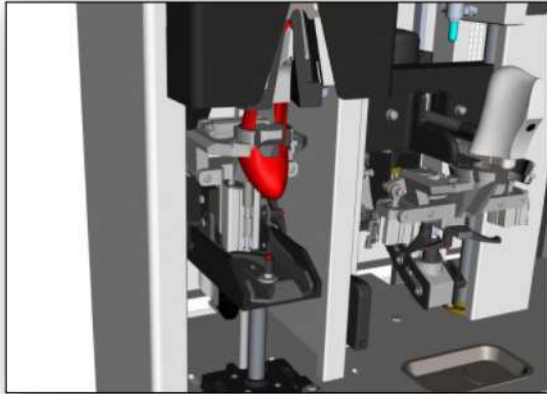
In case that there are metal decoratives on your uppers:

1. Use the Decoratives function on control panel.
2. In the hot station you can adjust the cushion movement as shown in the picture below.

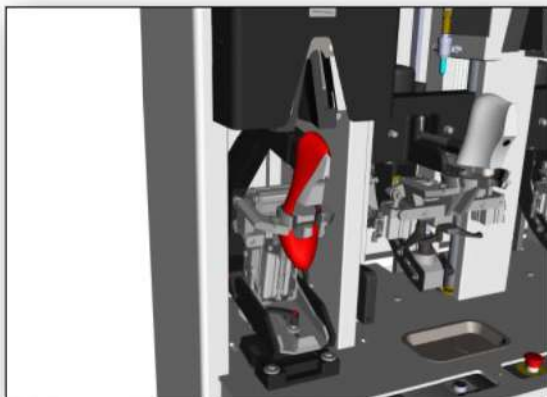


Operation

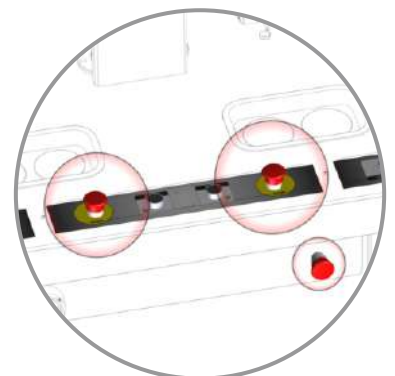
Hot Station



2. Press simultaneously in order to press the upper and complete the operation cycle



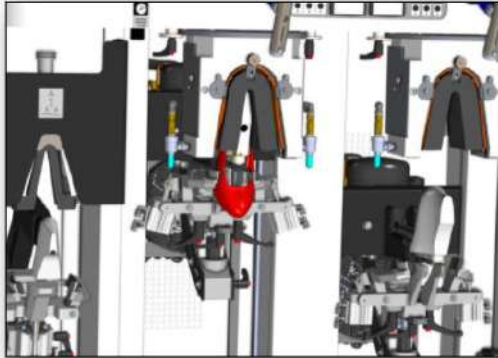
1. Press and keep your foot on the pedal to pull the upper.



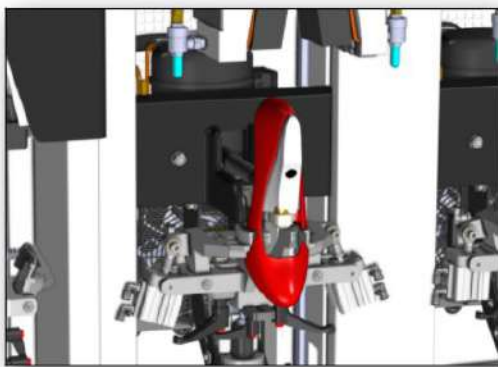
**In case of emergency
press the emergency
stop button**

Operation

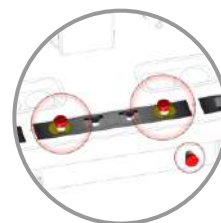
Cold Station



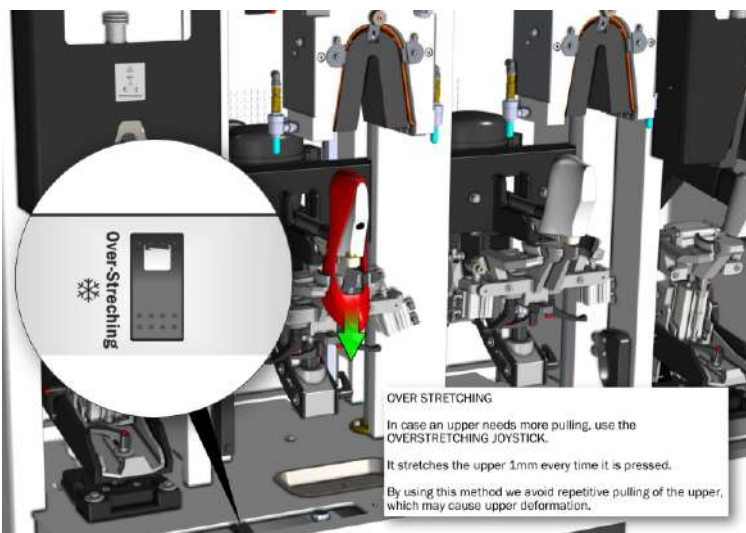
2. Press simultaneously in order to press the upper and complete the operation cycle



