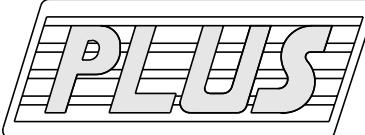
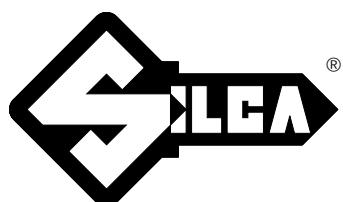


LANCER 

Operating manual

D411202XA

vers. 2.0



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CONTENTS

GUIDE TO THE MANUAL	1
GENERAL INSTRUCTIONS	2
1 TRANSPORT	3
1.1 Packing	3
1.2 Transport	4
1.3 Opening the packing	4
1.4 Handling the machine	4
2 KEY CUTTING MACHINE DESCRIPTION	5
2.1 Working parts	7
2.2 Technical data	8
2.3 Electrical circuit	8
3 ACCESSORIES PROVIDED	9
3.1 Graphics	9
4 MACHINE INSTALLATION and PREPARATION	10
4.1 Checking for damage	10
4.2 Atmospheric conditions	10
4.3 Positioning	10
4.4 Description of work station	10
5 CHECKING CALIBRATION	11
5.1 Checking AXIAL CALIBRATION	11
5.2 Checking DEPTH CALIBRATION	12
6 MACHINE REGULATION and POSITIONING of KEYS	13
6.1 Main carriage	13
6.2 Jaws	13
6.3 Tracers.....	14
6.4 Positioning of keys	14
7 CUTTING OPERATIONS	15
7.1 Cutting of keys with radiused lever cuts (CHUBB type)	15
7.2 Cutting of keys FLAT LEVER CUTS	16
7.3 Cutting of FLAT STEEL KEYS	16
7.4 Cutting of keys with SIDE and BULLET WARDS	17
8 MAINTENANCE	19
8.1 REPLACEMENT OF CUTTERS	19
8.2 REPLACEMENT OF FUSES	20
9 DISPOSAL	21
10 ASSISTANCE	22
10.1 How to request service	22

GUIDE TO THE MANUAL

This manual has been produced to serve as a guide for users of the LANCER PLUS key-cutting machine. Read it carefully; it is essential if you wish to operate your machine safely and efficiently.

CONSULTATION

The contents of the manual are divided into sections relating to:

- Transport and handling	Chapter	1
- Checking and safety of the machine	Chapter	4
- Proper use of the machine	Chapters	5-6-7
- Maintenance	Chapter	9

TECHNICAL TERMS

Common technical terms are used in this manual; fig. 1 shows the names of the different parts of the keys most commonly copied with the LANCER PLUS.

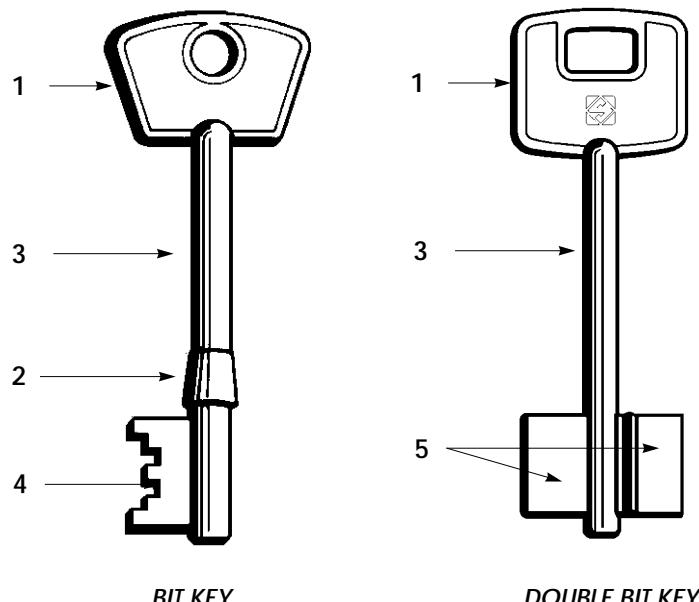


Fig. 1

- 1) Head
- 2) Shoulder
- 3) Stem
- 4) Bit
- 5) Double bit

GENERAL INSTRUCTIONS

The LANCER PLUS key-cutting machine has been designed according to the specifications of the Machine Directives.

Right from the design stage risks for the operator have been eliminated in all areas: transport, key-cutting, regulation and maintenance.

Other risks have been eliminated by the use of protective devices for the operator.

The protective devices used are designed not to provoke further risks and, above all, they cannot be ignored unless deliberately cut out. They do not hinder visibility of the work area.

A special adhesive label is attached to the machine warning the operator to use goggles during the cutting operations, and this is strongly recommended in this manual.

The material used in the manufacture of this machine and the components employed during use of the machine are not dangerous and their use complies with standards.

USE

The LANCER PLUS must be installed and used in the way laid down by the manufacturer.

If the key-cutting machine is used differently or for purposes different from those described in this manual, the customer will forego any rights he may have over Silca S.p.A. Furthermore, unforeseen danger to the operator or any third parties may arise from incorrect use of the machine.

Negligence in the use of the machine or failure on the part of the operator to observe the instructions given in this manual are not covered by the guarantee and the manufacturer declines all responsibility in such cases.

It is therefore essential to read the operating manual carefully in order to make the best use of the LANCER PLUS and benefit from its potential.

FURTHER RISKS

There are no further risks arising from the use of the LANCER PLUS key-cutting machine.

PROTECTION AND SAFETY PRECAUTIONS FOR THE OPERATOR

The LANCER PLUS key-cutting machine is built entirely to standards. The operations for which it has been designed are easily carried out at no risk to the operator.

The adoption of general safety precautions (wearing protective goggles) and observation of the instructions provided by the manufacturer in this manual eliminate all human error, unless deliberate.

The LANCER PLUS key-cutting machine is designed with features which make it completely safe in all its parts.

- **Power supply**

The machine is supplied with electricity by means of an earthed plug and differential switch.

- **Start-up**

The machine is started up by means of the master switch on the front.

- **Operations**

The switch inbuilt into the vertical lever handle activates the motor.

- **Maintenance**

The operations to regulate, service, repair and clean the machine have been devised in the simplest possible way. There is no danger of removable parts being replaced wrongly or unsafely.

- **Machine identification**

The LANCER PLUS key-cutting machine is provided with an identification label which shows the serial number (fig. 2).

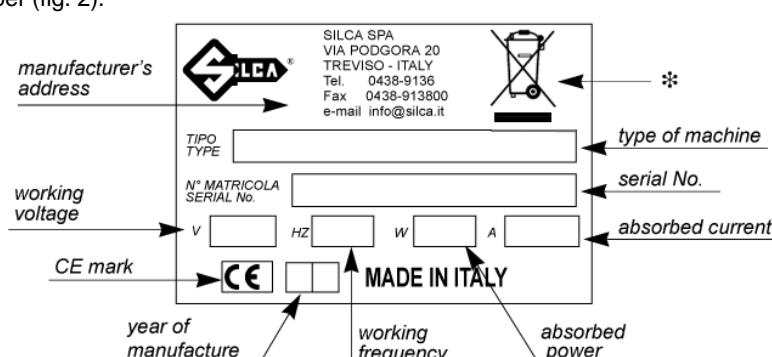


Fig. 2

(*) see ch.9 "DISPOSAL", page 21.

1 TRANSPORT

The LANCER PLUS key-cutting machine is easily transported and is not dangerous to handle. The packed machine can be carried by two persons.

1.1 Packing

The packing used for the LANCER PLUS guarantees that the machine will travel safely without danger of damage to it or its components.

The packing comprises: 1 pallet, 1 cardboard box, straps and supports in expanded plastic in the machine is wrapped.

A strong outer cardboard box, the measurements of which can be seen in fig. 4, and the plastic wrapping protect the machine even over a long period of storage.

