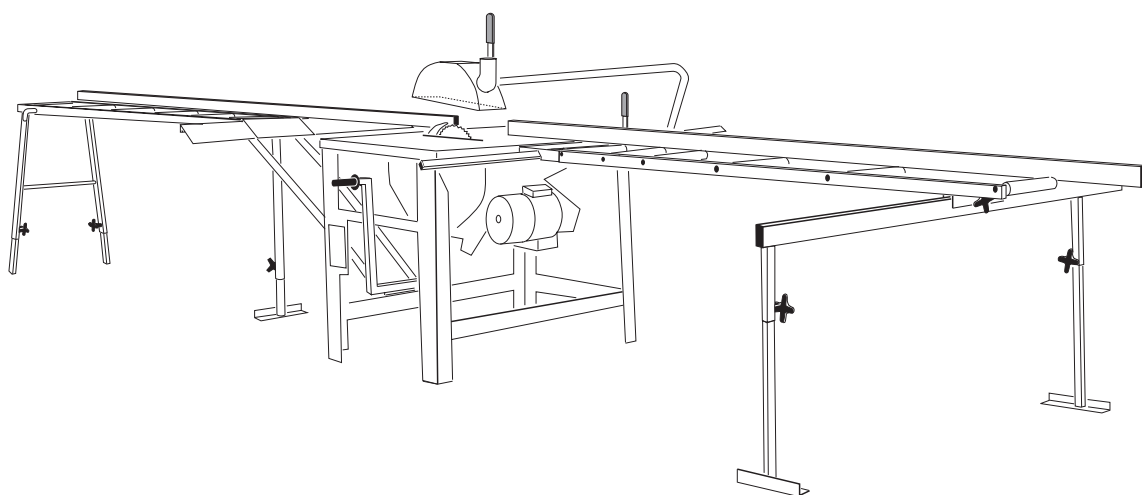


User Manual



2003



Ernex AS

Bjørnstadgt. 7, N-1792 Tistedal, Norway.
Tlf. +47 69 17 83 30 - Fax. +47 69 17 83 60
E-mail: ernex@ernex.no - www.ernex.no

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1. Safety instructions

The European Union Machinery Directive 2006/42/EF, 2006/95/EF and EN 1870-5:2, requires manufacturers, importers, suppliers and dealers to ensure that machines are designed and built to avoid causing injury to users and others by accident or inappropriate work posture or strain. Machinery used at a workplace must - wherever practicable - be secured and pose no risk to operator health during installation, operation, cleaning or maintenance.

Persons who will use the equipment must receive the necessary information on operation, usage and precautions necessary for safe operation without risk to life or health.

The Directive applies to purchase, resale (wholesale, retail), leasing, short and extended hire, and hire-purchase.

Persons installing the machines at a workplace are required under the regulations to ensure that - wherever practicable - no aspect of the installation has rendered the machine unsafe or causes it to pose a hazard at any time during assembly, use, cleaning or maintenance. The Directive also covers assembly, electrical hookups, accessories, safety features and extractor fans/ ventilators. Make sure there is sufficient light and space before commencing installation.

The Norsaw 2003 comes complete with the safety features enabling the operator to comply with the regulations. Details on correct installation and use, combined with a guide to installation and proper adjustment of the safety systems, are described in this User Guide. It is an absolute requirement under the Directive that the employer and employee shall ensure themselves that all safety features are properly installed, adjusted and maintained and that personal protective gear is worn.

Repairs and maintenance must only be done by a competent person. Be sure to check that the power supply is off and the plug is out before starting a maintenance procedure. Instructions for maintenance procedures are included in this User Guide.

The machine operator must receive adequate training and instruction on the hazards of the machine and the precautions that must be observed and the actions that the law requires of him, or alternatively must work under the close supervision of a person thoroughly familiar and experienced with the machine who knows and understands the proper precautions to be taken.

Persons under the age of 18 years must take and pass an approved HSE course before using the machine at the workplace except when on a training course under adequate supervision and guidance.

The saw is ideal for use with wood, plywood and chipboard.

The saw must not be used on plasterboard, polystyrene and tarred paper (for roofing).

WARNING: Safety equipment such as riving knife, blade guard and push sticks must not be removed, but have to be used.

2. General Instructions

2.1 Safety precautions

- **CAUTION!** Under the CE regulations operators must always use both tables when operating this saw bench.
- Make sure there is adequate uncluttered space around the saw.
- Make sure the floor/ground is level.
- Sawdust extractor should be used when working indoors. This has a flexible duct, 80 mm inside diameter. Air velocity should be over 20 m/s.
- **CAUTION!** If the saw is used without the extractor, take out the suction duct from the blade housing.
- Ensure adequate ventilation.
- Ensure adequate work light and wear ear protectors and safety goggles.
- Always lower top guard before lifting saw.
- Keep table top tidy, remove offcuts.
- Use a push stick when ripping small workpieces and whenever the distance from blade to table fence is less than 120 mm (5 inches).
- Turn off the motor before tilting the arbor (bevel adjustment) or slewing the turntable (mitre adjustment).
- Lower blade below table when not in use.
- Never use the saw without a riving knife in place behind the blade.
- Blades should be sharp, without missing teeth, fractures, deformation or wobble.
- Remove power plug when changing the blade and for all other maintenance procedures.
- Be sure to close blade housing securely after cleaning, blade replacement, or replacing or adjusting riving knife.
- Replace the aluminium packing strips on the turntable when these get worn or damaged.
- When cutting long or unwieldy workpieces it is best to use some form of outfeed support, for example the outfeed table or support trest
- Remember that all electrical plugs, extension cords and connections must have ground protection.

2.2 Dust and Noise

- Dust and noise measurements have been performed for work with the materials and saw blades for which the machine is intended (see section 1 Safety Instructions).

Measurement uncertainty is related to local conditions and can vary with the saw blade/transmission characteristics. Follow the maintenance instructions (see Section 6 Maintenance/Repair).

Ear protection must be used, and a dust mask is recommended.

For indoor use, the machine must be connected to an extractor that provides a minimum air speed of 30 m/s i.e. 1.8 kPa.

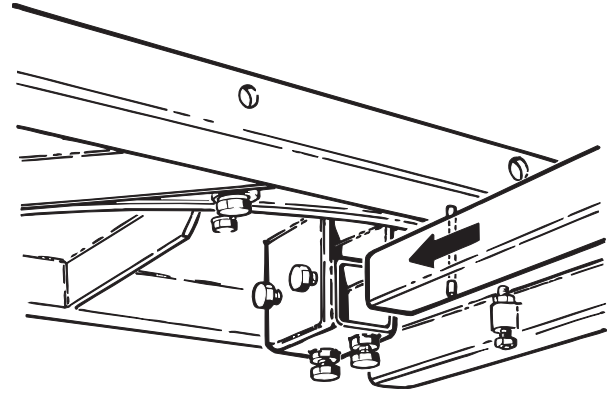


3. Mounting/Transport/Power supply

3.1 Install top guard

- Push top guard stand into slot below table until it bottoms on splint Fig. 1. Install top guard so that wooden edging strip on inside of guard is **3 mm** from blade slot.

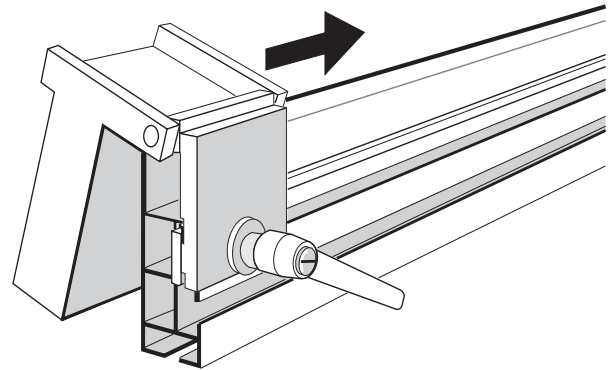
Fig. 1



3.2 Length stops

- Mount length stops on fence as shown in Fig 2. If using stops and ruler, the fence must be bolted in place at the correct ruler setting. Fine adjustment can be made with the length stop.

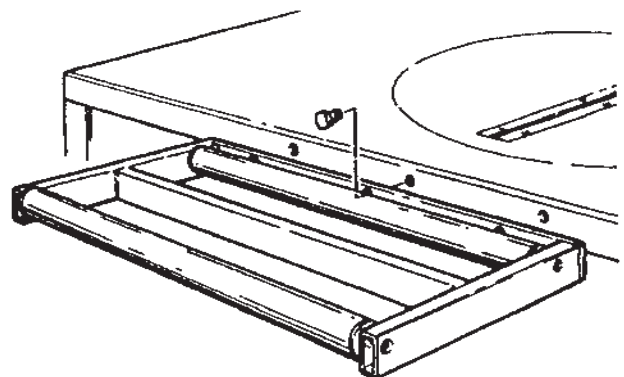
Fig. 2



3.3 Mounting of short work support

Mount the short work support as shown in Fig. 3.