1. Press and keep your foot on the pedal to pull the upper.

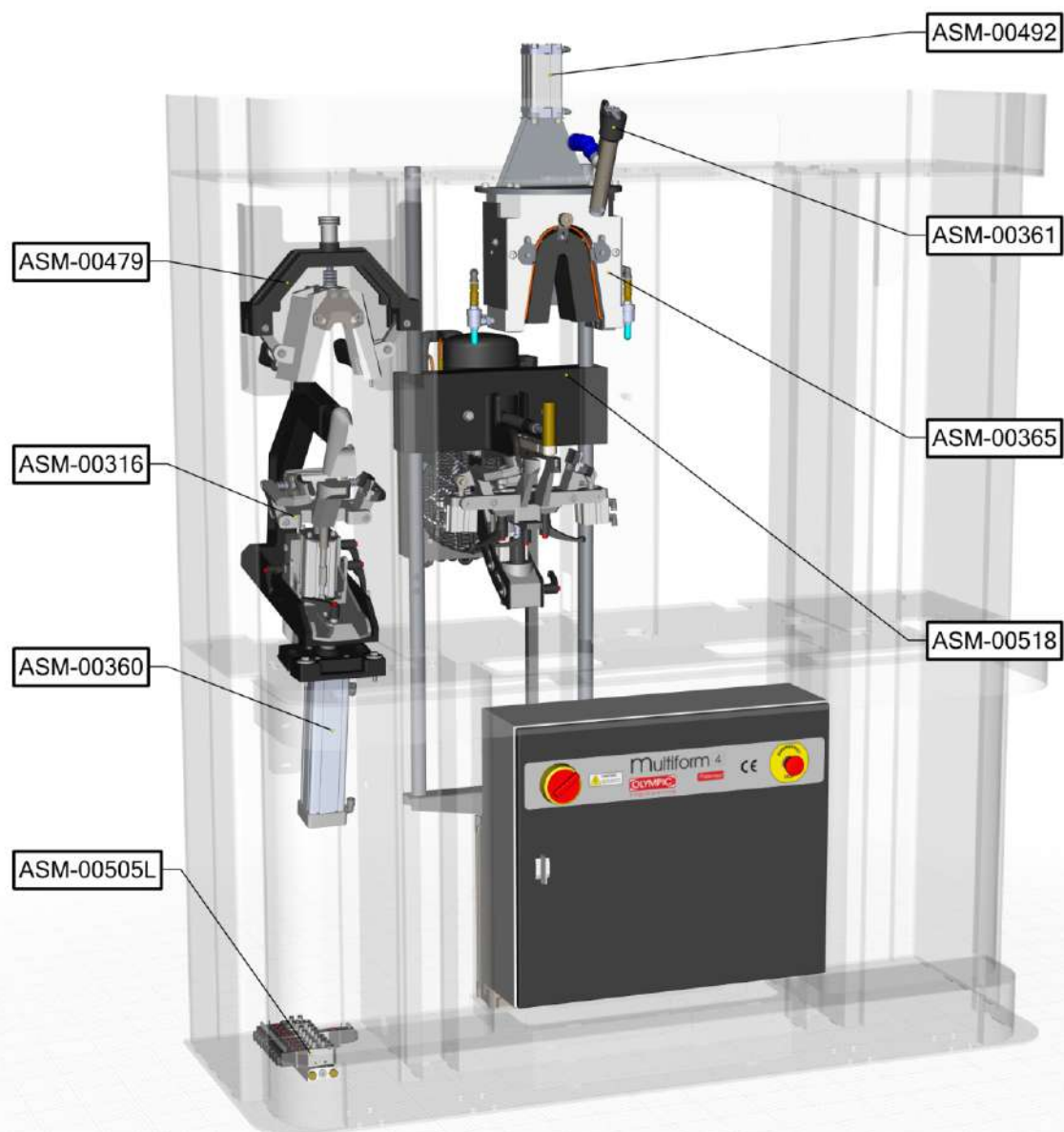


In case of emergency
press the emergency
stop button



Final result



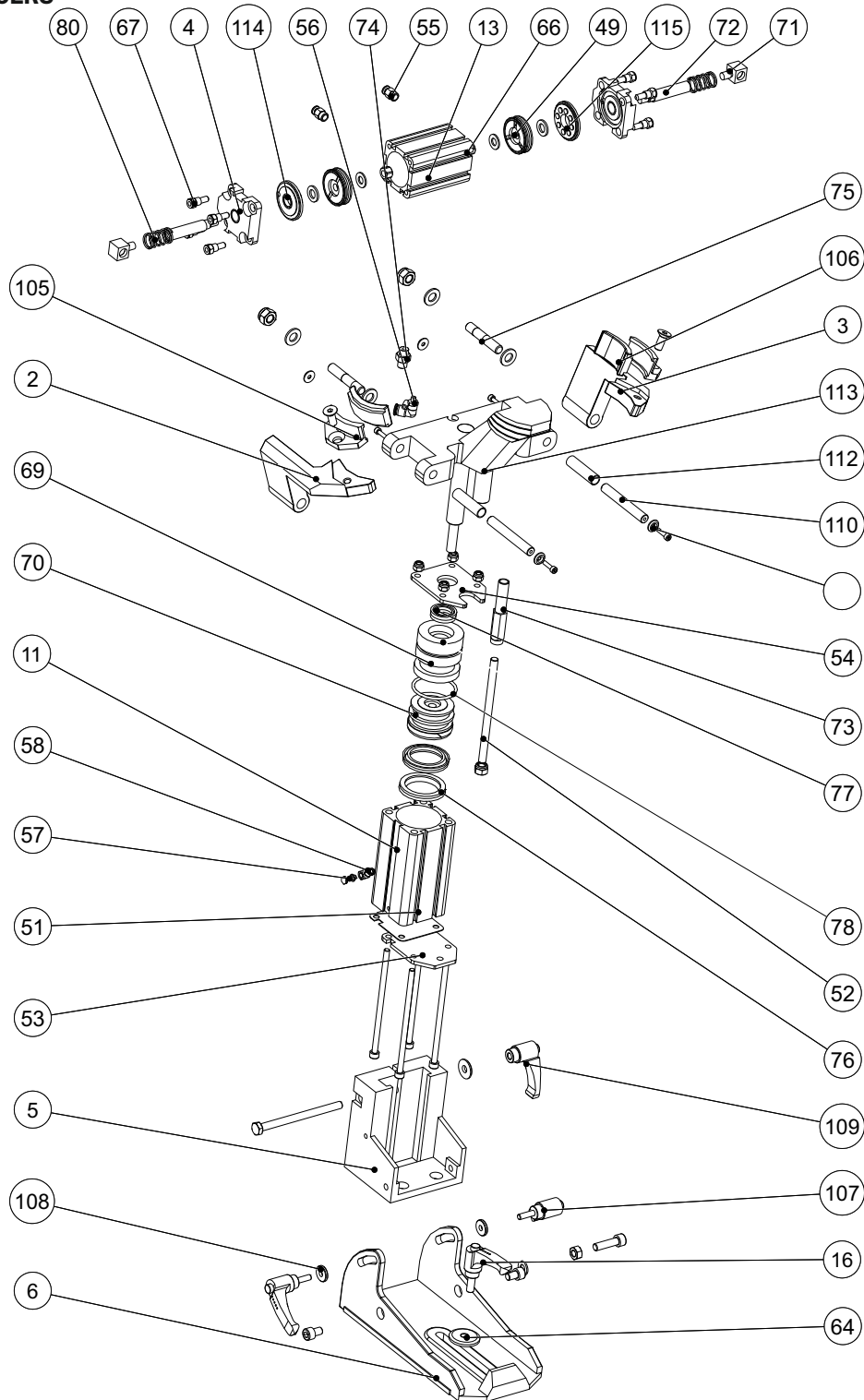


This exploded view diagram illustrates the assembly of a mechanical component, likely a bracket or arm. The main assembly consists of a large, curved bracket (2) with a central vertical rod (12) passing through it. A spring (10) is positioned between the bracket and a base plate (13). The base plate is secured with a nut (56) and a washer (57). A small rectangular component (4) is attached to the base plate. A cylindrical component (61) is shown being inserted into the top of the bracket, with a washer (63) and a nut (60) being used to secure it. A small rectangular component (8) is shown being inserted into the side of the bracket. A small rectangular component (11) is shown being inserted into the side of the base plate. A small rectangular component (54) is shown being inserted into the side of the base plate. A small rectangular component (55) is shown being inserted into the side of the base plate. A small rectangular component (58) is shown being inserted into the side of the base plate. A small rectangular component (14) is shown being inserted into the side of the base plate. A small rectangular component (13) is shown being inserted into the side of the base plate. A small rectangular component (56) is shown being inserted into the side of the base plate. A small rectangular component (57) is shown being inserted into the side of the base plate. A small rectangular component (4) is shown being inserted into the side of the base plate. A small rectangular component (8) is shown being inserted into the side of the bracket. A small rectangular component (11) is shown being inserted into the side of the base plate. A small rectangular component (54) is shown being inserted into the side of the base plate. A small rectangular component (55) is shown being inserted into the side of the base plate. A small rectangular component (58) is shown being inserted into the side of the base plate. A small rectangular component (14) is shown being inserted into the side of the base plate. A small rectangular component (13) is shown being inserted into the side of the base plate. A small rectangular component (56) is shown being inserted into the side of the base plate. A small rectangular component (57) is shown being inserted into the side of the base plate. A small rectangular component (4) is shown being inserted into the side of the base plate.

BOM ID	PartNo	Description	Qty
2	CAS-00102	CUSHION SUPPORT	1
4	ASM-00476	HEATED CUSHION (LEFT), MF-3 & MF-4	1
8	ELE-00016	ELECTRIC ELEMENT ISOLATOR	2
10	FAS-00003	WASHER, SPRING, DIN9023, 28X12.2X1	16
11	GEN-00245	BRACKET	2
12	ASM-00434	GUIDE	1
13	LAS-00051	WASHER RECTANGULAR Ø7x16	2
14	ASM-00475	HEATED CUSHION (RIGHT), MF-3 & MF-4	1
54	LAS-00453	HOT CUSHION COVER	1

BOM ID	PartNo	Description	Qty
55	REV-00029	Φ5 WASHER FOR CUSHION PINS	6
56	REV-00067	PIN	2
57	REV-00074	NUT, CUSTOM, M6	2
58	REV-00078	WASHER, CUSTOM, FLAT, Φ6	2
60	REV-00245	AXLE	2
61	REV-00255	STROKE ADJUSTER	1
63	RUB-00089	ORING, NBR, 35x3.5	2

HOT STATION PINCERS

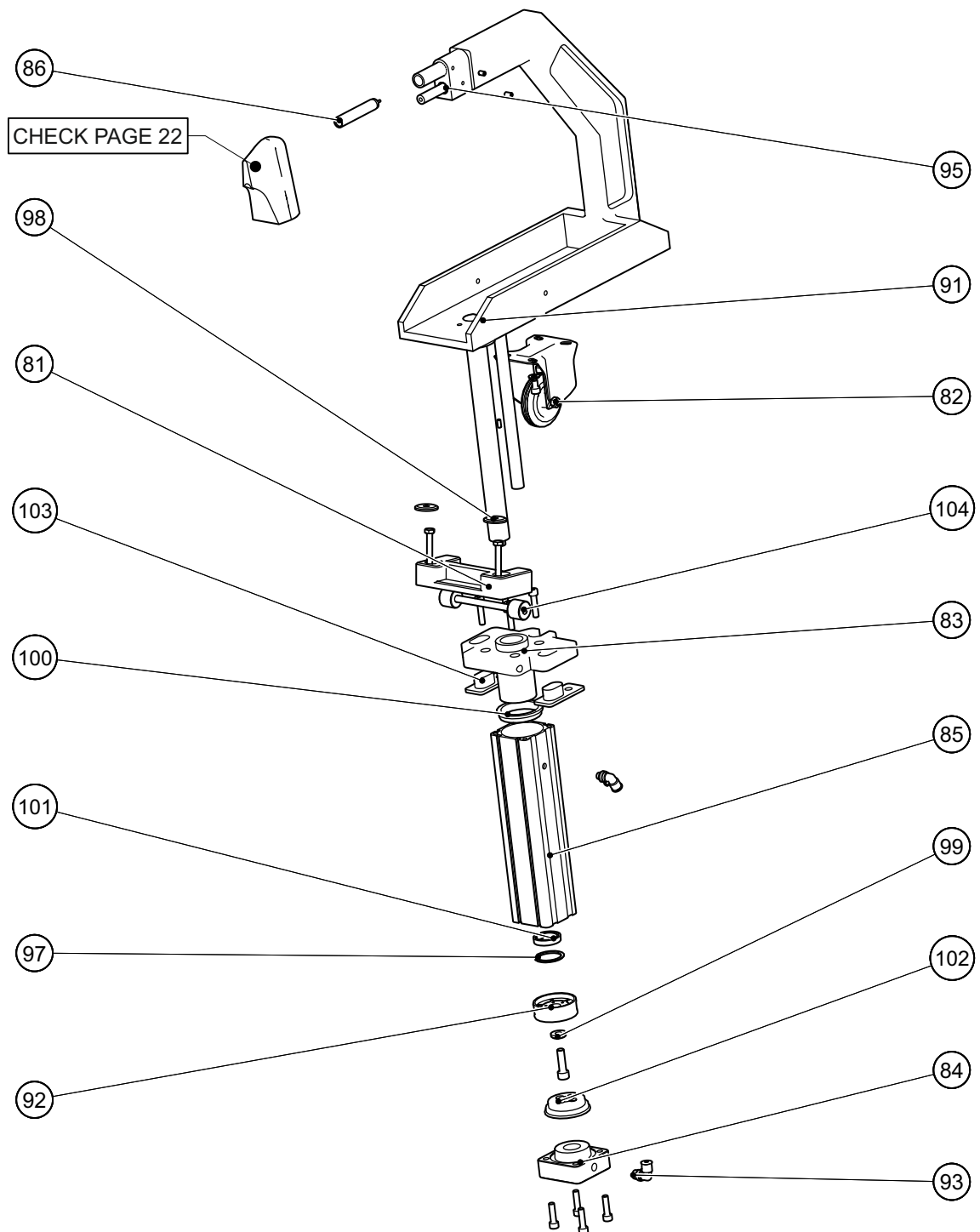


BOM ID	PartNo	Description	Qty
2	CAS-00050	CASTED ARM BODY (LEFT)	1
3	CAS-00051	CASTED ARM BODY (RIGHT)	1
4	CAS-00069	CBS PISTON CAP, FRONT, Ø40	2
5	CAS-00082	CYLINDER SLIDING BASE	1
6	CAS-00083	SLIDING PINCER'S BASE	1
11	CYL-00027	CYLINDER Ø50X115	1
13	CYL-00029	CYLINDER Ø40 FOR PINCERS	1
16	GEN-00068	CL. LEVER, MALE, ELESA, M8X20	1
49	GEN-00072	DKN Ø40	2
51	GEN-00226	OAK PISTON INTERNAL SEAL (MF)	1
52	GEN-00250	THREAD ROD M8	1
53	LAS-00159	Ø50 PISTON CAP	1
54	LAS-00160	Ø50 PISTON CAP	1
55	PNE-00028	FITTING, PARALLEL, 1/8 - Ø4	2

BOM ID	PartNo	Description	Qty
56	PNE-00030	FITTING, ANGLE, M5 - Ø4	1
57	PNE-00971	M5 BANJO STEM SINGLE LIGHT	1
58	PNE-00972	SINGLE BANJO BODY	1
64	REV-00113	WASHER, CUSTOM	1
66	REV-00136	NUT, CUSTOM, M8, CUT EDGES	2
67	REV-00138	CBS SCREW, M6	8
69	REV-00197	BRASS BEARING Ø50	1
70	REV-00198	PISTON	1
71	REV-00201	SPACER	2
72	REV-00202	ROD	2
73	REV-00234	PULLING REGULATOR	1
74	REV-00295	FITTING, CUSTOM	1
75	REV-00296	M10 THREADED PIN	2
76	RUB-00012	PISTON SEAL Ø50	2

BOM ID	PartNo	Description	Qty
77	RUB-00015	ROD WIPER	1
78	RUB-00062	ORING, NBR, 44X3	1
80	SPR-00018	COMPRESSION SPRING	2
105	CAS-00017	PINCER	2
106	RUB-00092	PINCER RUBBER (v.2014)	2
107	GEN-00067	CL. LEVER, MALE, ELESA, M6X20	2
108	REV-00078	WASHER, CUSTOM, FLAT, Ø6	2
109	GEN-00070	CL. LEVER, FEMALE, ELESA, M8	1
110	REV-00028	MF88-99 BRACKET PINS	2
112	REV-00192	STEEL TUBE Ø10-Ø12	2
113	ASM-00316	CASTED PINCER SUPPORT	1
114	RUB-00072	BRAKE RUBBER, FRONT, Ø40	1
115	RUB-00068	BRAKE RUBBER, BACK, Ø40	1