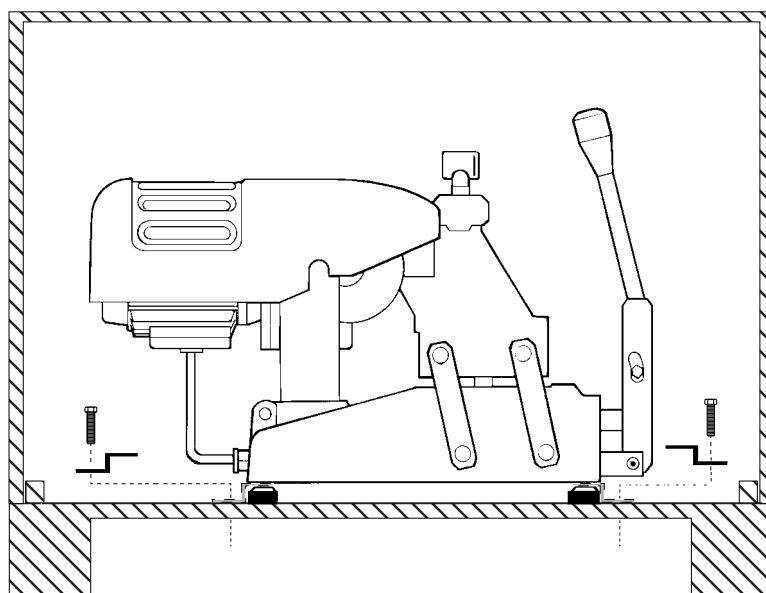


Fig. 3

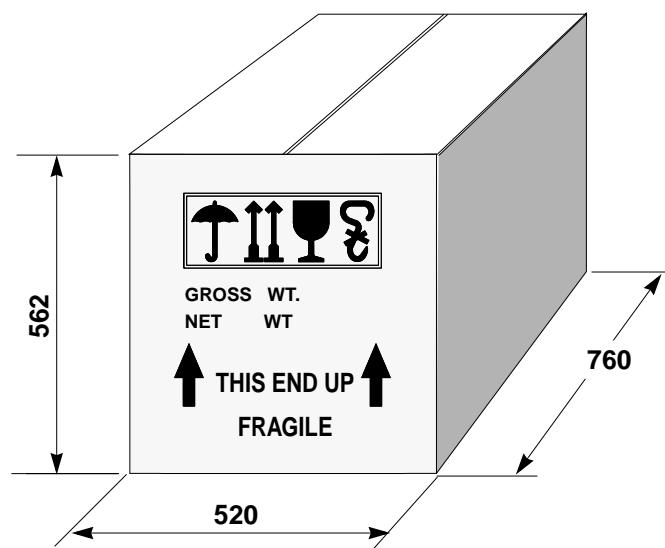


Fig. 4

1.2 Transport

The symbols on the outside of the packing box show the ideal conditions for transport.
Use of the packing box whenever the machine is transported will avoid knocks or bumps which could cause damage.

1.3 Opening the packing

To remove the machine from the packing box:

- 1) cut the straps with scissors and remove.
- 2) prise off the staples.
- 3) open the box without damaging it as it may be used again (removals, dispatch to the manufacturers for repairs or servicing).
- 4) remove the machine as follows:
 - a) pull up the packing box.
 - b) remove the brackets anchoring the machine to base using the wrench (supplied with the machine).
 - c) when handling the machine (unpacking, lifting, moving) never grip the carriages or other sensitive parts of the machine. **Always grip the bottom of the base.**
- 5) check the contents of the box, which should comprise:
 - 1 LANCER PLUS key-cutting machine.
 - 1 set of documents including: operating manual, spare parts list and guarantee.
 - 1 connecting wire.

1.4 Handling the machine

When the LANCER PLUS has been unpacked, place it directly on its workbench.

This operation can be carried out by two persons, **firmly holding the base, and no other part, to lift and carry the machine.**

2 KEY CUTTING MACHINE DESCRIPTION

The LANCER PLUS is a modern, high performance, key cutting machine, with the ability to cut many different type of keys without the use of specific jaws or carriages.

A sliding carriage offers you the possibility to cut many types of keys.

LANCER PLUS cuts the following types of keys:

- ① *bit and double bit keys*
- ② *keys with radiused lever cuts (Chubb type)*
- ③ *keys with bullet wards*
- ④ *keys with side wards*
- ⑤ *flat steel keys*

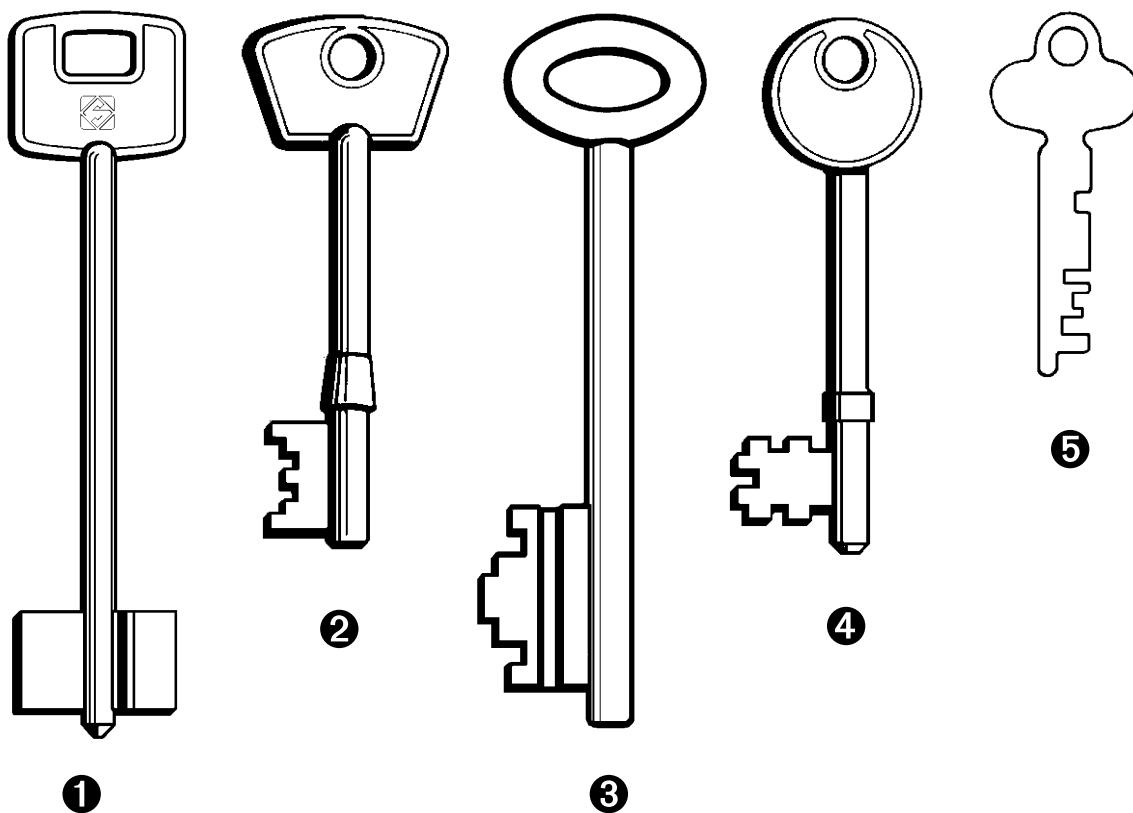


Fig. 5

The high quality of components parts guarantees precise duplication with the LANCER PLUS:

• **MOVEMENTS**

on the X and Y axes: on guides.

on the Z axis: grinding and tempered column.

• **JAWS**

Reversible jaws permit sure locking of both radiused lever cuts keys and flat steel keys.

• **HEADCLAMP**

Maintains the bit of the key in a horizontal position.

• **TRACERS**

Tracer (M) gives a radiused cutting on all those keys of chubb type.

Tracer (N) can be rotated in order to follow the form of both bullet and side ward cuts.

• **CUTTERS**

Ø 80 mm: side chip milling cutter for frontal cuts.

Ø 25 mm:cutter for side and bullet wards.

• **LEVERS**

Lever (G) operates the vertical movement and has a switch inbuilt into the ergonomically designed handle to operate the drive-motor.

Lever (F) operates the movement on both the X and Y axes.

