COLLI FGB S.R.L.

USER MANUAL GP4

OPERATION AND MAINTENANCE OF INDUSTRIAL MACHINERY

IN ACCORDANCE WITH ANNEX I OF THE NEW MACHINERY DIRECTIVE 2006/42/EC

UPPER LINING TRIMMING MACHINE

MANUFACTURER: ***COLLI F.G.B. S.R.L.***

VIA RUSSO, 25

VIGEVANO (PV) - ITALY

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MACHINE CODE	***GP4***
USER MANUAL CODE	***GP4 ING***
EDITION	***01 / 2015***

KEEP THIS USER MANUAL FOR FUTURE REFERENCE AND FOR THE MACHINE'S ENTIRE LIFETIME

COLLI FGB S.R.L.

EC DECLARATION OF CONFORMITY

The Manufacturer

COLLI F.G.B. S.R.L.

Via Russo, 25 - 27029 Vigevano (PV) - ITALY

Declares that the machine

MACHINE	***TRIMMER***
MODEL	***GP4***

See also

attached

EC Declaration of Conformity

conforms to all provisions of Directives

2006/42/EC - NEW MACHINERY DIRECTIVE

2014/35/UE ï LOW VOLTAGE

2014/30/UE ï ELECTROMAGNETIC COMPATIBILITY

HARMONISED APPLIED STANDARDS

NON-HARMONISED APPLIED STANDARDS

and constitutes its technical file

The Managing Director

CE

INTRODUCTION AND NOTE TO USERS

This operating manual provides all the necessary information allowing machine users to correctly operate the machine.

Standards for routine periodic maintenance aimed at maintaining the machine in efficient operating condition are listed herein.

***The manufacturer recommends carefully reading this user handbook in all its parts before using the machine for the first time**.*

***Some information and illustrations in this manual may differ from the machine actually delivered to the user, since all machine configurations are described and illustrated, including OPTIONAL accessories: refer solely to the information describing the machine configuration acquired**.*

This operating manual is compiled exclusively for use by the manufacturerג customers, providing users with the most up-to-date documentation on the use of the product on the date of issue.
The use of this manual is under the userג full responsibility.

No further guarantees will be conceded by the manufacturer for any defects, incompleteness and/or operating difficulties, expressly excluding any liability by the manufacturer for direct or indirect damages howsoever arising from the use of this document.

COLLI F.G.B. S.R.L. reserves the right to make changes to the product described in this manual at any time and without prior notice.

CONTENTS

1. GENERAL INFORMATION

1.1. IDENTIFICATION OF THE MANUFACTURER

Manufacturer:	*COLLI F.G.B. S.R.L.*
Address:	*VIA RUSSO, 25*
City:	*27029 VIGEVANO (PV)*
Country:	*ITALY*
Tel:	*+39 0381 84022*
Fax:	*+39 0381 78393*
E-mail:	*collifgb@collifgb.it*
Website:	*http://www.collifgb.it*

1.2. MACHINE IDENTIFICATION

The machine's identification appears in detail on the nameplate situated on the motor safety guard. When ordering spare parts or requesting recommendations on operation and maintenance, always cite the machine model and serial number on the identification nameplate.
It is absolutely forbidden to remove the identification nameplate or alter its data.

1.3. RECOMMENDATIONS ON THE MACHINE'S OPERATION AND MAINTENANCE

This user manual describes all operations regarding the machine's correct usage and normal maintenance.
The machine must be operated only by qualified and trained operators of adult age.
The head of safety and production should ensure that the person assigned to the machine's operation has read and understood the information provided in this user manual.

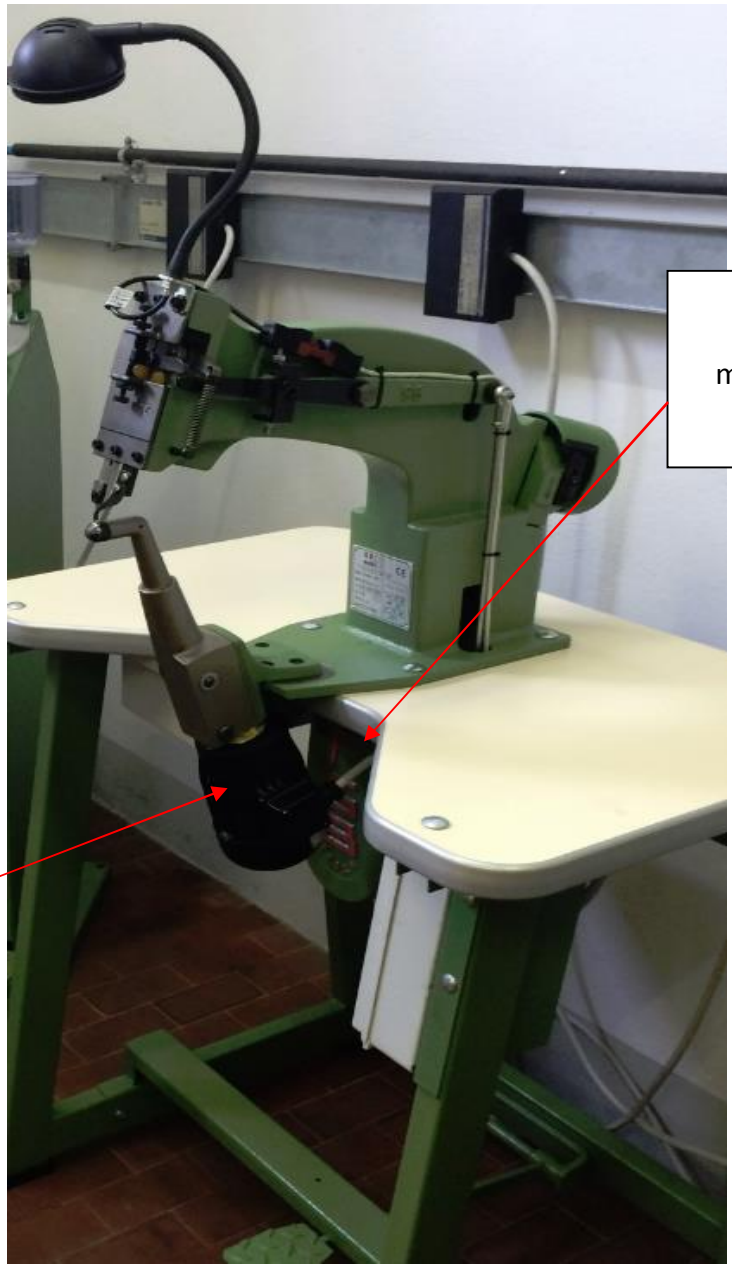
Maintenance staff providing both routine and extraordinary machine maintenance are required to possess proper mechanical and electrical knowledge. During the machine's operation, it is advisable not to remove the safety protections. The manufacturer recommends not carrying out any other type of workmanship, repairs or intervention other than those indicated in this user manual. All operations and interventions requiring the disassembly of machine parts must be entrusted to authorized technicians. Follow the instructions and indications contained in this manual for a correct usage of the machine.The manufacturer recommends keeping this operating manual in good condition in a location where it can be easily accessed for consultation by machine operators. A careful and meticulous observance of the indications contained in this manual will ensure a safe and correct usage of the machine.

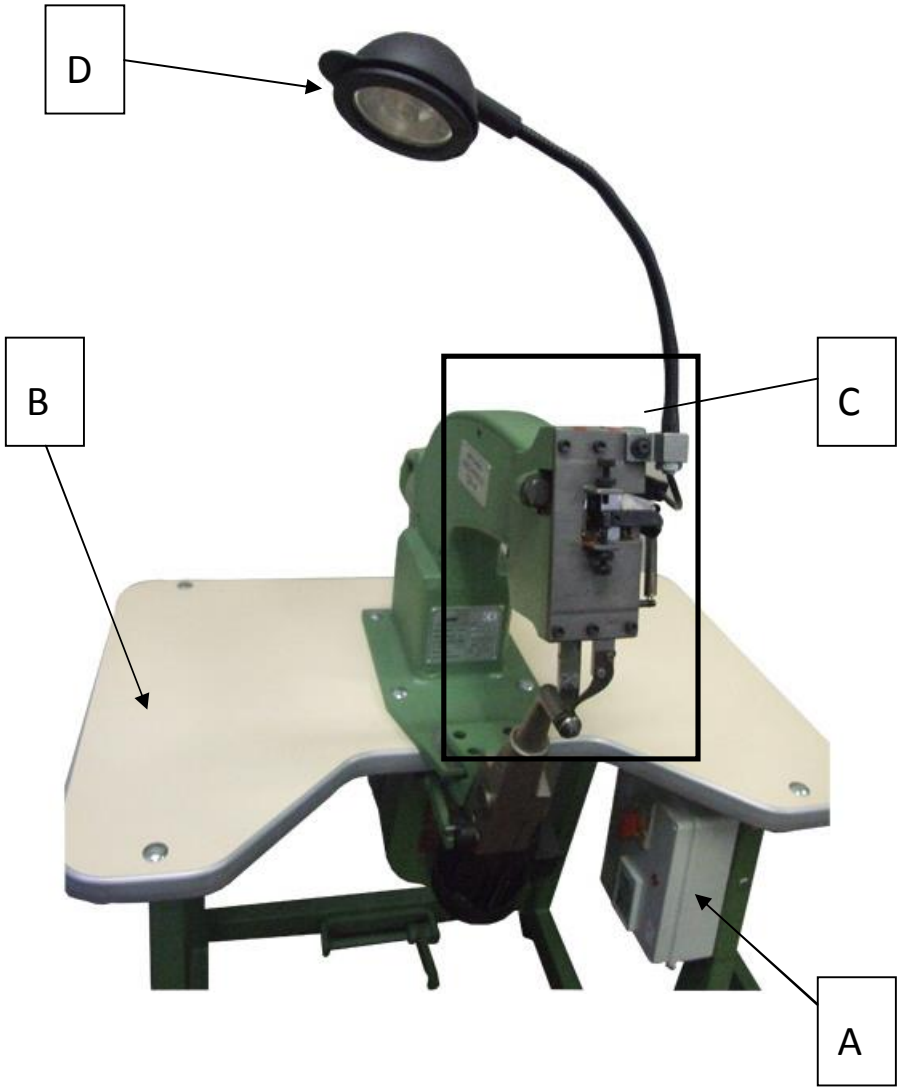
ANY MANIPULATION OR REMOVAL OF THE SAFETY ELEMENTS CAN CAUSE SERIOUS ACCIDENTS: IT IS FORBIDDEN TO REMOVE, EXCLUDE OR ALTER ANY OF THE SAFETY ELEMENTS ON BOARD THE MACHINE.
THE PERFECT OPERATION OF THE SAFETY ELEMENTS MUST BE GUARANTEED AT ALL TIMES THROUGH PERIODIC CHECKS.
ANY DEFECTS OR PROBABLE MALFUNCTIONS ENCOUNTERED MUST BE ELIMINATED IMMEDIATELY.