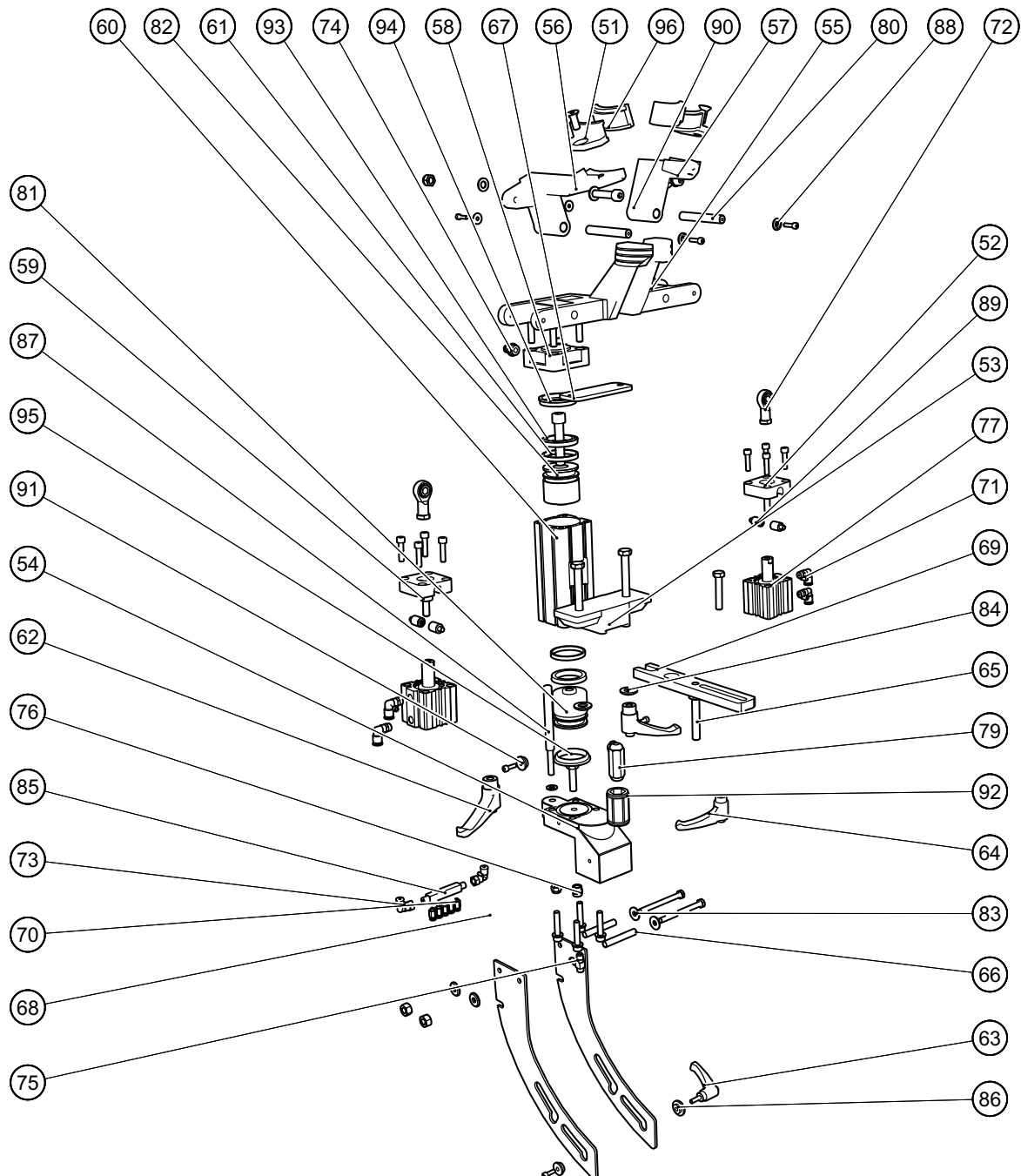
ASM-00354 (HOT STATION MOULD SUPPORT)



BOM ID	PartNo	Description	Qty
91	ASM-00317	HOT STATION MOULD	1
83	ASM-00322	END CAP	1
82	ASM-00325	WHEEL	1
81	CAS-00081	ARTICULATION	1
84	CAS-00099	END CAP, Ø63	1
85	CYL-00028	CYLINDER Ø63X295	1
86	ELE-00217	RESISTANCE Ø16X85 48V450W S400 M/M	1
104	GEN-00225	AXLE Ø10X142	1
92	GEN-00294	DKN Ø63, NORMAL	1
93	PNE-00043	FITTING, ELBOW, 1/4 - Ø6	1

BOM ID	PartNo	Description	Qty
95	REV-00056	THERMISTOR BRACKET	1
97	REV-00076	WASHER	1
98	REV-00113	WASHER, CUSTOM	2
99	REV-00193	WASHER, CUSTOM, TAPER, Ø23xØ10x5	1
100	RUB-00005	PISTON RUBBER Ø63	1
101	RUB-00018	RUBBER	1
102	RUB-00019	STOPPER	1
103	RUB-00060	SHOCK ABSORBING RUBBER	2

COLD STATION PINCERS

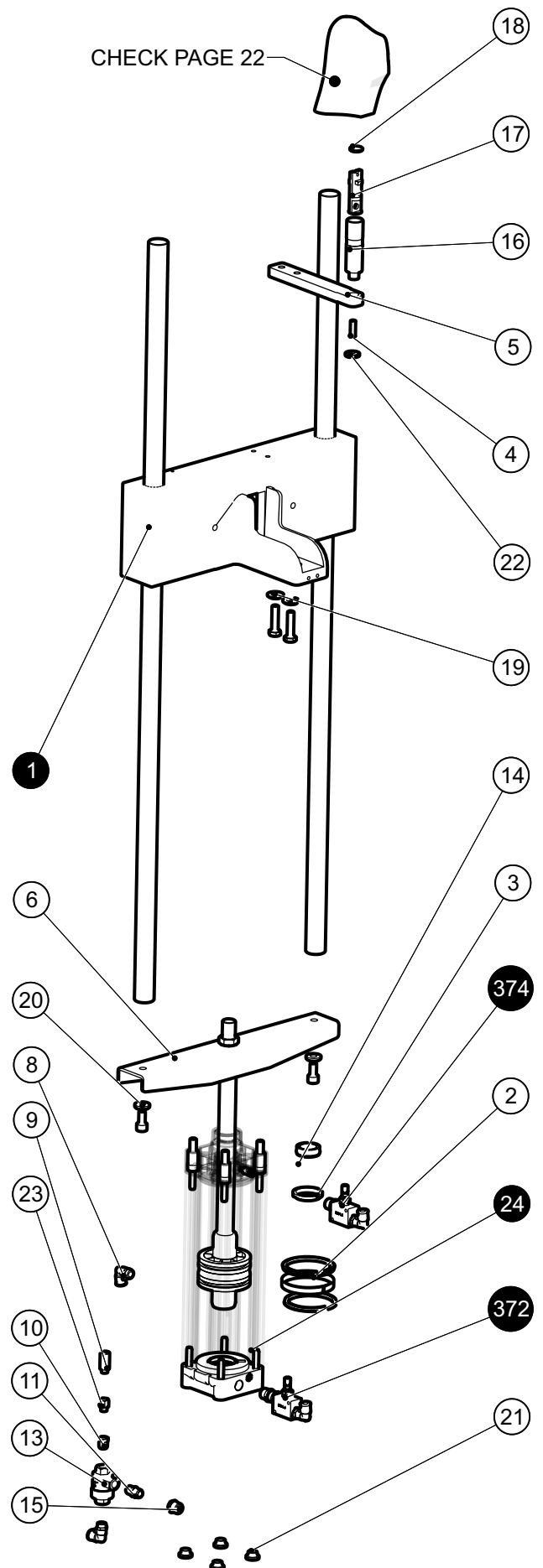


BOM ID	PartNo	Description	Qty.
77	ASM-00417	PISTON Ø40X20	2
51	CAS-00017	PINCER	2
52	CAS-00039	TOP CAP PLATE	2
53	CAS-00040	BASE	1
54	CAS-00041	BOTTOM CAP	1
55	CAS-00043	PINCER BRACKET SUPPORT (RIGHT)	1
56	CAS-00048	PINCER BRACKET (LEFT)	1
57	CAS-00049	PINCER BRACKET (RIGHT)	1
58	CAS-00054	PISTON END CAP Ø63	1
59	CBSXX-99	BRASS RING FOR ØXX CAP	1
60	CYL-00013	CYLINDER Ø50 X 144	1
61	GEN-00013	PISTON SEAL RING 45.2x50.1X5.37	2
62	GEN-00066	CL. LEVER, FEMALE, ELES, M10	2
63	GEN-00067	CL. LEVER, MALE, ELES, M6X20	1
64	GEN-00070	CL. LEVER, FEMALE, ELES, M8	1
65	GEN-00076	THREADED ROD M10	1
66	GEN-00077	MOULD METAL CYLINDER	2
67	LAS-00142	PINCER MOUNTING PLATE (FASTENING PLATE)	1
68	LAS-00148	BRACKET INOX REAR FLANGE	2
69	LAS-00158	GUIDE BRACKET	1
70	PNE-00013	FITTING, STRAIGHT, M5 - Ø4	5
71	PNE-00029	FITTING, ELBOW, 1/8 - Ø4	4
72	PNE-00061	FISH, UNIVERSAL JOINT, M8	2

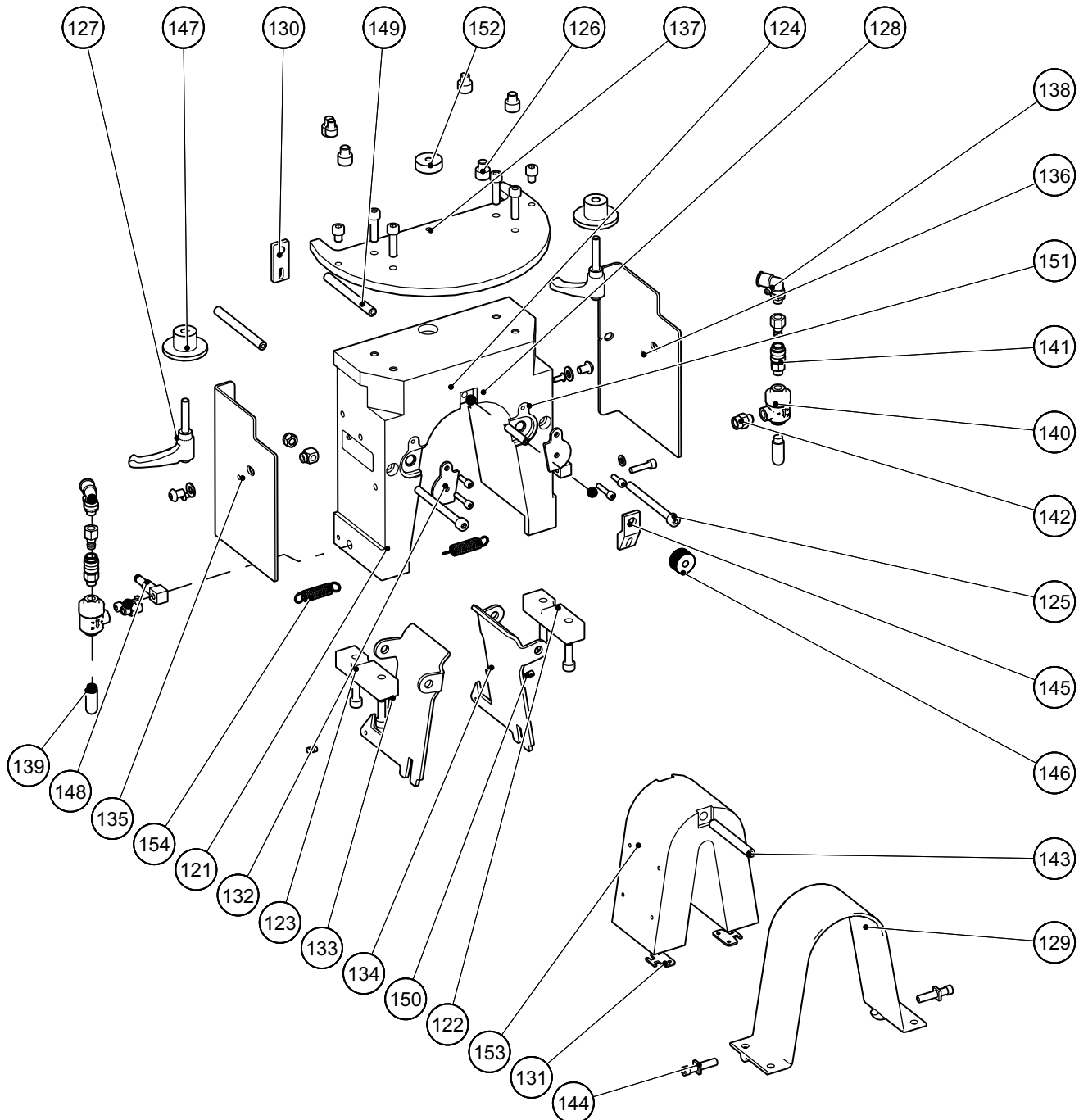
BOM ID	PartNo	Description	Qty.
73	PNE-00078	FITTING, ELBOW, FEMALE, 1/8 - Ø4	2
74	PNE-00084	FITTING, STRAIGHT, 1/4 - Ø6, SMALL HEXAGON	1
75	PNE-00666	FLOW REGULATOR, ANGLE, 1/8 - Ø4	1
76	PNE-00713	SLEEVE, 1/8 (F) - 1/8 (F)	1
79	REV-00023	REGULATOR	1
80	REV-00028	MF88-99 BRACKET PINS	2
81	REV-00065	Ø50 CYLINDER BACK CAP	1
82	REV-00072	UPPER PISTON	1
83	REV-00079	WASHER, CUSTOM, FOR Ø8	4
84	REV-00080	WASHER, CUSTOM, FOR Ø10	2
85	REV-00130	5-INPUTS DISTRIBUTION FITTING	1
86	REV-00131	WASHER, CUSTOM, FOR ELES M6	1
87	REV-00132	GUIDE	1
88	REV-00133	WASHER, CUSTOM, Ø14X2.5	4
89	REV-00137	ROTATION RING	4
90	REV-00192	STEEL TUBE Ø10-Ø12	2
91	REV-00275	MOUNTING BRACKET'S WASHER	3
92	RUB-00009	REGULATOR COVER	1
93	RUB-00012	PISTON SEAL Ø50	2
94	RUB-00032	Ø50 STOPPER	1
95	RUB-00066	PISTON RUBBER Ø50	1
96	RUB-00092	PINCER RUBBER (v2014)	2