2.1 Working parts

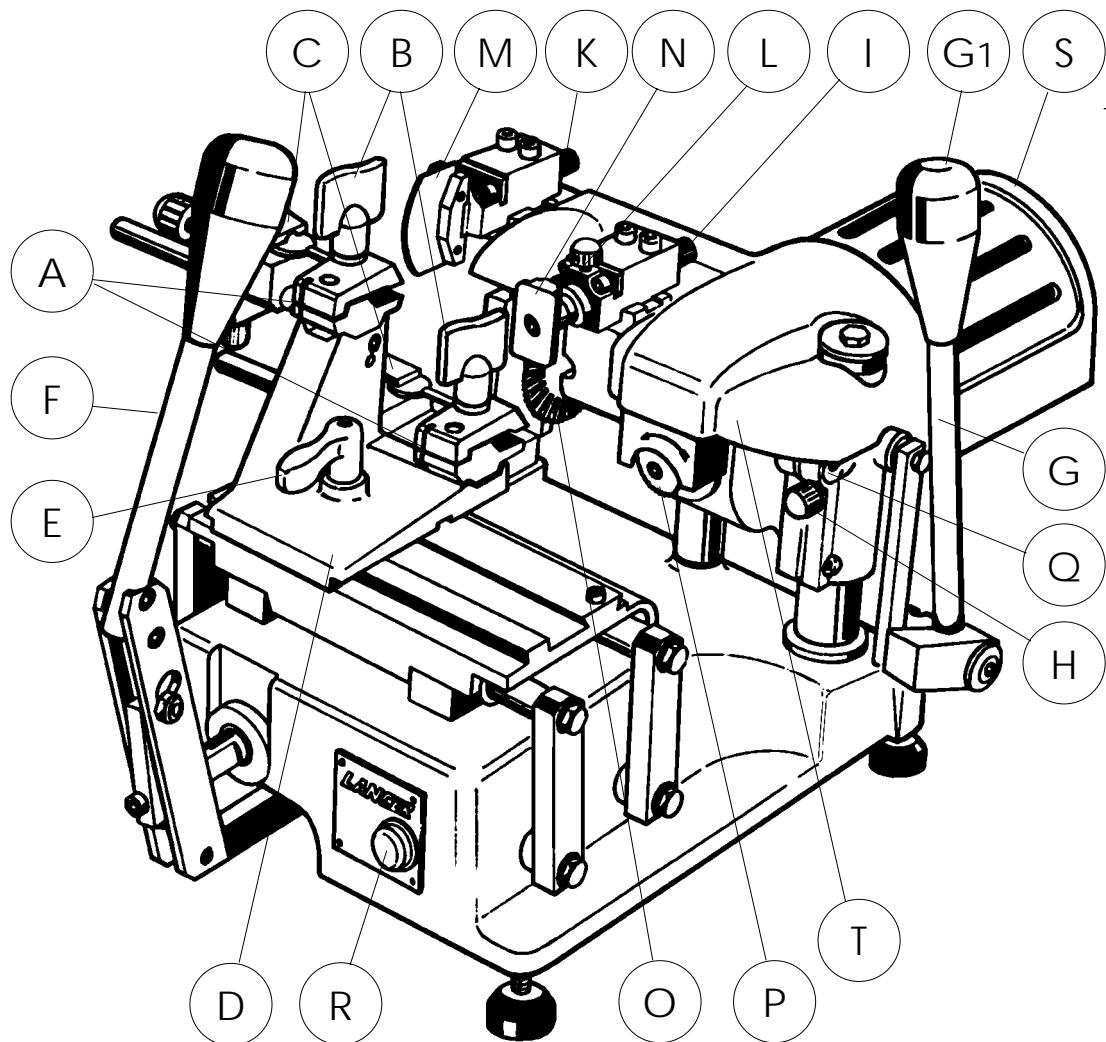


Fig. 6

- A - reversible jaws
- B - locking jaw handle
- C - headclamp
- D - main carriage
- E - main carriage locking lever
- F - lever (X and Y axes)
- G - lever (Z axis)
- G1 - handle with motor switch
- H - vertical carriage locking knob
- I - tracer depth regulation knob
- K - tracer depth regulation knob
- L - tracer locking knob
- M - tracer (for ø 80 mm cutter)
- N - tracer (for ø 25 mm cutter)
- O - ø 80 mm side chip milling cutter
- P - ø 25 mm cutter
- Q - locking bar hole
- R - main switch
- S - motor
- T - cover

2.2 Technical data

MOTOR: single phase, 220V - 50Hz

CUTTERS: super rapid steel (HSS)

MOVEMENTS: three axes on guides, grinding and tempered column.

JAWS: reversible (180°) and removable

DIMENSIONS: width: 450 mm depth: 680 mm height: 300 mm

WEIGHT: Kg. 33

Noise pressure: Lp (A) = 86,15 dB (A) Noise potential: Lw (A) = 98,98 dB (A)

2.3 Electrical circuit

The main parts of the electrical circuit on the LANCER PLUS are listed below:

① Mains inlet

- houses the two rapid fuses which protect the two phases from short circuits.

② Main switch with light

- supplies power to the entire machine.

③ Terminal board

- for the connection of the electrical parts.

④ Microswitch

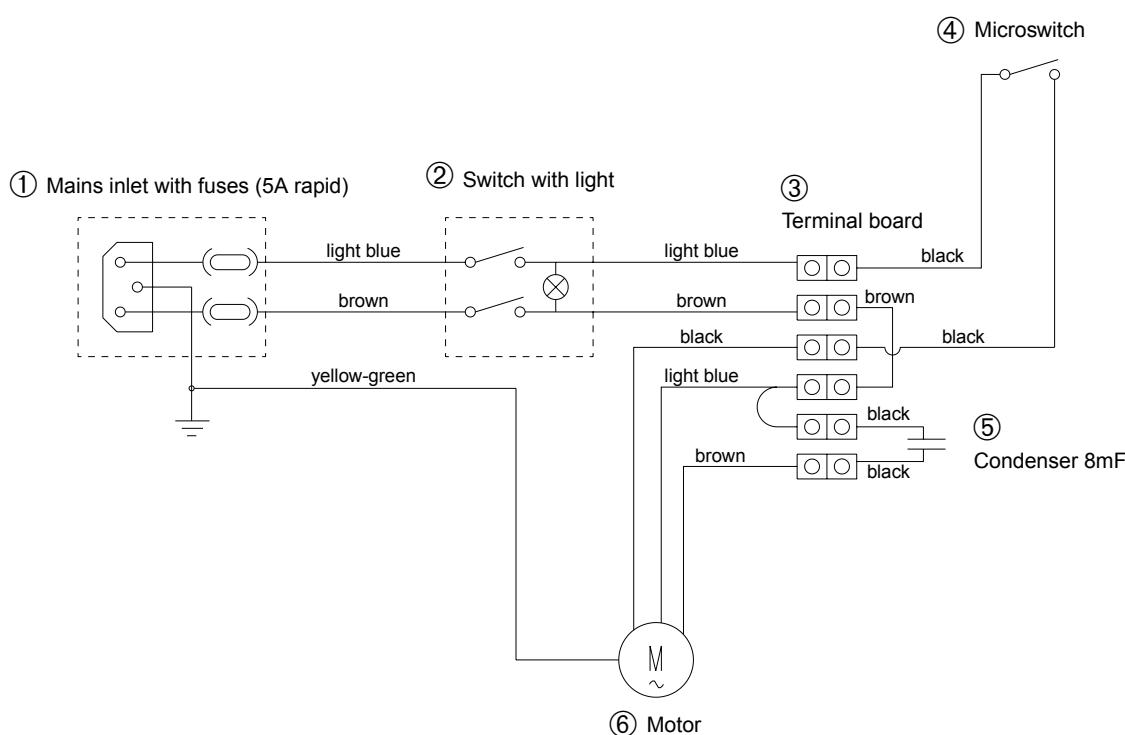
- activates the motor.

⑤ Condenser

- 8 µF

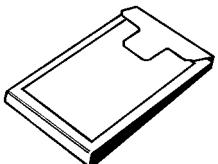
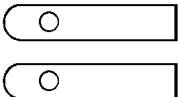
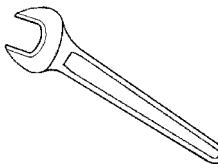
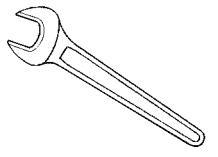
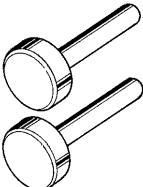
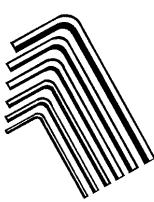
⑥ Motor

- asynchronous, single phase.



3 ACCESSORIES PROVIDED

A set of accessories is supplied for use with the machine or for servicing (tools, Allen keys etc.).

 <p>1 code D401198ZZ TOOLS WALLET 1 pcs.</p>	 <p>6 code D402302BA STEEL TIP STOP BAR 2 pcs.</p>
 <p>2 code D400754BA LOCKING BAR 1 pcs.</p>	 <p>7 code D401224ZZ STEEL PIN Ø 1.20 mm 2 pcs.</p>
 <p>3 code D300783ZZ SPANNER 19 mm 1 pcs.</p>	 <p>8 code D401225ZZ STEEL PIN Ø 1.70 mm 2 pcs.</p>
 <p>4 code D300308ZZ SPANNER 10 mm 1 pcs.</p>	 <p>9 code D401029BA SETTING TOOLS 2 pcs.</p>
 <p>5 ALLEN KEYS 6 pcs. 2 mm code D300221ZZ 2.5 mm code D300222ZZ 3 mm code D300223ZZ 4 mm code D300224ZZ 5 mm code D300225ZZ 6 mm code D300226ZZ</p>	 <p>10 FUSE (2 pcs.) code D310788ZZ 5 Amps rapid for 220V</p>

3.1 Graphics



4 MACHINE INSTALLATION AND PREPARATION

The key-cutting machine can be installed by the purchaser and does not require any special skills. The machine is supplied ready for use and does not need to be set up, except when changing to different tools. However, some checks and preparation for use need to be carried out by the operator.

4.1 Checking for damage

The LANCER PLUS key-cutting machine is solid and compact and will not normally damage if transport, unpacking and installation have all been carried out according to instructions. Notwithstanding, it is always advisable to check that the machine has not suffered any damage.

4.2 Atmospheric conditions

To ensure that the best use is made of the LANCER PLUS key-cutting machine, certain parameters must be borne in mind:

- damp, badly ventilated sites should be avoided.
- the ideal conditions for the machine are: temperature: from 0 to 40°C; relative humidity: approx. 60%

4.3 Positioning

Place the key-cutting machine on a horizontal surface, solid enough to take the weight.

The workbench should be approx. 100-120 cm high to give easy access to the working parts of the machine.

