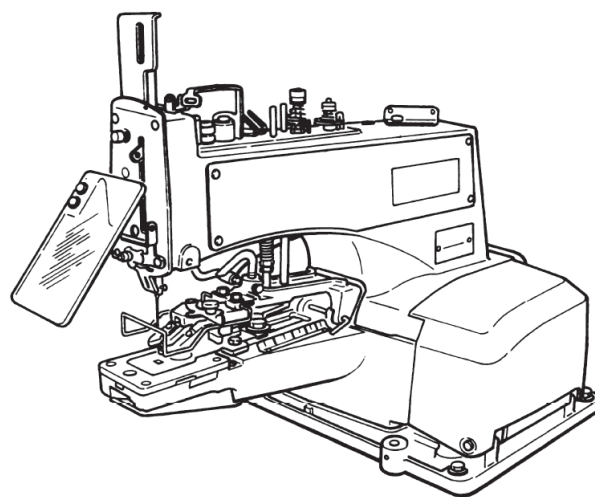


INSTRUCTION MANUAL

XF

Automatic industrial button sewing machine



 *texi*



注意

為了防止意外的起動造成的事故，請關掉電源，確認馬達確實停止轉動後再進行。

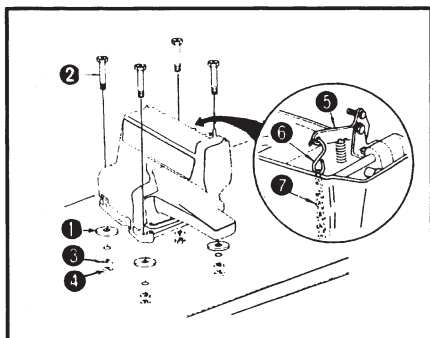


WARNING:

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1. 縫紉機的安裝

INSTALLATION OF MACHINE HEAD

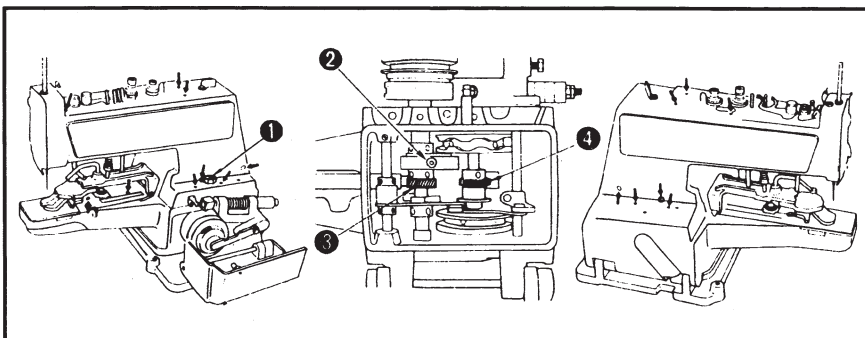


1. 把防震膠墊 1 放到機台上，然後把機頭放到上面，用固定螺絲②、墊片③、螺母④固定好。然後把 S 型掛鉤⑥和鐵連⑦安裝到起動環⑤上。

1. Put rubber cushion ① on the table, place the machine head on the rubber cushion and fix it to the table using screws ②, plain washers ③ and nuts ④. Attach "S" chain hook ⑥ and chain ⑦ to stop motion trip lever ⑤.

2. 加油

LUBRICATION

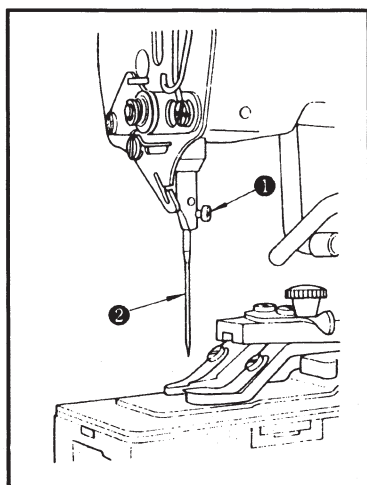


1. 把 T10[#] 新機油加入到箭頭部。(每周 1~2 次)
2. 擰鬆安裝螺絲①，放倒縫紉機，把潤滑脂加到螺旋齒輪③和滑輪④上。
3. 每周檢查 1 次機座安裝臺內的加油毛氈上面是否吸滿油，不够時請加油。同時請往曲軸部②上也加油。

1. Apply T10[#] to the components shown by the arrows. (Once or twice a week)
 2. Loosen connecting screw ①, tilt the head backward and apply some grease to driving worm gear ④ and gear ③.
 3. Check, approximately once a week, that oil amount is sufficient to reach the top of the oil felt placed inside the bed mounting base. If the amount of oil is insufficient, add an adequate amount of oil. At this time, also apply oil to crank rod ②.