ASM-00364 (COLD STATION CYLINDER)

BOM ID	PartNo	Description	Qty
1	ASM-00364	MAIN SUPPORT, MF3 & MF4	1
2	RUB-00101	PISTON SEAL FOR Ø80	2
3	RUB-00099	CAP SEAL FOR PISTON Ø80	1
4	GEN-00295	THREADED ROD, INOX, M8X25	1
5	LAS-00140	COOLING PIPE MOUNTING BASE	1
6	LAS-00385	TOP PISTON MOUNTING BASE, COLD STATION	1
8	PNE-00008	FITTING, ELBOW, 1/4 - Ø8	2
9	PNE-00018	SILENCER, 1/8, PLASTIC, BLUE	1
10	PNE-00037	ADAPTOR, 1/4(M) - 1/8(F)	1
11	PNE-00059	NIPPLE, TAPER, 1/4 (M) - 1/4 (M)	1
13	PNE-00089	QUICK EXHAUST VALVE, 1/4	1
14	RUB-00100	AXLE SEAL FOR Ø80	1
15	PNE-00895	ADAPTOR, TAPER, 3/8-1/4	1
16	REV-00019	84N MALE METAL MOLD SHAFT	1
17	REV-00020	84N EVAPORATOR INSERT	1
18	REV-00021	FRIDGE SHAFT CAP	1
19	REV-00080	WASHER, CUSTOM, FOR Ø10	2
20	REV-00193	WASHER, CUSTOM, TAPER, Ø23xØ10x5	2
21	REV-00254	CYLINDER WASHER	4
22	REV-00281	WASHER, CUSTOM, FOR PIPE MOUNTING BASE	1
23	REV-00298	ADAPTOR MALE G1/8 - FEMALE G1/4 - HOLE Ø2 (FLOW REDUCTOR)	1
24	ASM-00416	CYLINDER Ø80x250	1
372	ASM-00824	FLOW REGULATOR WITH PNEUMATIC COMPONENTS	1
374	ASM-00825	FLOW REGULATOR WITH PNEUMATIC COMPONENTS	1



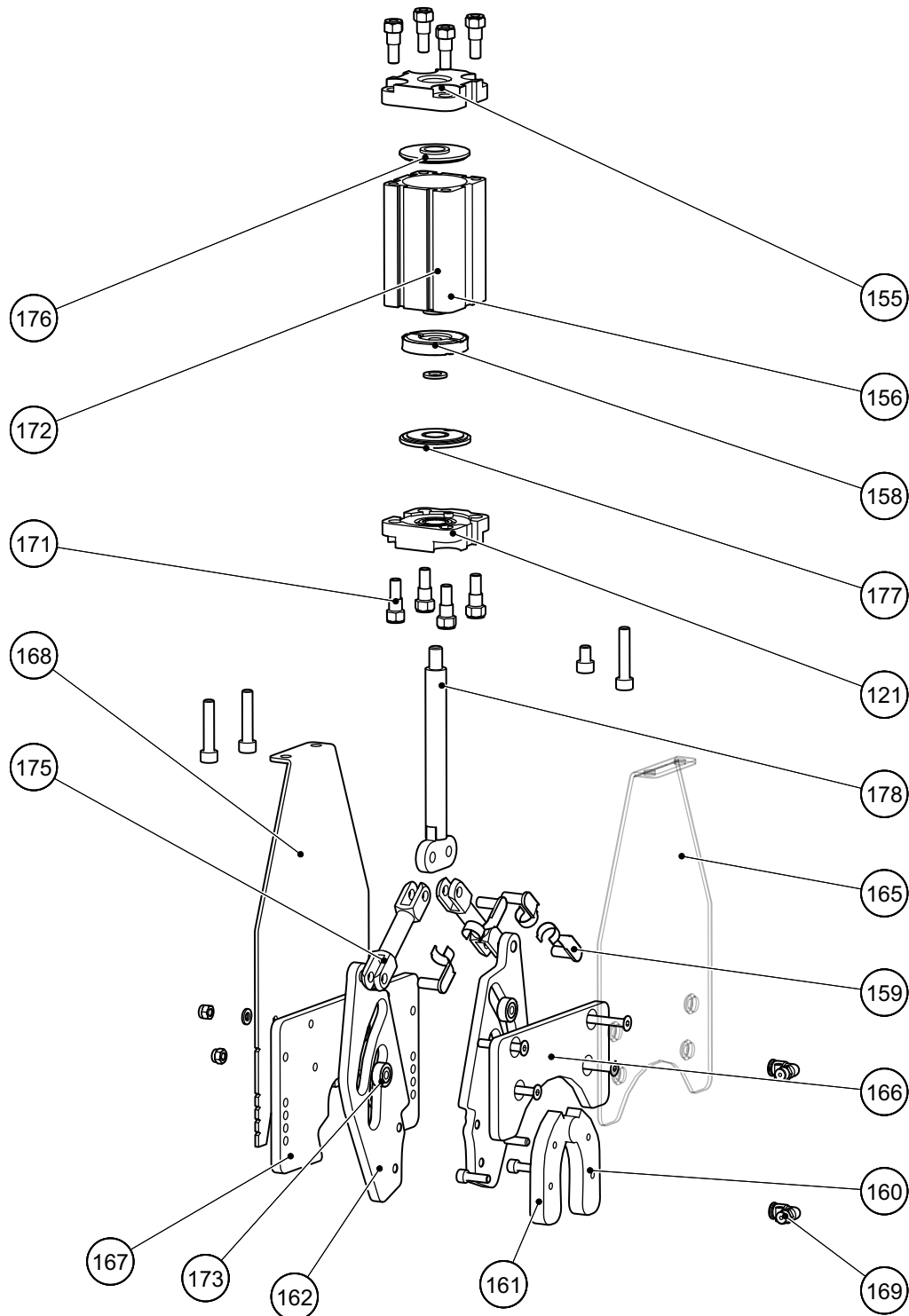
ASM-00365 (COLD STATION CUSHION)



BOM ID	PartNo	Description	Qty
121	ASM-00318	HEAD CASTED BODY	1
122	CAS-00011	CLAMP CONNECTOR	1
123	CAS-00061	CLAMP CONNECTOR, RIGHT	1
124	CAS-00087	HEAD BASE	1
125	FAS-00031	BIDA, ALLEN, M.K., MAYPH, DIN 912 M8 x 90	2
126	FAS-00440	HEX SOCKET HEAD SCREW, DIN 912, M10 x 10	5
127	GEN-00069	CL. LEVER, MALE, ELESA, M8X40	2
128	GEN-00213	CASTED BODY HEAD TUBE	2
129	GEN-00227	TUBULAR, COLD STATION, POLYFORM 84N	1
130	LAS-00049	MOULD SUPPORT PLATE	1
131	LAS-00200	PLATE	2
132	LAS-00202	ROD'S HOLDING CAP	2
133	LAS-00391	CONNECTING PLATE (LEFT)	1
134	LAS-00392	CONNECTING PLATE (RIGHT)	1
135	LAS-00415L	CUSHION'S LEFT FLANGE	1
136	LAS-00415R	CUSHION'S RIGHT FLANGE	1
137	LAS-00445	UPPER CUSHION PLATE, MF-4	1
138	PNE-00044	FITTING, ELBOW, 1/8 - Ø6	2

BOM ID	PartNo	Description	Qty
139	PNE-00050	SILENCER, 1/8, PA	2
140	PNE-00098	QUICK EXHAUST VALVE, 1/8	2
141	PNE-00109	COUPLING, MINI, SINGLE SHUT-OFF, RECTUS, 1/8	2
142	PNE-00722	REDUCER, TAPER, 1/8(M)-1/8(F)	2
143	REV-00012	MOULD SUPPORT CONNECTION PIN	1
144	REV-00016	FITTING	2
145	REV-00022	MOULD SUPPORT	1
146	PNE-01075	GRIP KNOB	1
147	REV-00050	ELESA HOLDER	2
148	REV-00203	CONNECTING ARM	2
149	REV-00204	CUSHION M5 AXLE	2
150	REV-00205	CONNECTING PIN	2
151	REV-00225	GUIDE	2
152	REV-00273	MF-4 HEAD ROTATION BASE	1
153	RUB-00016	MOULD POLYURETHANE GENERAL	1
154	SPR-00017	CONNECTING SPRING	2

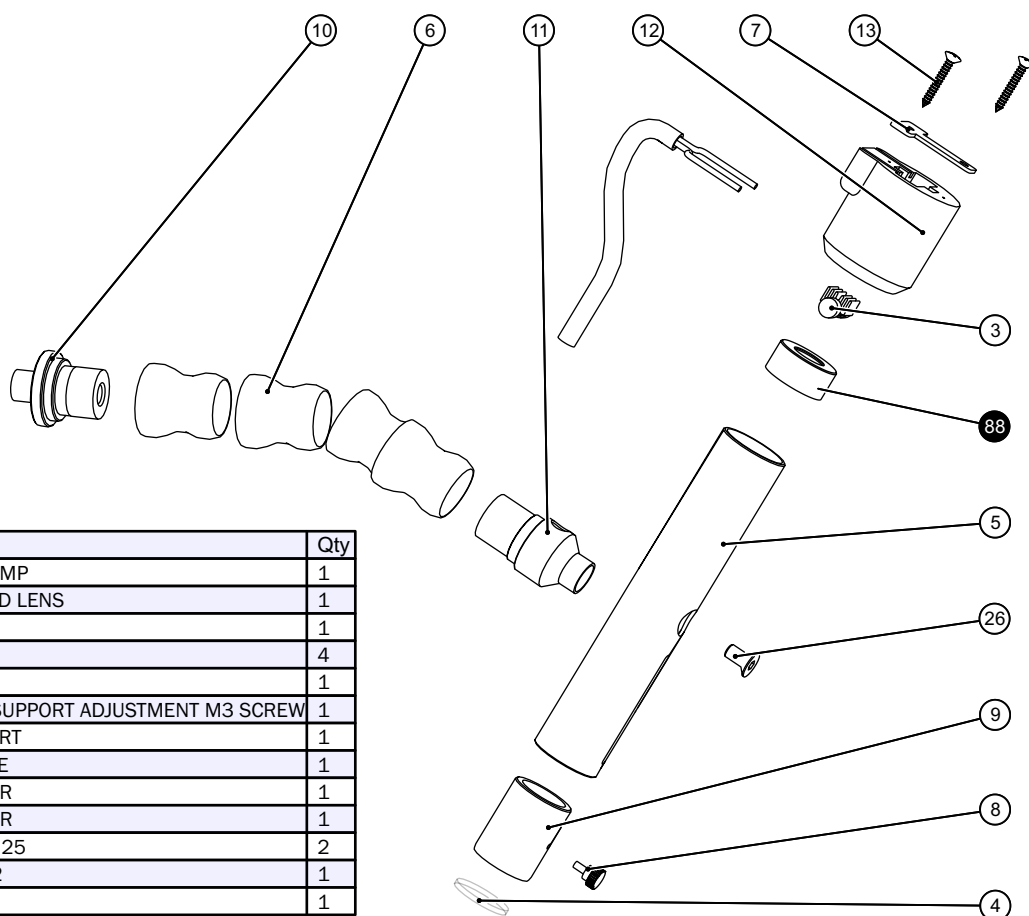
WIPERS



BOM ID	PartNo	Description	Qty
121	CAS-00070	CBS PISTON CAP, FRONT, Ø50	1
155	CAS-00078	CBS PISTON CAP, BACK, Ø50	1
156	CYL-00030	CYLINDER Ø50X95	1
158	GEN-00229	DKN Ø50	1
159	GEN-00230	JOINT PIN	4
160	LAS-00151	PINCER, NORMAL, (MALE PART)	1
161	LAS-00152	PINCER, NORMAL, (FEMALE PART)	1
162	LAS-00154L	WIPER PLATE, LEFT	1
165	LAS-00227	OUTER FRONT PLATE	1
166	LAS-00356	INNER FRONT PLATE	1
167	LAS-00442	HEAD INNER REAR PLATE, MF3&MF4	1