Fig. 3



3.4 Mounting of adjustable-/fixed and standalone table.

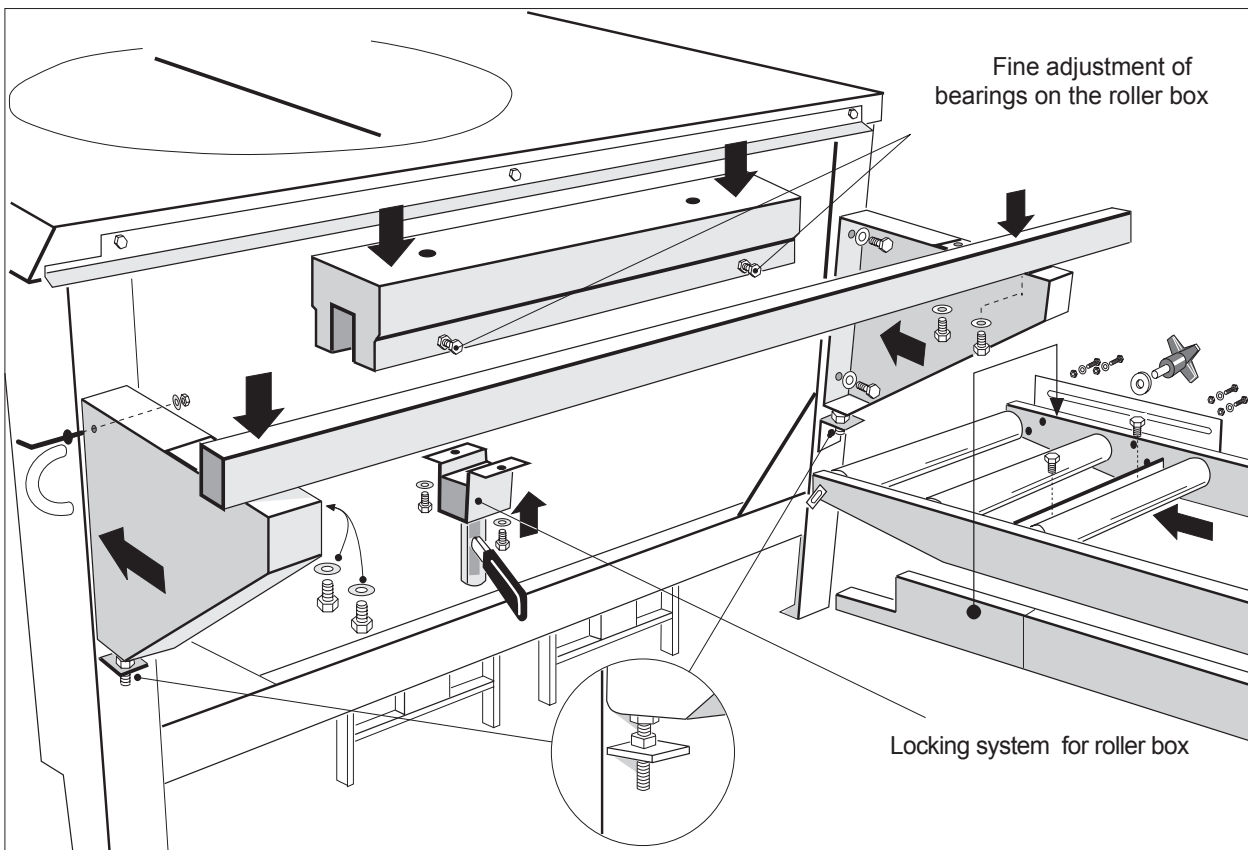


Fig. 1 - Mounting of adjustable table, right side

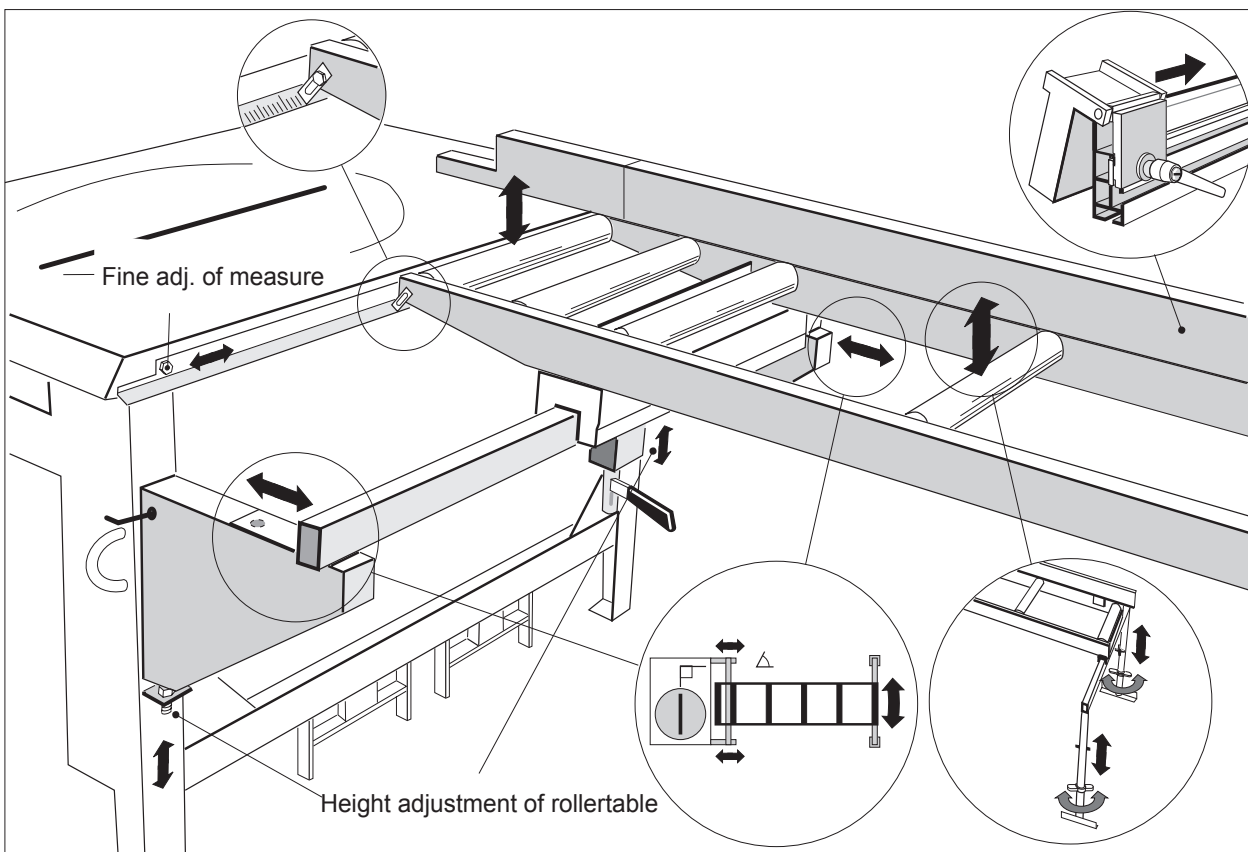
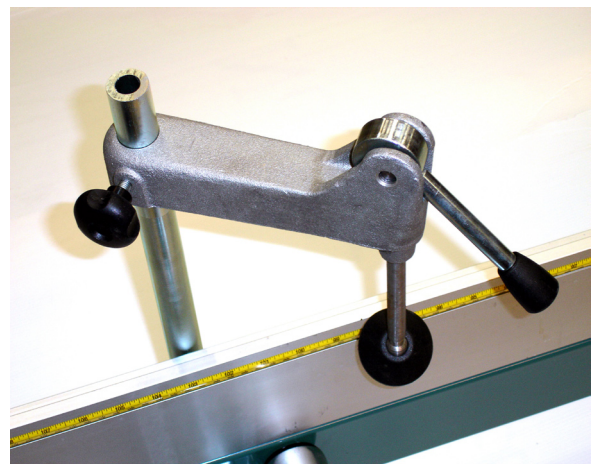