3. 機針的安裝方法

ATTACHING THE NEEDLE



★標準機針為 FY-372 使用 TQ × 7 # 16, FY-373 使用 TQ × 7 # 20 機針。

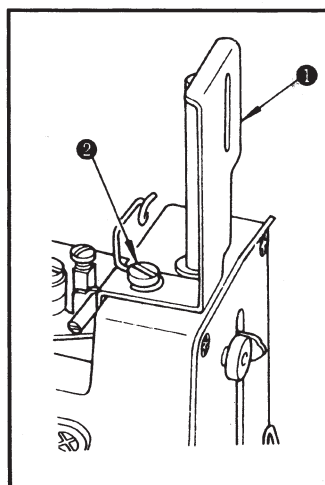
1. 擰鬆機針固定螺絲①，手拿機針把機針②長溝轉到面前。
2. 把機針②插到針杆孔的深處。
3. 擰緊機針固定螺絲①。

★ Use a standard needle of TQx7 # 16 for FY-372 and TQx7 # 20 for FY-373.

1. Loosen screw ①
2. Insert needle ② up into the needle hole in the needle bar until it comes in contact with the deepest end of the needle hole.
3. Tighten screw ① firmly.

4. 針杆護板的安裝方法

ATTACHING THE NEEDLE BAR GUARD



1. 擰鬆固定螺絲②，並把它卸下；
2. 把針杆罩①安裝到第二道線器下面；
3. 用固定螺絲②固定起來。

1. Loosen screw ② and remove the thread guide No. 2.
 2. Place needle bar guard ① under the thread guide No. 2.
 3. Fix the thread guide No. 2 and needle bar guard ① together using screw ②.



注意

爲了防止意外的起動造成的事故，請關掉電源，確認馬達確實停止轉動後再進行。

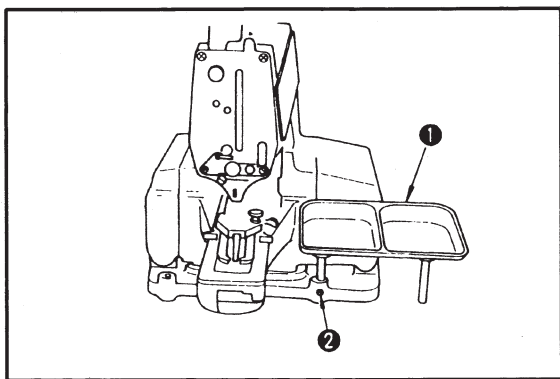


WARNING:

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5. 鈕扣托盤的安裝方法

ATTACHING THE BUTTON TRAY ASSEMBLY

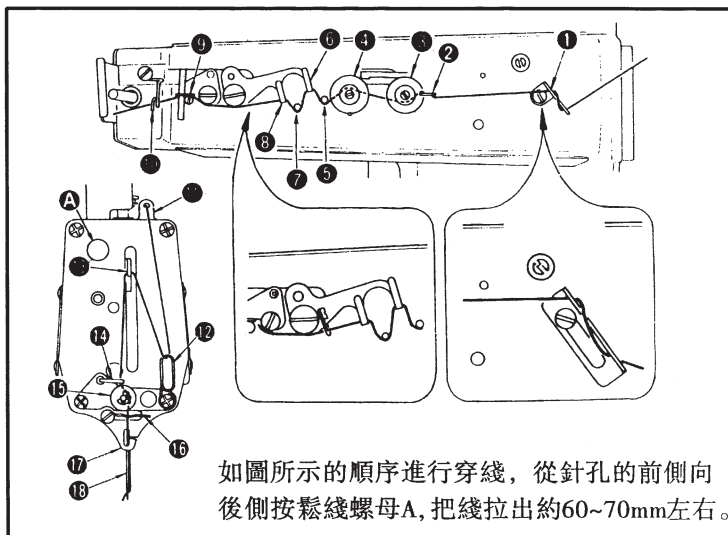


把鈕扣盤1插進機座的前部右側的孔上，并把固定螺絲2擰緊固定。如果，右側抓鈕扣不方便的話，請改裝到左側。

Insert the posts of button tray ① in hole on the right of the machine sub-base and tighten each setscrew ②. You may use also the installation hole on the left if the operator wants.

6. 穿線方法

THREADING THE MACHINE

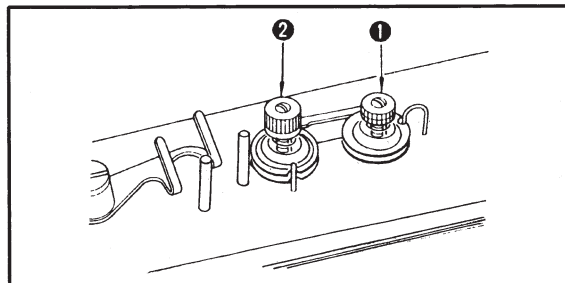


如圖所示的順序進行穿線，從針孔的前側向後側按鬆線螺母A，把線拉出約60~70mm左右。

Thread the machine in the order of ① to 18 as illustrated and pass the thread through the needle eye from the front for 60 to 70 mm as you depress nipper releasing knurled thumb nut A.