BOM ID	PartNo	Description	Qty
168	LAS-00466	OUTER REAR PLATE	1
169	PNE-00007	FITTING, ELBOW, 1/8 - Ø4	2
171	REV-00206	M8 CBS SCREW	8
172	REV-00207	NUT, CUSTOM, M10, CUT EDGES	1
173	REV-00238	RING	4
175	REV-00282	FORK JOINT	2
176	RUB-00069	BRAKE RUBBER, BACK, Ø50	1
177	RUB-00073	BRAKE RUBBER, FRONT, Ø50	1
178	ASM-00321	MOVEMENT ROD ASSEMBLY	1

ASM-00492 (LED PROJECTOR)



BOM ID	PartNo	Description	Qty
3	ELE-00364	PROJECTOR LED LAMP	1
4	GEN-00006	PROJECTOR CURVED LENS	1
5	GEN-00248	PROJECTOR TUBE	1
6	GEN-00249	JOINT	4
7	LAS-00437	LED HOLDER	1
8	REV-00037	PROJECTOR LENS SUPPORT ADJUSTMENT M3 SCREW	1
9	REV-00038	PROJECTOR SUPPORT	1
10	REV-00231	PROJECTOR FLANGE	1
11	REV-00232	PROJECTOR HOLDER	1
12	RUB-00078	PROJECTOR RUBBER	1
13	FAS-00829	DIN 7049 - ST3.5 x 25	2
26	FAS-00185	DIN 7991 - M6 x 12	1
88	ASM-00030	TOP LENS HOLDER	1

EXTRA HOT STATION MOULDS - ON DEMAND

	LADIE'S HIGH HEEL	BOOTS - STITCH DOWN	MEN'S	PREMOULDED COUNTERS	UNIVERSAL	MEDIUM, LOW BOOTS
AUTO RELEASE	 STL-00085 (No15)	 STL-00086 (No02)	 STL-00081 (No22)	 STL-00079 (No14)	 STL-00078 (No11)	 STL-00080 (No13)
STANDARD MOULDS	 STL-00016 (No15)	 STL-00020 (No02)	 STL-00083 (No22)	 STL-00014 (No14)	 STL-00015 (No11)	 STL-00017 (No13)
	 STL-00027 (No15)	 STL-00023 (No02)	 STL-00082 (No22)	 STL-00026 (No14)	 STL-00025 (No11)	 STL-00029 (No13)

Multiform-4 Accessories

Baby attachment - ON DEMAND



Goodyear attachment (ASM-00389) - ON DEMAND



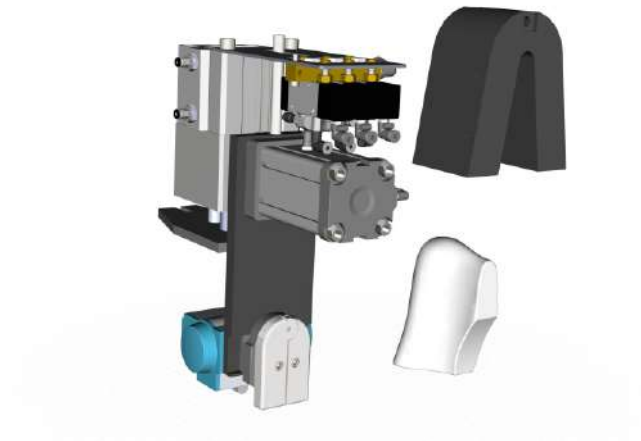
Mocassin attachment (ASM-00376) - ON DEMAND



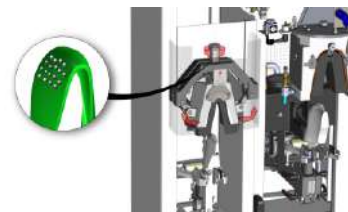
Pincer mini counter attachment (ASM-00391) - ON DEMAND



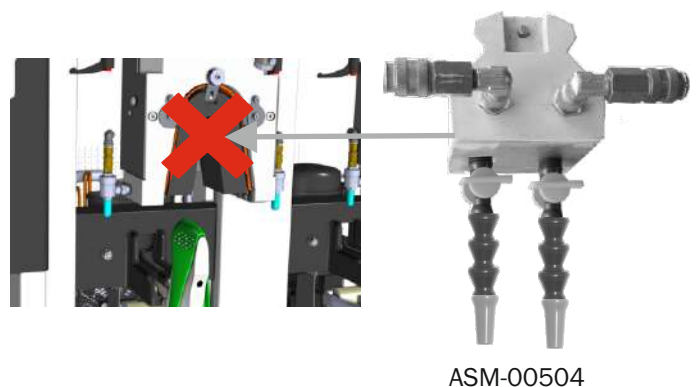
Stitch down attachment - ON DEMAND (Half pair)



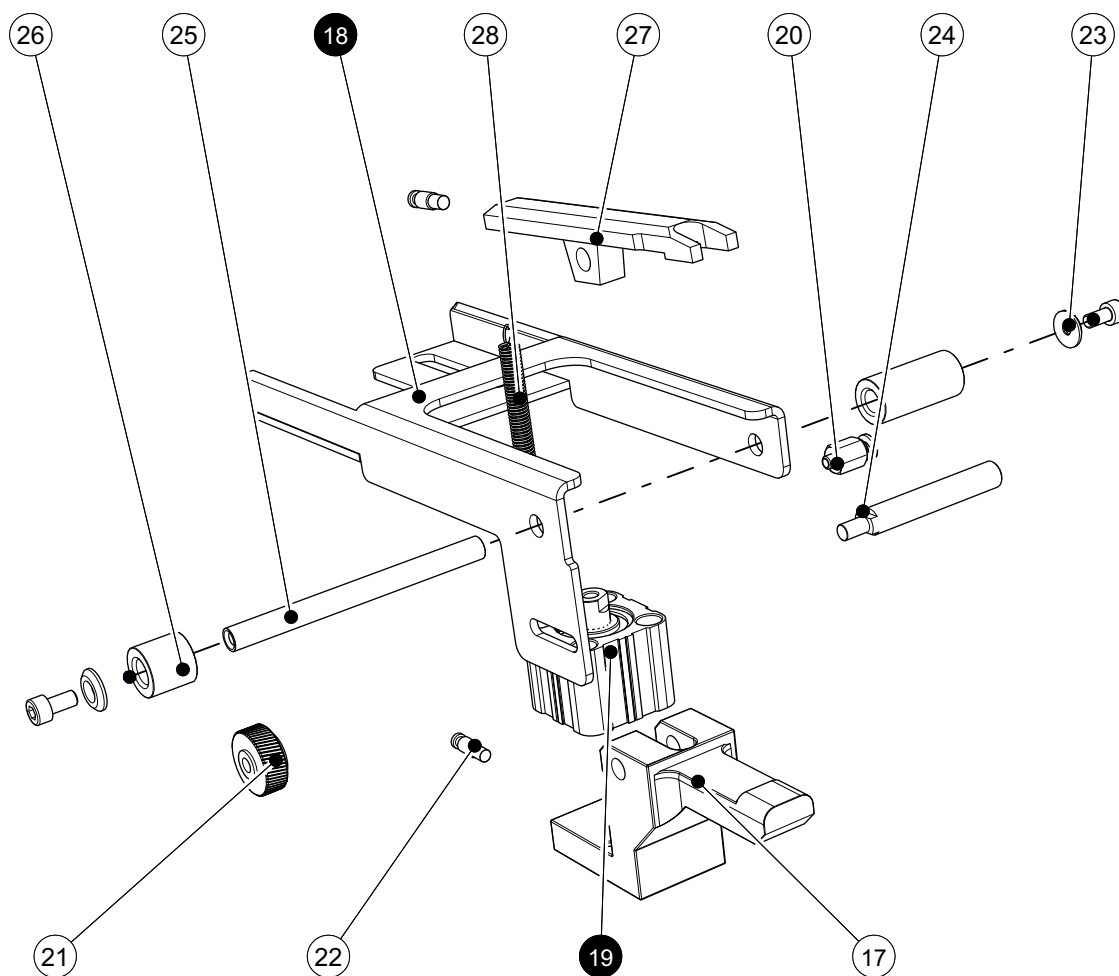
Blower (for uppers with decoratives)



Blower for the cold station cushion.
Ideal for uppers with decoratives.
It is installed on the cushion and blows the upper when the "decoratives" operation is chosen