2. SPECIFICATIONS

2.1. GENERAL DESCRIPTION OF THE MACHINE

This GP 4 trimming machine is designed to trim the linings of footwear uppers, including curved and difficult to trim shapes.
The machine consists of a wooden worktop with a drawer, anchored to a welded iron frame; the operating head is set on a support base, assembled to the workbench; the electrical box is assembled to thewelded iron frame and contains the machine's operating switch.
The machine is equipped with two motorsfor the alternating motion of the cutting knife and rotary movementof the counter knife.
The motor which drives the motion of the cutting knife is set under the wooden worktop, and is protected by closed casing. The other motor is situated at the front of the machine, below the counter knife group.
Mounted above the operating head support base are the machine's operating head, with the knife rod bearing the cutting knife,the operating head casing and protection guards for the grindstone and handwheel. Ashaft bearing bickern with a rotating counter knife are located at the front of the machine base.
Lastly, a LED lamp provides working visibility on the operating head.


Knife movement motor
Counterknife motor



GP 4

A- CONTROL PANEL

B-WOODEN WORKBENCH

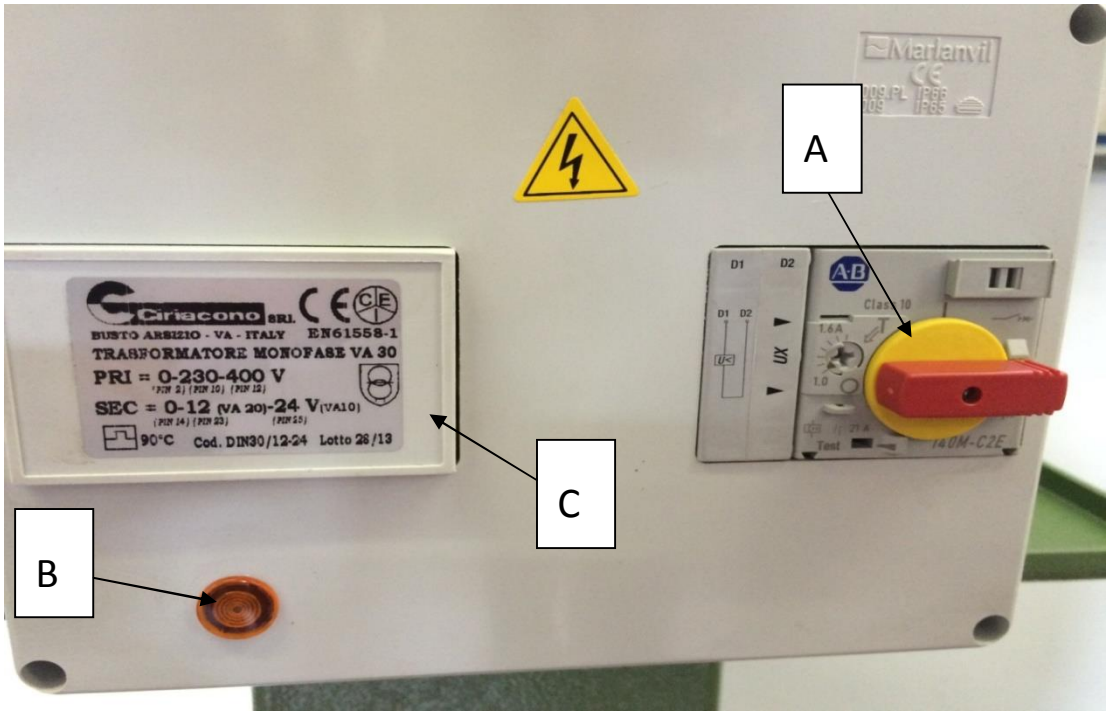
C-OPERATING HEAD AND KNIFE

D-LED LIGHTING

2.2. TECHNICAL SPECIFICATIONS

TECHNICAL SPECIFICATIONS	
WEIGHT	70 Kg
WIDTH	80 cm (workbench)
DEPTH	70 cm (workbench)
HEIGHT	120 cm (workbench)
LIGHTING	LED driver 12V - 6W
VOLTAGE	220/380 V standard (other voltages on request)
FREQUENCY	50/60 Hz
NUMBER OF PHASES	3 standard (single phase on request)
MOTOR POWER	0.25 kW for knife - 0.16 kW for counterknife
NOISE EMISSIONS	Leq< 70 dB (A) Lpc(C)<130 dB(C)
KNIFE STROKE	5000 per minute
PRODUCTION	500 - 800 pairs daily
ABSORBED POWER	0.5 kW

2.3. CONTROL PANEL



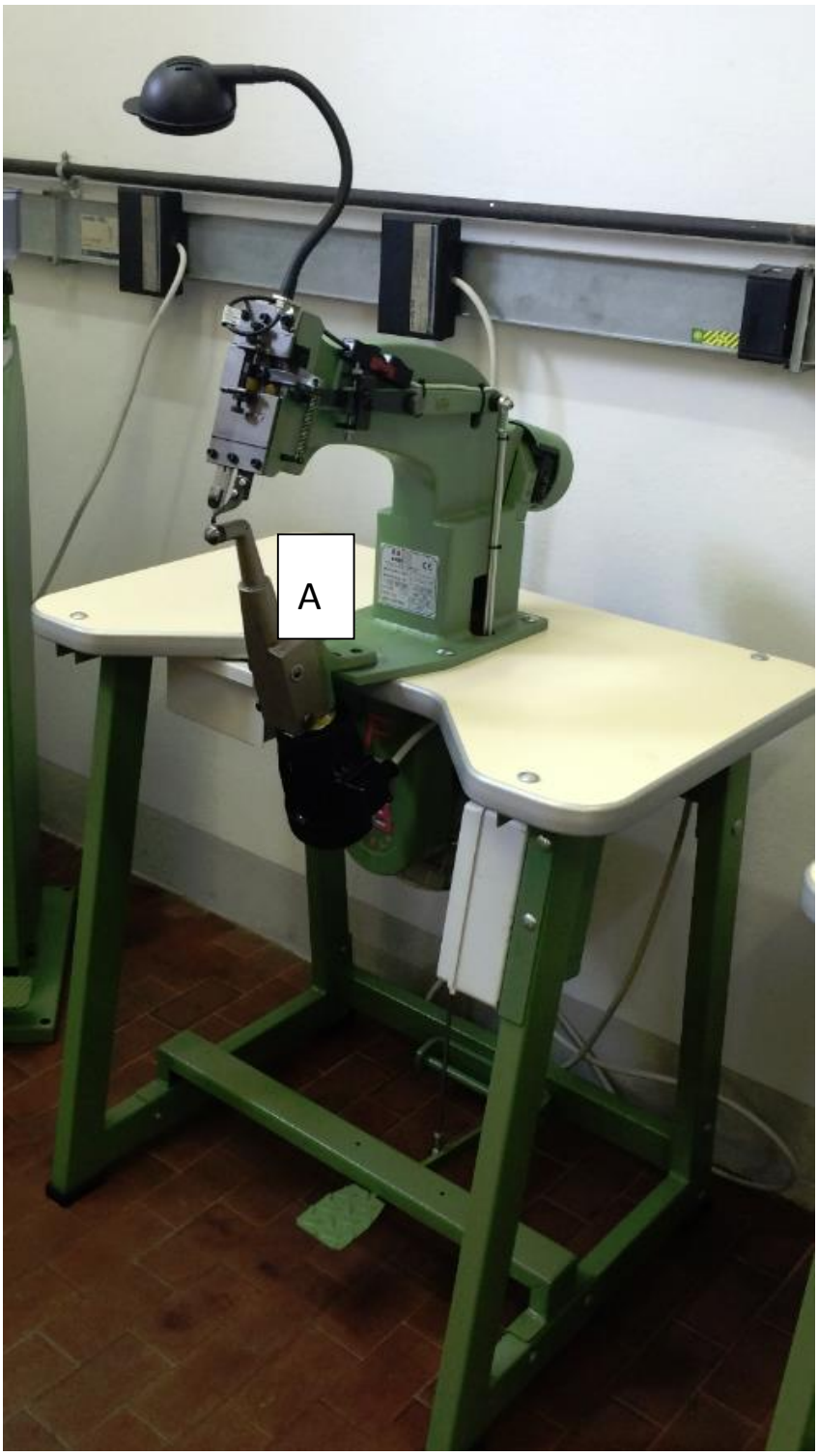
A - Power ON/OFF lockable rotary main switch

B ï Power light

C - Transformer

2.4. OPERATING CONDITIONS AND INTENDED USE

- The machine is designed to be used by a single operator.