7. 夾線器

THREAD TENSION ADJUSTMENT



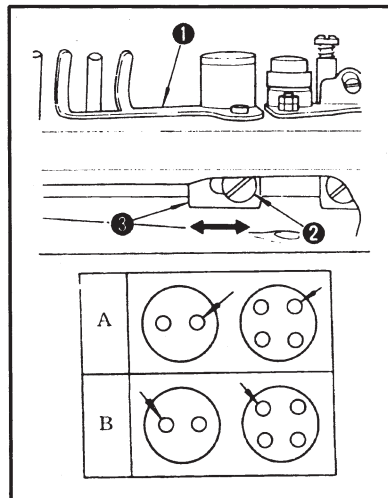
第一線張力螺母①是調整釘扣強度用的，僅能調節極小的張力。

第二張力調整螺母②是調整背面的緊線程度，其張力比第一線張力螺絲①強，根據使用的機綫、布料、鈕扣厚度等情况進行調整。

Tension post No. 1 ① is used to adjust the thread tension to sew on the button and a relatively low tension will be enough. Tension post No. 2 ② is used to adjust the thread tension applied to the root of the button sewing stitches. This tension must be determined according to the type of thread, fabric and thickness of the button and must be higher than that of tension post No. 1 ①. Turn the tension nuts clockwise to increase or counterclockwise to reduce the thread tension. Turn the adjusting nut clockwise to increase or counterclockwise to reduce the tension.

8. 拔線杆的調節

ADJUSTMENT OF THE THREAD PULL-OFF LEVER



調節綫調節杆①實，請把螺絲刀插進左側面板上的孔中，擰鬆固定螺絲②，然後左右移動綫調節杆的活動滑塊③進行調整。縫制結束，如果頭從A部箭頭的孔中露出時，請把綫調節杆活動滑塊③向左移動，如果綫頭從B部箭頭的孔中露出時，請把滑塊向右移動，不讓綫頭露出來。

Adjustment of the thread pull-off lever ①, insert a screw driver through an opening in the machine arm side cover (left), loosen screw ② and adjust the position of nipper bar block (rear) ③ to the left or the right. If the end of thread is drawn from arrow hole A in the button after sewing, change the position of nipper bar block (rear) ③ to the left. Move the lever to the right when the thread end comes out from arrow hole B.



注意

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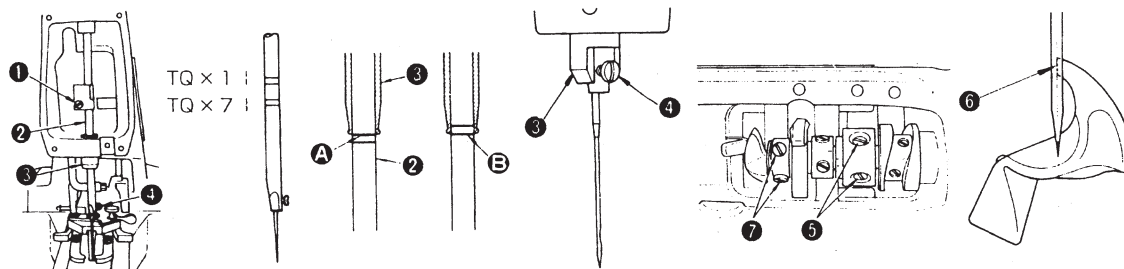


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9. 机针与线钩的关系

NEEDLE-TO-LOOPER RELATION



★機針和彎針按如下方法進行調整。

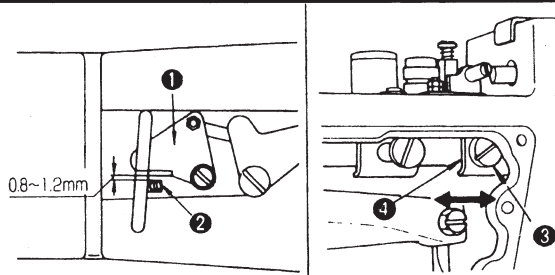
1. 把踏板踩到底，沿轉動方向轉動驅動皮帶輪，讓針杆落到最下點，然後擰鬆固定螺絲①。
(決定針杆高度。)
2. TQ × 1 機針時，使用上方的2條刻線，TQ × 7機針時，使用下方的2條刻線，把其中的上刻線 A 對準針杆下端塊③的下端，然後擰緊固定螺絲①。這時應讓機針固定螺絲 4 進入到避免與針杆下端塊③相碰的溝槽裏。
(決定彎針的位置。)
3. 擰鬆固定螺絲5，轉動皮帶驅動輪，把針杆②的2條一組的刻線中的下線B對準針杆下端③的下端。
4. 在此狀態，把彎針的針尖⑥對準機針的中心，然後擰緊固定螺絲⑤。
5. 擰鬆固定螺絲⑦，把彎針間隙調整為 0.05~0.1mm，再擰緊螺絲⑦。

★ Adjust the needle-to-looper relation as follows:

1. Depress the pedal fully forward, turn the needle driving pulley in the normal sewing direction to bring down the needle bar to the lowest point of its stroke and loosen screw①. (Adjusting the needle bar height)
2. Adjust the height of the needle bar using top two lines engraved on the needle bar for the TQx1 needle and using the bottom two lines for the TQx7 needle. Align the upper line A with the bottom end face of needle bar bushing (lower)③ and tighten screw① in the way that needle clamp screw④ rests in the slot of the needle bar bushing (lower)③. (Looper position)
3. Loosen screws⑤ and turn by hand the needle driving pulley until lower line B of two lines aligns with the bottom end face of needle bar bushing (lower)③.
4. By keeping the machine in this state, align looper blade ⑥ with the center of the needle and tighten screws⑤.
5. Loosen screw⑦ and provide a 0.05 to 0.1 mm clearance between the looper and the needle. Tighten screw⑦.