Leave enough space around the machine (20-30 cm) to ensure good ventilation and room for manoeuvre.

ATTENTION: ensure that the key-cutting machine voltage is suitable for the mains supply available, which must be earthed and provided with a differential switch.

4.4 Description of work station

The key-cutting machine needs only one operator, who has the following controls at his/her disposal:

- master switch (R) placed on the front of the machine.
- motor switch (G1) placed on the vertical lever handle (G).
- levers:
 - lever (F) main carriage movement (axes X-Y)
 - lever (G) vertical carriage movement (axis Z)

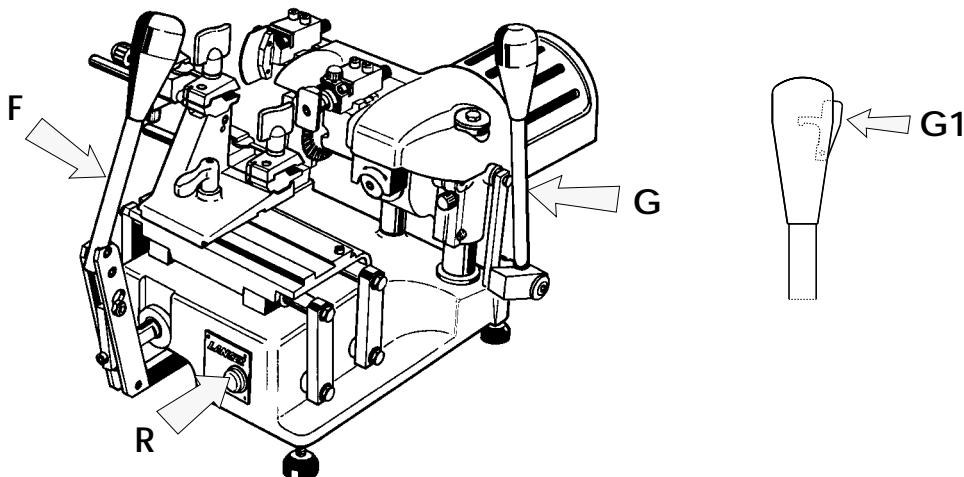


Fig. 7

5 CHECKING CALIBRATION

The LANCER PLUS is calibrated in the Silca factory before dispatch but it's recommended to check before operating.

It's also recommended to carry out these operations when fitting new cutters or tracer points.

5.1 Checking AXIAL CALIBRATION

AXIAL CALIBRATION for LEVER CUTS

Position the main carriage on the left hand side (position 1 - fig. 12 on page 13) to install the setting tools (X) into the jaws.

Check that the setting tools (X) align correctly on the left hand side of cutter and tracer (see fig. 8).

If it does not occur:

- loosen the two allen screws (M1) and move laterally the tracer until it is aligned with the setting tools.

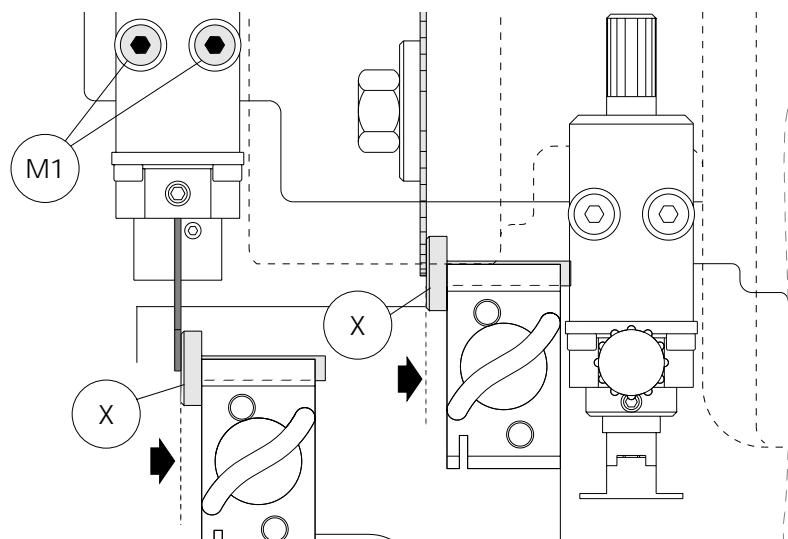


Fig. 8

AXIAL CALIBRATION for SIDE and BULLET WARDS

Position the main carriage on the left hand side (position 1 - fig. 12 on page 13) to install the setting tools (X) into the jaws.

To calibrate the ward cutter, position the carriage on the right hand side (position 2 - fig. 12).

Check that the setting tools (X) align correctly on the right hand side of the cutter and tracer (fig. 9). If it does not occur:

- loosen the two allen screws (N1) and move laterally the tracer until it is aligned with the setting tools (X).

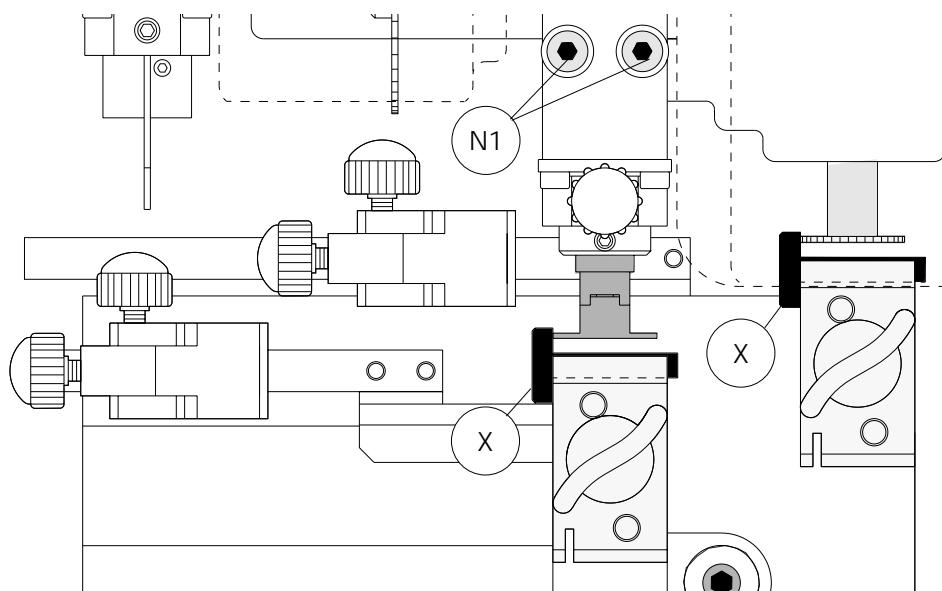


Fig. 9

5.2 Checking DEPTH CALIBRATION

DEPTH CALIBRATION for lever cuts ($\varnothing 80$ mm cutter)

Position the main carriage on the left hand side (position 1 - fig. 12 on page 13) and install the setting tools (X) into the jaws.

Check that the setting tools (X) touch simultaneously cutter and tracer. If it does not occur:

- loosen the grub screw (V) and turn clockwise or anti-clockwise the (K) knurled knob until the setting tools align with cutter and tracer. Lock the grub screw (V).

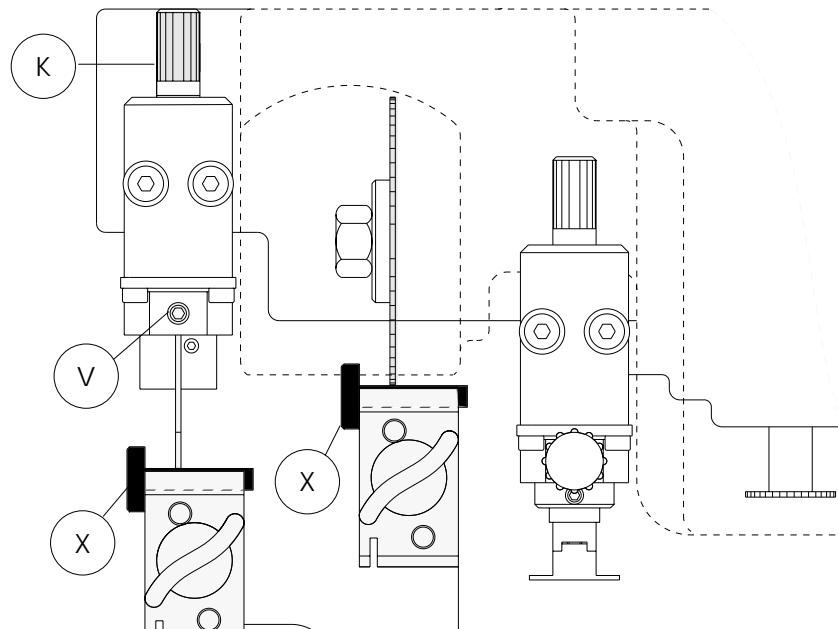


Fig. 10

DEPTH CALIBRATION for side wards cuts ($\varnothing 25$ mm cutter)

Position the main carriage on the left hand side (pos.1 - fig. 12) to install the setting tools (X) into the jaws.

To calibrate the ward cutter, position the carriage on the right hand side (position 2).