Working position:

A- Detail of workmanship on an upper

MACHINE EQUIPMENT

LIGHTS (part 36)	1
SCREWDRIVER 5x100	1
LUBRICATOR 50cc	1
ELASTIC BELT (part 118)	1
KNIFE CONTROL TEMPLATE (part 117)	1
KNIFE (part 71)	2
COUNTER KNIFE (part 93)	1
GUIDE (part 79)	1
TWIST SPRING (part 81)	1
KNIFE SCREW (part 46)	2
GUIDE SCREW (part 47)	2
WORKBENCH ANTI-VIBRATING FEET (part169)	4
SPARE PARTS CATALOGUE AND INSTRUCTIONS	1

Any damage to persons, animals or objects due to an improper usage of the machine is not attributable to the manufacturer.

2.5. IMPROPER OPERATING CONDITIONS

- The end user is responsible for damages caused by any usage of the machine differing from that which is specified in this user manual, or using materials differing from those for which the machine has been designed.
- It is forbidden to mishandle the safety protections and make use of the machine without having correctly installed the protections.
- Any actions that do not respect the indications mentioned herein shall be considered improper usage.
- Any alteration is prohibited and invalidates the machine's Declaration of Conformity.
- The machine is identified by the data printed on the nameplate on the main casing.

When ordering spare parts or requesting advice on the machine's use or maintenance, always cite the machine model and serial number on the nameplate.

This type of machinery can be hazardous unless used properly.

Machine operators must meticulously follow all safety related indications.

- The machine operator must be trained on the machine's correct use, as well as on the operation of the protection devices and all accessory equipment.
- Devices mounted onto the machine must be correctly assembled and adjusted.
- The entire machine must undergo routine and extraordinary maintenance procedures on a regular basis, as required for its usage.
- Prior to using the machine, make certain that you have read and properly understood the operating manual supplied by the manufacturer.
- Before performing any operation whatsoever on the machine, make certain that the work area around the machine is clear of people or other obstacles that might be a source of danger.
- Make certain that the power cable connecting to the mains line is whole, properly extended and laid out straight rather than rolled up.
- Any interventions on the machine must be performed with the electrical power switched off and blocked.
- Do not place flammable substances in the machine's proximity, since any sparks produced can cause an explosion or fire.
- The operator must always reflect on all possible consequences before moving in with his/her hands to the machine's most dangerous areas.
- Always keep the machine powered off when not in use, and for extended pauses in production disconnect the machine from its electrical power source.

All safety measures cited in this user manual are provided solely and exclusively in relation to the machineôs correct uses, as authorized by the manufacturer. These uses refer to the procedures involving the machineôs preparation, operation and maintenance.

It is forbidden to use the machine for work processes not authorized by the manufacturer.

It is forbidden to alter the machine and/or any of its parts without the prior consent of the manufacturer.

2.6. SCOPE

This GP 4 trimming machine is designed to trim the linings of footwear uppers, including curved and difficult to trim shapes.
The following is a brief list of the machineôs main operating characteristics:

- **Easy operation.** The knife / counter knife feeder device allows the machine to perform quick, perfect trimming operations.

- **High production**. Up to 800 pairs trimmed per day.

- **Knife sharpening grinding wheel**. When the cutting edge of the knife is worn out, a specially shaped emery wheel set in the rear section of the machine allows for the knife toolôs quick and easy sharpening.

- **Material guide**. Cutting operations can be adjusted according to the thickness of the burr to be trimmed off, using a specially designed material guide.

- **Lighting providing high visibility for the cutting area**.

-**Pedal for trimming doubled linings and internal profiles.**Pressing down on the pedal completely to allow the guide 79 and knife 71 to rise completely, allowing for the passage of the upper and trimming of any internal profiles, holes and slots.

- **Low noise emissions**. Noise emissions are well tolerated by the operator and anyone in the machineôs vicinity. Particular attention has been paid to the machineôs design in order to reduce noise emissions to a minimum.

- **Operating safety**. A special safety guard has been installed to protect the operator in the area of the counter knife and moving parts (drive belt, grinding wheel, pulley).

- **Minimum maintenance**. Simple periodic maintenance operations allow the machine to keep running in perfect condition for many years.

- **All machine spare parts are readily available**. Refer to the spare parts drawings and their description when ordering parts, specifying the machine type, part identification number and quantity of parts.

- **Use original spare parts only**.

- **NEVER remove the machineôs safety protections during operation**.

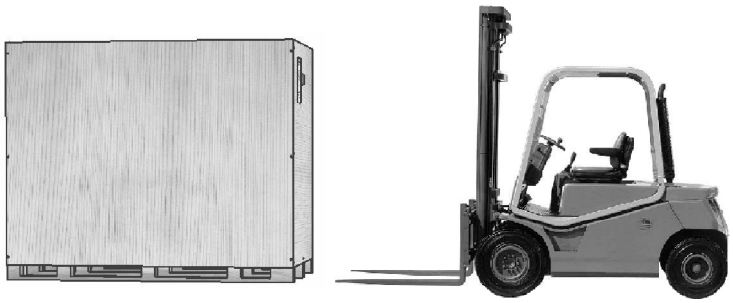
- **Conforms to CE standards**

3. INSTALLATION AND ASSEMBLY

- Lifting and handling operations must be carried out by qualified, specially trained personnel.
- Make certain the surrounding area is free of obstacles and that no one is in the immediate vicinity of the machine, or within the radius of the equipment being used for lifting, handling and/or transporting the machine.
- During all lifting and handling procedures, use extreme caution to avoid hazards to the machine people and property.

3.1. LIFTING AND HANDLING

The machine arrives at its destination packed in a wooden crate, or wooden case or support. Lifting and handling operations can be carried out using a fork lift truck or pallet handler.



Before beginning any manoeuvres, free the machine of all parts that have not been firmly fixed to it due to transport or packaging requirements. Check that the load bearing capacity of the lifting equipment used is suitable to the gross weight of the machine (see data in the TECHNICAL SPECIFICATIONS).

For storage purposes, keep the machine in a dry place, away from rain, snow or humidity.

Use a fork lift truck or pallet truck for machine handling operations.

- if the machine is installed on a pallet, or inside a crate or case (4 M12 holes are available at the base for anchoring the machine to a wooden pallet), insert the lifting forks on the fork lift truck (or pallet truck) underneath the pallet until they protrude at the rear by at least 15 cm;

- lift slowly and handle with maximum care, avoiding oscillations to a minimum, and position the machine in the pre-established area.

3.2. MACHINE PLACEMENT

The machine must be installed inside an industrial building that is well lit and ventilated, and has a solid and level floor capable of supporting the machine's weight, and not on a sloping floor.

The working environment should not be humid.

Set the machine in the most suitable position, according to production needs, positioning it in a place where there is an easy connection to the mains line, and where there is sufficient lighting to ensure that all parts of the machine are visible.

The lighting must comply with the laws in force in the country where the machine is installed, and should provide good visibility at every point, without creating dangerous reflections, allowing a clear view of the control panel and identification of the emergency buttons, without interfering with any equipment installed on board the machine.

Make sure the machine is perfectly set on the floor.

Do not use solvents such as gasoline and diesel fuel when cleaning the machine, since these substances can damage the paintwork and render it opaque, or produce rust on different parts.

3.3. INSTALLATION

- Remove the packing and check for any damage on the machine suffered during transport.

- Position the machine in a non-humid environment, on a stable non-sloping floor.

- Set a minimum clearance of 1 meter in order to allow for correct operation in safety conditions.

- Install the 4 anti-vibrating support feet supplied with the machine.

- Carefully clean the machine, removing grease from not painted parts and lubricating the points highlighted in red on the operating head 20.

- Assemble the machine's lighting supplied.

- Check to make sure the machine's voltage corresponds to the power supply and connect to a disconnecting switch.

- If the voltage on the mains line is not identical with the machine's voltage, change the connections on the motor terminal and transformer.

- Turn the main power switch 33 to position I.

- Check the correct direction of motor rotation by making sure that the grinding wheel 108 turns in the direction indicated by the arrow on the grindstone casing 113.

- If the direction of rotation is incorrect, reverse two phase wires of the power cable.

- The machine is now ready for operation.

3.4. CONNECTING THE MACHINE TO THE POWER SUPPLY

WARNING: THE ELECTRICAL CONNECTION, OPERATING CHECKS AND MAINTENANCE TO THE ELCTRICAL SYSTEM MUST BE PERFORMED BY QUALIFIED AND TRAINED PERSONNEL ONLY

The manufacturer recommends not connecting the machine to the power line until it has been correctly set in its working location. Prior to connecting the machine to the power line, check to make sure the electrical system meets the following power and safety requirements:

- Check to make sure the production plant's grounding and trunk line to which the machine will be connected are perfectly efficient.

- Make sure the trunk line to which the machine will be connected is protected upstream by a differential switch.

- The mains must be provided with an efficient neutral and ground line (equipotential grounding).

- Ensure the presence of fuses or circuit breakers against short circuits on every RTD cable conductor, except for the grounding.

- The electrical system must comply with CEI 64.8 (CENELEC HD 384, IEC364-4-41).

- Make sure the line voltage (V) and frequency (Hz) correspond to the machine's design specifications.

- If the voltage on the mains line is not identical with the machine's voltage, change the connections on the motor terminal and transformer.

Consult the wiring diagrams annexed to this user manual for references.

The manufacturer is not liable for damage due to the machine's incorrect connection to the mains line or problems deriving from malfunctions to the mains line.

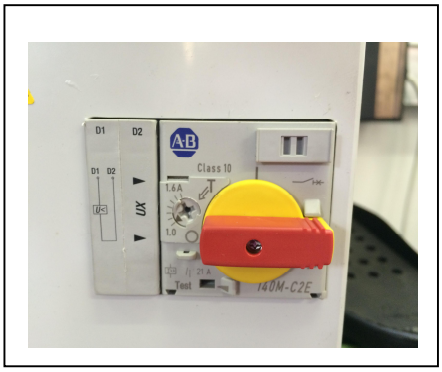
After correctly connecting the machine to the mains line, start up the machine and check the correct direction of rotation of the motor by making sure that the grinding wheel 108 rotates in the direction indicated by the arrow on the grinding wheel casing 113.

If the direction of rotation is incorrect, invert two phase wires of the power cable (RTD or L1-L2-L3); be sure to cut off the power supply beforehand, and never intervene on the neutral and ground connection.

The machine is supplied with an electric cable without a plug; this allows the machine to be set to the requirements of each country it is exported to.

4. STARTING UP THE MACHINE

4.1. SETTINGS



To start up the machine:
- turn the main power switch 33 to position I.
Simultaneously with the machineôs start-up, the orange pilot light on the electrical panel will light up, together with the light that illuminates the machineôs cutting area.

- set the guide 79 according to the thickness of the material to be trimmed
(maintain a gap between the guide 79 and counter knife 93 that is slightly wider than the thickness of the burr to be trimmed off).

- proceed with the trimming operation, keeping the lining or other product to be trimmed set against the counter knife to facilitate the feed process.
- lightly press the pedal on parts in which the lining is doubled or thicker.
- press down on the pedal completely to allow for the passage of the upper and trimming of any internal profiles (holes and slots).

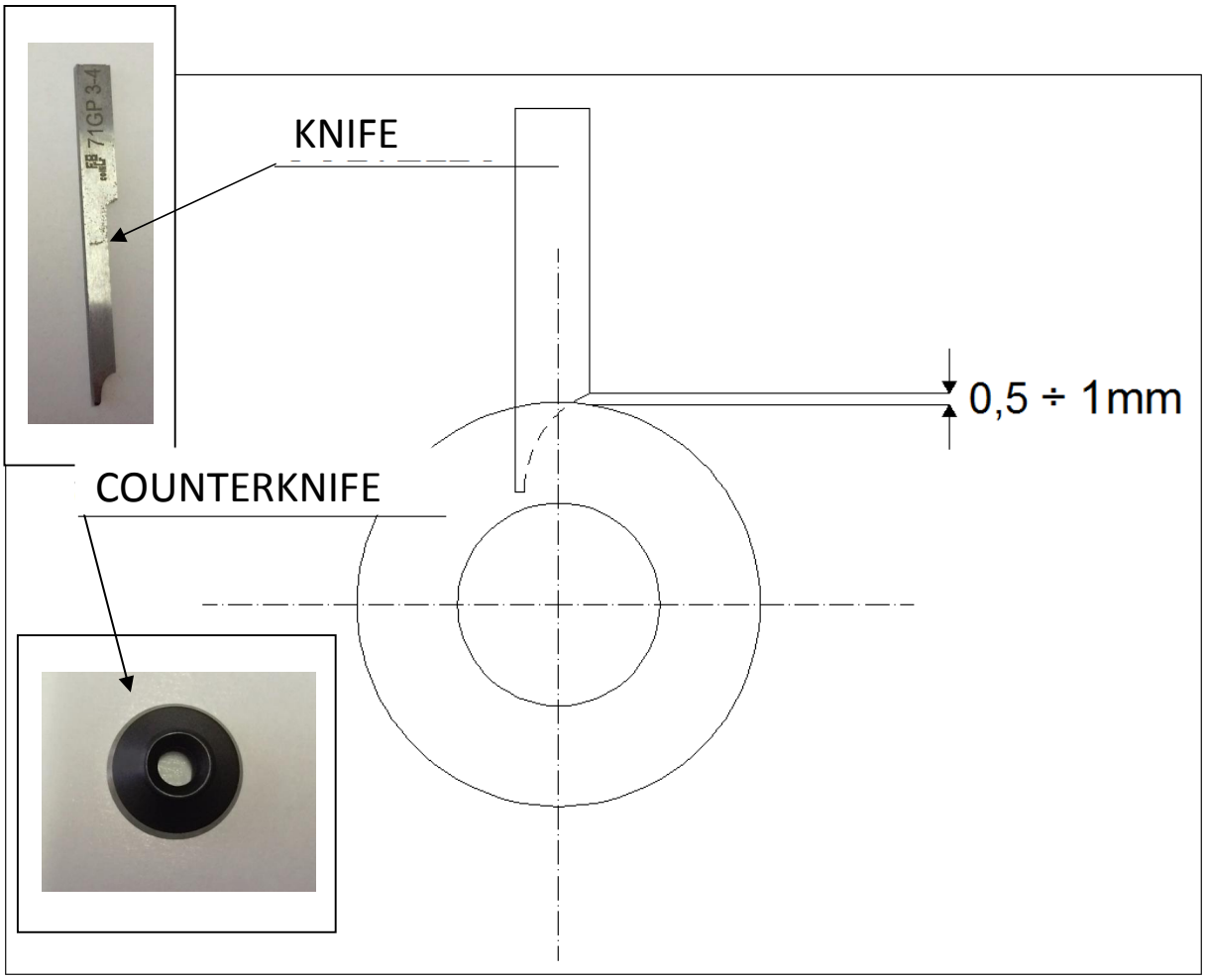
To stop the machine:
- turn the main power switch 33 to position O.

La The machine has a fixed cutting speed.

4.2. ADJUSTING THE CUTTING KNIFE 71

With the machine powered off, turn the rear ball grip 112 until the knife rod 67 is at its lowest point.

With the knife locking screw 46 loosened, position the knife 71 so that the gap between the upper edge of the cutting knife and the counter knife is about 0.5 - 1mm.



4.3. ADJUSTING THE GUIDE 79

Loosen the lower lock nut 78b, and depending on the thickness of the material to be trimmed, set the gap between the guide 79 and counter knife 93 by adjusting the lower screw 78a.

Then loosen the upper lock nut 78b and adjust the upper screw 78a to adjust the stroke of the guide to allow for the passage of materials of varying thickness.

Once the adjustment is completed, remember to tighten the upper and lower lock nuts 78b.

5. SAFETY DEVICES AND RESIDUAL RISKS

5.1. PREMISE

The machineôs risk analysis and related considerations, included in this section of the manual, are based on the following notions:
- knowledge of normal operating conditions and the machineôs expected usage, as specified in this user manual;

- the premise that the machine is designed to be used for trimming linings on uppers;

- the premise that machine operators have been suitably trained and made aware of existing specific risks.
The protective measures the production manager must provide to workers are: collective and individual.

5.2. INFORMATION ON RESIDUAL RISKS

In spite of the validity of the protection systems adopted by the manufacturer, the machine operator is nonetheless exposed to the following hazards:
- Contact with the cutting tool
- Contact with moving parts (belts, pulleys, gears, etc.)
- Ejected inserts from the cutting tool (cutting blades, knife, counter knife)
- Electrocution from contact with live parts
- Risk linked to improper tool assembly

Never touch any moving part on the machine during its operation, for any reason, whether directly or indirectly.

Always make sure that the machine is disconnected from all electrical power sources before carrying out any cleaning, lubrication, maintenance, repairs, adjustments or part replacements.

The operator mustnôt ever, for whatever reason, leave the machine unattended when in use.

5.3. *PERSONAL PROTECTIVE EQUIPMENT*

To prevent risks during the installation, adjustment, operation, routine and extraordinary maintenance, the manufacturer recommends the use of the following personal protective equipment:

- gloves (e.g. for handling machine parts and replacing the knife tool);
- protective safety non-skid footwear ;
- eye goggles or a face mask shielding against possible splinters during processing or subsequent machine cleaning;
- dust masks

!The use of goggles or a face shield is obligatory during knife sharpening 71 using the grinding wheel 108.

Clothing must be suitable in order to prevent the following hazards:

- entanglement, dragging, crushing, slipping and abrasion;
- the use of contact lenses is forbidden.

Furthermore, the machine operator must adhere to the following warnings:

- maintain the machine and work area in order and clean;
- provide suitable containers and/or demarcated areas for storing both work pieces and already processed pieces.

This type of machine can be dangerous if not used appropriately.
We strongly recommend that the operator carefully follow all safety information.
All safety measures cited in this user manual are provided solely and exclusively in relation to the machineôs correct uses, as authorized by the manufacturer.
These uses refer to the procedures involving the machineôs preparation, operation and maintenance.
It is forbidden to use the machine for work processes not permitted by the manufacturer.
It is forbidden to alter the machine and/or any of its parts without the prior consent of the manufacturer.

- do not use the machine if not under normal physical conditions;
- wear suitable clothing to avoid impediments and/or hazardous entanglement to/from the machine;
- wear personal protective equipment as required in this Instruction Manual and the operations to be performed;
- do not remove or alter the nameplates affixed by the manufacturer on the machine;
- do not remove or circumvent the security systems on board the machine.
-

5.4. SAFE WORKING PRACTICES

It is essential for operators to be:
- suitably trained on the use, settings and operation of the machine;
- knowledgeable of factors that affect exposure to noise;
- informed of factors that affect exposure to dust, such as:
    - the type of material being processed;
    - the importance of local extraction (collection at source);
    - the correct adjustment of hoods, deviators, etc.

It is essential that:
- the pavement in the work area around the machine is level, properly maintained and free of loose materials, e.g. plastic and waste;
- suitable general or localized lighting is provided in the work area;
- raw materials and finished pieces are placed near the operatorôs normal working position.

It is essential that the operator:
- use personal protective equipment whenever necessary.

This can include:
- devices for hearing protection to reduce the risk of hearing loss;
- respiratory protection to reduce the risk of inhaling hazardous dust;
- gloves when handling the knife tools (knife tools should be stored in a special tool box);

- shut down the machine when it is left unattended;
- report any defects or malfunctions to the machine, as soon as they appear;
- adopt safe procedures for cleaning and maintenance, regularly remove plastic materials and dust to prevent a risk of fire;
- follow the manufacturerôs instructions on the operation, adjustments and repairs of the knife tools;
- abstain from removing discarded pieces or other parts in the cutting area while the machine is operating;
- make sure that all safety casings and other safety devices necessary for the machineôs operation are in place, in good condition and subjected to proper maintenance.

5.5. CHECKING THE SAFETY DEVICES

WORK AREA: prior to beginning any activity, check that the work area and machine are clean and devoid of plastic materials and dust. Make sure the work area is properly illuminated and the material storage area and finished pieces area are within armôs length and in order.

MAIN SWITCH: the machine is equipped with a power ON/OFF switch that also functions as a safety device.
Periodically check that the main switch is in operating correctly.

PROTECTIONS: the machine is equipped with protections for the counter knife and moving parts (belts, grinding wheel, pulleys) designed to prevent the operator from coming into contact with the machineôs hazardous parts.
Periodically check that the protections are undamaged and operating correctly.

5.6. RISK DUE TO NOISE EMISSIONS

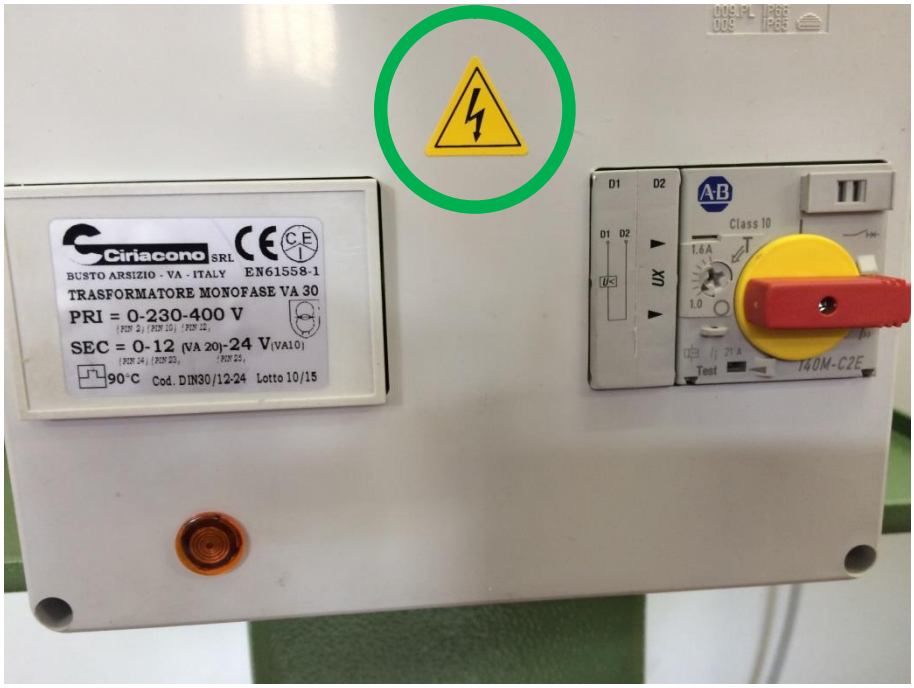
The machine is designed to reduce noise emission at its source.
The machineôs acoustic levels are listed in point 2.3 of the following report.

NOTE:
The noise emissions values indicated are emission levels and do not necessarily represent safe operating levels. In spite of the fact that a relationship exists between emission levels and exposure levels, this cannot be used reliably to establish whether further precautions are necessary. The factors that determine the level of exposure to which workers are exposed include the duration of exposure, worksite characteristics and other sources of noise (overall number of machines, adjoining processes, etc.).
Furthermore, allowable exposure levels can vary from one country to another.
In any case, the information cited herein will enable the machine user to better assess the hazard and risk to which the operator is subjected.
The following rules must be meticulously adhered to in order to avoid increasing noise levels over time:
- periodically check and replace the work tools and related fastening devices;
- clean and lubricate machine parts at the recommended frequency.

5.7. RISK DUE TO VIBRATIONS

Under user conditions conforming to the indications of correct usage, vibrations are not such as to give rise to hazardous situations.

5.8. NAMEPLATES



The above image on the electrical panel signals the presence of live current.

Check to make sure that the images, colours and headings of all signs affixed to the machine are in perfect condition; any signs must be replaced promptly if worn out or unclear, notifying the production manager and/or supervisor, who will take appropriate action.

6. *MAINTENANCE*

Lubricate daily through the points highlighted in red on the operating head 20 (use ESSO FEBIS K68 or an equivalent lubricant).

- **Prior to carrying out any maintenance, the operator must disconnect the machine from its electrical powersource.**
- **Always wear personal protective equipment.**

Adeguate maintenance is a decisive factor towards obtaining optimal operating conditions and a long machine lifetime.

Follow the procedures and recommendations described in the user manual.

6.1. REPLACING THE TOOLS

ALWAYS WEAR PROTECTIVE GLOVES WHEN HANDLING TOOLS.

POWER OFF THE MACHINE BEFORE PROCEEDING WITH ANY TOOL REPLACEMENTS.

Periodically check the condition of the tools; re-sharpen or replace them as required.

POWER OFF THE MACHINE BEFORE LIFTING THE PROTECTIVE CASING

7. TROUBLESHOOTING

WARNING: THE MACHINE MUST BE DISCONNECTED FROM ALL ELECTRICAL POWER SOURCESBEFORE CARRYING OUT ANY INTERVENTIONS

PROBLEM	CAUSE	SOLUTIONS
THE MACHINE DOES NOT START UP WHEN THE MAIN SWITCH 33 IS TURNED TO POSITION I	1- Check the connection to the mains line. 2- Check the condition of the elastic belt 118 to ensure it is not broken.	1- Use a tester to check for voltage on all three phases. 2- Replace the elastic belt 118.
DIRECTION OF ROTATION OF THE GRINDING WHEEL 108 CONTRARY TO THE ARROW ON THE GRINDING WHEEL HOOD CASING 113	1- Incorrect electrical connection.	1- Reverse two phase wires on the mains cable.
THE TRIMMING IS NOT SATISFACTORY ï IRREGULAR TRIMMING	1- Incorrect adjustment of the knife and counter knife. 2- The knife 71 and/or counter knife 93 are worn out.	1- Check the position of the knife and counter knife and adjust as required. 2- Check for wear and sharpness on the knife and counter knife. 3- Sharpen the knife or replace the knife and/or counter knife.
THE LINING IS NOT REMOVED COMPLETELY	1- Incorrectly regulated guide. If the guide is too close to the counter knife, the lining will not be trimmed at the base near the stitching. If the guide is too far from the counter knife, the lining will not be guided, resulting in irregular trimming, with the risk of cutting the upper as well.	1- Adjust the guide accordingly. (See point 4.3.)

THE MATERIAL DOES NOT RUN SMOOTHLY AT SOME POINTS	1- In sections where the thickness to be trimmed is more consistent, the guide 79 fails to rise or does not rise sufficiently, and ultimately holds back the feed process.	1- Adjust the guide accordingly. (See point 4.3.)
THE LIGHTING 36 DOES NOT SWITCH ON	1- Check the thermal device for voltage overload. 2- Faulty lighting.	1- Wait for the protection to cool down and power on again. 2- Replace the light.
THE MAIN SWITCH 33 IS TRIGGERED REPEATEDLY DURING THE WORK PROCESS	1- Incorrect calibration of the main switch 33.	1- Increase the calibration on the main switch 33.
EXCESSIVE MACHINE NOISE	1- Probable wear on the bearings and rocker arm 61.	1- Replace the bearings and rocker arm 61.

N.B. CONTACT QUALIFIED TECHNICIANS ONLY FOR ANY OTHER PART REPLACEMENTS, INTERVENTION OR REPAIRS.

8. SPARE PARTS AND MAINTENANCE

8.1. SHARPENING OR REPLACING THE KNIFE 71

Power off the machine.

Unfasten the two screws 47 and remove the guide 79.

Loosen the screw 46 and extract the knife tool.

Tighten the screw 46.

Replace the knife or power on the machine and insert the knife tool to be sharpened in the housing on the bracket 111 situated at the rear of the machine.

Sharpen the knife tool using the grinding wheel 108.

Check the cutting edge using the template 117 provided with the machine.

Re-assemble and adjust the knife and guide as specified at points 4.2 and 4.3

8.2. REPLACING THE COUNTER KNIFE 93

Power off the machine.

Unfasten the screw 94 blocking the counter knife.

Replace the counter knife and tighten the screw 94 properly.

COUNTER KNIFE 93

8.3. REPLACING THE GRINDSTONE 108

Power off the machine.

Unfasten the handwheel 162 and remove the protective belt casing 161.

Unscrew the ball grip 112.

Remove the grinding wheel protection 113.

Unfasten the lock nut M8, remove the washer 109, and replace the grinding wheel.

Re-assemble all parts.

8.4. REPLACING THE BELT118

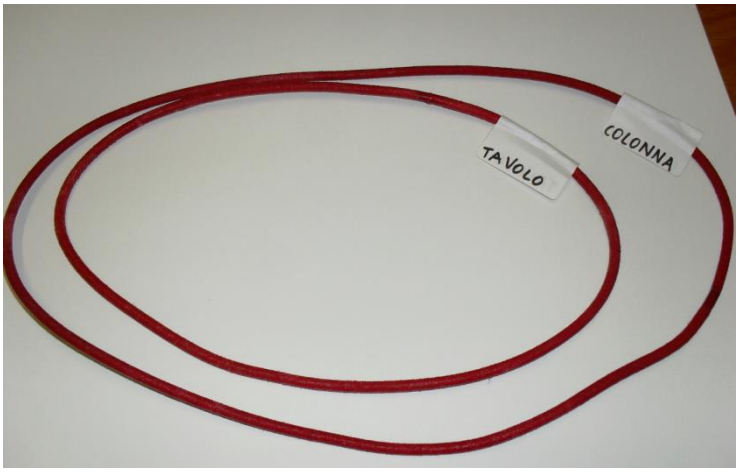
Power off the machine.

Unfasten the handwheel 162 and remove the protective belt casing 161.

Unscrew the ball grip 112.

Remove the grinding wheel protection 113.

Replace the belt and re-assemble all parts.



N.B. FOR ANY OTHER PART REPLACEMENTS, INTERVENTION OR REPAIRS, CONTACT QUALIFIED TECHNICIANS ONLY.

9. CLEANING

Regular cleaning on all of the machine's main parts and the surrounding work environment translates into greater safety for the operator and an extended machine life time.

Prior to carrying out any cleaning on the machine make certain that all parts have cooled down.

AFTER EVERY WORK CYCLE AND AT THE END OF EACH WORK SHIFT
Carefully clean the machine and all its parts, meticulously removing any plastic material and dust. Use compressed air only when strictly necessary, making use of protective eye goggles and a face mask.

9.1DISCONTINUING AND DISPOSING OF THE MACHINE

During the production process, waste substances or discarded scraps of material are generated which must be collected, recycled or disposed of in accordance with current laws and regulations in force in the country in which the machine is installed. The following substances are produced during the production process:
- raw material waste (synthetic material, leather, etc.).

In the event that the machine needs to be dismissed, follow the instructions below strictly in order to protect the safety of people and/or the environment in which the machine and its parts may come into contact.

ī Separate parts made of plastic, which must be sent to an authorized waste collection site in accordance with current regulatory standards.

ī For metal parts on the machine, simply group by type of material to allow for the recycling of the materials making up the original machine.

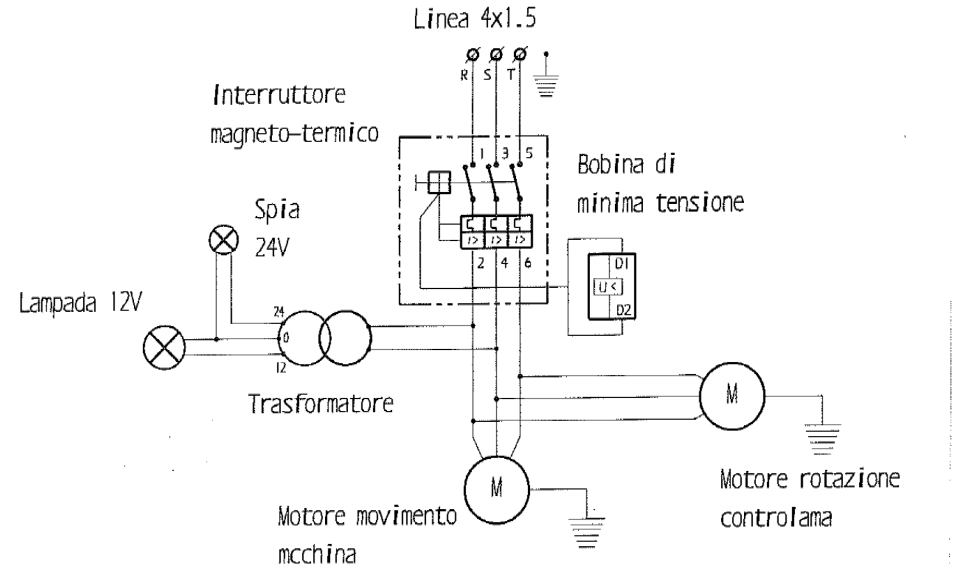
ī Remove all electrical components, so that they can be re-used after being checked or reconditioned.

ī Do not dump non-biodegradable products and lubricant oils into the environment.

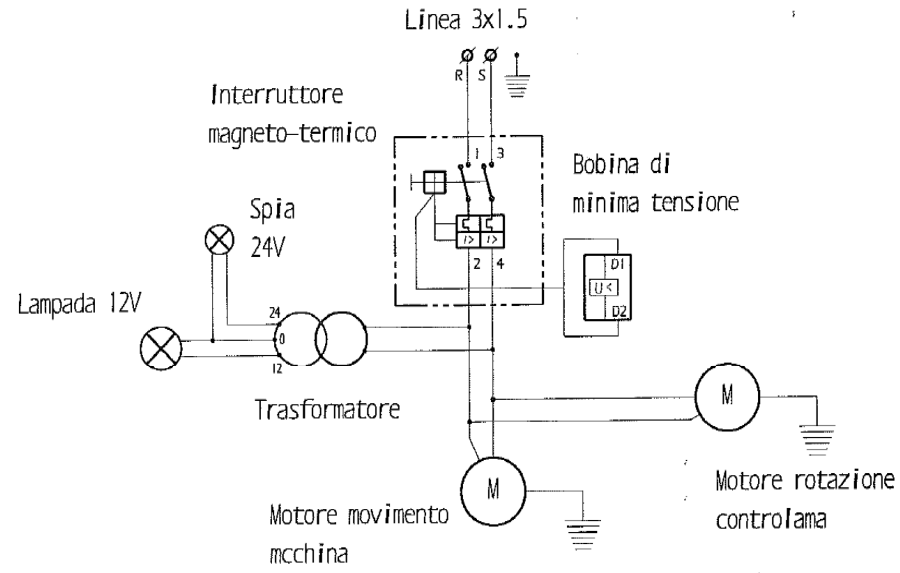
ī Contact a qualified waste collection company for the recovery and disposal of materials (solid and liquid) in order to dispose of the various materials, in accordance with current laws and regulations in force.

10. WIRING DIAGRAM AND ELECTRICAL COMPONENTS

SCHEMA ELETTRICO TRIFASE
GP4



SCHEMA ELETTRICO MONOFASE
GP4



11. WARRANTY

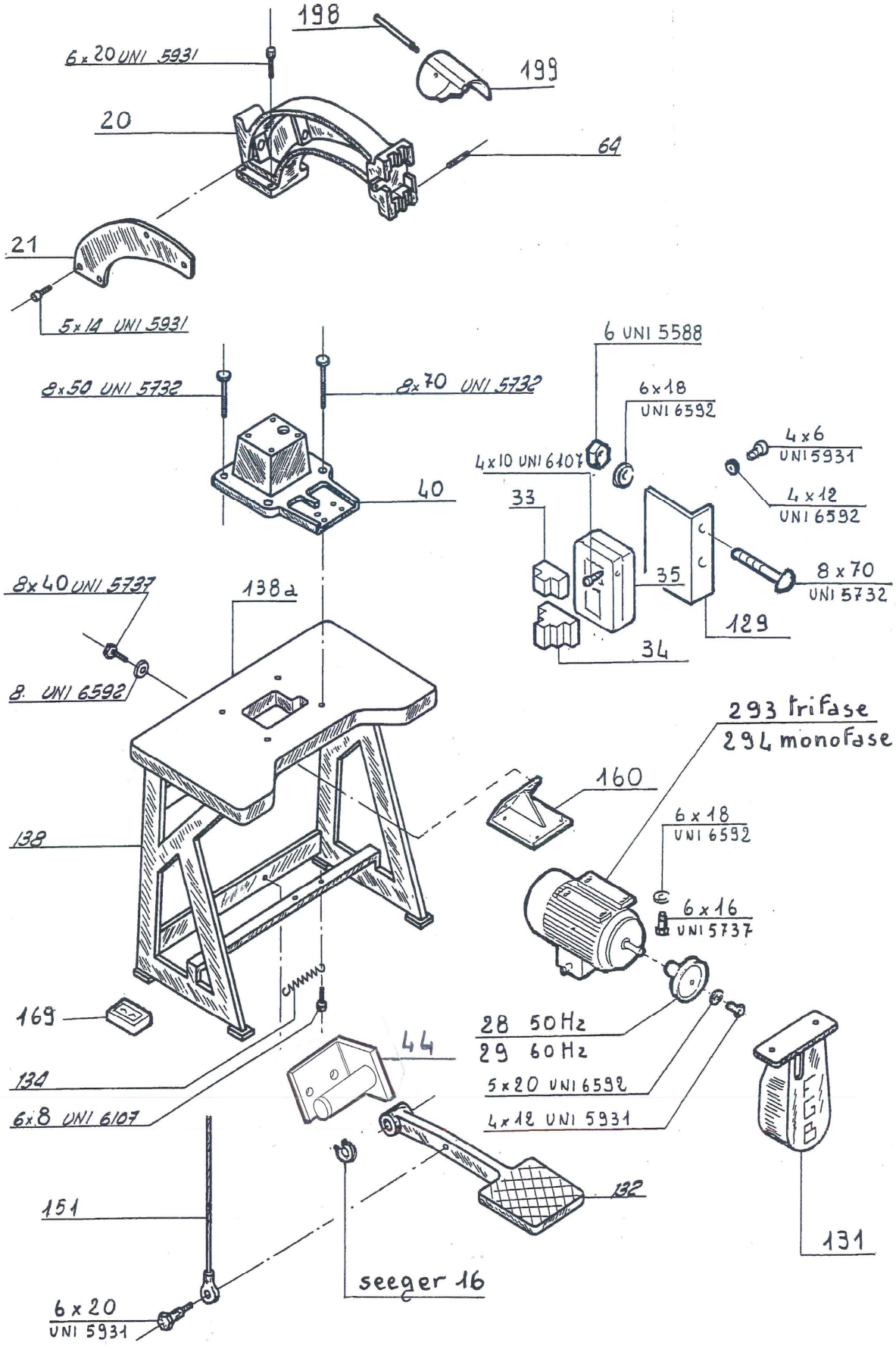
The warranty certificate is valid for one year from the date of purchase.
During the warranty period, the Manufacturer will consequently replace any defective parts, charging the customer only the shipping costs.
The warranty shall not be effective if the machine is used improperly or is damaged during transport.

WARRANTY CERTIFICATE

The machine is designed and built according to technological and safety criteria, and tested at our manufacturing plant before being shipped.
COLLI F.G.B. S.R.L. guarantees the operation and quality of the machine, in accordance with the law, for a period of 12 months.
Any improper use and maintenance which fails to respect the provisions cited in this user manual, such as machine settings and adjustments not approved by the manufacturer, will invalidate the warranty.
Warranty conditions on the machineôs correct operation are tied to the respect of all indications provided in this OPERATION AND MAINTENANCE MANUAL.
Any defective parts shall be replaced free of charge only after having verified the machineôs correct usage.
Any warranty claims and interventions shall be accepted solely upon presentation of the machineôs serial number, as it appears on the identification nameplate.
Upon receiving the machine, check to make certain the packing materials have not been damaged.
Unless otherwise agreed, the manufacturer is not liable for damage caused during transport.
In the event that damages are apparent on the packaging, please contact the carrier immediately.
Our company will be available to provide the necessary support.

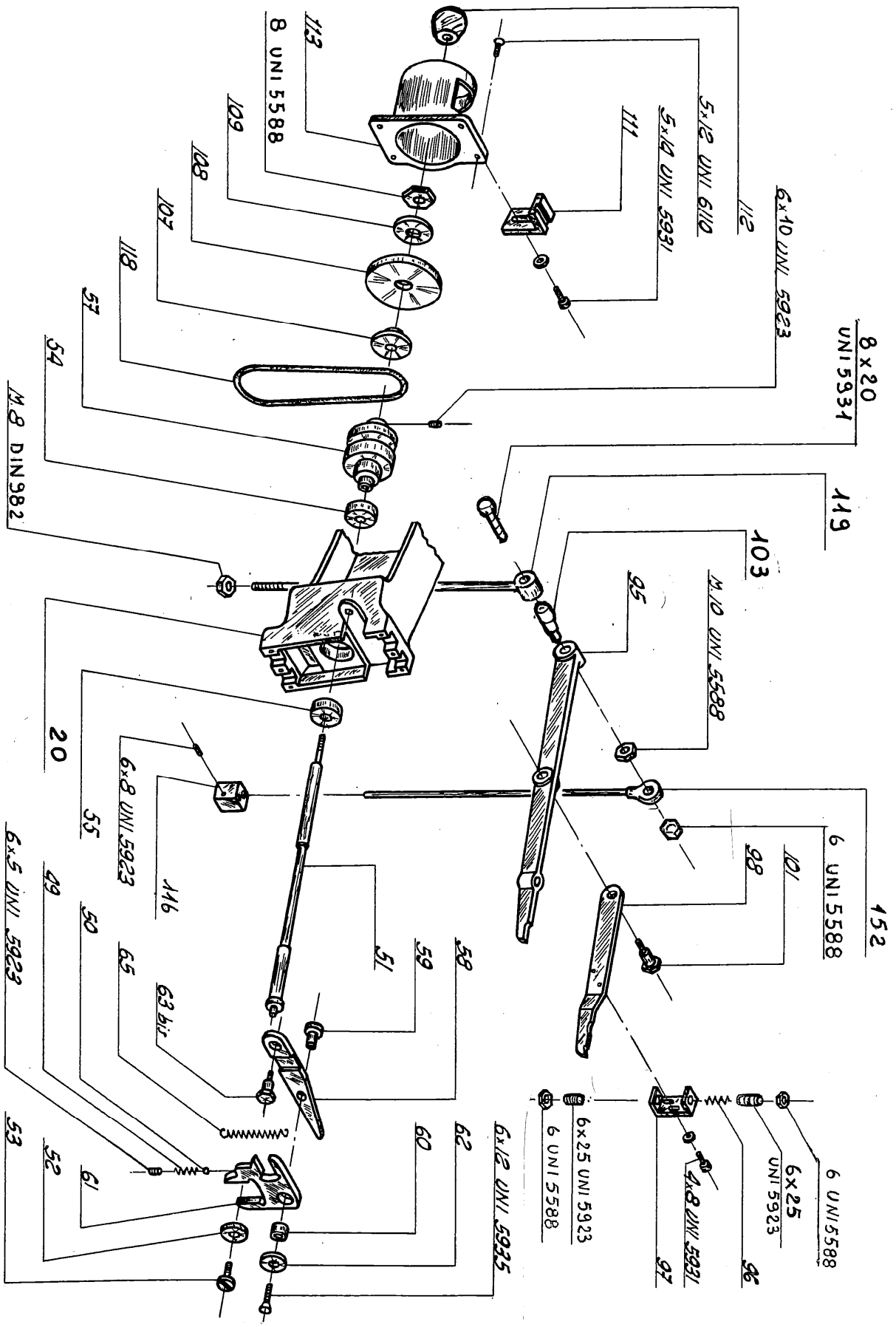
12 SPARE PARTS

12a Workbench



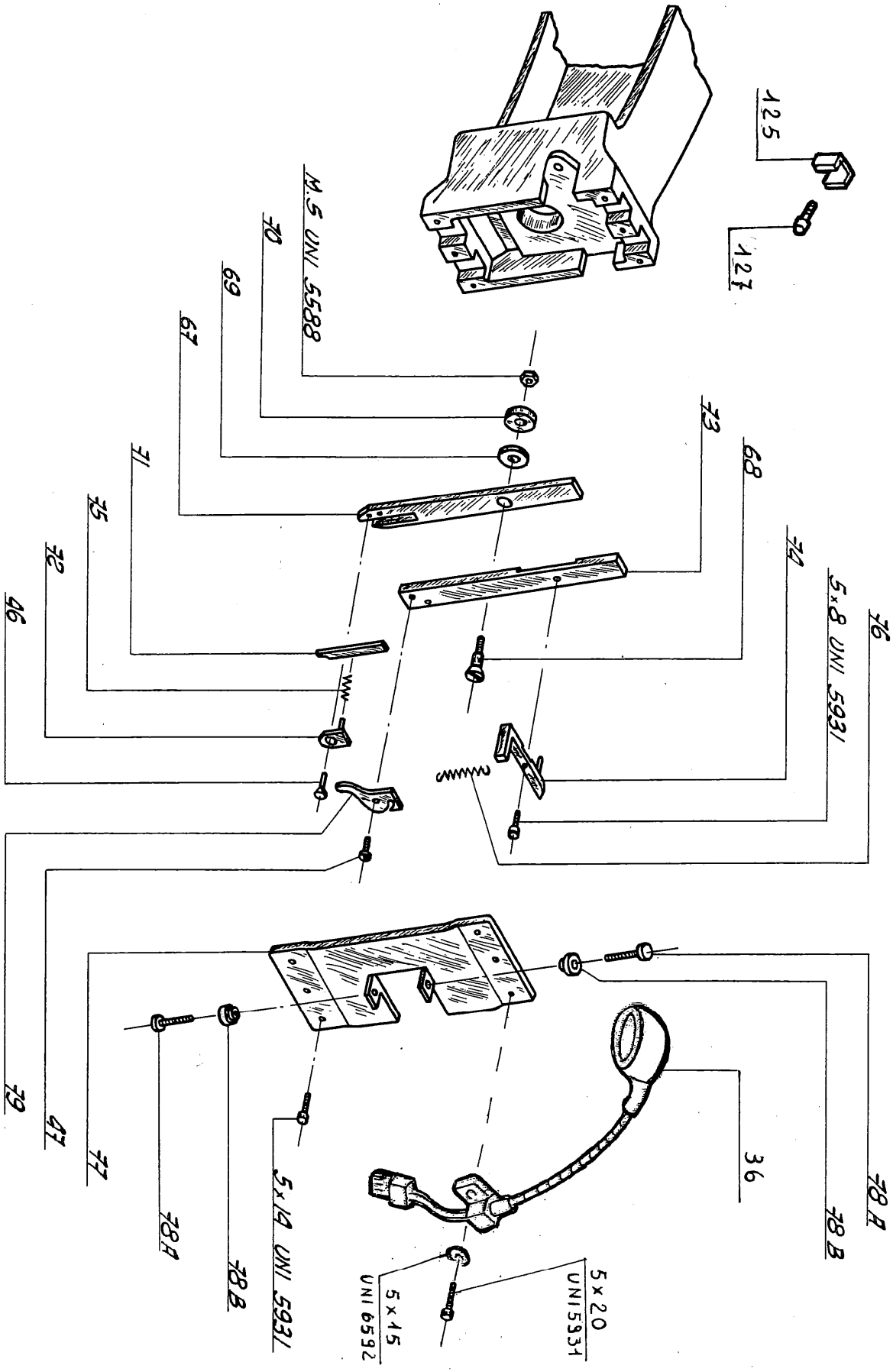
12 SPARE PARTS

12b Rocker arm



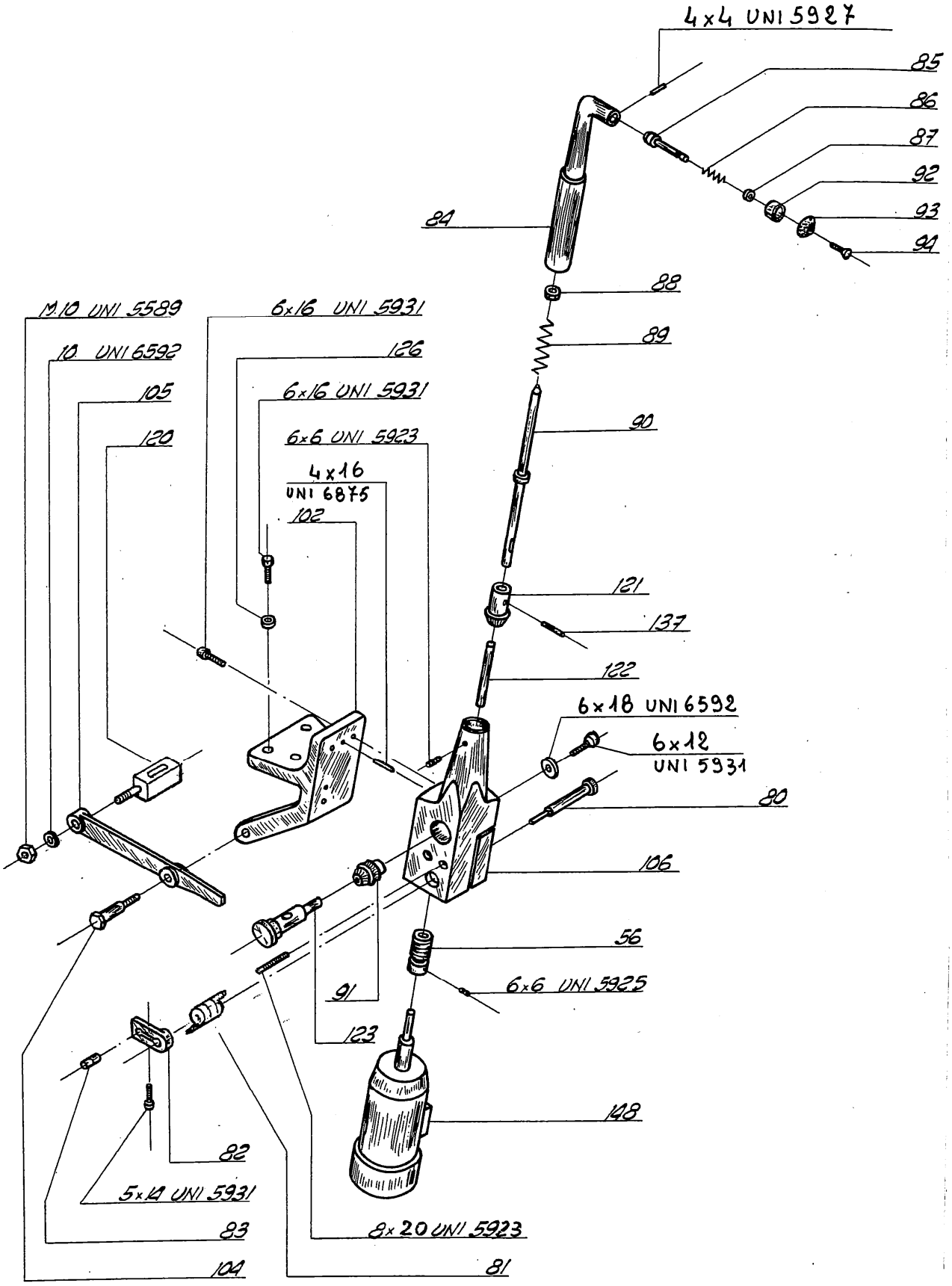
12 SPARE PARTS

12c Knife



12 SPARE PARTS

12d Counter knife



COLLI FGB S.R.L.

LIST OF SPARE PARTS FOR TRIMMING MACHINE GP 4

PART	PAGE	DESIGNATION
20	32.33	Operating Head
21	32	Head casing
28	32	Motor pulley 50 Hz
29	32	Motor pulley 60 Hz
33	32	Main switch
34	32	Transformer 30VA
35	32	Electrical box
36	34	LED lighting
40	32	Head support
44	32	Pedal support
46	34	Knife stop plate locking screw
47	34	Guide locking screw
49	33	Rocker arm spring
50	33	Ball 3/16"
51	33	Main shaft
52	33	Bearing 608 2RS
53	33	Bearing stop screw
54	33	Bearing 6201 2RS
55	33	Bearing 6201 2Z
56	35	Worm screw
57	33	Shaft pulley
58	33	Rocker arm oscillating lever
59	33	Rocker arm pin
60	33	Bearing needle K 12.16.8
61	33	Rocker arm
62	33	Rocker arm stop washer
63bis	33	Rocker arm lever stop pin

PART	PAGE	DESIGNATION
64	32	External head spring tensioning pin
65	33	Rocker arm lever spring
67	34	Knife tool shaft
68	34	Shaft bearing pin
69	34	Shaft bearing washer
70	34	Bearing 625 2Z
71	34	Knife
72	34	Knife stop plate
73	34	Guide shaft
74	34	Guide shaft bracket
75	34	Knife plate spring
76	34	Knife shaft return spring
77	34	Front plate
78a	34	Guide setscrew
78b	34	Guide screw nut
79	34	Guide
80	35	Counter knife shifting cam pin
81	35	Counter knife shifting torsion spring
82	35	Counter knife shifting clamp
83	35	Clamp roller unit
84	35	Bickern
85	35	Counter knife gear
86	35	Counter knife gear spring
87	35	Counter knife gear guide bushing
88	35	Bickern anti-friction washer
89	35	Long stem conical gear spring
90	35	Long stem conical gear
91	35	Gearing unit
92	35	Spander guide
93	35	Counter knife

PART	PAGE	DESIGNATION
94	35	Counter knife screw
95	33	Knife raising iron lever
96	33	Iron lever spring
97	33	Lever C bracket
98	33	Guide and knife raising Z lever
101	33	Iron lever and Z lever pin
102	35	Bracket support for reducer
103	33	Tie rod pin
104	35	Lower lever pin
105	35	Counter knife shifting lower lever
106	35	Bickern reducer
107	33	Grindstone washer
108	33	Grindstone
109	33	Grindstone stop washer
111	33	Knife sharpening support
112	33	Ball grip
113	33	Grindstone hood casing
116	33	Tie rod clamp
117	-	Knife and grindstonecontrol die
118	33	Elastic belt
119	33	Connecting lever tie rod
120	35	Tie rod pin
121	35	Conical gear
122	35	Counter knife shifting shaft
123	35	Gear unit pin
125	34	Knife shaft guide dowel
126	35	Reducer support washer
127	34	Dowel screw
129	32	Electrical box plate
131	32	Motor and belt protection

PART	PAGE	DESIGNATION
132	32	Pedal
134	32	Pedal return spring
137	35	Threaded gear pin
138	32	Welded iron bench frame
138a	32	Wooden top with drawer
148	35	Reducer motor
151	32	Lower tie rod
152	33	Upper tie rod
160	32	Motor support
169	32	Anti-vibration support foot
198	32	Handwheel and grindstone protection pin
199	32	Handwheel and grindstone protection
293	32	Three phase motor 0.25 kW
294	32	Single phase motor 0.25 kW

N.B. WHEN REQUESTING SPARE PARTS, IT IS ESSENTIAL TO SPECIFY THE PART NUMBER, QUANTITY OF PARTS AND MACHINE TYPE "GP4"

13 REQUEST FOR SPARE PARTS

NOTE! FILL OUT THIS FORM IN DETAIL

Customer é . Address é é	Date é Telephone é Fax é

MACHINE TYPE	**SERIAL NO.**	**DELIVERY DATE**	
GROUP CODE	CODE	DESIGNATION	QUANTITY

Notes
é ......
é ....
é ....

N.B. Attach a photocopy of each table in which the requested part is found.