10. 拔针器的调整

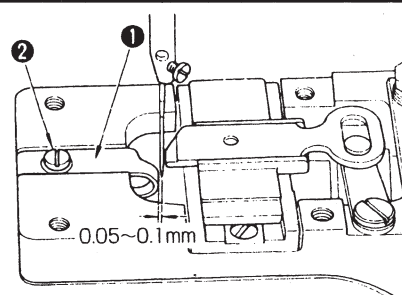
ADJUSTMENT OF THE NIPPER



運轉時，把拔針器的方塊②和拔針器①的間隙調整為0.8~1.2mm，不讓拔針器①往壓住機線。調節方法是，擰鬆固定螺絲③，左右移動拔針器活動滑塊④。

11. 针导向器的位置

POSITION OF THE NEEDLE GUIDE



在針杆最下點，擰鬆螺絲②，左右移動針導向器①，把機針和針導向器①的間隙調整為0.05~0.1mm。

Provide a 0.8 to 1.2 mm clearance between nipper ① and nipper block ② to prevent the nipper from nipping the thread while stitching. Loosen screw ③ and move nipper bar block ④ to the left or the right.

Loosen screw ② and provide a 0.05 to 0.1 mm clearance between the needle guide ① and the needle by moving the needle guide ① to the left or the right when the needle is in the lowest position.



注意

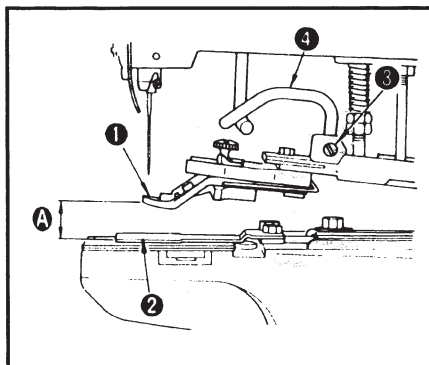
為了防止意外的起動造成的事故，請關掉電源，確認馬達確實停止轉動後再進行。



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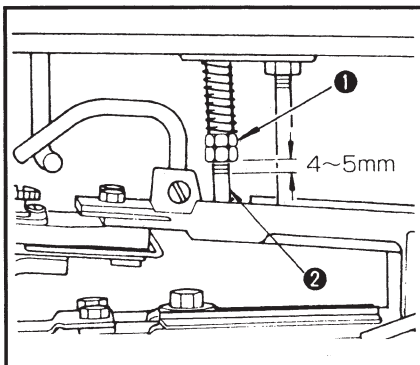
12. 抓扣装置的高度 HEIGHT OF THE BUTTON CLAMP



在斷開位置，鈕扣抓腳①的底面和布壓腳下板②上面的間隔A，372的標準為12mm，372的標準為9mm。

The standard clearance (A) between the bottom face of button clamp jaw lever (1) and the top face of feed plate (2) is 12 mm for 373 and 9 mm for 373. Loosen screw (3) and adjust the height of button clamp lifting hook (4).

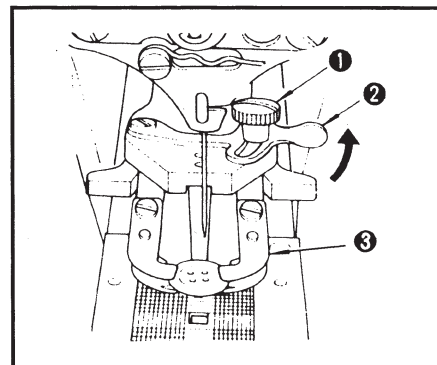
13. 布壓腳壓力的調節 WORK PRESSING FORCE



布壓腳的壓力，以在轉動螺母①2個螺母的下端和壓腳壓力調節杆②的螺絲部間隙為4~5mm時為標準。

The standard work pressing force is obtained by providing a 4 to 5 mm clearance between the bottom face of nut (1) and the bottom end of the screw of pressure adjusting bar (2).