Check that the setting tools (X) touch simultaneously cutter and tracer. If it does not occur:

- loosen the knob (L) and loosen grub screw (L1).
- turn clockwise or anti-clockwise the (I) knurled knob until the setting tools align with cutter and tracer.
- after correctly calibrating the tracer it is necessary to locate and lock the setting ring (L2) against the body of the tracer. Lock knob (L).

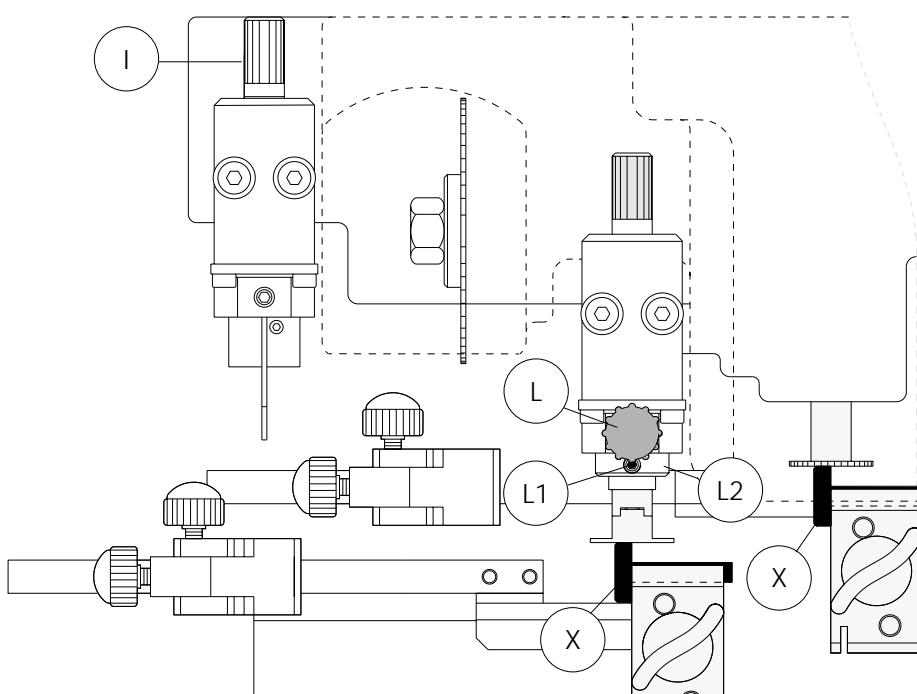


Fig. 11

6 MACHINE REGULATION AND POSITIONING OF KEYS

6.1 Main carriage

Depending on the type of cut to be made the main carriage must be located in:

position 1: to the left for flat, radiused lever cuts and flat steel keys;

position 2: to the right for side and bullet wards.

The carriage is secured by lever (E).

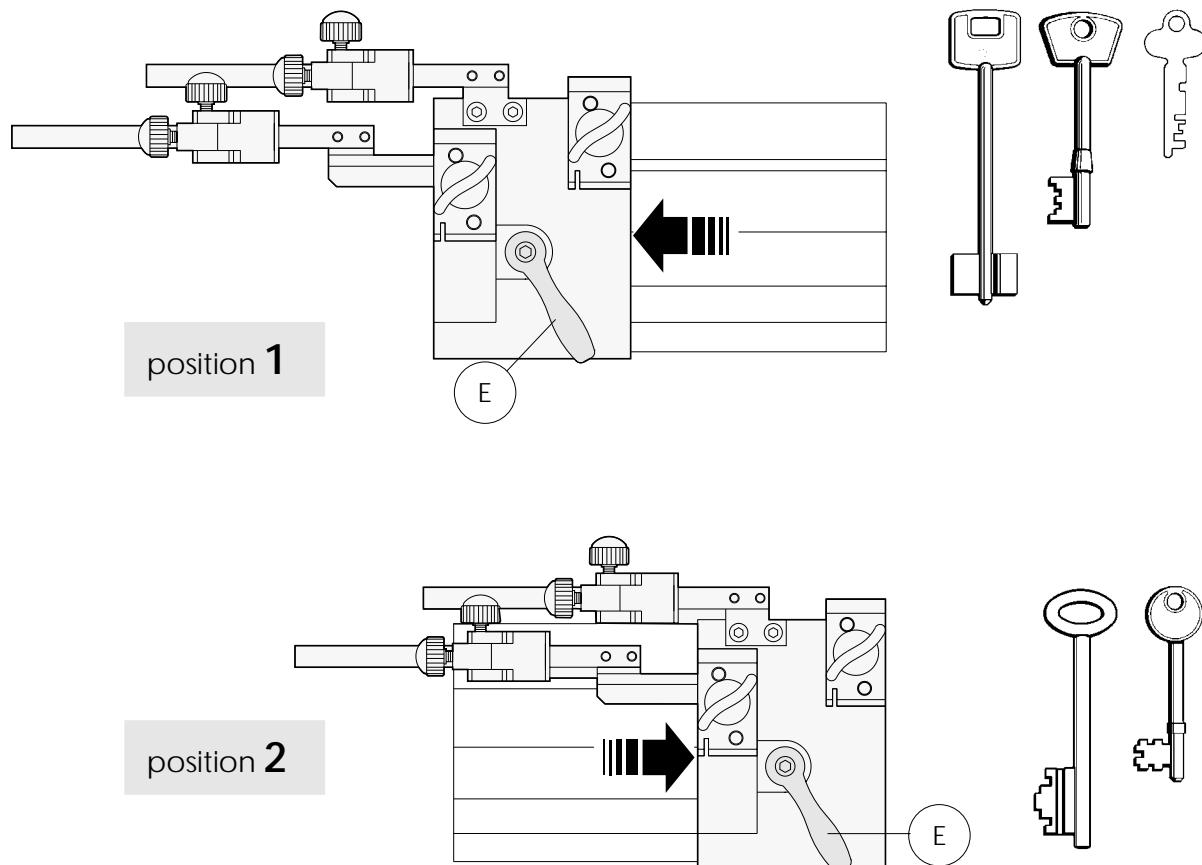


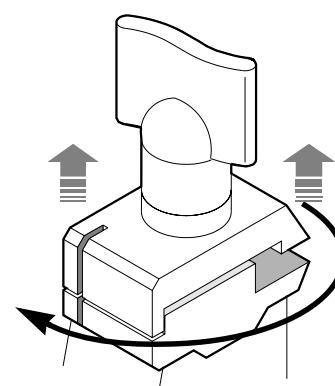
Fig. 12

6.2 Jaws

The jaws are reversible guaranteeing perfect clamping of both: bit keys and flat steel keys.

To change the jaw from one type of key to the other, it's necessary to loosen the jaw handle, lift the jaw and rotate 180°.

Fig. 13



6.3 Tracers

With the tracer (N) positioned as shown in fig. 14 you can make the side ward cuts.
Loosening the locking screw (L) you can rotate the tracer and into the position shown in fig. 15 allowing you to cut bullet wards.

ATTENTION: the calibration is not altered by the rotation of the tracer point.

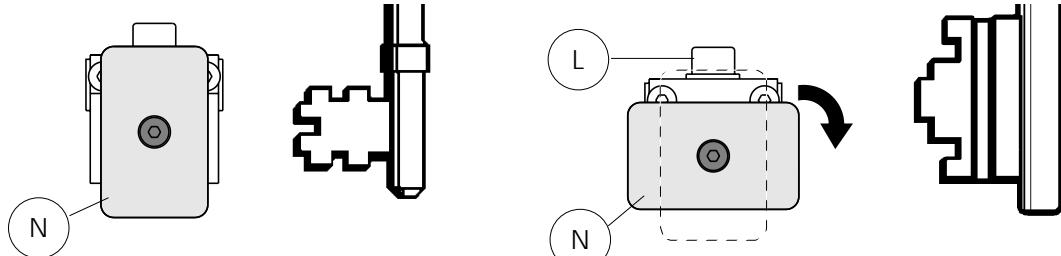


Fig. 14

Fig. 15

6.4 Positioning of keys

ATTENTION: to install the keys the carriage must be positioned on the left hand side (position 1 - fig. 15).

- 1) loosen the thumbscrew (B) to open the jaw.
- 2) insert the original key in the left hand jaw aligning the shoulder with the side of the jaw (fig. 16) tightening the thumbscrew (B) slightly.
- 3) to fit headclamp loosen screws (C1), (C2) and (C3) (fig. 17), slide the headclamp over the head of the key, ensure that the bit of the key is horizontal and re-tighten the screws in the following order: (C1), (C2) and (C3).
- 4) fully tighten thumbscrew (B).
- 5) repeat the same operation for the blank key.

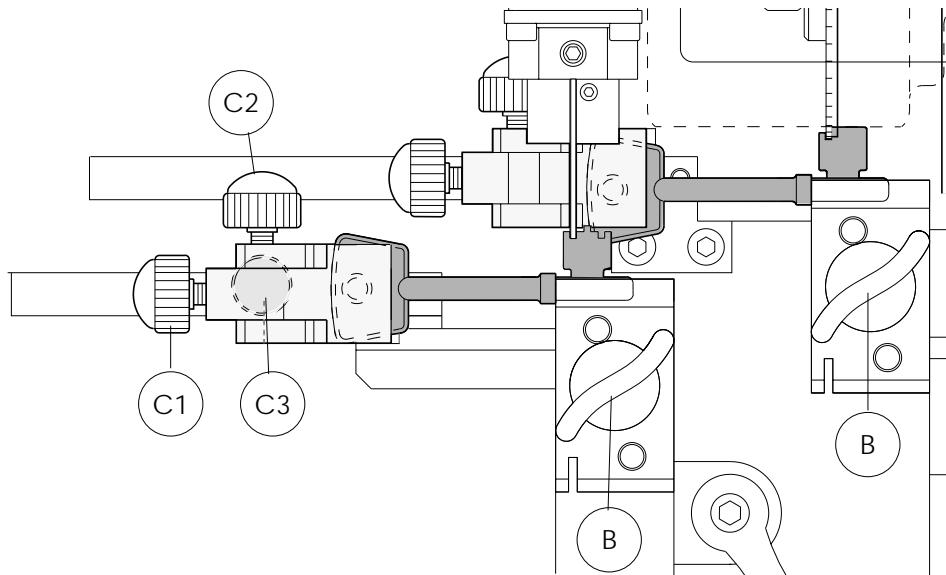


Fig. 16

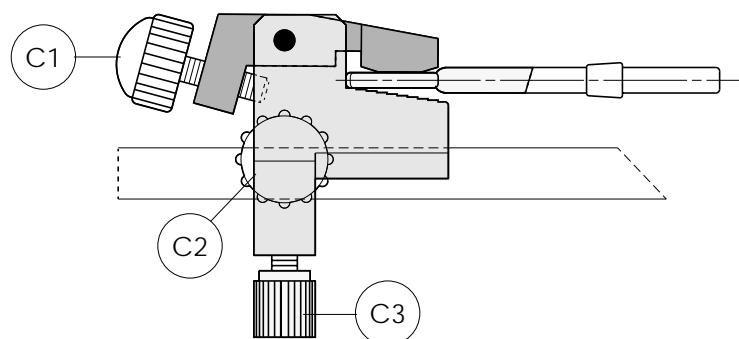


Fig. 17

7 CUTTING OPERATIONS

- Cutting of keys with radiused lever cuts (CHUBB type)
- Cutting of keys with flat lever cuts
- Cutting of flat steel keys
- Cutting of keys with side and bullet wards



For complete safety during the cutting operations, take the following precautions:

- Always work with dry hands.
- Check that the machine is properly earthed.
- Wear protective goggles even if the machine is provided with a safety shield over the cutting tool.
- Do not turn on the motor (lever switch), unless keys are placed into jaws beforehand.
- Keep hands away from the cutting tool in motor.

7.1 Cutting of keys with radiused lever cuts (CHUBB type)

After inserting the keys proceed as follows:

- 1) grasp both levers (F) and (G) (fig. 6, page 7).
- 2) lower the motor carriage using lever (G) until the bit of the key is aligned with the center of the cutter and tracer and operate the switch in the handle introducing the bit of the original key onto the tracer by moving forward handle (F), rounding the bit of the key is achieved by raising and lowering the motor carriage through handle (G1).

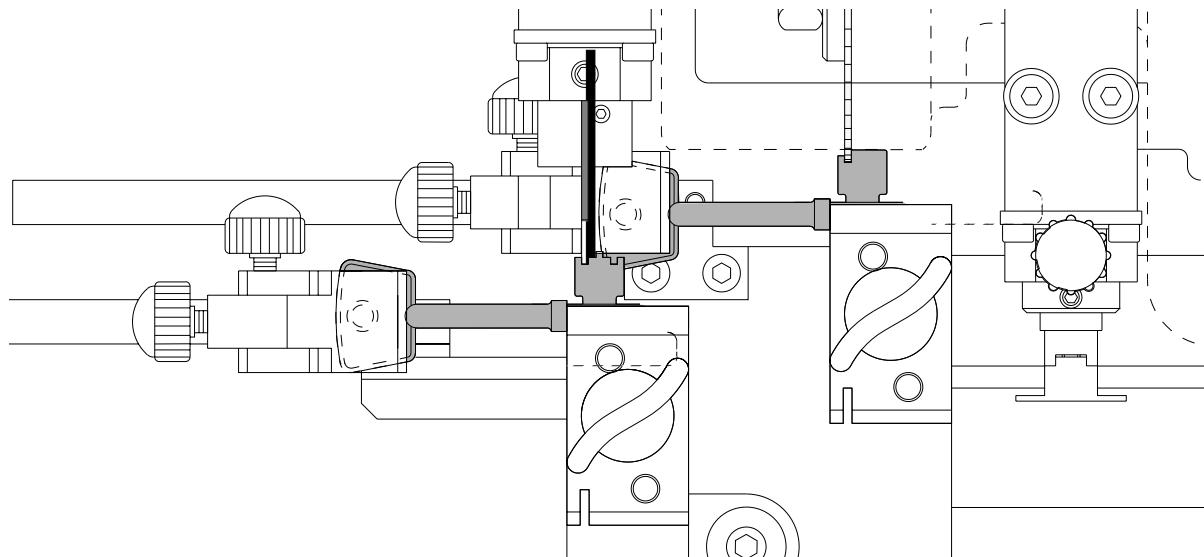


Fig. 18

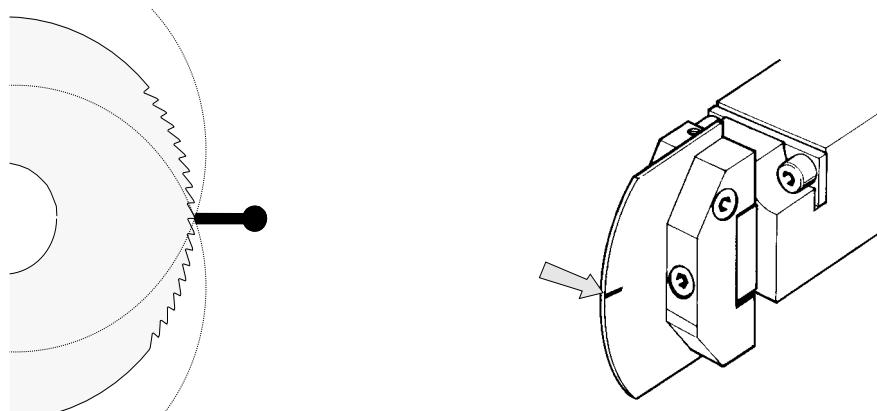


Fig. 19

7.2 Cutting of keys FLAT LEVER CUTS

Install the keys and duplicate as follows:

- 1) lowering the motor carriage using the lever (G1) until the original bit is aligned with the center mark on the tracer (fig. 19, page 15) and lock using knob (H) (fig. 6, page 7).
- 2) proceed to duplicate the key using lever (F).

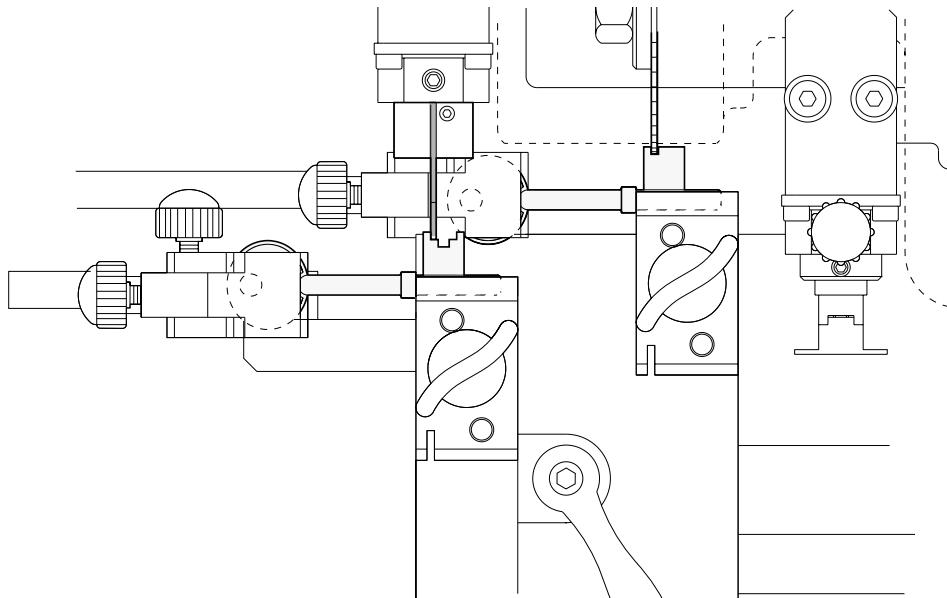


Fig. 20

7.3 Cutting of FLAT STEEL KEYS

- 1) position the main carriage on the left hand side (pos. 1 - fig. 12) and rotate the jaws 180°.
- 2) install the keys using the tip stops (J) in the slot located on the right hand side of the jaw.
- 3) lower the motor carriage using the lever (G1) until the original bit is aligned with the center mark on the tracer and lock using knob (H).
- 4) proceed to duplicate the key using lever (F).

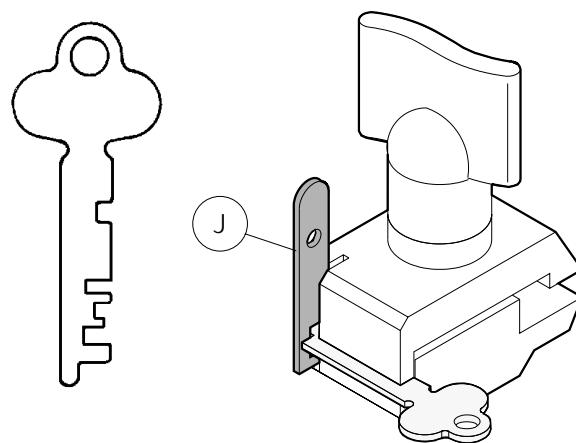


Fig. 21

7.4 Cutting of keys with SIDE and BULLET WARDS

Install the keys and position the main carriage on the right hand side (position 2 - fig. 12).

SIDE WARDS

- 1) position the tracer as shown in fig. 22 and operate as follows:
 - 2) locate the tracer into the side ward on the right hand side of the bit and lower the motor carriage cutting the key in a downward movement.
- To cut the left hand side repeat as above only cut in an upward movement.

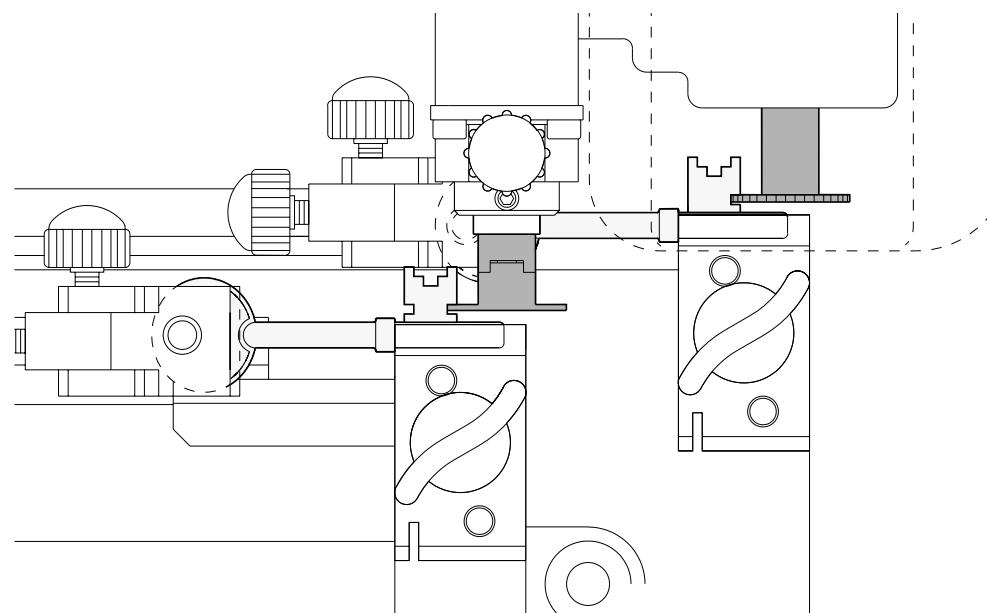
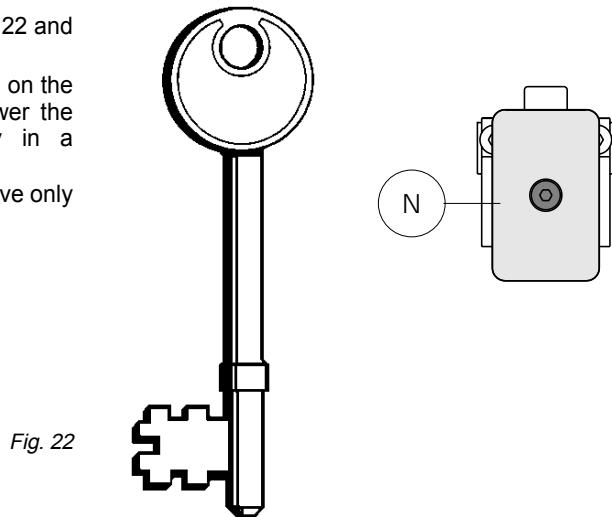


Fig. 23

BULLET WARDS

- 1) position the tracer as shown in fig. 24 and operate as follows:
- 2) locate the tracer into the bullet ward using lever (F) and (G) while operating the switch in the handle, then sliding the main carriage from left to right you will reproduce the bullet ward.

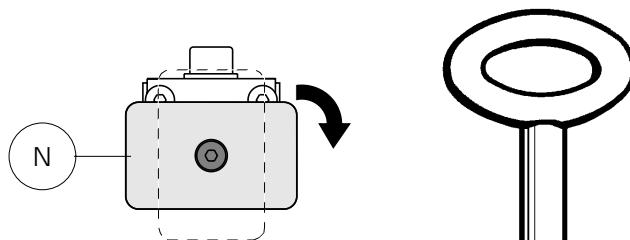


Fig. 24

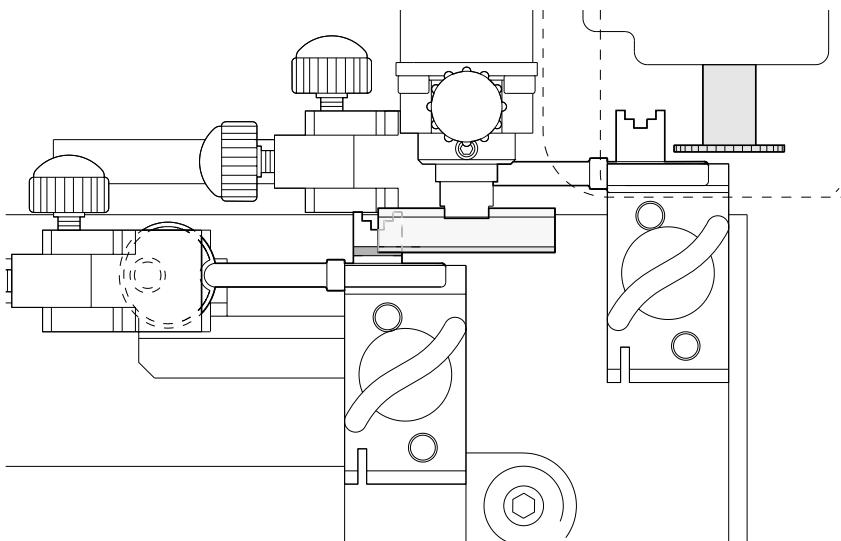
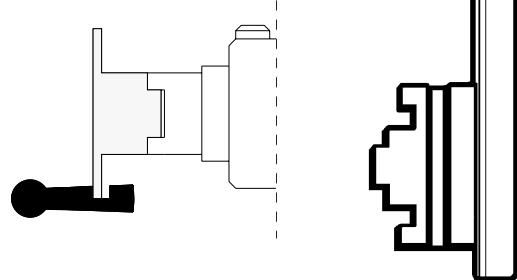


Fig. 25

8 MAINTENANCE

ATTENTION: for repairs or replacement of parts for maintenance, the 'CE' mark is guaranteed only if original spare parts provided by the manufacturer are used.

Although the LANCER PLUS key-cutting machine does not require special maintenance, it is advisable to check and, if necessary, replace the parts subject to wear, such as: cutter, tracer and fuses. Replacement is simple and can be carried out by the operator.

CLEANING: keep the carriage and clamps free of chippings from the cutting operations by cleaning with a dry brush. **▲ WARNING: DO NOT USE COMPRESSED AIR!**

ATTENTION: to keep the machine well maintained we recommend using protective oil, e.g. WD40 or similar, applied to the burnished mechanical parts. This prevents oxidation of the parts in question (clamps, guides, carriages, etc.).

Before starting any type of maintenance (checks or replacements), read the instructions below:

- never carry out maintenance or servicing with the machine switched on.
- always remove the mains plug.
- follow all the instructions in the manual to the letter.
- use original spare parts.

8.1 Replacement of cutters

Ø 25 MM CUTTER

Operate as follows:

- 1) position the carriage on left (position 1).
- 2) insert the locking bar (Y) to lock drive movement.
- 3) using the key provided unscrew the screw (P1) in the center of the cutter.
- 4) remove the old cutter and replace with a new one re-fixing the screw.
- 5) remove locking bar (Y).

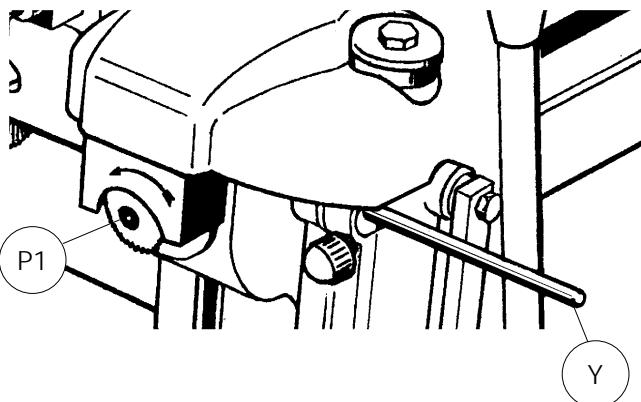


Fig. 26

Ø 80 MM CUTTER

Operate as follows:

- 1) position the carriage on the left (position 1).
- 2) unscrew the three screws (T1) and remove the cover (T).
- 3) insert the locking bar (Y) to lock drive movement and remove the nut (O1) holding the cutter with the spanner provided.

ATTENTION: the nut is left hand thread.

- 4) remove the old cutter and replace with the new one locking the nut (O1) and replacing the cover (T).
- 5) remove locking bar (Y).

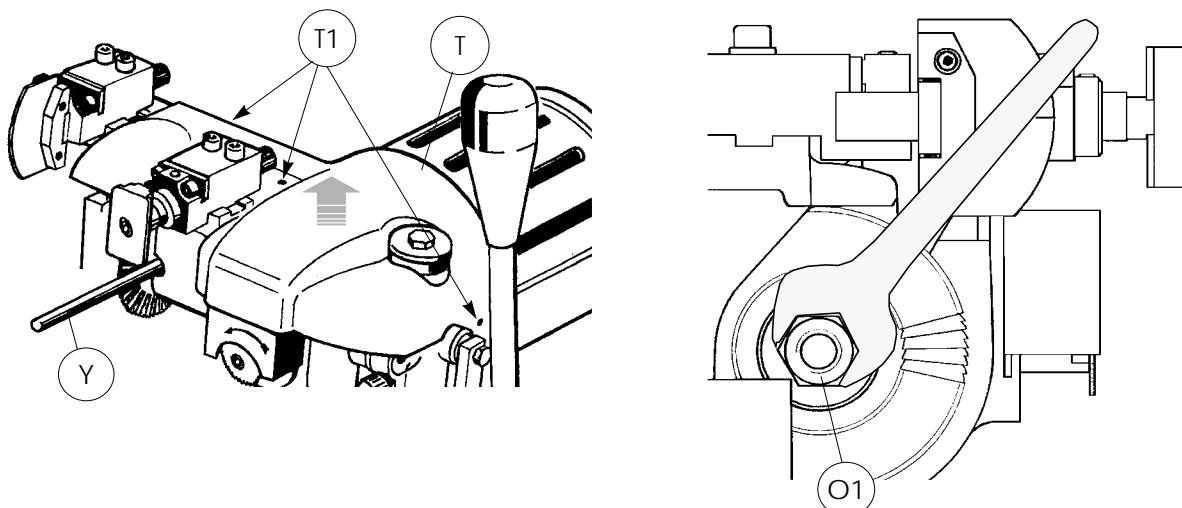


Fig. 27

8.2 Replacement of fuses

The fuses should always be checked with a continuity measuring instrument (tester, ohmmeter, multimeter etc.) as a visible check may not reveal an electrical fault. Fuses must always be replaced with others of the same type (rapid or delayed) and with the same Amps, as shown in the manual.

The LANCER PLUS key-cutting machine has two fuses (for both phases):

5 Amps rapid for machines with 220 Volt

placed in the inlet socket on the back, to protect the key-cutting machine from sudden changes in voltage or short circuits.

It is advisable to check the fuses if the machine is not activated by pushing the master switch. Proceed as follows:

- 1) switch off the master switch (R) and remove the mains plug.
- 2) pull the fuse board and rotate it (fig. 28).

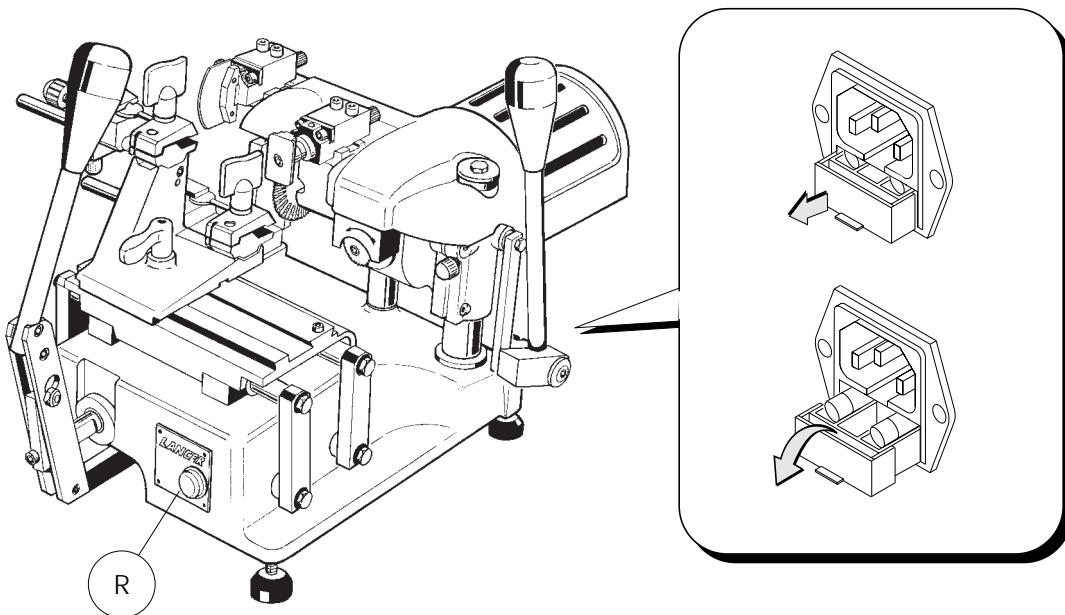


Fig. 28

9 DISPOSAL

For correct disposal please refer to current standards.

INFORMATION FOR USERS OF PROFESSIONAL EQUIPMENT



From "Actuation of Directive 2012/19/EU regarding Waste Electrical and Electronic Equipment (WEEE)"

The symbol of a crossed waste bin found on equipment or its packing indicates that at the end of the product's useful life it must be collected separately from other waste so that it can be properly treated and recycled.

In particular, separate collection of this professional equipment when no longer in use is organised and managed:

- a) directly by the user when the equipment was placed on the market before 31 December 2010 and the user personally decides to eliminate it without replacing it with new equivalent equipment designed for the same use;
- b) by the manufacturer, that is to say the subject which was the first to introduce and market new equipment that replaces previous equipment, when the user decides to eliminate equipment placed on the market before 31 December 2010 at the end of its useful life and replace it with an equivalent product designed for the same use. In this latter case the user may ask the manufacturer to collect the existing equipment;
- c) by the manufacturer, that is to say the subject which was the first to introduce and market new equipment that replaces previous equipment, if it was placed on the market after 31 December 2010;

Suitable separate collection for the purpose of forwarding discarded equipment for recycling, treatment or disposal in an environmentally friendly way helps to avoid possible negative effects on the environment and human health and encourages re-use and/or recycling of the materials making up the equipment.

The sanctions currently provided for by law shall apply to users who dispose of products in unauthorised ways.

10 ASSISTANCE

Silca provides full assistance to purchasers of the LANCER PLUS key-cutting machine. To ensure complete safety for the operator, any job not specified in this manual should be carried out by the manufacturer or in the special Service Centres recommended by Silca. On the back cover of this manual is a list of the manufacturer's addresses; listed below are the addresses of specialised Service Centres.

10.1 How to request service

The guarantee attached to LANCER PLUS key-cutting machine ensures free repairs or replacements of faulty parts within 24 months of purchase. All other service calls must be arranged by the customer with Silca or with Silca Service Centre.



VITTORIO VENETO 24/03/2011

CE DECLARATION OF MACHINE COMPLIANCE

**SILCA S.p.A. - VIA PODGORA 20 (Z.I.)
31029 VITTORIO VENETO (TV) - (ITALY)
TEL. 0438 9136 - FAX. 0438 913800**

Declares under its own responsibility that the **Key-cutting machine model**

LANCER PLUS

complies with the requirements of the following European Directives:

European Union **DIRECTIVE 2006/42/CE** (Machines)
and with the EN 292/1 – EN 292/2 Standards

European Union **DIRECTIVE 2004/108/CE** (Electromagnetic Compatibility)
and with the EN 55013 (section 3.2) – EN 55014 (section 4.1.2) Standards

European Union **DIRECTIVE 2006/95/CE** (Low Voltage)
and with the EN 60204-1 (sections 20.2 – 20.3 – 20.4) Standards

Claudio Tomasella of the Silca S.p.A. Research & Development Division is authorized
to create a Technical File.

General Manager Basic Production Center

Stefano Setti

| 97 |

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Hofwisenstrasse 24, ai sensi e per gli effetti degli articoli 2497 - 2497sexies del Codice Civile.