Fig. 2 - Adjustment of adjustable table, right side

Fig. 3 - Mounting of left rollertable



Subcarrier locking at the rear end of left table



Clamp f/alu.fence



Length stop mounted on alu. fence



Lockingbracket for fence

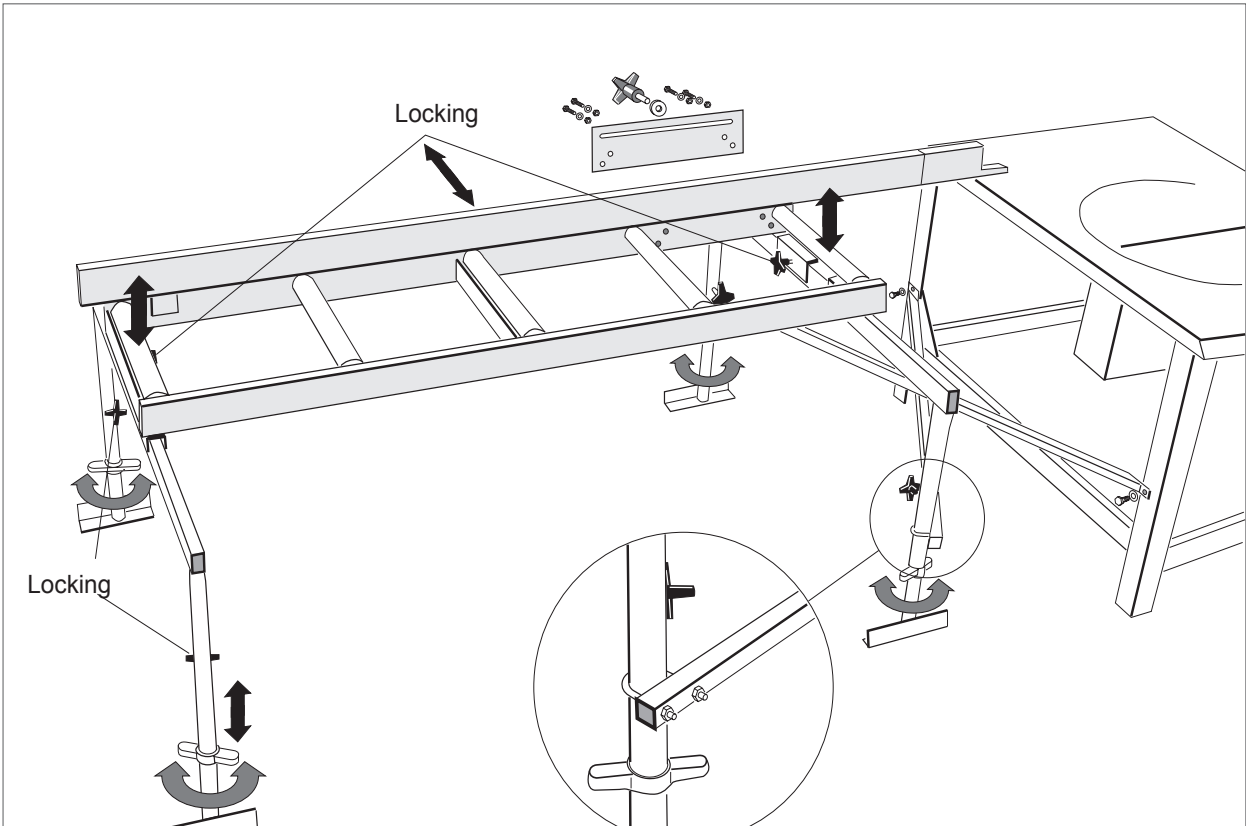


Fig. 4 Mounting and adjustment of standalone table, left side

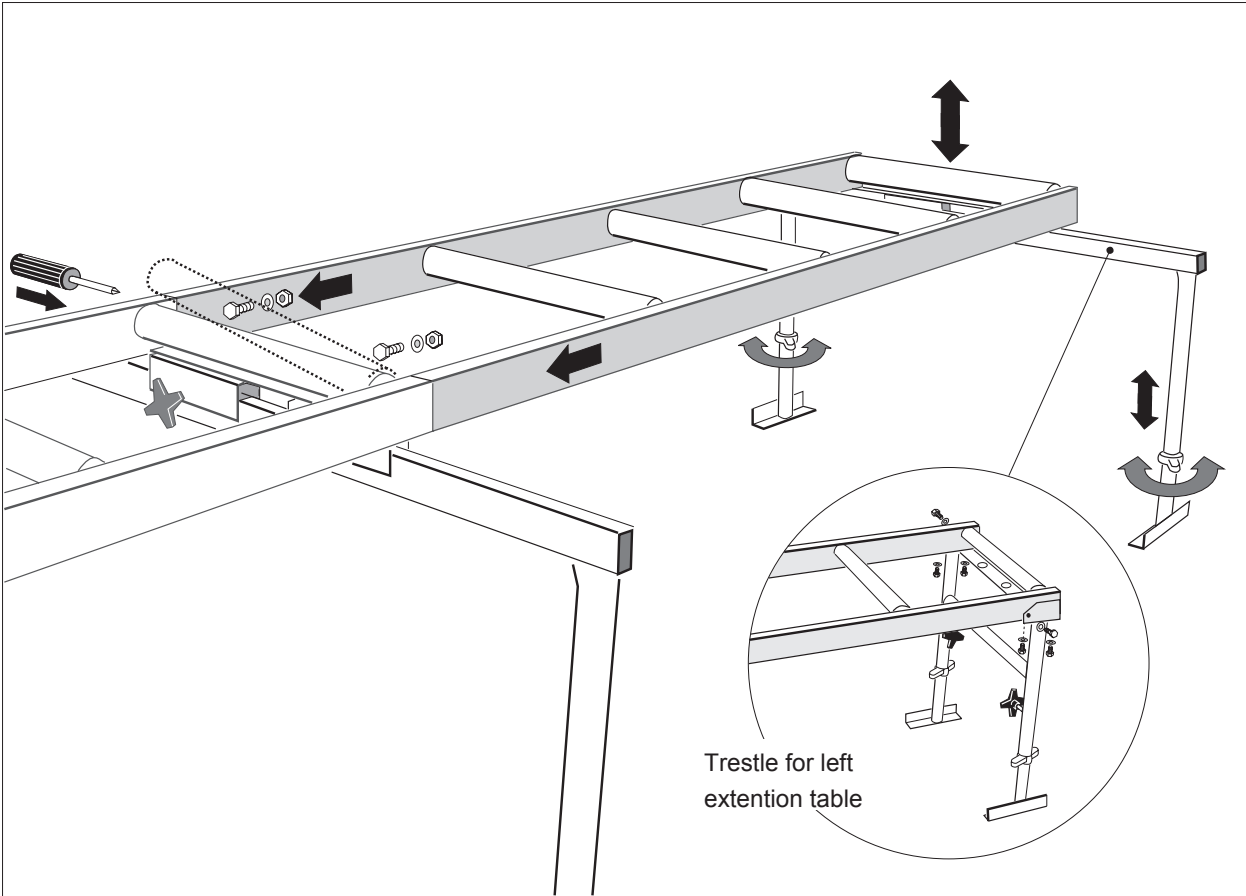


Fig. 5 - Mounting and adjusting of extension table, right/left side

3.5 Move saw with forklift

- It is possible to move the saw with a forklift or warehouse trolley. See Fig. 4 which shows where to place the forks.

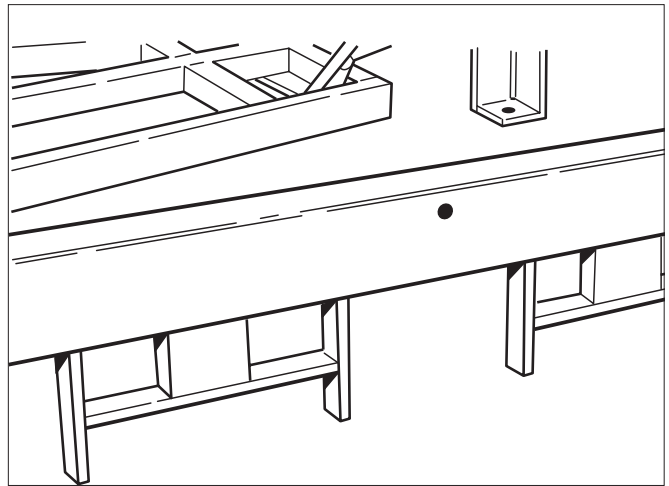
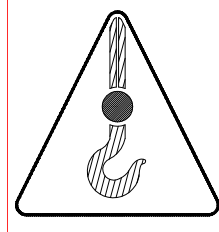


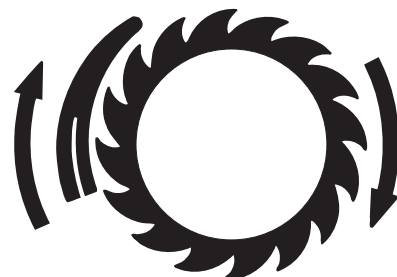
Fig. 4

3.6 Power, phase reversal, blade spin

- When connecting to the power supply you must check the direction of blade spin. It must spin away from the riving knife, as is indicated on the blade housing below the table. If it spins backwards, release the phase selector and turn one half circle (180°) using a screwdriver. (Applies to 400 V model only.) Fig 5.

CAUTION! If the saw starts in reverse the blade may kick the workpiece away with great force or become unscrewed, with severe risk of injury to operator and bystanders.

Fig. 5



Correct spin direction

3.7 Power supply

If you need to use an extension lead, make sure it is an earth lead with 2.5 sq.mm conductor cross-section. Fuses can be minimum 16 A (slow), but we recommend 32 A. The 400 V 3-phase model has a plug and phase selector (see Fig. 6).

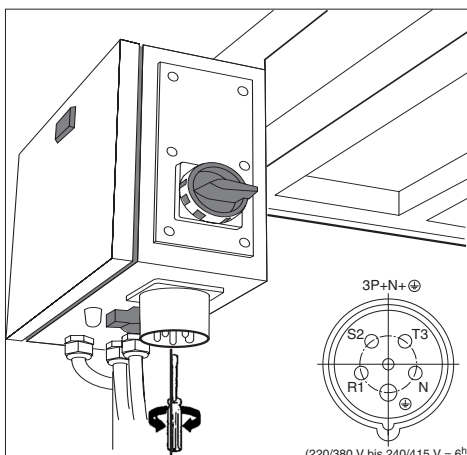


Fig. 6

4. Functions

4.1 Motor start/stop

The On/off switch for the saw is mounted on one of the table legs. Another stop switch is mounted behind the saw, beside the 230V accessory socket. Fig 6 and 8. The switch box contains a voltage-loss cut-out to prevent restart after a power failure. If the motor is overworked, the built-in thermal overload reset will disconnect the power. Following a brief cooling-off period the motor will restart when you depress the start button. Avoid overloading the motor.

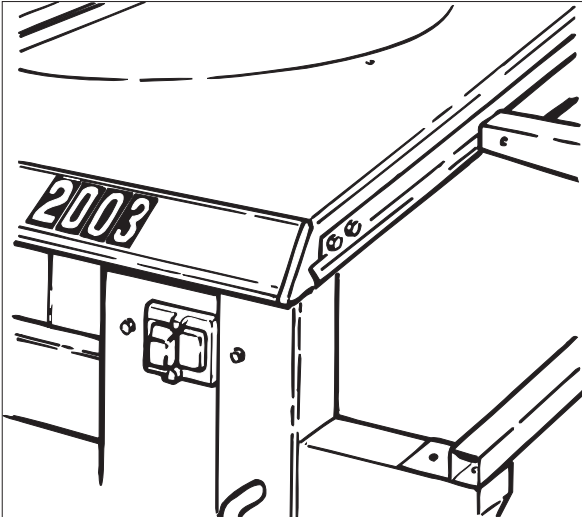


Fig. 8

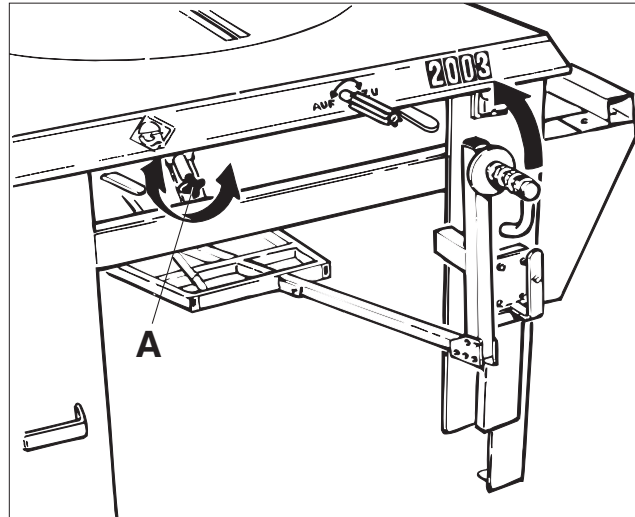


Fig. 9: Elevation adjustment and lock bolt A

4.2 Depth of cut (elevation) adjustment

The saw is raised and lowered using the elevation arm, Fig 9. The blade may be locked in the elevated position using the bolt marked A in the figure.

4.3 Bevel (tilt) adjustment, gauge, detents

The saw must be lowered before adjusting the arbor tilt angle. Release bolt B and the lock handle to tilt from 0 to 45°. Detents are provided for secure positioning at 0° and 45° Fig 10. The bevel gauge, below the table, indicates the arbor tilt angle.

NOTE: Up to 3° error may occur in either direction.