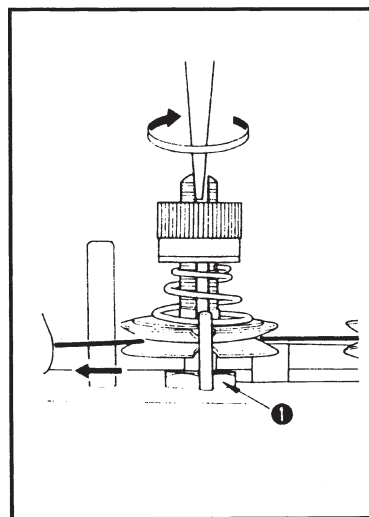
14. 抓腳打開撥杆的調節 ADJUSTMENT OF THE BUTTON CLAMP STOP LEVER



在斷開狀態，擰鬆固定螺絲①，用抓腳打開撥杆②開關打開抓腳③，把鈕扣設定到正確的位置。讓鈕扣容易放進取出，然後擰緊螺絲①。

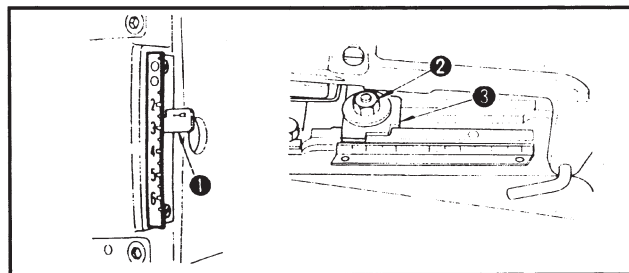
Set the machine for stop-motion state, loosen clamp screw (1), place a button correctly in the sewing position and adjust button clamp stop lever (2) to permit the button properly to rest on button clamp jaw levers (3). Tighten clamp screw (1) after determining the distance between the left and right jaw levers (3).

15. 松線同步時間的調整 TIMING OF THREAD TENSION RELEASE



沿箭頭方向拉機線，轉動驅動皮帶輪，有一個第二線張力盤浮起，機線迅速拔出的點。此時，從針杆上端塊上面到針杆上端的高度為54~56mm時為標準。特別是頻繁發生下列現象時，進行如下調節。擰鬆螺母①，把螺絲刀插入第二線張力杆，沿箭頭方向轉動的話，針杆高度變低，向相反方向轉動，則變高。

16. 两个孔和四个孔的调整方法 SETTING FOR 2-OR 4-HOLE BUTTONS



首先量一下鈕扣孔間隔有幾mm，4眼鈕扣的豎送量和橫送量值應設為相同。

★豎送量

向下壓豎送調節杆①，2眼鈕扣時設到0的位置，4眼鈕扣時根據測定值設定。

★橫送量

擰鬆螺母②，把指針③對準相應的測定值刻度，然後擰緊螺母②。(注意) 請確認機針準確地落入鈕扣各孔的中心後再運轉縫紉機。



注意

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現 象	針杆高度 Z
1. 布料裏側的緊綫不好時。	稍稍高一點。
2. 斷開時，機綫中途斷綫時。	稍稍高一點。
3. 經常斷綫時。	稍稍低一點。

Troubles	Needle bar height z
1. When the stitch made on the wrong side of the work-piece is too loose;	Make the needle bar slightly higher.
2. When the thread is broken at the time of stop-motion;	Make the needle bar slightly higher.
3. When the thread is broken frequently	Make the needle bar slightly lower.

Measure the distance between two holes in a button and set equally crosswise and lengthwise feed regulators for 4-hole buttons.

★Lengthwise feed

Push down lengthwise feed adjusting lever (1) and set it to "0" for 2-hole buttons or a corresponding amount for 4-hole buttons.

★Crosswise feed

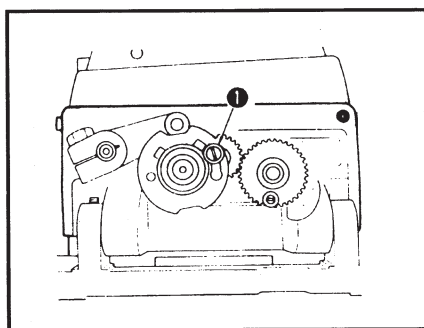
Crosswise nut (2) and set pointer (3) to a corresponding amount indicated by the crosswise feed graduation plate. Tighten firmly nut (2). (Caution) Before operating the machine, ensure that the needle enters the center of each hole in the button.

Turn the needle driving pulley as you draw the thread in the direction of the arrow as illustrated and you will find a point at which the tension disc on the tension post No. 2 release the thread. At this moment, the standard distance from the top end of the needle bar down to the top end of the needle bar bushing (upper) is 54 to 56 mm. Relation of the needle bar height (above-mentioned distance; 54 to 56 mm) to the timing of thread tension release is adjustable by turning the tension post No.2; loosen nut (1), insert the blade of a screw driver to the top slot of the tension post No. 2 and turn it in the direction of the arrow to lower the needle bar, (to reduce the said distance), and vise versa. Your adjustment is required when following troubles are frequency;

17. 针数 SETTING A NUMBER OF STITCHES

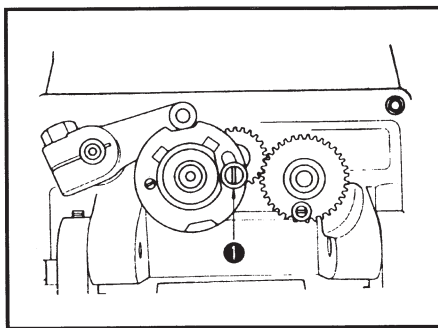
變更針數時，打開左側防護罩，用針數調節旋鈕①和針數調節撥杆④(選購品)進行調整。另外，下圖是卸下預備停止裝置後的圖示，不卸下來也能變換針數。

To change the number of stitches, open the left-hand side cover and change the number of stitches using stitch number adjusting knob (1) and stitch number adjusting lever (4) (optional). The illustration gives the machine with the auxiliary stop device removed. The number of stitches can be changed with ease with the auxiliary stop device attached.