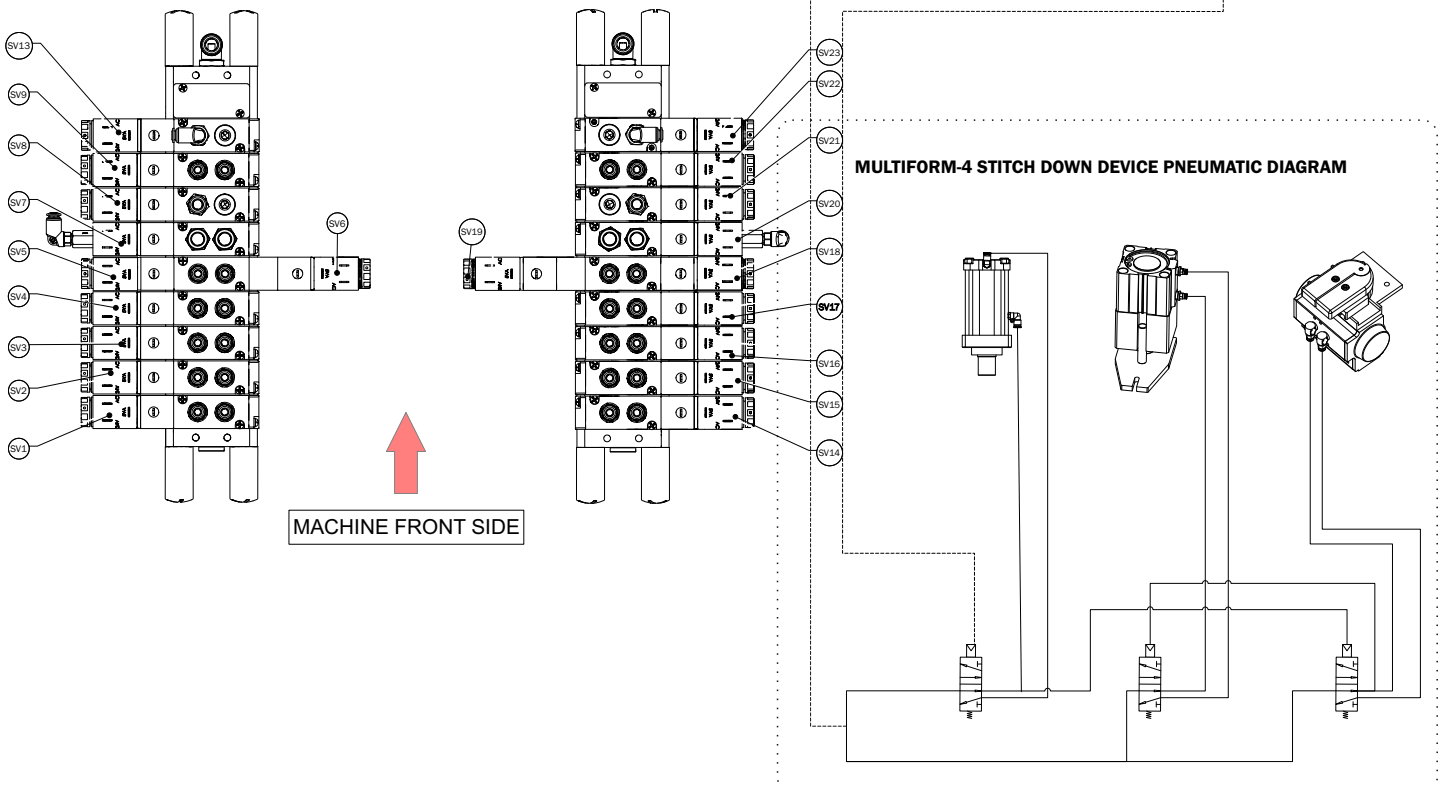
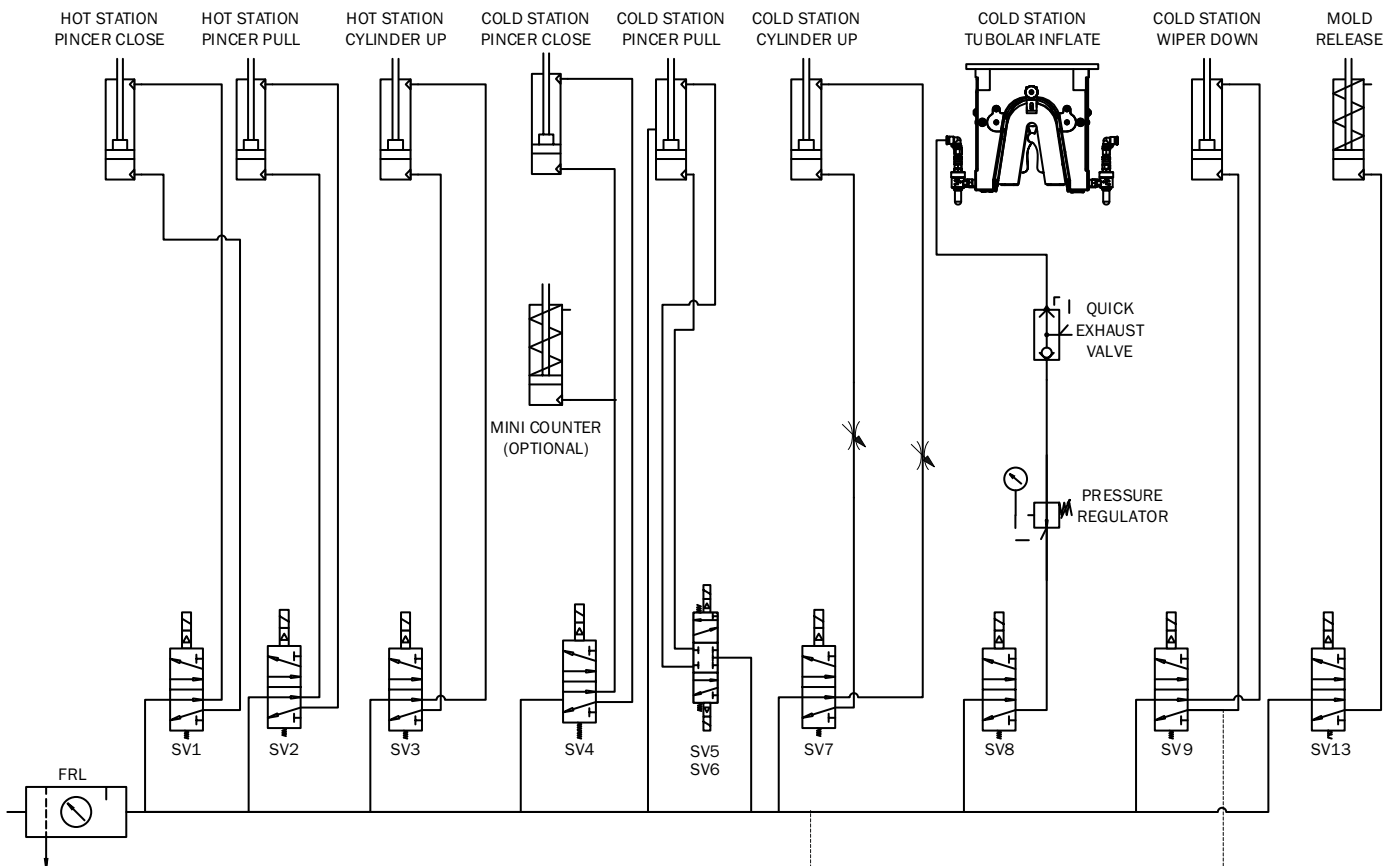
Mini Counter parts



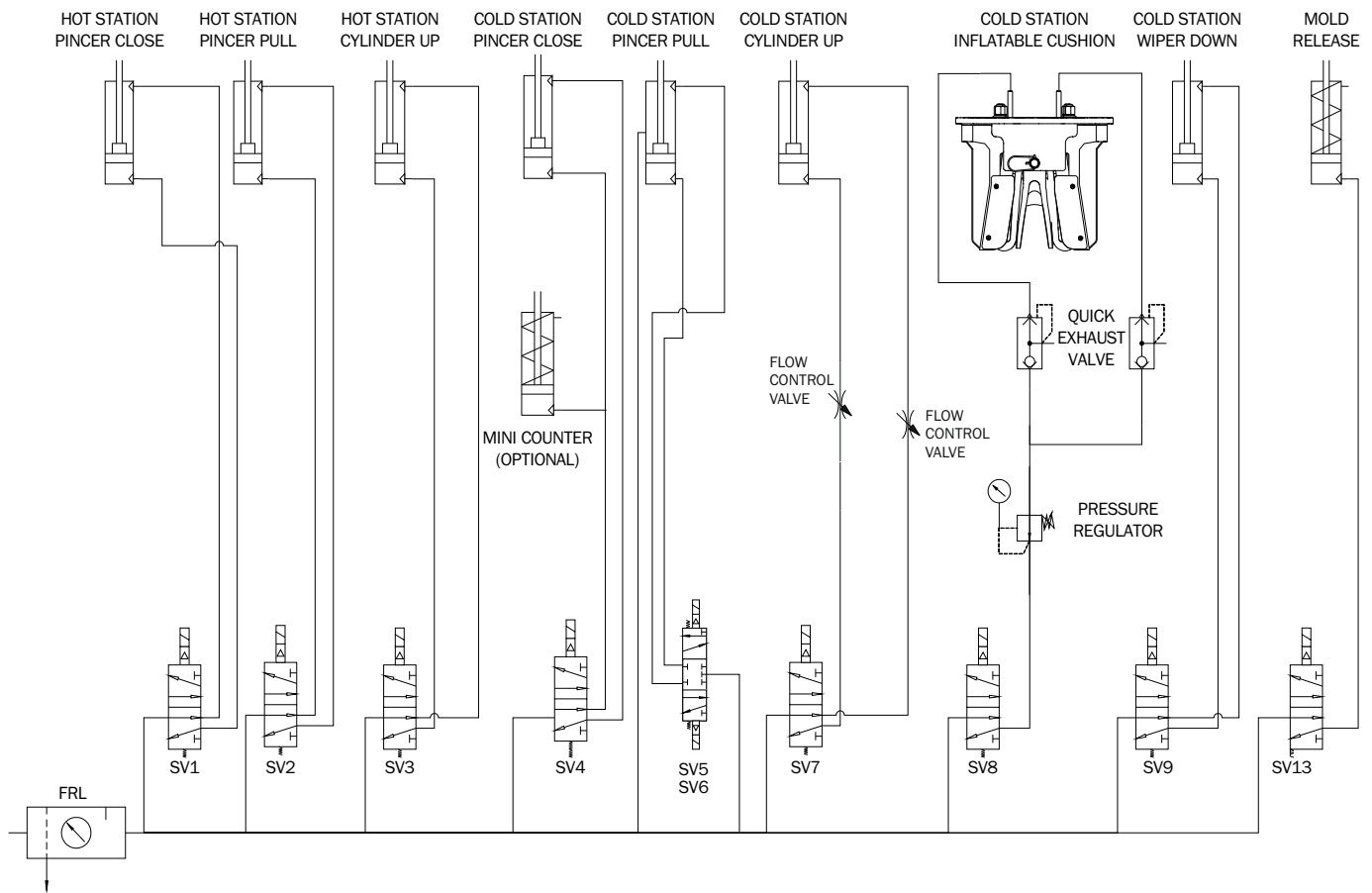
BOM ID	PartNo	Description	Qty
18	ASM-00392	MINI COUNTER BASE	1
19	ASM-00497	CYLINDER ACQ25X10 FOR MINI COUNTER	1
17	CAS-00106	BASE FOR MINI COUNTER'S PISTON & Pincer	1
20	PNE-00013	FITTING, STRAIGHT, M5 - Ø4	1
21	REV-00024	HANDLE	1
22	REV-00032	WIPER SPRING PIN	2
23	REV-00133	WASHER, CUSTOM, Ø14X2.5	2

BOM ID	PartNo	Description	Qty
24	REV-00247	PIN	1
25	REV-00248	INTERNAL PIN	1
26	REV-00250	SPACER	2
27	REV-00283	MINI COUNTER Pincer	1
28	SPR-00021	SPRING, MINI COUNTER TILTING Pincer	1

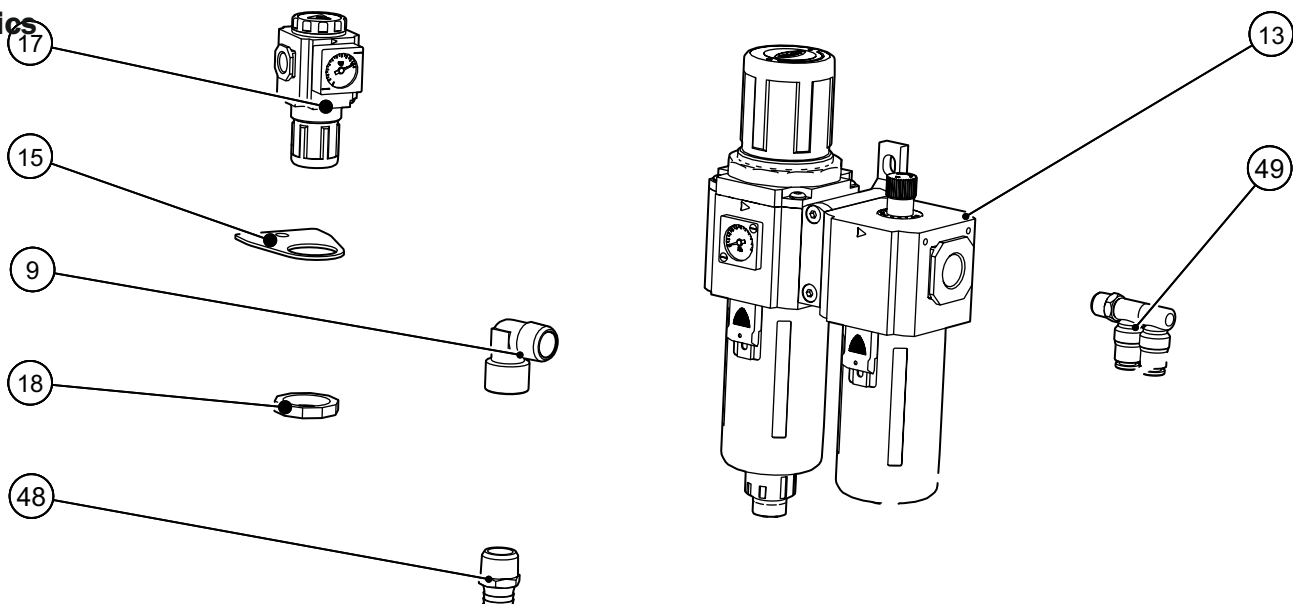
MULTIFORM-4 MAIN PNEUMATIC DIAGRAM



MULTIFORM-4 MAIN PNEUMATIC DIAGRAM (INFLATABLE CUSHION)



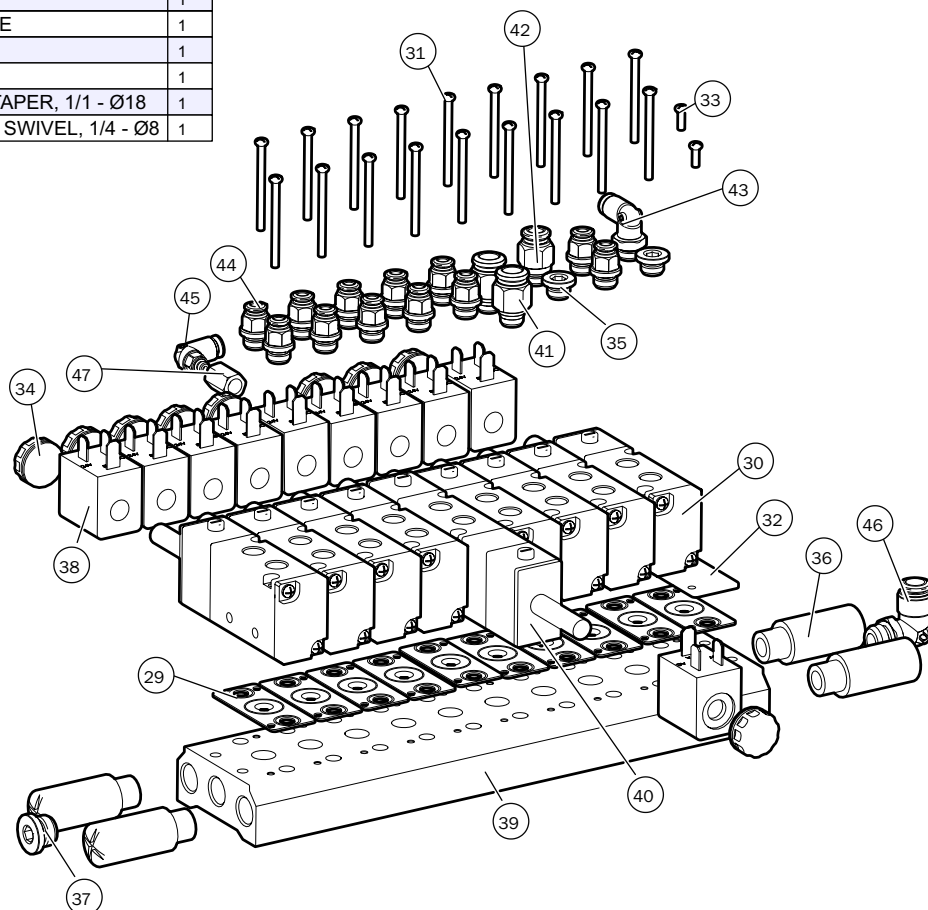
Pneumatics



BOM ID	PartNo	Description	Qty
9	PNE-00201	FITTING, ANGLE, 1/2 (M) - 1/2 (F)	1
13	PNE-00771	FRL G1/2 SIZE 400	1
15	GEN-00253	REGULATOR MOUNTING BASE	1
17	PNE-00543	PRESSURE REGULATOR 1/4	1
18	PNE-00543B	REGULATOR NUT	1
48	PNE-00909	HOSE ADAPTER, RG, MALE, TAPER, 1/1 - Ø18	1
49	PNE-00973	FITTING, ELBOW, 2-TAPERED SWIVEL, 1/4 - Ø8	1

NOTICE:

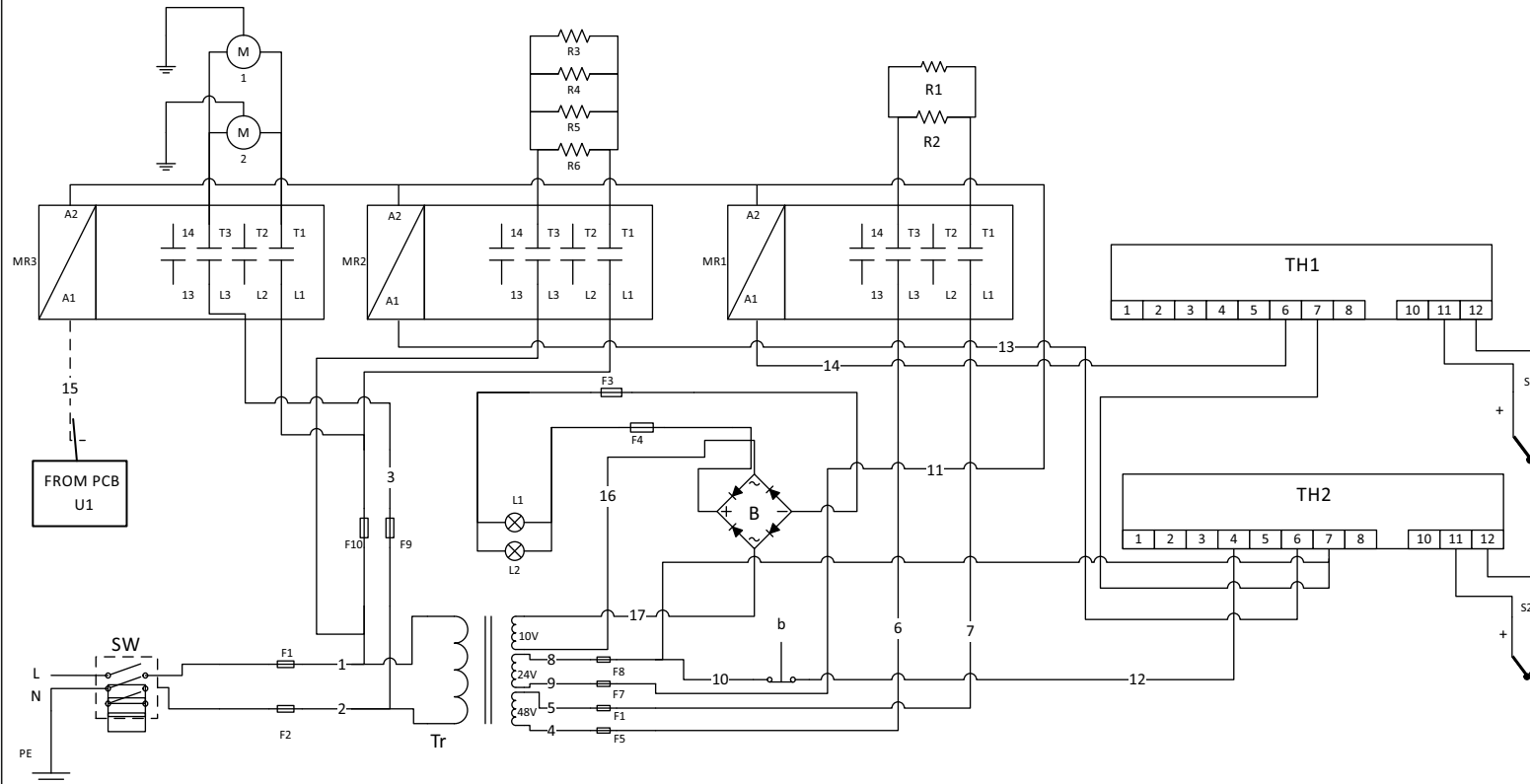
Rest of pneumatic components can be found in the previous assembly pages.



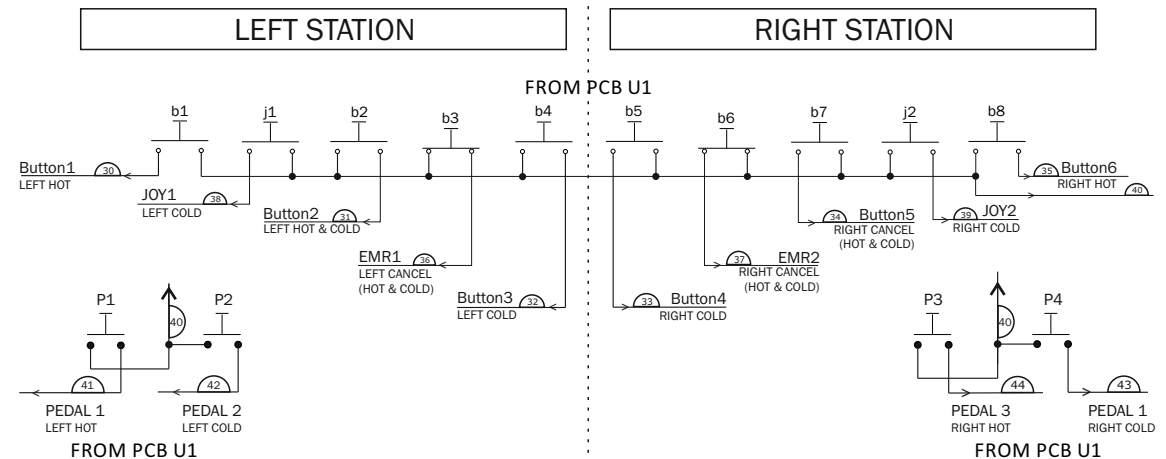
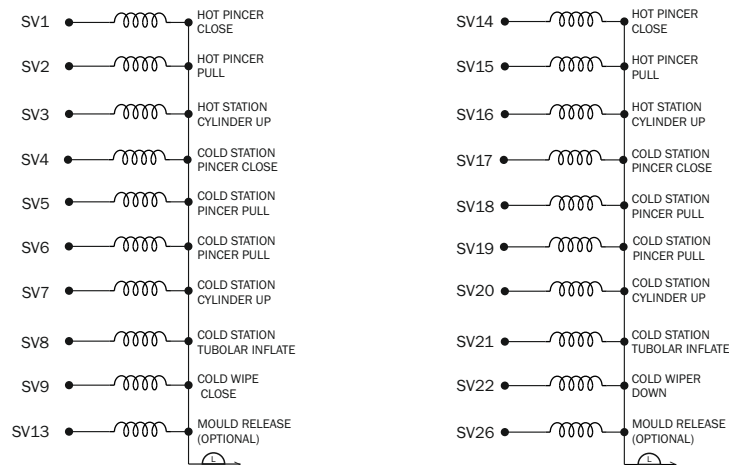
BOM ID	PartNo	Description	Qty
29	GEN-00093	PNEUMATIC MANIFOLD CAP RUBBER BOTTOM	11
30	PNE-00016	VALVE BODY ELECTRIC PILOT 5/2 G1/8, NO COIL	9
31	PNE-00016C	SCREW M3 FOR 5/2 VALVE	18
32	PNE-00016D	CAP	1
33	PNE-00016E	SCREW M3 FOR 5/2 VALVE	2
34	PNE-00021	COIL NUT, G1/8	9
35	PNE-00072	PLUG, MALE, PARALLEL, 1/8	2
36	PNE-00094	SILENCER, 1/4, PLASTIC, BLUE	4
37	PNE-00213	CAP ALLEN, +OR 1/4	1
38	PNE-00752	COIL Ø9 - 24VAC, 5W	10

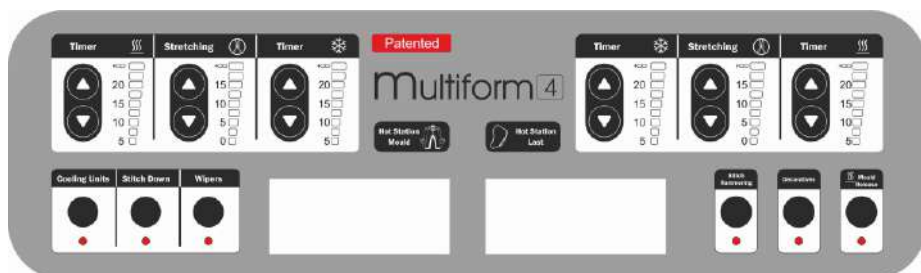
BOM ID	PartNo	Description	Qty
39	PNE-00947	MANIFOLD, 1/4, 10 STATION, 200M10F	1
40	PNE-00976	VALVE BODY ELEC. PILOT 5/2 G1/8 (DOUBLE 24V COIL)	1
41	PNE-01001	FITTING, STRAIGHT, 1/8-Ø8, FOR AIR UNIT	2
42	PNE-01097	STRAIGHT MALE ADAPTOR (PARALLEL) 6-1/8"	1
43	PNE-09916	ORIENTING ELBOW MALE ADAPTOR (PARALLEL) 4-1/8"	1
44	PNE-09919	STRAIGHT MALE ADAPTOR (PARALLEL) 4-1/8"	13
45	PNE-09922	ORIENTING ELBOW MALE ADAPTOR (PARALLEL) 4-M5	1
46	PNE-09925	ORIENTING ELBOW MALE ADAPTOR (PARALLEL) 8-1/4"	1
47	REV-00083	CUSTOM ADAPTOR FOR M5 FITTING	1

MULTIFORM 4 VERSION 2014 ELECTRIC DIAGRAM



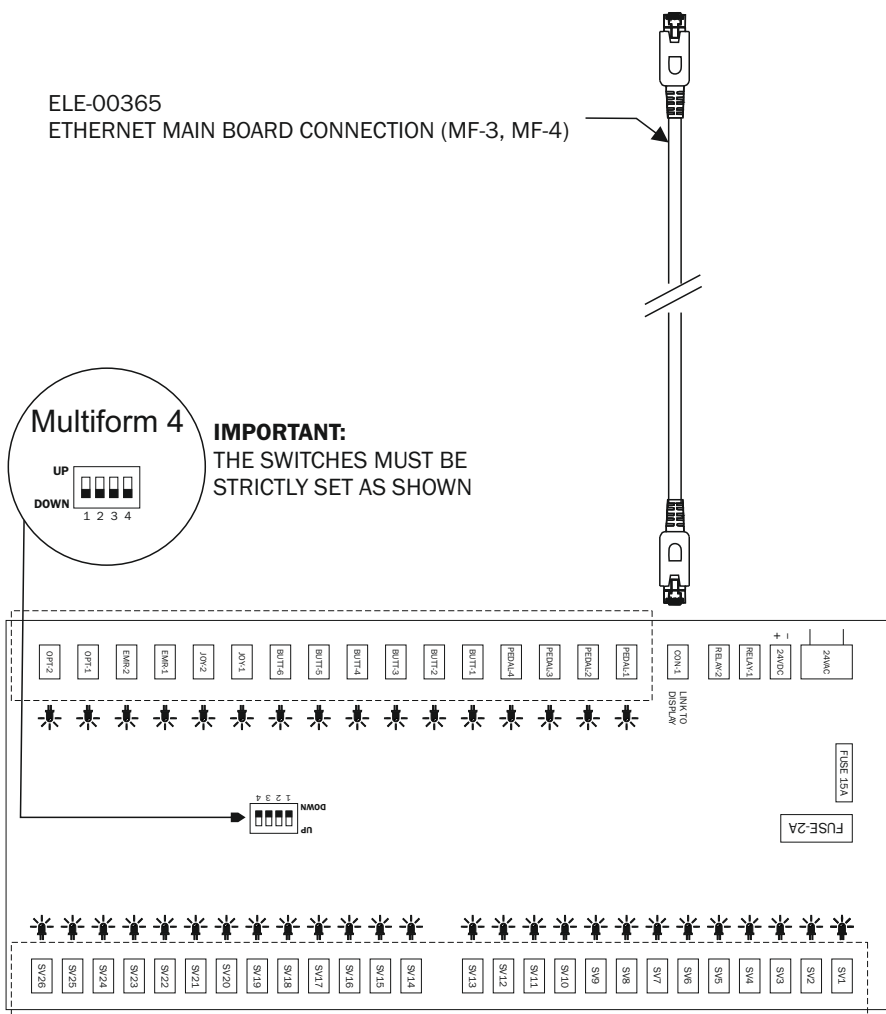
Part No	Diagram indication	Description
ELE-00011	SW	MAIN SWITCH
ELE-00018	R3,R4,R5,R6	ELEMENT 230V - 300W (FOR CUSHIONS)
ELE-00171	F1, F2	FUSE 16A
ELE-00326	MR1,MR2	CHINT NC1-1810 RELAY
ELE-00298	MR3	RELAY, MINI, CHINT NC6-0910
ELE-00217	R1,R2	RESISTANCE Ø16x85 48V450W S400 M/M
ELE-00131	S1	HEATING SENSOR Ø6x30 (L=500CM)
ELE-00017	S2	HEATING SENSOR Ø6x30 (L=230CM)
ELE-00001	b1,b2,b4,b5,b7,b8	START BUTTON, Ø22, BLACK
ELE-00002	b3,b6	STOP BUTTON, Ø40, RED, WITH MOUNT
ELE-00264	TH1,TH2	R38S-LFR-B--A-E (Regulator 78x35mm sensitive touch)
ELE-00003	P1,P2,P3,P4	ELECTRIC FOOT SWITCH
PNE-00017	SV1-SV26	COIL 7/9 24AC
ELE-00263	Tr	TRANSFORMER, 230V - 48V / 24 V / 12V 1250 VA
ELE-00027	F7,F8,F9,F10	AUTOMATIC FUSE 2P 10A
ELE-00281	F3,F4	RAIL FUSE M4/8
ELE-00211	F5,F6	RAIL FUSE 20A
ELE-00331	B	BRIDGE 10A/1000V KBPC HY
ELE-00002	b	STOP BUTTON, Ø40, RED, WITH MOUNT
ELE-00364	L1,L2	PROJECTOR LED LAMP 10-30V / 3W
PCB-00005	U1	MAIN BOARD PCB FOR MF-3, MF-4
PCB-00004	U2	DISPLAY PCB FOR MF-3, MF-4
ASM-00429	M1,M2	COOLING UNIT COMPLETE, MF-3 & MF-4
ASM-00419	J1, J2	OVER-STRETCHING BUTTON





PCB-00004: DISPLAY BOARD

ELE-00365
ETHERNET MAIN BOARD CONNECTION (MF-3, MF-4)



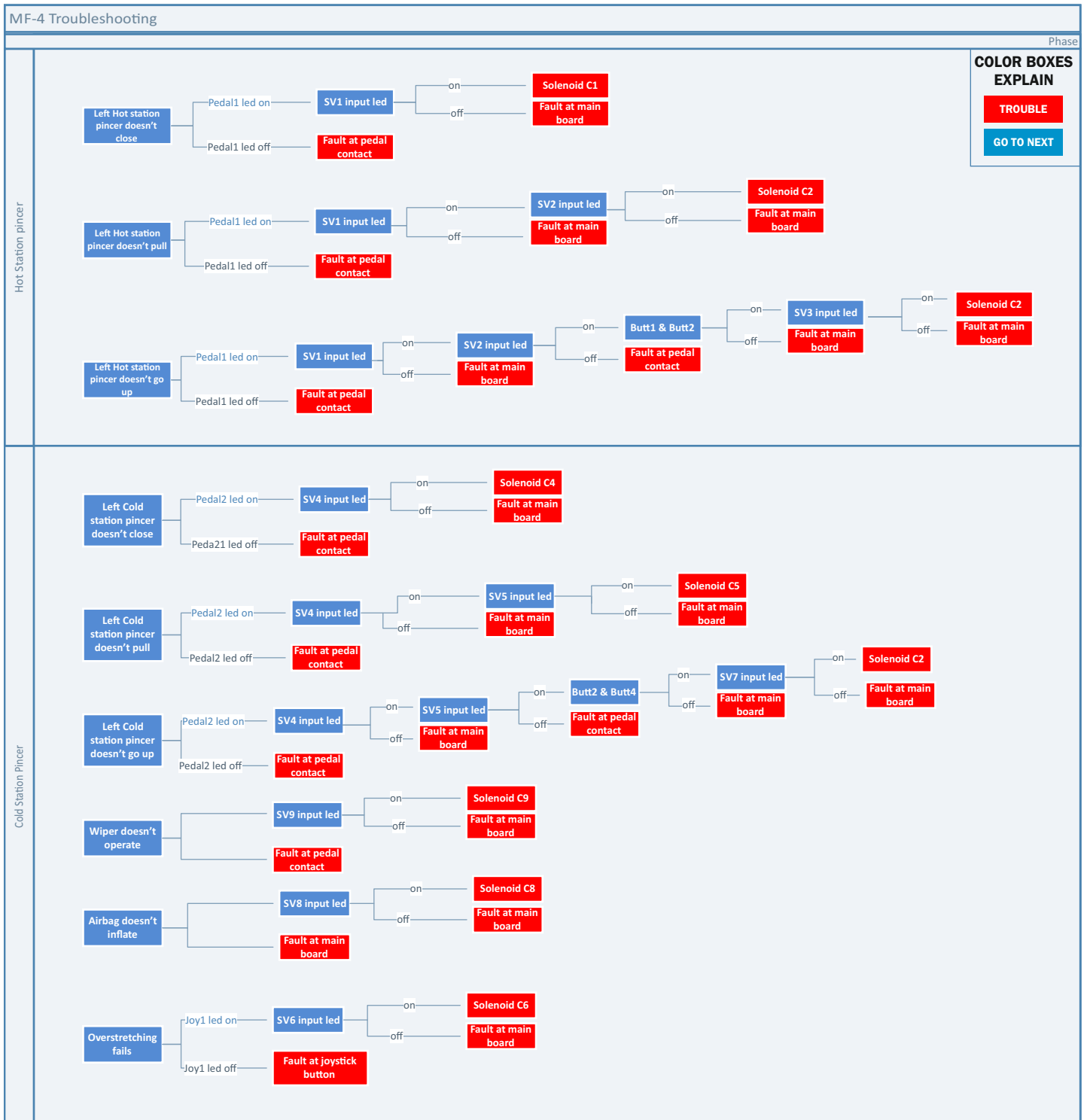
PCB-00005 : MAIN BOARD

INPUTS			
LEFT SIDE		RIGHT SIDE	
PEDAL1	LEFT HOT	PEDAL3	RIGHT HOT
PEDAL2	LEFT COLD	PEDAL4	RIGHT COLD
BUTTON1	LEFT HOT	BUTTON4	RIGHT COLD
BUTTON2	LEFT HOT & LEFT COLD	BUTTON5	RIGHT COLD & HOT
BUTTON3	LEFT COLD	BUTTON6	RIGHT HOT
JOY1	LEFT COLD	JOY2	RIGHT COLD
EMR1	LEFT CANCEL (HOT & COLD)	EMR2	RIGHT CANCEL (HOT & COLD)
OPT1	<NOT USED>	OPT2	<NOT USED>

OUTPUTS	
LEFT SIDE	
SV1	HOT STATION Pincer CLOSE
SV2	HOT STATION Pincer PULL
SV3	HOT STATION CYLINDER UP
SV4	COLD STATION Pincer CLOSE
SV5	COLD STATION Pincer PULL
SV6	COLD STATION Pincer PULL
SV7	COLD STATION CYLINDER UP
SV8	COLD STATION TUBULAR INFLATE
SV9	COLD STATION WIPER DOWN
SV10	
SV11	
SV12	
SV13	MOULD RELEASE
RELAY 1	COOLING UNIT
RELAY 2	AUX

RIGHT SIDE	
SV14	HOT STATION Pincer CLOSE
SV15	HOT STATION Pincer PULL
SV16	HOT STATION CYLINDER UP
SV17	COLD STATION Pincer CLOSE
SV18	COLD STATION Pincer PULL
SV19	COLD STATION Pincer PULL
SV20	COLD STATION CYLINDER UP
SV21	COLD STATION TUBULAR INFLATE
SV22	COLD STATION WIPER DOWN
SV23	
SV24	
SV25	
SV26	MOULD RELEASE

Troubleshooting



Notes

This image shows a full page of blank graph paper. The grid consists of thin, light gray horizontal and vertical lines that intersect to form small squares across the entire surface. There are no margins, text, or other markings on the paper.