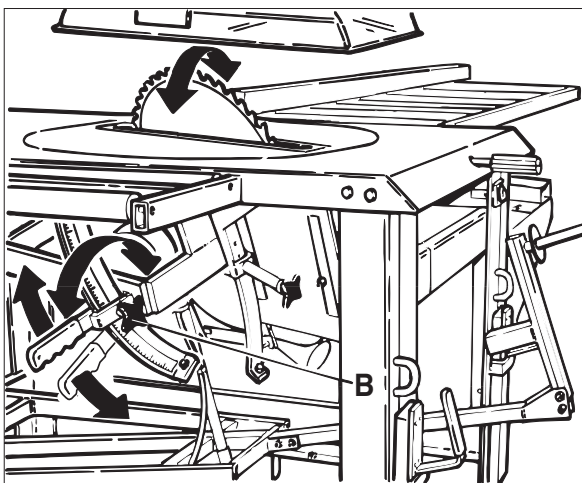


Fig. 10: Bevel adjustment, bolt B

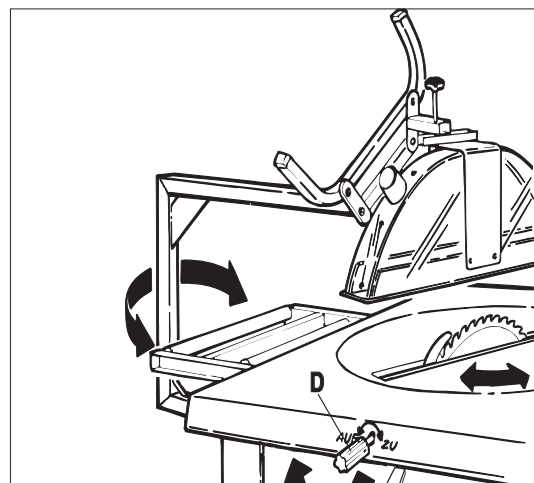


Fig. 11: Mitre adjustment, handle C, bolt D

4.4 Mitre (slew) adjustment, gauge, prestops

The blade can be slewed in the turntable from rip position (0°) to 135°. The turntable has pre-stops in the most used angles 0°, 45°, 67.5°, 90°, and 135°. Use lock handle C to release and lock turntable in wanted position Fig 11. The table will also lock in inter-mediate positions using bolt D on the front of the table.

NOTE: Up to 3° error may occur in either direction.

5. Operation

5.1 Cross cuts

There are two ways of making cross cuts with the turntable locked in the 90° cross cut position.

- A** Place workpiece against fence, and raise the blade to make cut Fig. 12.
- B** Raise blade to desired elevation and lock in place. Place workpiece on infeed table against fence. Slide infeed table containing workpiece towards you to make cut Fig. 13.

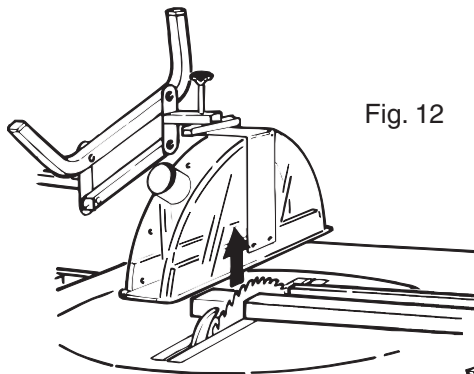


Fig. 12

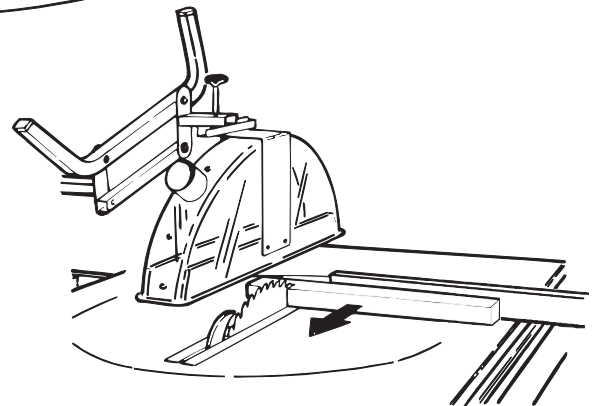


Fig. 13

5.2 Bevel cuts

- Adjust arbor tilt to desired bevel angle.
- Cut as described in 5.1 Cross cuts above. Fig 14 and 15.

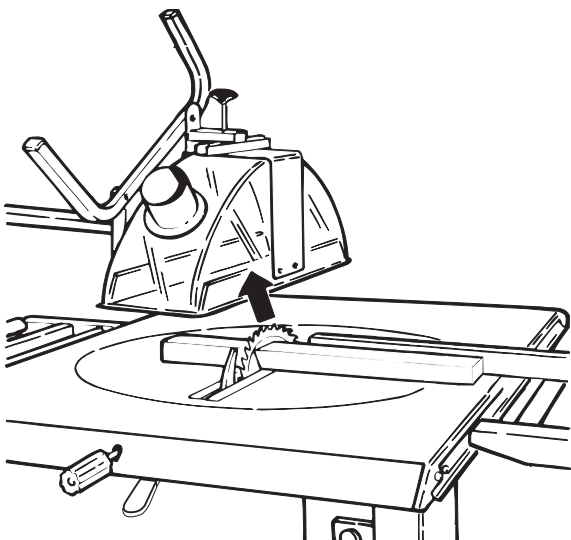


Fig. 14

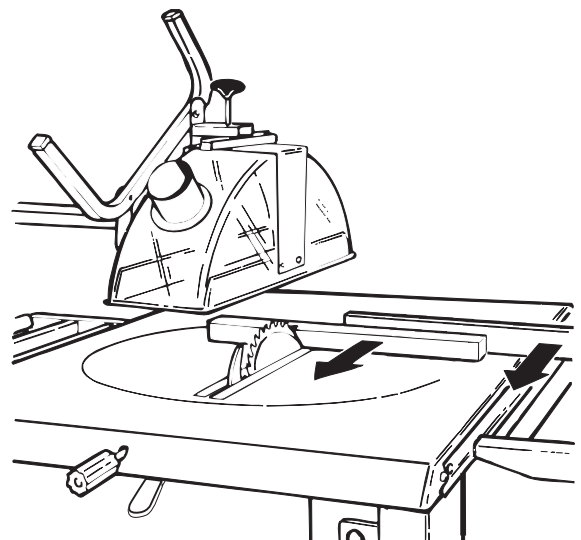


Fig. 15

5.3 Mitre cuts

- Adjust blade elevation to desired depth of cut but do not lock.
- Adjust turntable slew to desired mitre angle relative to fence.
- Place workpiece against fence and make cut by lifting blade.

5.4 Compound cuts

- Adjust as for mitre cuts, then adjust bevel angle as desired.
- Place workpiece against fence and make cut by lifting blade. Fig. 16.

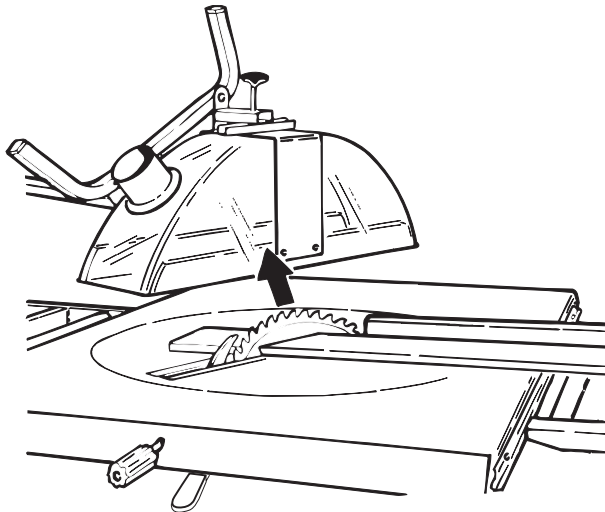


Fig. 16

5.5 Rip sawing

- Adjust blade elevation to desired depth of cut but do not lock. Blade should be parallel to fence on infeed table. **CAUTION!** Never make cross cuts with saw in rip position!
- Lock fence at desired width from blade.
- Slide fence back a little so it begins in middle of table, opposite blade centre. This will prevent workpiece binding and chattering between blade and fence during ripping operations.
- Slide workpiece forward along fence, using push stick for final **120 mm (5 in)** and if blade-fence width is less than **120 mm (5 in)**. Fig 17 and 18.

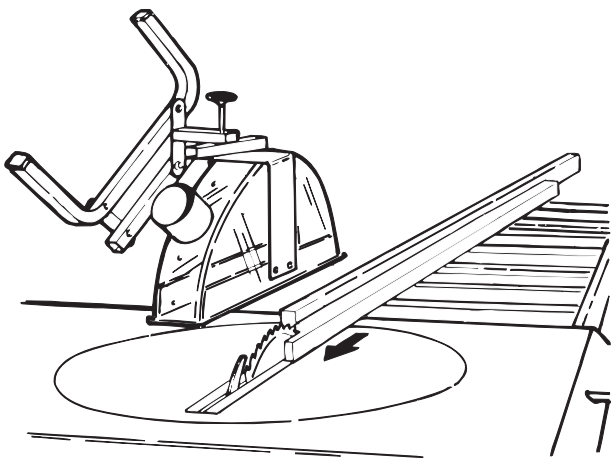


Fig. 17

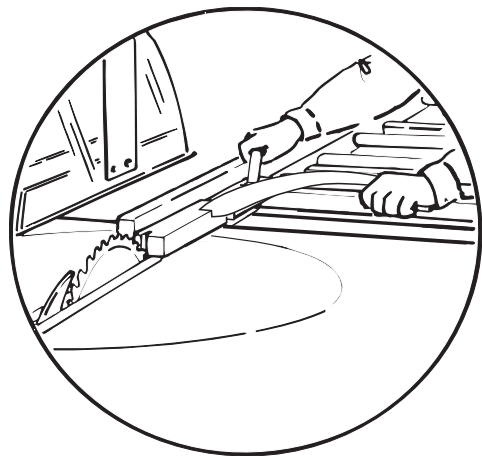


Fig. 18

5.6 Compound ripping

- Adjust as for ripping and additionally set arbor tilt to desired bevel angle. Perform rip operation as described in 5.5 Rip sawing Fig.19 and 20.

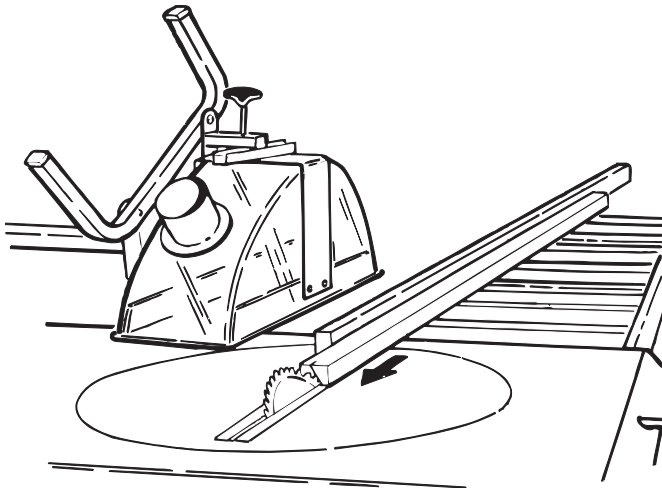


Fig. 19

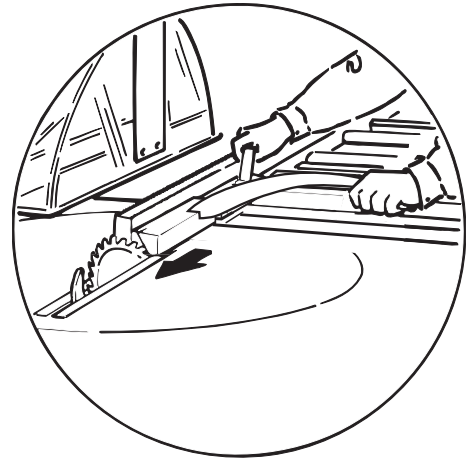


Fig. 20

5.7 Grooves and channels (rip saw)

- Adjust blade to desired elevation parallel to fence on infeed table (rip position, 0°) and lock in place.
- Lock fence at desired width from blade.
- Slide workpiece forward along fence, using push stick for final **120 mm** (5 in) and if blade-fence width is less than **120 mm** (5 in).
- Adjust fence and repeat rip until groove attains desired width Fig. 21 and 22.

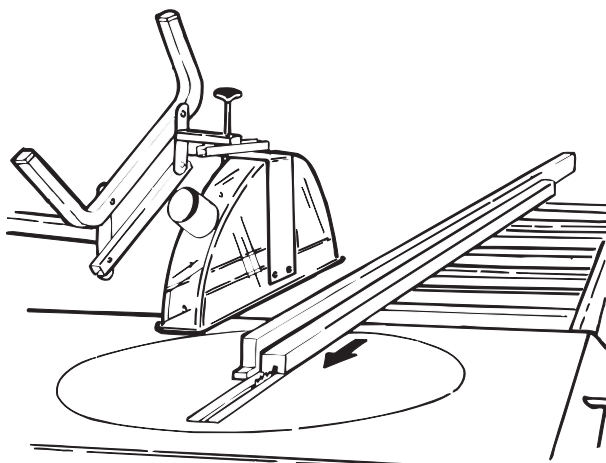


Fig. 21

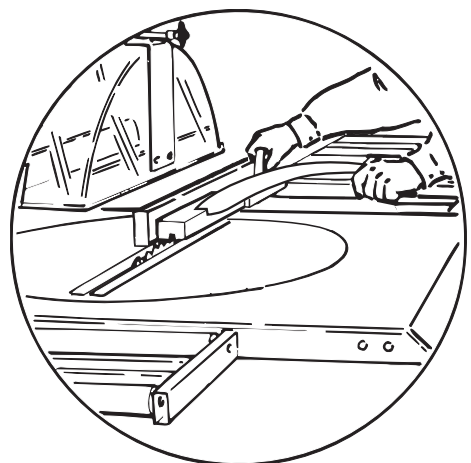


Fig. 22

5.8 Rabbets and mortises (cross cut saw)

- Set turntable at 90° and lock blade at desired elevation.
- Choose order of cuts so that offcuts land on left-hand side of blade, seen from operator.
- Place workpiece snugly against fence and pull infeed table to make cut.
- Adjust position of workpiece and repeat cut until rabbet has desired width Fig. 23.

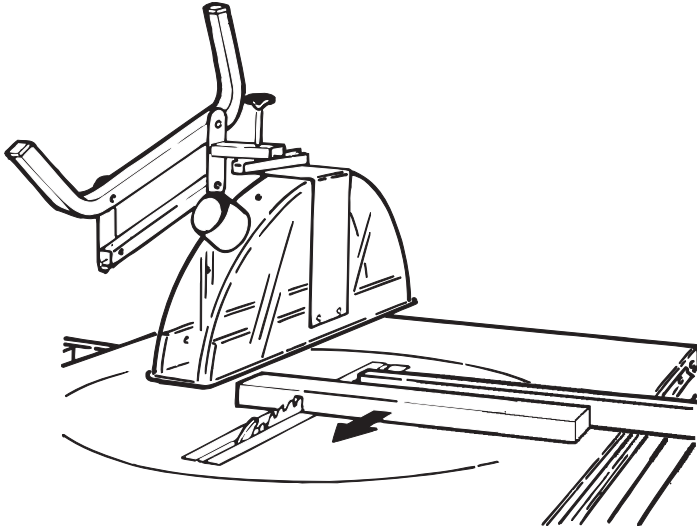


Fig. 23

6. Maintenance

CAUTION! Make sure power is disconnected before commencing maintenance operation. Routine maintenance of the saw is required to ensure many years of dependable operation.

- Grease moving parts, linkages and turntable bearings regularly.
- Check tightness of nuts and bolts regularly.
- Do not allow saw or blade housing to become clogged by sawdust, and be particularly careful to keep motor air inlet and cooling fans clear.
- Keep blade clean and in working order. Replace blade if cracks develop or teeth are lost. Remove built-up resin/harpix with suitable solvent.
- Check tension of V-belts regularly. Its is important to ensure that the arbor pulley and the motor pulley are align.

6.1 Replace blade

- Lower blade below table for removal.
- Open top half of blade housing case and hang out of way using chain provided.
- Open lower case using suitable tools. Remove blade by releasing lock nut with special spanners provided Fig. 24. Note that as lock nut is left-handed you turn clockwise to unscrew. To keep your hands free, wedge lock spanner against riving knife bracket.
- Reverse procedure to install new blade, not forgetting to close casing securely after replacement.

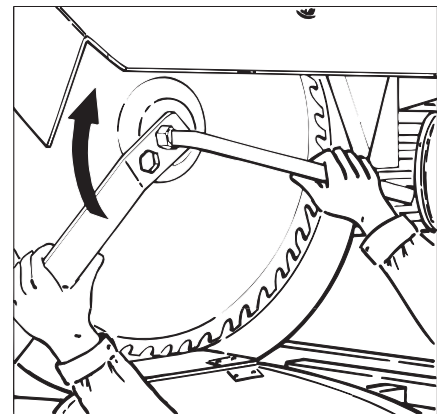


Fig. 24

6.2 Adjust or replace riving knife

- Never use the saw without a riving knife (splitter) in place behind the blade. To replace or adjust Fig. 25 and 26.
- When you install a thicker or thinner blade you need to fit a new riving knife of suitable thickness, usually midway between blade metal thickness (not counting tooth camber) and cut thickness. Loosen knife by loosening nuts **E**.
- Reverse procedure to install new riving knife, not forgetting to close casing securely after replacement.

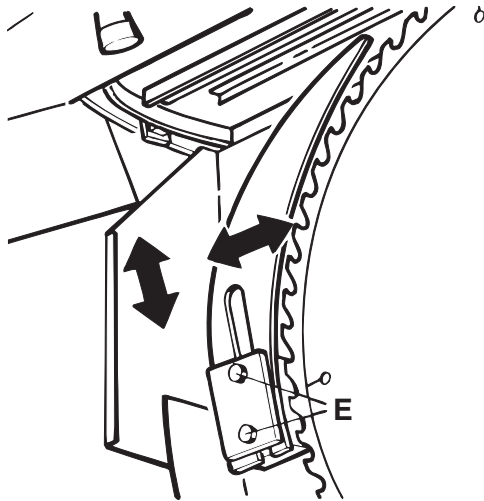


Fig. 25

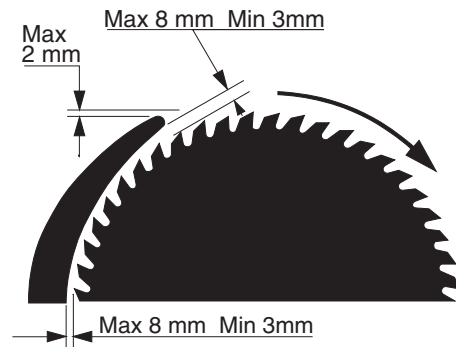


Fig. 26

6.3 Adjust or replace V-belts

- Tension the V-section drive belts using the motor attachment bolts **F** and **G** beneath the motor baseplate.
- Check that motor pulley and arbor pulley are align
- Tighten all four bolts after belt adjustment. Fig. 27.

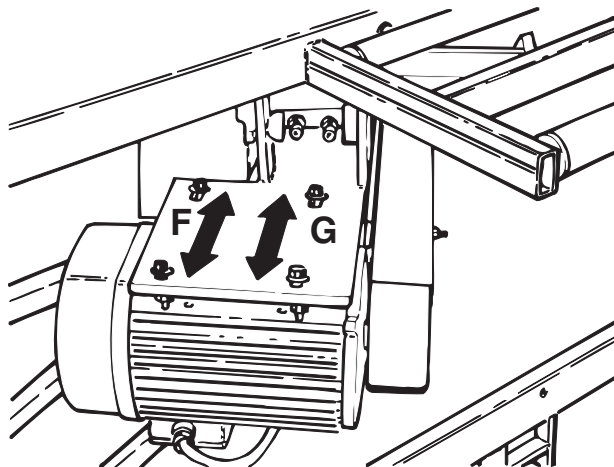


Fig. 27

6.4 Replace damaged top guard or push stick

- These vital safety devices must be replaced without delay if damaged.

7. REPAIR

Routines at repair:

* The machine must only be repaired by qualified electricians or authorised service work shops.

Testing the brakes:

* The brake for the saw blade rotation should be tested regularly. The stop-time must be max. 10 sec. Start/stop the saw 10 times in a row and check the stop-time.

TROUBLESHOOTING

The saw does not start:

- * check the power supply
- * do not use the cable with several machines at the same time
- * check that the cable is not too long, and that the cross-section is not too small
- * contact an electrician

The saw vibrates and is weak:

- * check that the blade box under the bench does not contain chips and sawdust
- * check that the toothed belt is whole and undamaged
- * check the spindle
- * check the blade for eccentricity, and that all the teeth are whole and sharp

The saw blade is heavy to lift and does not go down completely:

- * check that nothing is stuck in the blade box
- * check that the bearings in the universal joint and the movable glide rings at either end of the spindle are not stuck

8. WARRANTY

Notwithstanding any statutory requirements, Ernex AS provide warranty in accordance with the legislation of the customer's own country of residence, but in all cases for a minimum of 3 years, except for electrical parts which still has a 1-year warranty commencing from the date on which the machine is sold to the end user. Ernex AS/The importer promise to repair, or at our option, replace with like grade and quality any product determined to be faulty due to the failure of parts, material or workmanship.

The warranty covers defects in material and/or workmanship only. When making a claim under the warranty, proof of purchase bearing the original date of purchase must be submitted. The repairs under warranty may only be carried out by Ernex AS, or by authorized Ernex warranty service agents or the importer.

The warranty will not apply in cases of:

- incorrect use, overloading of the machine or fitting non-approved accessories
- use of force, damage caused by external influences, or foreign bodies
- damage caused by non-observance of the instructions for use, such as connection to an unsuitable mains supply or voltage or non-compliance with the installation instructions
- normal wear and tear

The warranty also does not cover machines which have been partially or completely dismantled.

9. Technical Data

Norsaw 2003

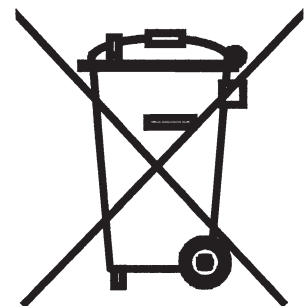
Manufacturer:	Ernex AS, Norway
Model:	Norsaw 2003.
Table top:	920 x 1350 mm
Transport height:	1050 mm
Table height:	900 mm
Weight:	Approx 350 kg
Blade:	Carbide-tipped, Z = 54 Diam: 550 mm
To fit arbor diam:	30 mm
Tooth width:	4.2 mm
Riving knife:	Standard 60 mm x 3.5 mm, DIN 38820 Part 1
Depth of cut:	200 mm (8") at 90° vertical 135 mm (5 1/4") at 45° bevel
Motor:	3-phase 7,5kW-400V
Motor speed:	2800 rpm.
Arbor speed:	1650 rpm.
Pheripheral speed:	Standard blade: 47 m/s.
Reset rating:	IP54
Cable dimension:	5 x 1.5 sq.mm
Fuse required:	(16A slow) 32A recommended
Motor reset:	Thermal, inside housing
Transmission:	3 pcs V-belts A52
Extractor duct:	80 mm diameter
Noise rating:	82,0 dB (A) No-load
2006/42/EC:	83,2 dB (A) Loaded
CE -mark:	Approved by Danish Technology Institute, Aarhus. ID No.: 0396 - Type certificate No. TI-09-MD-0313.

10. Standard Accessories

- Top guard
- Short work support
- Push sticks
- Tool kit

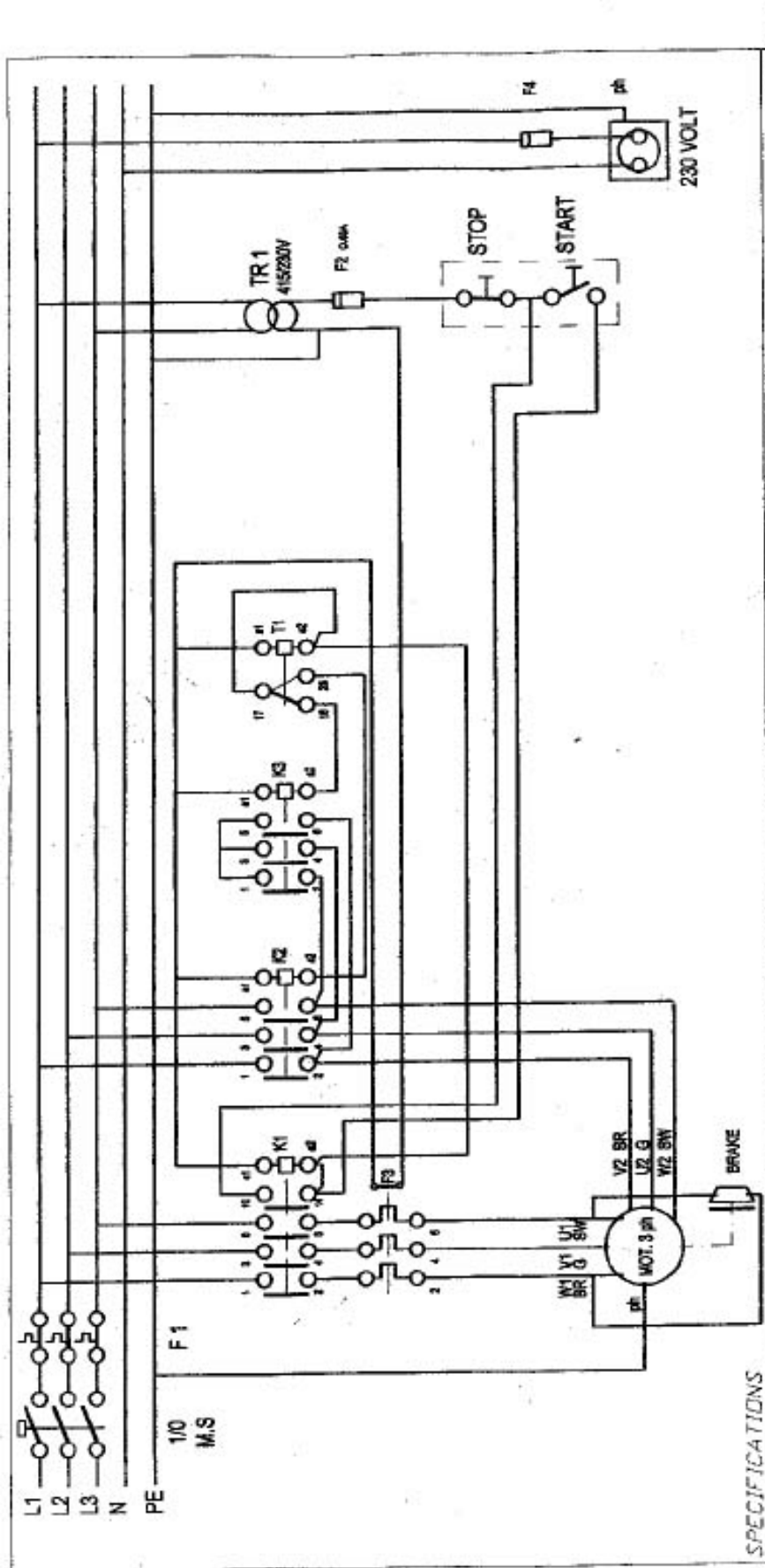
Optional Accessories

- Infeed table
- Fence, alu. f/infeed table w/length stop
- Outfeed table
- Fence, alu. f/outfeed table w/length stop
- Table extentions (2 m each)
- Dust extractor
- Laser



CAUTION! Under the CE-regulations operators must always use the infeed table when operating this building saw.

10. Circuit diagram switch 717750 (7,5 kW - 400V/3)



11. Part List Switch 717 750 7,5 kW

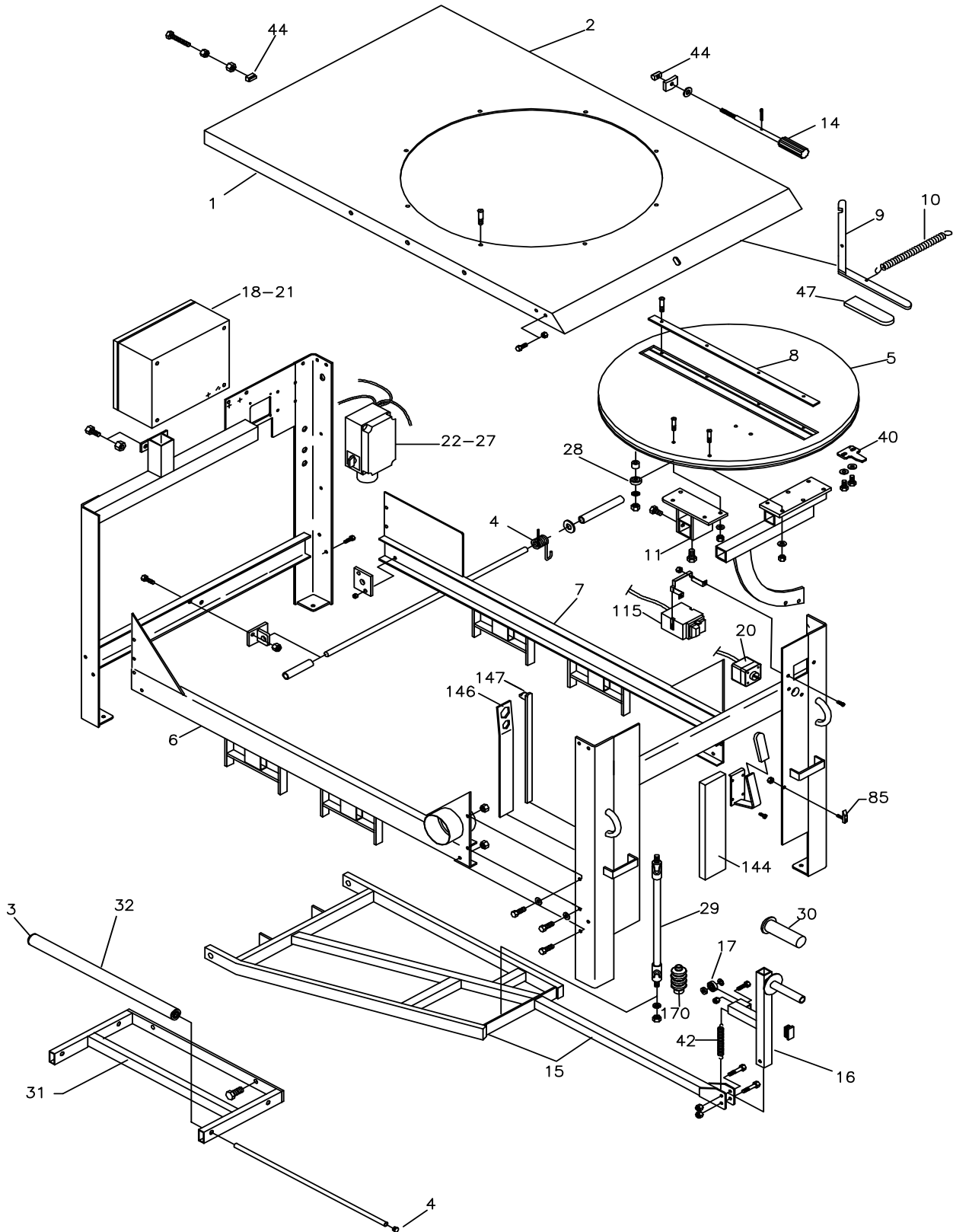
Ersatzteilliste 717750 7.5kW 2003

NORM	Bezeichnung	TYP	FABRIKAT
K1	kontaktor	LC 1 D 18 10 M 7	Telemecanique
K2	kontaktor	LC 1 D 18 10 M 7	Telemecanique
K3	kontaktor	LC 1 D 12 10 M 7	Telemecanique
ZR	Zeitrelais	MET 220 Volt	General Electric
Q 1	Hauptschalter	KG 32 AT 103	Skansol
TR 1	transformator	OFB - 25	Tramo
F 1	Sicherung	C-25 S 193 25 Amp	Malmbergs
F 2	Sicherung	PTF 35 630 ma	Elfa
F 3	Sicherung	PTF 35 630 ma	Elfa
F 4	Motorschütz	LR 2 D 1316 9-13 Amp	Telemecanique
F 5	Sicherung	T 11-211 12 Amp	Weber
	Ein/Aus Schalter	201 784	Tripus
	Anschluss	2-pol 10 A/250 V 553578	Tripus
	Kabel	HO 7 RN F 5 x 2,5	
	Kabel	HO 5 RN F 2 x 1,0	
	Kabel	HO 7 RN 7 x 1,0	
	Kabel	HO 7 RN 4 x 1,5	

Ernex AS Spare Part List Gjerde 2003

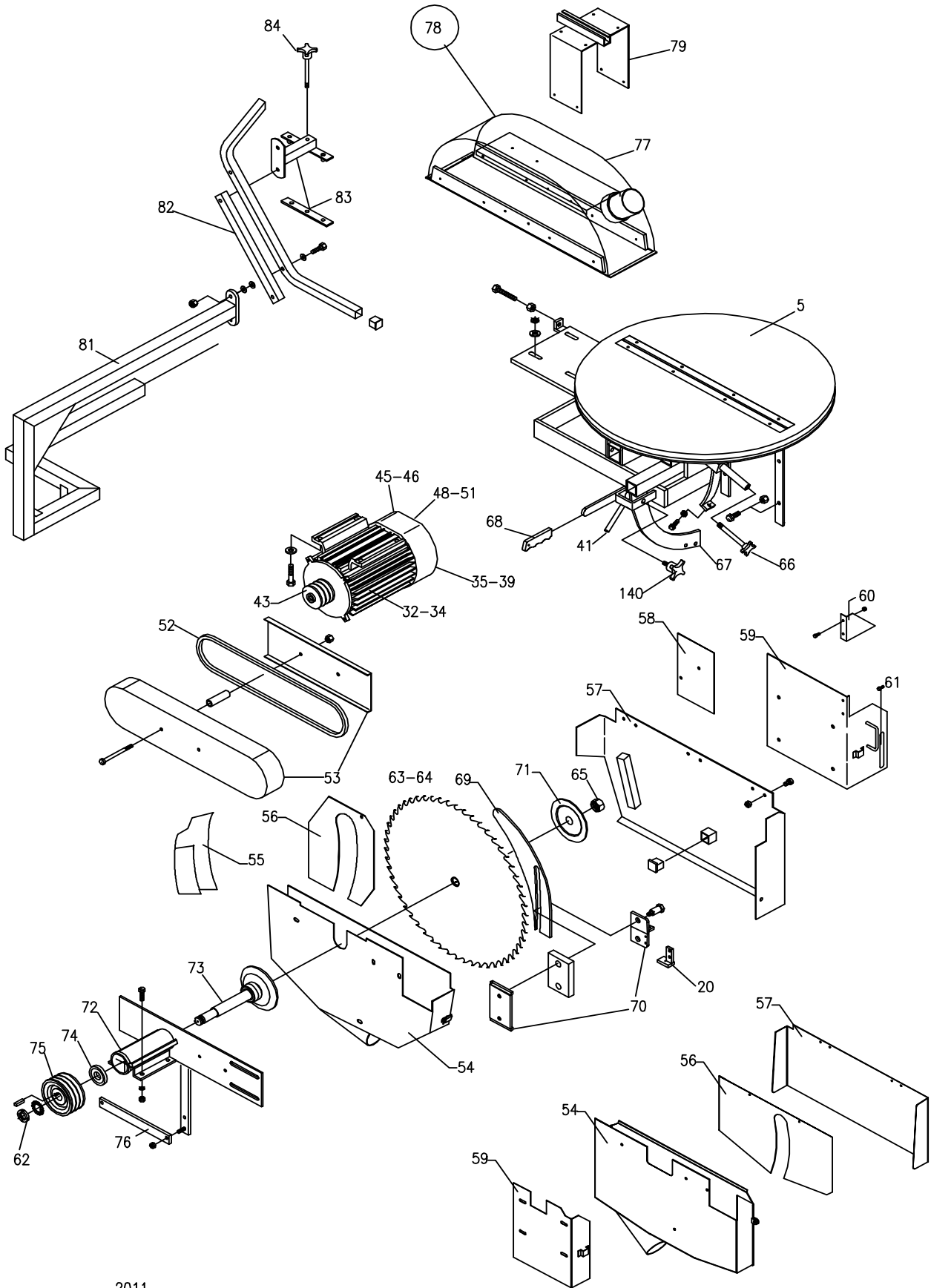
Pos.	Art.No.	Text
1	717 001	Sawtable w/elev. frame
2	717 025	Sawtable
4	707 004	Spring f/elevation frame
5	717 111	Turntable compl.
6	717 064	Balk compl., left
7	717 067	Balk compl., right
8	717 108	Packing strip
9	717 585	Handle f/pre-stop, turntable
10	717 587	Spring f/pre-stop handle
11	717 630	Fixing bracket f/guard arm
14	717 311	Locking assy. f/turntable
15	717 330	Elev. handle, lower part
16	717 338	Elev. handle, upper part
17	717 331	Bearing f/elev. arm
18	717 750	Switch 400V/3-7.5kW CEG
19	717 707	Switch f/laser
20	717 706	Laser bracket
21	717 900	Switch 230V/3-4kW
22	717 566	Trafo f/switch 7.5kW
23	717 557	Trafo f/switch 4kW
24	717 522	Electronic card 400/3 Tripus
25	717 524	Fuse f/electr. card 15AMP
26	717 521	Relay 230-400V/3 Tripus
27	717 309	Stop switch
28	717 312	Bearing assy. f/turntable
29	717 329	Ball jointed arm compl.
30	720 073	Plastic sleeve Ø22 f/elev.arm (99-)
31	717 710	Short work support
32	717 570	Motor 230/400V/3-4kW
34	719 000	Motor 400V/3 w/brake 7.5kW CEG
35	717 571	Brake assy. Seipe
36	717 572	Fan Seipe
37	717 577	Fan cover Seipe
38	717 574	Junction piece Seipe
39	717 575	Terminal box Seipe
40	707 952	Pre-stop f/turntable
41	717 667	Pre-stop set f/tilting
42	707 072	Spring
43	717 304	Motor pulley
44	707 398	Brass pc. f/locking screw
45	717 578	Bearing, front Seipe
46	717 581	Cover, rear Seipe
47	720 074	Plastic sleeve 25x8 mm
48	719 405	Fan cover CEG
49	719 403	Fan CEG
50	719 404	Terminal box CEG
51	717 576	Cover f/terminal box
52	717 305	V-belt 1250 LI A49
52	719 672	V-belt A52 (01/10-)
53	717 317	V-belt cover
53	717 699	V-belt cover
54	717 314	Blade cover compl.
54	717 704	Blade cover compl. (01/10-)
55	717 315	Slide cover
56	717 097	Plastic lid f/blade cover
56	717 703	Lid f/blade cover (01/10-)
57	717 110	Cover plate
57	717 702	End plate f/blade cover (01/10-)
58	717 365	Cover plate, rear
59	717 316	Protection plate, sawblade
59	717 705	Protection plate, sawblade
60	717 582	Cover f/laser opening
61	717 669	Locking screw f/cover plate
62	707 102	Nut & washer w/cotter
63	717 340	Sawblade Ø550 54Z Ø30mm-Std.
64	717 391	Sawblade f/alu. Ø550 120Z Ø30mm
65	707 106	Arbormut (left handed)
66	717 318	Height locking clamp
67	717 320	Tilting scale
68	820 213	Plastic sleeve
69	717 324	Riving knife 3.5mm
70	717 326	Clamps & bolts f/riving knife
71	717 105	Blade retaining plate
72	717 100	Spindle assembly
73	717 101	Spindle
74	717 104	Bearings f/spindle compl.
75	717 103	Arbor pulley
76	717 109	Parallell bar
77	717 608	Dome (wide)
79	717 295	Retaining f/wide dome
81	717 600	Guardarm w/bracket
82	717 601	Adjusting bars
83	717 210	Fixing bracket
84	745 307	Locking screw f/fixing bracket
85	717 223	Stop f/elevation handle
115	707 808	Switch Tripus (-92)
170	708 789	Sleeve f/ball jointed arm