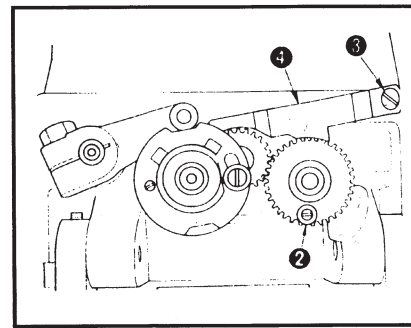
★ 8針(6針)的調整方法

設定爲8針時，請把針數調節旋鈕①向前拉出然後轉到圖示的位置。



★ 16針(12針)的調節方法

在設定爲8針的狀態下，把針數調節旋鈕①再繼續向右轉，把針數調節旋鈕①設定到圖示的位置。



★ 32針(24針)的調節方法

設定爲16針的狀態下，針數調節齒輪螺絲②轉到下側時，用螺絲③(選購品)安裝上針數調節撥杆④(選購品)。



注意

爲了防止意外的起動造成的事故，請關掉電源，確認馬達確實停止轉動後再進行。



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★8 stitches (6 stitches)

Pull stitch adjusting cam knob ① and set it as shown in the illustration.

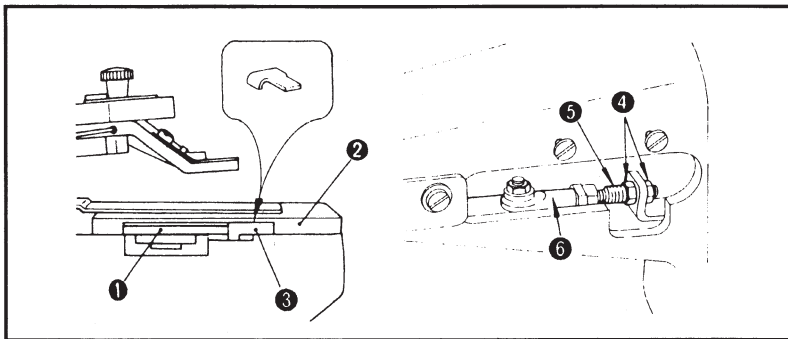
★16 stitches (12 stitches)

When stitch cam knob ① being set for "8 stitches" has arrived at the right end as illustrated, set knob ① in the illustrated position.

★32 stitches (24 stitches)

When the number of stitch is set to 16, move stitch number adjusting gear roller ② to the lower position. Now, attach stitch number adjusting lever ④ (optional) in position using screw ③ (optional).

18. 关于剪线装置的调整 AUTOMATIC THREAD TRIMMER

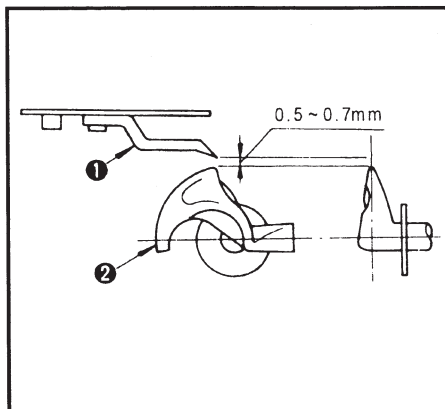


★ 移動剪刀位置的調整

分離後壓腳上升到最高處時，切綫連接板(前) ① 和針板 ② 槽溝端面的間隔標準爲12.5mm。調節12.5mm時，請使用附屬品的定位尺 ③，放倒縫紉機，卸下防油板，擰鬆螺母 ④ (2個)，前後移動連結螺絲 ⑤，進行調整。另外，擰緊螺母 ④ 時，請注意切綫連結接頭 ⑥ 應基本保持水平。

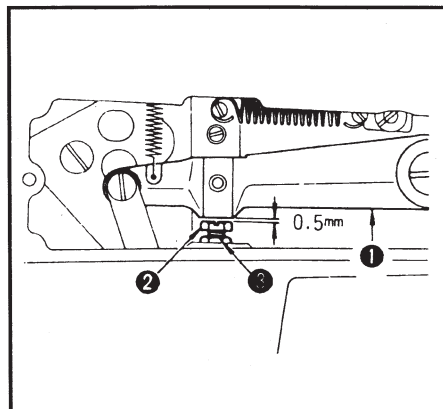
★ Position of the moving knife

When the machine stops in the state of "stop-motion" and its button clamp assembly rests in the highest position, there must be a standard clearance of 12.5 mm between thread trimming connecting link (front) ① and the end face of the slit in throat plate ②. This clearance is determined gauge ③ which is stored in the accessory box; tilt the head backwards, remove the bed oil shield, loosen two nuts ④ and adjust the clearance by moving connecting screw ⑤ in the axial direction. When you tighten two nuts ④, ensure that joint ⑥ stays in the horizontal position.



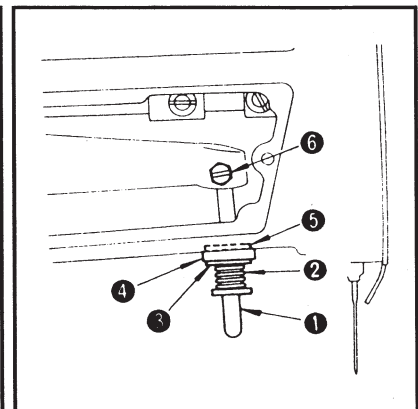
★移動刀分綫爪高度調整

分綫爪 ① 和彎針 ② 的間隙爲0.5 ~ 0.7mm，如果分綫爪高度不正確時，請弄彎分綫爪 ①。



★提升撥杆和調節螺絲的間隙

把提升撥杆 ① 端面和調節螺絲 ② 的間隙調整爲0.5mm，然鈕擰緊調節螺絲螺母 ③。



★L型提升杆的安裝方法

按移動刀反彈彈簧 ②、分離墊片 ③、分離墊 ④、分離墊片 ⑤ 的順序安裝到L型提升杆上。確認完全分離之後讓機梁的凸部和分離墊片端面緊密結合，不要有任何鬆動，用螺絲 ⑥ 擰緊固定。

★ Height of the moving knife thread separation nail

There must be a 0.5 to 0.7 mm clearance between looper blade point ② and thread separation nail ①. If nail ① does not provide the necessary clearance, bend the nail slightly and adjust the clearance.

★ Clearance between the button clamp lifting lever and the adjusting screw

Provide a 0.5 mm clearance between button clamp lifting lever ① and adjusting screw ② and the tighten nut ③.

★ How to set the L-shaped lifting rod
Put moving knife push-back spring ②, stop-motion rubber cushion ④ and stop-motion rubber cushion washer ⑤, in this order, to L-shaped lifting rod ①. After making sure that the stop-motion mechanism has engaged completely, fix the L-shaped lifting rod by tightening screw ⑥ in the way that the end face of the stop-motion rubber cushion washer comes into close contact with the jaw of the machine arm.

19. 规格 SPECIFICATIONS

	XF		option
Sewing speed	Max. 1,500 s.p.m		Max. 1,500 s.p.m (Normal 300 s.p.m)
Number of stitches	8, 16 and 32 stitches (6, 12 and 24 by changing the cam)		8, 16, 32
Feed amount	Lateral feed 2.5 to 6.5 mm Longitudinal feed 0 to 6.5 mm		
Button size	10 to 28 mm		
Needle used	TQx7, TQx1 #16 (#18, #20)	TQx7, TQx1 #20 (#18)	TQx1 #16 (#14) (TQx7 #16 to #20)
Lubricating oil	T10#		

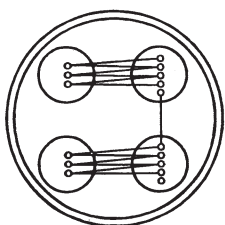
	XF		选项
縫紉速度	最高每分鐘 1,500 針		最高每分鐘 1,500 針 (常用每分鐘 1,300 針)
針數	8, 16, 32 針 (更換凸輪後可為 6, 12, 24 針)		8, 16, 32 針
送布量	橫向送布 2.5 ~ 6.5 mm 豎送布 0 ~ 6.5 mm		
鈕扣尺寸	10 ~ 28 mm		
使用針號	TQx7, TQx1 #16 (#18, #20)	TQx7, TQx1 #20 (#18)	TQx1 #16 (#14) (TQx7 #16 to #20)
機油	T10#		

21. 故障原因及对策

故 障	原 因	對 策
1 斷綫。	① 靠綫動作不良。 ② 第二綫張力盤的同步不好。 ③ 拔針器壓綫 ④ 機針沒有落到鈕扣的中心。 ⑤ 針與扣眼相比太粗。	調整靠綫左右同步。 提早綫張力盤浮起同步。 調節拔針器擺動滑塊。 用抓腳安裝台調整。 換為細針。
2 緊綫不良。	① 靠綫動作不良。 ② 第二綫張力盤的同步不好。 ③ 第二綫張力盤的張力不良 ④ 機針沒有落到鈕扣的中心。 ⑤ 布壓腳壓力不良。	調整靠綫左右同步。 稍稍推遲綫張力盤浮起同步時間。 用第二綫張力盤調整。 用抓腳安裝台調整。 調整布壓腳壓力。
3 鈕扣上第一針的綫出的太長。	綫張力撥杆調整不良。	調整綫張力撥杆擺動軸。
4 分離時切綫不良。	① 第二綫張力盤的同步不好。 ② 機針碰到鈕扣孔。 ③ 抓扣裝置上升不良。 ④ 拔針器壓綫不良。 ⑤ 布壓腳壓力太大。	稍稍推遲綫張力盤浮起同步，使緊綫變好。 調整落針。 讓抓扣腳到下板的距離為12mm。 調節拔針器擺動滑塊。 用布壓腳壓力調節螺母進行調節。
5 綫切不斷。	① 移動刀分綫爪不能把布側的綫確實分開。 ② 機針沒有落到鈕扣的中心。 ③ 最後落針跳針。 ④ 移動剪刀分綫爪高度不良。	調整移動刀位置。 用抓腳安裝台調整。 調整彎針。 調整動刀分綫爪高度。
6 面綫和底綫2根都斷綫。	① 移動刀位置不良 ② 移動刀分綫爪高度不良	調整分離時移動刀的位置。 調動移動刀分綫爪的高度。
7 切綫後布裏側綫出得太長。	① 綫移動刀切綫同步不良。 ② 抓扣裝置上升量過大。	調整移動刀位置。 把抓腳上升量調整為9mm。