2003



2011

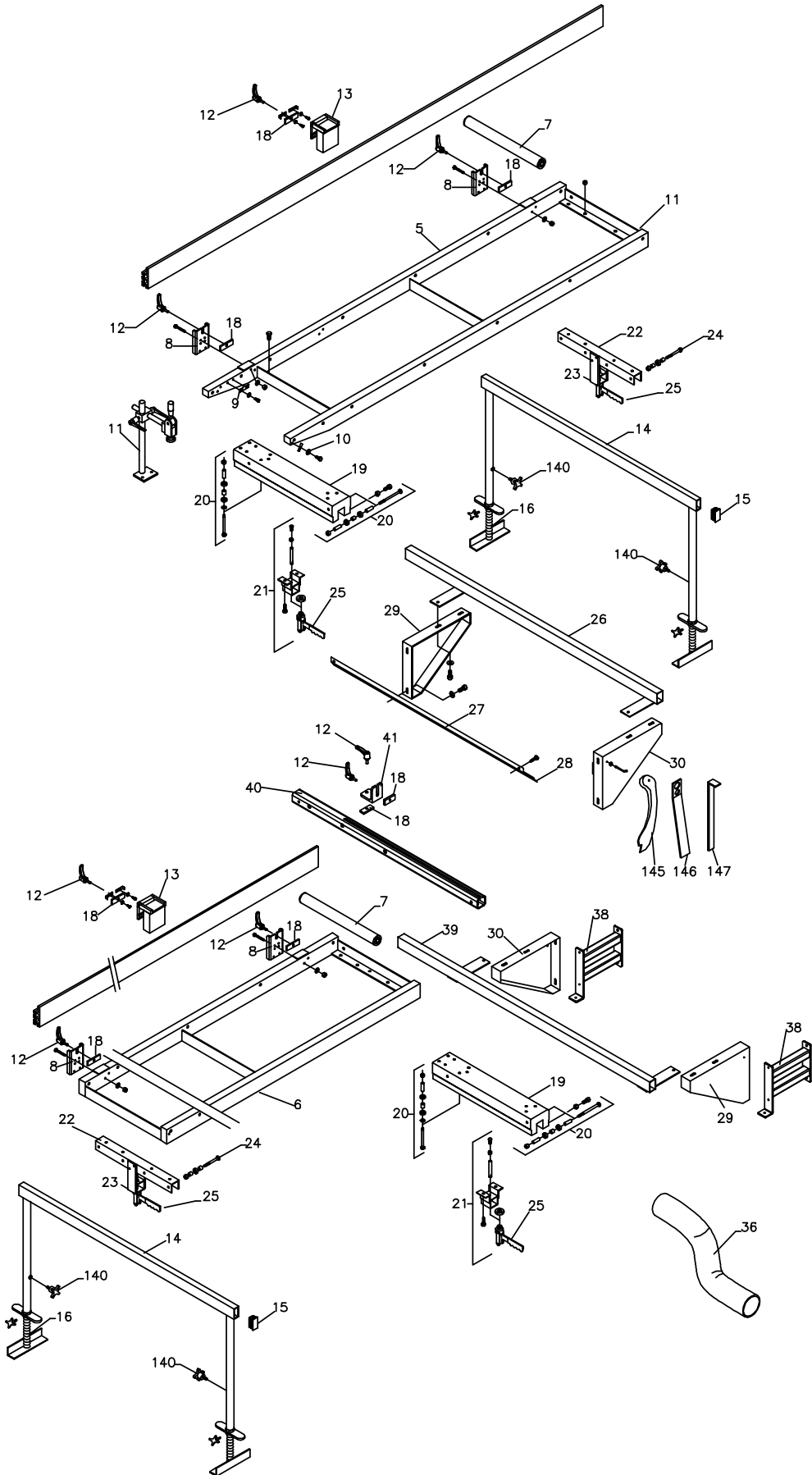
2003



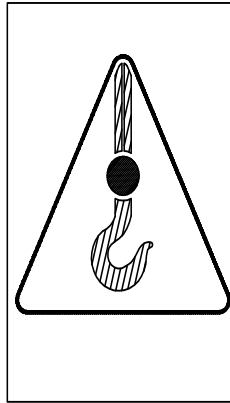
2011

Ernex AS Spare Part List Rollertables 2003

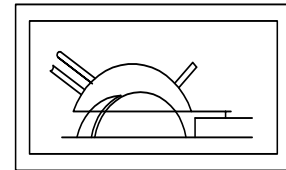
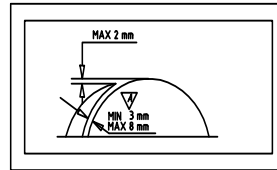
Pos.	Art.No.	Text
3	707 879	Nylon bearings (2)
4	772 878	Plug
5	717 451	Frame w/rollers
6	717 475	Frame
7	717 433	Roller compl.
8	719 341	Bracket f/alu. fence
9	717 607	Indicator f/fence
10	717 452	Indicator f/roller box
11	717 615	Tension assy.
12	717 548	Handle f/alu.fence
13	717 540	Length stop f/alu.fence compl.
14	717 732	Support trestle compl
15	745 923	End plug f/trestle
16	717 403	Trestle leg
17	717 425	Nut f/leg, support trestle
18	717 535	Nut f/fence & length stop
19	717 453	Roller box
20	717 492	Bearing assembly compl.
21	717 449	Locking, roller box
22	717 627	Sub-carrier
23	717 631	Locking f/sub-carrier
24	717 666	Bearings f/sub-carrier
25	717 434	Locking, infeed table
26	717 454	Guide bar compl.
27	771 708	Measure f/roller box
28	717 458	Angle f/measure
29	717 456	Fixing bracket f/guide bar, left
30	717 455	Fixing bracket f/guide bar, right
31	717 710	Short work support
32	717 711	Roller f/short work support compl.
33	717 478	Bar, upper
34	717 479	Bar, lower
35	717 493	End cap
36	717 228	Flexible tube Ø80mm per m
37	717 690	Rebuilding set
38	717 691	Extension fixed table
39	717 692	Guide bar left side (07-)
140	772 727	Locking clamp M10x30
144	707 328	Push stick
145	745 099	Push stick
146	701 114	Tool f/arbor nut
147	717 555	Spindle tool
148	717 657	Laser



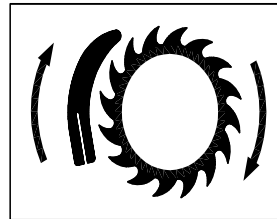
Anvising for heising.
 Direction for lifting
 Anweisung über Hochhebung



Justering av bladbeskytter
 og spaltekniv.
 Adjustment of hood
 and riving knife.
 Anweisung über Einstellung
 von Schutzhaube u. Spaltkeil.



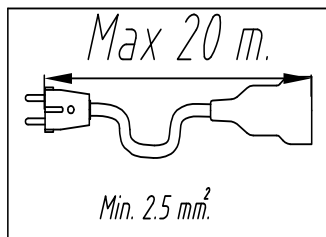
Rotasjonsretning.
 Direction of rotation.
 Anweisung über Drehrichtung.



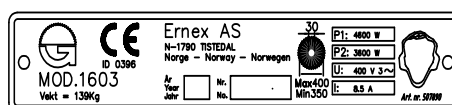
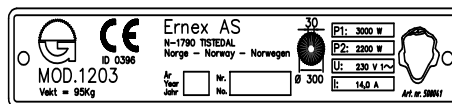
Anvisning for vern.
 Direction for blade cover.
 Anweisung über Sägeblatt Deckel.



Anbefalt tilførselskabel.
 Recommended extension
 of cord dim.
 Empfehlung von Zuleitung
 Dim.



Typeskilt med anvisinger.
 Type plate with info
 Kennzeichen Schild mit
 Anweisung.



Importers:

Sverige/Sweden: **Aspelin Motek AB**
 Fabriksgatan 11, Box 10, SE-63102 Eskilstuna
 Tel: +46 16 200 2000, Fax: +46 16 153029
 E-mail: kundservice@motek.se
www.motek.se

Sverige/Sweden: **Luna Verktyg & Maskin AB**
 Sandbergsvägen 1, SE-441 80 Alingsås
 Tel.: +46 322 606000, Fax: +46 322 606443
 E-mail: luna@luna.se
www.luna.se

Danmark/Denmark: **Junget A/S**
 Sigma 3, Søften, DK-8382 Hinnerup
 Tel: +45 893 65500, Fax: +45 893 65555
 E-mail: junget@junget.dk
www.junget.dk

Finland/Finland: **Oy Mechelin Co. AB**
 Mekaanikonkatu 13, SF-00880 Helsinki
 Tel: +358 9755151, Fax: +358 975515252
 E-mail: myynti@mechelin-company.fi
www.mechelin-company.fi

Island/Iceland: **Björn Gudmundsson & Co.**
 Laugavegi 29, IS-101 Reykjavik
 Tel.: +354 124321, Fax: +354 5624346
 E-mail: brynja@brynja.is
www.brynja.is

Holland/Netherlands: **Gjerde B.V.**
 Mors 9, NL-7151 MX Eibergen
 Tel: +31 545 472855, Fax: +31 545 472865
 E-mail: info@gjerde.nl
www.gjerde.nl

Tyskland/Germany: **Hüllinghorst
 Maschinenhandel GmbH & Co. KG**
 Höfeweg 70, DE-33619 Bielefeld
 Tel: +49 5219110612, Fax: +49 5219110699
 E-mail: jens@huellinghorst.de
www.huellinghorst.de

Tyskland/Germany: **Eumacop eG**
 Johann-Friedrich-Böttger Str. 21,
 DE-63322 Rödermark
 Tel: +49 607489170, Fax: +49 6074891717
 E-mail: info@eumacop.de

Estland/Estonia: **AS Nava**
 Peterburi Tee 56 B, EE-11415 Tallinn
 Tel.: +372 621 1360, Fax: +372 621 1361
 E-mail: info@nava.ee
www.nava.ee

Ungarn/Hungary: **Csiba Kft.**
 Rohonco u., PF. 130, H-9730 Köszeg
 Tel: +36 943 62731, Fax: +36 943 61384
 E-mail: house@csiba.hu
www.csiba.hu

Latvia/Latvia: **MekoTex SIA**
 Pārslas St. 3/5, LV-1002 Riga
 Tel.: +37 17616018, Fax: +37 17616019
 E-mail: uldis@mekotex.lv
www.mekotex.lv

**Ernex AS**

Bjørnstadgt. 7, N-1792 Tistedal, Norway
 Phone +47 69 178330 - Fax: +47 69 178360
 E-mail: ernex@ernex.no - www.ernex.no