22. 针迹型式

8.16.32 針

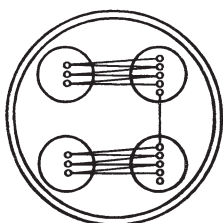


21. TROUBLES AND CORRECTIVE MEASURES

TROUBLES	CAUSES	CORRECTIVE MEASURES
1. Thread breakage.	(1) The yoke slide does not move in the correct way. (2) The thread tension post No. 2 fails to release the thread at correct timing. (3) The thread nipper catches the thread. (4) The needle does not enter the center of the holes in the button. (5) The needle is too thick for the diameter of the hole in the button.	(1) Adjust the timing of the motion of the yoke slide at each end. (2) Make the thread release timing slightly earlier. (3) Adjust the position of the nipper bar block. (4) Adjust the button clamp jaw lever holder. (5) Replace the needle by a thinner one.
2. Buttons are not sewn tightly.	(1) The yoke slide does not move in the correct way. (2) The thread tension post No. 2 fails to release the thread at correct timing. (3) The thread tension post No. 2 does not give sufficient tension. (4) The needle does not enter the center of the holes in the button. (5) The work pressing force is too high or too low.	(1) Adjust the timing of the motion of the yoke slide at each end. (2) Make the thread release timing slightly earlier. (3) Tighten the tension nut of tension post No. 2. (4) Adjust the button clamp jaw lever holder. (5) Adjust the work pressing force properly.
3. The first stitch trails relatively long thread from the right side of the button.	The thread pull-off lever does not work properly.	Adjust the thread pull-off lever by the nipper bar block (rear).
4. Thread trimming failure in the state of stop-motion.	(1) The thread tension post No. 2 fails to release the thread at correct timing. (2) The needle hits the edge of the holes in the button. (3) The button clamp assembly does not rise to the necessary height. (4) The thread nipper catches the thread or too low. (5) The work pressing force is too high.	(1) Make the thread release timing slightly later to give more tension to the stitches. (2) Adjust the button clamp jaw lever holder. (3) Provide a 12 mm clearance between the feed plate and the button clamp jaw levers when raised. (4) Adjust the nipper bar block. (5) Adjust the work pressing force by the pressure adjusting nut.
5. Thread trimming failure.	(1) The moving knife does not separate the thread on the fabric with its separation nail. (2) The needle does not enter the center of the holes in the button. (3) The last stitch skips. (4) The moving knife separation nail is too high or too low.	Adjust the position of the moving knife. Adjust the button clamp jaw lever holders. Adjust the looper. Adjust the height of the moving knife thread separation nail.
6. The needle thread is cut in two places on the wrong side of the fabric.	(1) The moving knife is set in wrong place. (2) The moving knife thread separation nail is too high or too low.	Adjust the position of the moving knife when the machine is in the stop-motion state. Adjust the height of the thread separation nail.
7. Buttons trails too long thread after thread trimming.	(1) Timing of the moving knife motion is wrong. (2) The button clamp assembly rises too much.	Adjust the position of the moving knife. Reduce the button clamp lift down to 9 mm.

22. STITCH FORMATION

8. 16. 32 針



CE DECLARATION OF CONFORMITY

Distributor:

Strima Sp. z o.o.

Swadzim, ul. Poznańska 54

62-080 Tarnowo Podgórne, Poland

We declare, that the following product:

Industrial sewing machine Texi brand

Model: **XF**

Has been designed and manufactured in compliance with provisions of the following CE directives:

2006/42/EC - Machinery Directive

2014/35/EU - Low Voltage Directive

2014/30/EU - Electro Magnetic Compatibility

Applied harmonized standards:

EN ISO 12100:2010,

EN ISO 10821:2005+A1:2009, 60204-1:2006+A1:2009+AC:2010,

EN 60204-31:2013

Certificate of Compliance No: 21151222.ZBSQS33

Technical Construction File no. RVT-BY20151211.003.007.009

Swadzim 01.06.2025

Strima Sp. z o.o.

NOTES

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

Dealer:

