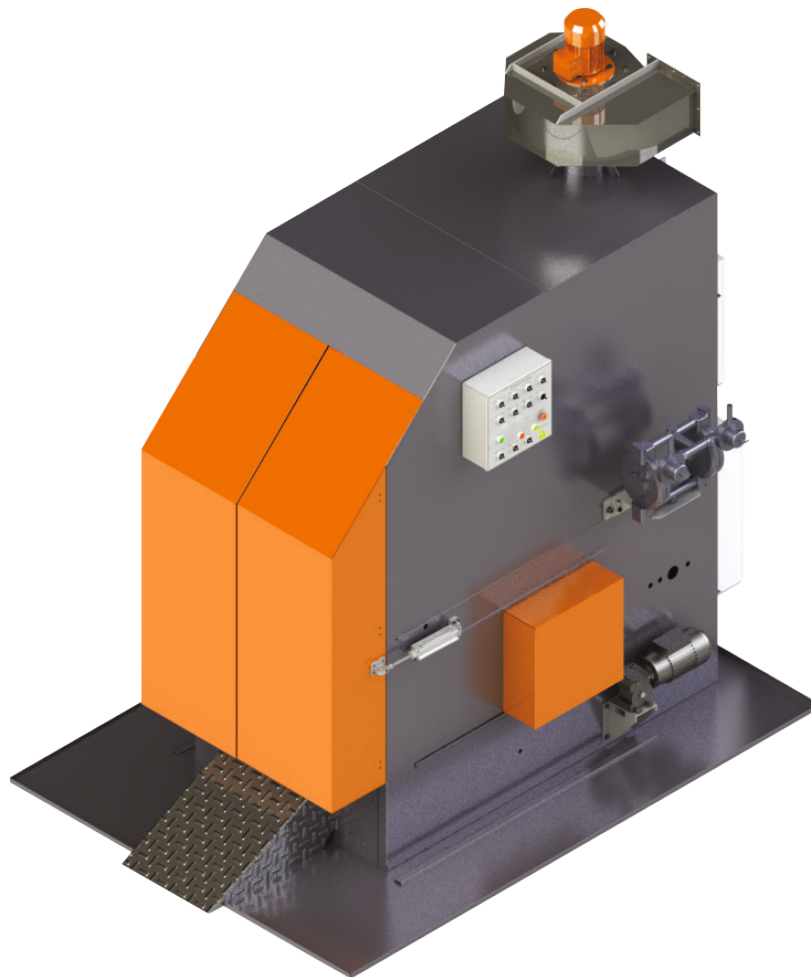




Tyre Painting Station PS 6-3



Instruction Manual

The company reserves the right to change equipment specifications and models without notice. Pictures are representative and may not be part of the standard equipment.

Elgi Rubber Company Limited

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Foreword

The Tyre Painting Station PS 6-3 is designed to give the finished retreaded tyre a Premium / New tyre appearance for the discerning customer. It is suitable for casing diameter from 700 to 1300 mm and section widths from 140 to 470 mm. It has an efficient PLC controlled automatic cycle to paint the tyre sidewall without operator intervention.

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01 Description

The Tyre Painting station PS 6-3 consists of the following major components:

Main Frame

The main frame houses all the main components of the machine such as Rotating assembly, Tyre holding assembly, Spray gun assembly, Tyre ejector assembly etc.

Cabinet

This is an enclosure which covers entire machine. It houses the spray pump, electrical cabinet, blower assembly and pneumatic cabinet.

Tyre Rotating Assembly

The tyre is rotated by rollers, which is driven by 0.5 hp motor kept outside the cabin.

Ramp

A ramp is provided for easy loading and unloading of tyres.

Spray Gun Assembly

A couple of auto spray guns are used in the assembly. It is controlled by PLC for the precise spray function. Paint is supplied by a diaphragm type pressure pump from container.

Tyre Holding Assembly

The tyre holding assembly consist of a roller, in which a profile is made to the curvature of the tyre for perfect holding. Two pneumatic cylinders will pull down the roller and hold the tyre in place. This holding is done to avoid lateral movement of tyre during the painting process.

Electrical and Pneumatic Assembly

Electrical and pneumatic components are kept in a separate enclosure and the enclosure is fitted on the cabinet.

02 Specifications

Model	PS 6-3
Catalogue Number	MA81 63 - X*
Tyre Range	6.50 - 14 to 12.00 - 24.5
Air Pressure Requirement (kPa / kg/cm ²)	800 / 8
Dimensions (L x W x H) (mm)	2415 x 1400 x 2350
X* in Cat. No. denotes power supply specifications (V / Hz / ph)	R - 220 / 60 / 3 O - 380 / 50 / 3 S - 380 / 60 / 3 P - 415 / 50 / 3 U - 440 / 60 / 3
Weight (kg)	~450
Installation	To be fixed to the floor

03 Assembly and Commissioning Tools

Accessories

Standard	Installation kit
----------	------------------

Tools

Spanners	
Double end 10 - 22	1 Set
Ring end 16 - 19	1 Set
Box bit 24" with extrn. rod	1 No.
Screw driver - 6" & 8"	1 No. each
Line tester	1 No.
Allen keys (mm)	1 Set
Combination plier - 8", 10"	1 No. each
Nylon hammer	1 No.
Circlip plier - 6" (internal and external)	1 No. each
Ball peen hammer (500 g)	1 No.

Materials

Lubricating oil (SAE 20)	¼ L
Multi-purpose grease	¼ kg
Electric cable 4 core, 1.5 sq.mm	Length as per installed position

04 Installation and Commissioning

Unloading

Unload the machine only by using eye bolt / forklift option given in the machine. Remove the machine bed bolt and take it out of the wooden pallet.

Positioning

The machine does not need a foundation. It is sufficient if it is fixed to the ground. Position the machine in the desired location on a level surface. The area where the machine is located should be well illuminated.

Electrical and Pneumatic Connection

Connect the machine with the help of 2.5 sq.mm copper 4 core cable. From the nearest air point, draw a line using PU14 Pneumatic hose with quick connection fittings.

Air Pressure Setting

Ensure the air pressure in the regulator:

- (R1) is 7 kg/cm²
- (R2) is 2 kg/cm²
- (R3) is 4 kg/cm²
- (R4) is 2 kg/cm²

05 Pre-Operation Checks

- Remove the shipment clamps that are provided below the table, which are marked and painted red / orange (refer to included drawing).
- Check for free movement of all moving parts.
- Check if all nuts and bolts are properly tightened.
- Check if the spray gun point nozzles are facing the tyre.
- Check if the roller is seated in place.
- Check and ensure no twists, or crush in air line.
- Check and ensure that the foot switch cable is not crushed.
- Check and ensure that the paint hoses are not crushed.
- Check for any earth (electrical grounding) leakage.
- Check for any air leakage on the pneumatic lines.

06 Operation

1. Open the slide valve of pneumatic panel.
2. Check the air pressure in the gauge. It should be 8 kg/cm² for the main inlet gauge.
3. Switch ON the main switch of the electrical control panel.
4. Open the door by operating the switch on the operating panel.
5. Roll the tyre over ramp and position it in between the rollers.
6. Choose the category of the tyre as LCV/TRUCK on the operating panel.
7. Set the MODE to AUTO.
Note: Manual mode is given only for trouble shooting and maintenance.
8. Close the door.
9. Press cycle start button on the operating panel. The machine will initiate the task and the tower lamp will glow in green.
10. After completion of the cycle, the machine will stop and this will be indicated by a red colour tower lamp.
11. Remove the tyre by pressing foot switch and unload it.
12. Cleaning cycle: Once the painting is completed (per shift or per day), take out the suction hose from paint container and dip it into a container filled with fresh water. Press the cycle start button and operate the machine with water to clean the nozzle and hoses. Repeat the cycle once more. Finally leave the suction hose in water until production starts for the next day.
Note: Do not use any solvents or detergents for cleaning the nozzle.
13. Take out the paint over-flow container and empty it at regular intervals.

Note: In case of any malfunction, hit the emergency button on the operating panel and call for service technician.

07 Do's and Don'ts

Do's

- Place the machine in an open space where there is ample light and ventilation.
- Ensure that there is no leakage in the pneumatic valve and cylinder.
- Ensure correct pressure for cylinder as recommended are maintained.
- Ensure the cleaning cycle is performed, when machine is stopped over an hour.
- Ensure paint container is filled with water based paint.
- Use only the ramp to load tyres on the machine.
- Lubricate the chains weekly.
- Use only the eye bolts to lift the machine.

Don'ts

- Do not operate the machine until the shipment locks are removed.
- Do not place hand between doors while closing.

08 Troubleshooting

Symptoms / Problems	Possible Causes	Remedies
Machine does not run when switched on	<ol style="list-style-type: none"> 1. Incoming supply failure 2. Improper panel board connection 3. Failure of fuse 4. Emergency switch in locked position 	<ol style="list-style-type: none"> 1. Check incoming supply 2. Check and correct wiring as per circuit diagram 3. Check and replace fuse 4. Release emergency switch
Motor runs on continuous pressing of switch and stops when is released	<ol style="list-style-type: none"> 1. Contactor connection loose 2. Push button contact lock connection loose 3. Push button contact lock failure 	<ol style="list-style-type: none"> 1. Clean contactor terminals and tighten connections 2. Check and rectify 3. Replace contact block
Motor stops while running	<ol style="list-style-type: none"> 1. Motor over loaded 2. Wrong amperage setting 	<ol style="list-style-type: none"> 1. Check whether over loaded and correct 2. Reset relay amperage correctly and increase if needed within allowable limit
Tyre rotation speed decrease while painting	<ol style="list-style-type: none"> 1. Chain loose 2. Low voltage 	<ol style="list-style-type: none"> 1. Check chain tension - correct or replace 2. Check and correct
Spray gun is not working	<ol style="list-style-type: none"> 1. Check the paint availability 2. Check the pneumatic pressure of cap, piston and pump 3. Check the nozzle for any blockage 	<ol style="list-style-type: none"> 1. Refill the paint 2. Fix it as recommended 3. Perform cleaning cycle or manual clean the nozzle



Symptoms / Problems	Possible Causes	Remedies
Paint is over / under sprayed	<ol style="list-style-type: none"> 1. Check the tyre category selection on the operating panel 2. Check the nozzle adjustment 3. Check for any blockage in nozzle 	<ol style="list-style-type: none"> 1. Choose proper category as Truck or LCV 2. Adjust the spray gun knob for coverage 3. Perform cleaning cycle or manual clean the nozzle
Tyre is squeezed when painting cycle is in process	<ol style="list-style-type: none"> 1. Over pressure in cylinder 2. Tyre holding assembly proximity sensor failure 3. Sensor clamp or stopper plate dislocation 4. Nylon roller damaged or bearing failure 	<ol style="list-style-type: none"> 1. Set the appropriate pressure 2. Check and change the sensor 3. Locate the sensor to right position and fasten the bolts 4. Check and replace rollers / bearings
Foot switch pressed but tyre not ejecting	<ol style="list-style-type: none"> 1. Electrical line disconnection 2. Ejector cylinder pressure is not sufficient 3. Ejector cylinder seal damaged 4. Solenoid valve seal damaged 	<ol style="list-style-type: none"> 1. Check and connect 2. Check and set air pressure as mentioned in page 7 3. Check and replace the seal kit 4. Check and replace the seal kit

09 Preventive Maintenance

Name of the Post	Final Paint Station
Name of the Equipment	Tyre Painting Station
Model No.	PS 6-3

S. No.	Activity	Frequency	Acceptance Criteria
1	Clean the machine	Daily	Dust free
2	Clean the paint spray nozzles	When machine is stopped more than a hour	No water in the filter unit
3	Check air pressure is 8 kg/cm ²	Daily	Pressure in between - 8 ± 0.5 kg/cm ²
4	Check air line and fitting for any leakage	Daily	No leakage
5	Check the paint collection tray and clean it	Daily	No damage / wear / tear
6	Grease the chain and bearings	Monthly	Smooth movement of rollers
7	Clean the pneumatic cylinders and guide shafts, if any paint is deposited	Daily	Smooth movement of hold rollers

10 Electrical Drawings

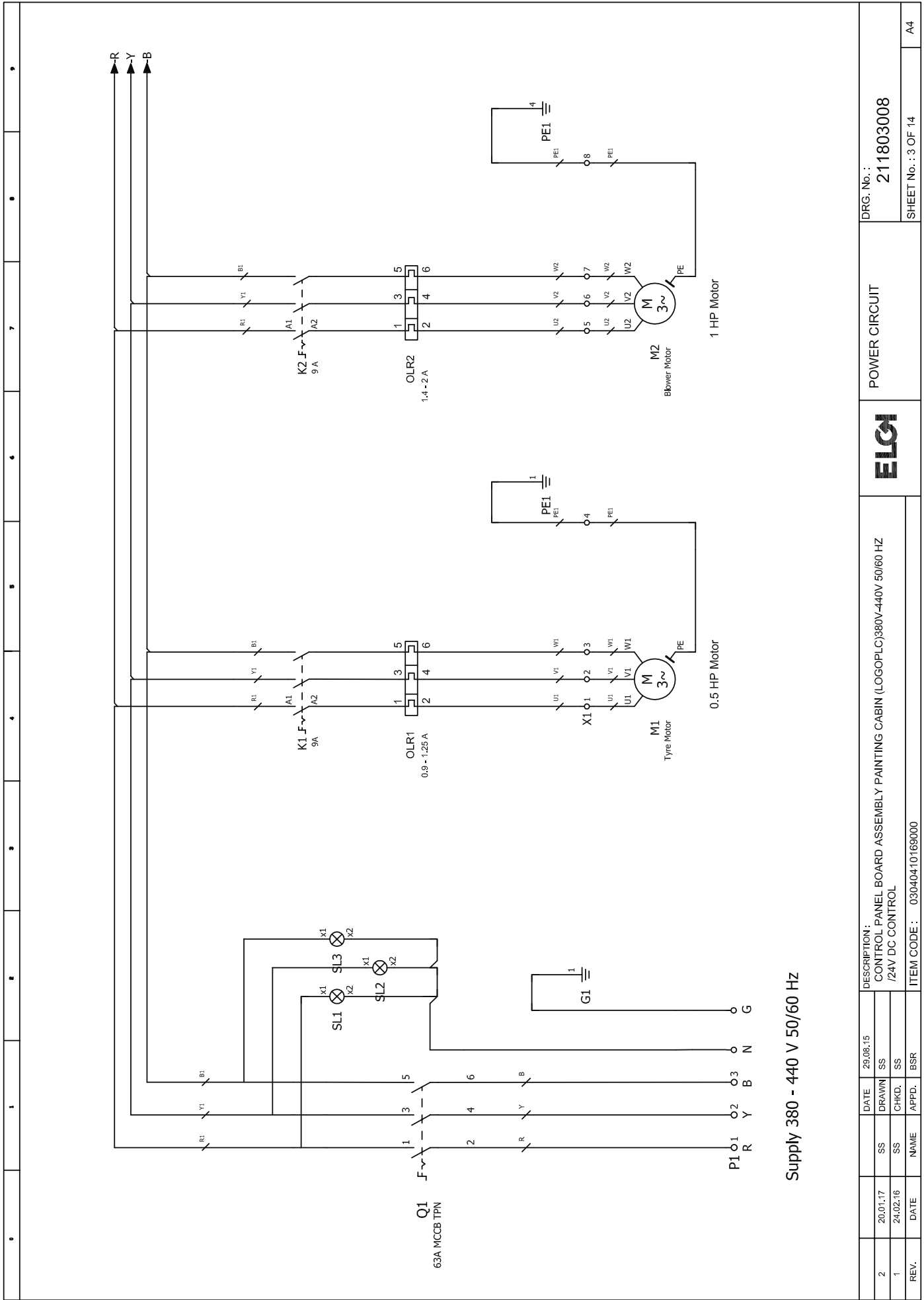
		Elgi Rubber Company Limited 641005 Coimbatore Phone. 9894510000							
TYRE PAINTING CABIN - 380-440 V / 50-60 HZ - 24V DC Control 211803008 Elgi									
Company / customer Project description Drawing number Commission		03040410169000 CONTROL PANEL BOARD ASSEMBLY PAINTING CABIN (LOGOPLC)380V-440V 50/60 HZ /24V DC CONTROL 03040410170000 CONTROL SWITCH BOARD ASSEMBLY PAINTING CABIN /24V DC CONTROL							
Created on Edit date		29.08.15 Number of pages 14							
									
TITLE PAGE		DRG. No. : 211803008 SHEET No. : 1 OF 14							
DESCRIPTION : CONTROL PANEL BOARD ASSEMBLY PAINTING CABIN (LOGOPLC)380V-440V 50/60 HZ /24V DC CONTROL ITEM CODE : 03040410169000									
REV.	DATE	NAME	APPD.	BSR	DATE	29.08.15	SS	DRAWN	SS
1	24.02.16	SS	SS	CHKD.	SS	SS	SS	SS	SS
2	20.01.17	SS	SS	CHKD.	SS	SS	SS	SS	SS
A4									

TECHNICAL INFORMATION

ALL DIEMENSIONS ARE IN MM DOORS ARE ONLY AT FRONT SIDE CONTROL PANEL CONSTRUCTION		PAINT SHADE : PEBBEL GRAY 415V AC 24V DC 1 SQMM BLUE
PANEL MAKE PART NO HEIGHT WIDTH DEPTH DOOR		INSIDE SIDE SURFACE INCOMING SUPPLY CONTROL VOLTAGE CONTROL CABLES EARTHING TO BE PROVIDED AS PER STANDARD SHROUDING TO BE PROVIDED AS PER STANDARD
RITTAL AE 1090500 500 500 210 SINGLE DOOR		
OPERATING BOX CONSTRUCTION		
PANEL MAKE PART NO HEIGHT WIDTH DEPTH DOOR		
RITTAL AE 1555500 300 300 120 SINGLE DOOR		

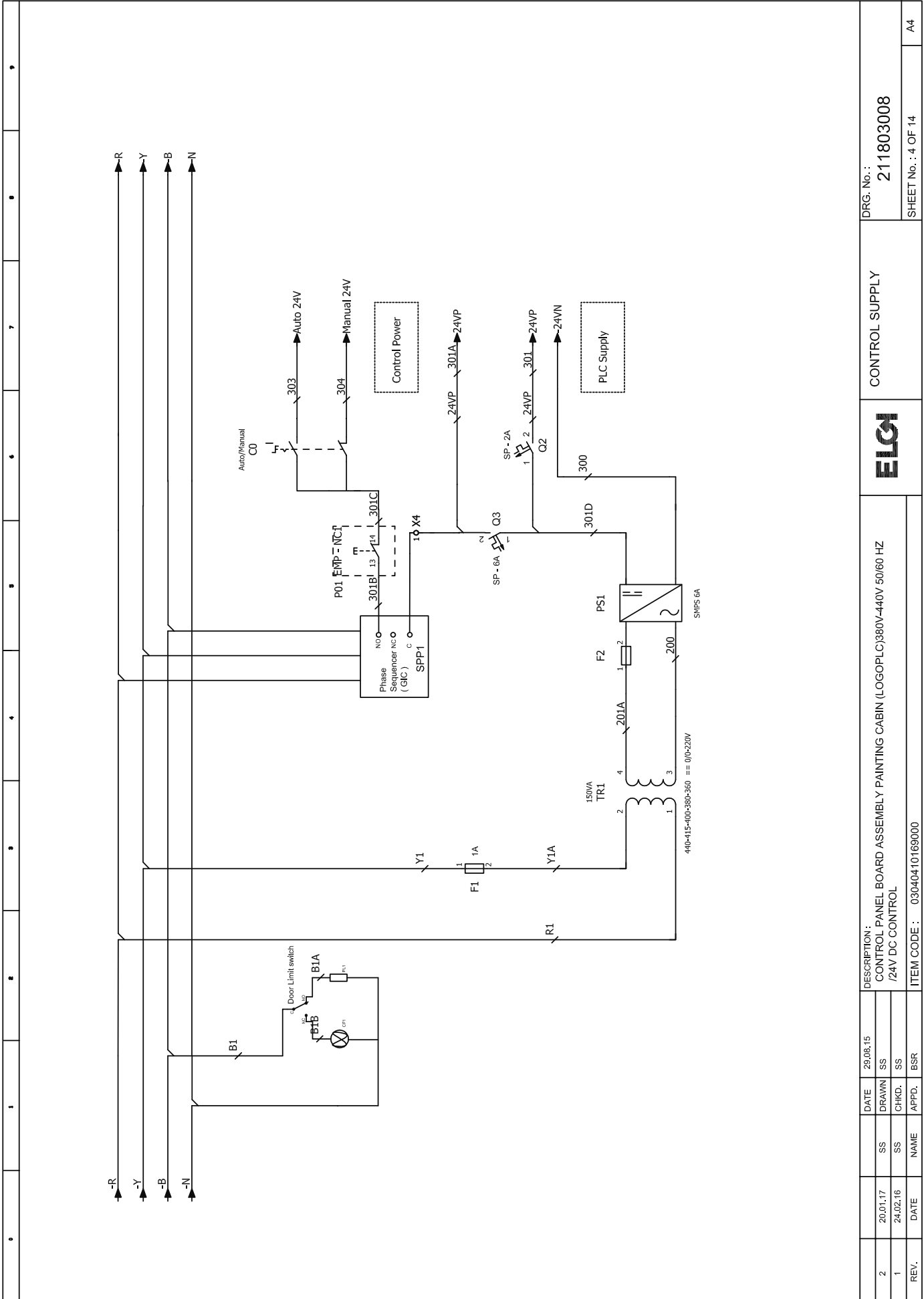
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1	24.02.16	SS	CHKD.	SS	APPD.	SS	CONTROL PANEL BOARD ASSEMBLY PAINTING CABIN (LOGOPLC)380V-440V 50/60 HZ /24V DC CONTROL	DESIGN INSTRUCTION		
REV.	DATE	NAME	APPD.	BSR	ITEM CODE: 03040410169000				SHEET No. : 2 OF 14	A4



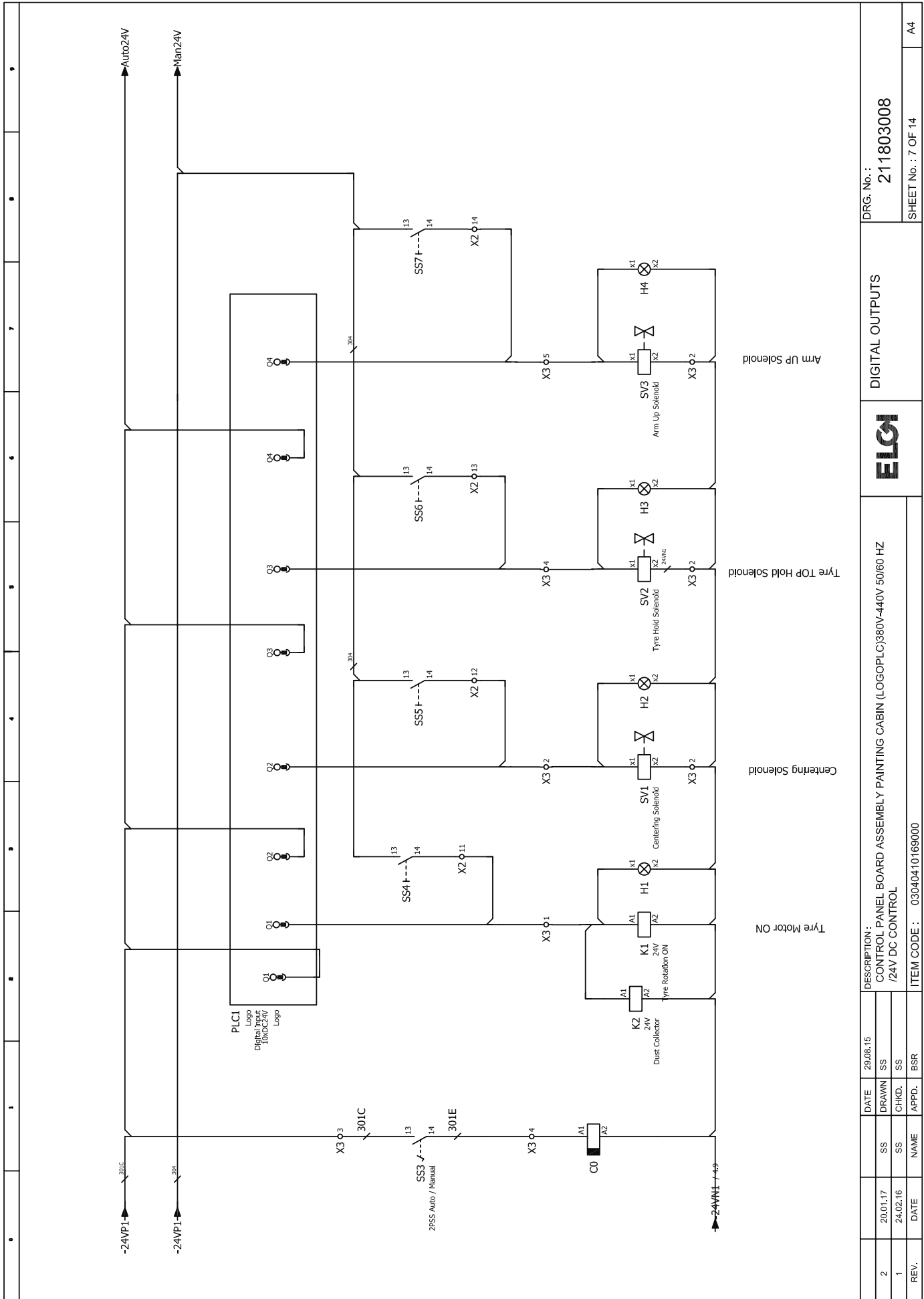


Supply 380 - 440 V 50/60 Hz

REV.		DATE	NAME	APPD.	BSR	ITEM CODE : 03040410169000	
2	20.01.17	SS	DRAWN	SS		DESCRIPTION : CONTROL PANEL BOARD ASSEMBLY PAINTING CABIN (LOGOPLC)380V-440V 50/60 HZ /24V DC CONTROL	
1	24.02.16	SS	CHKD.	SS		ELGI	
						POWER CIRCUIT	
						DRG. No. : 211803008	
						SHEET No. : 3 OF 14	
						A4	



2	20.01.17	SS	DATE	29.08.15	DESCRIPTION :	CONTROL PANEL BOARD ASSEMBLY PAINTING CABIN (LOGO PLC) 380V-440V 50/60 HZ /24V DC CONTROL	DRG. No. :	211803008
1	24.02.16	SS	DRAWN	SS				
REV.	DATE	NAME	CHKD.	APPD.	BSR	ITEM CODE :	03040410169000	SHEET No. : 4 OF 14
CONTROL SUPPLY								A4
ELGI								



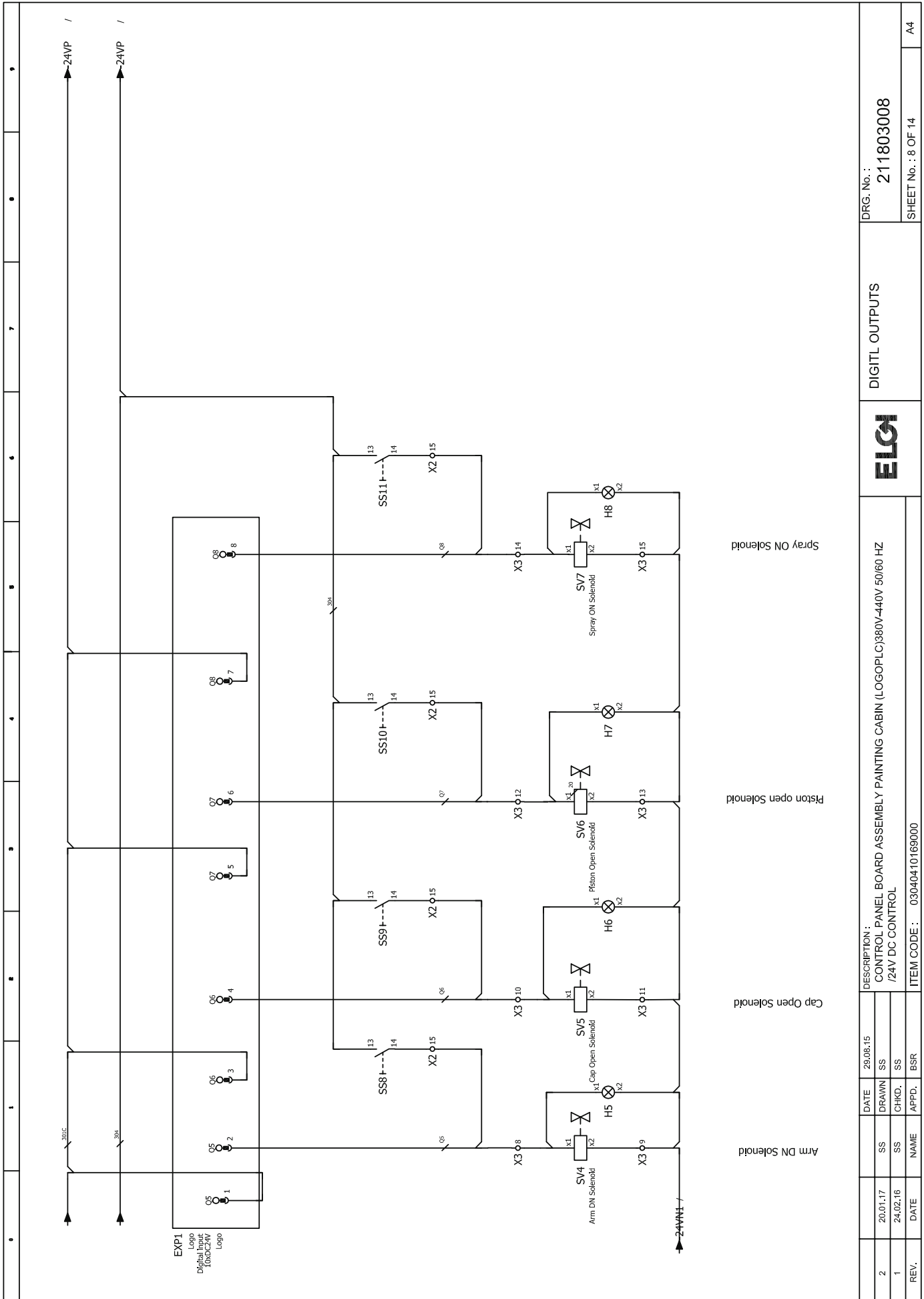
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SHEET No.: 7 OF 14
A4

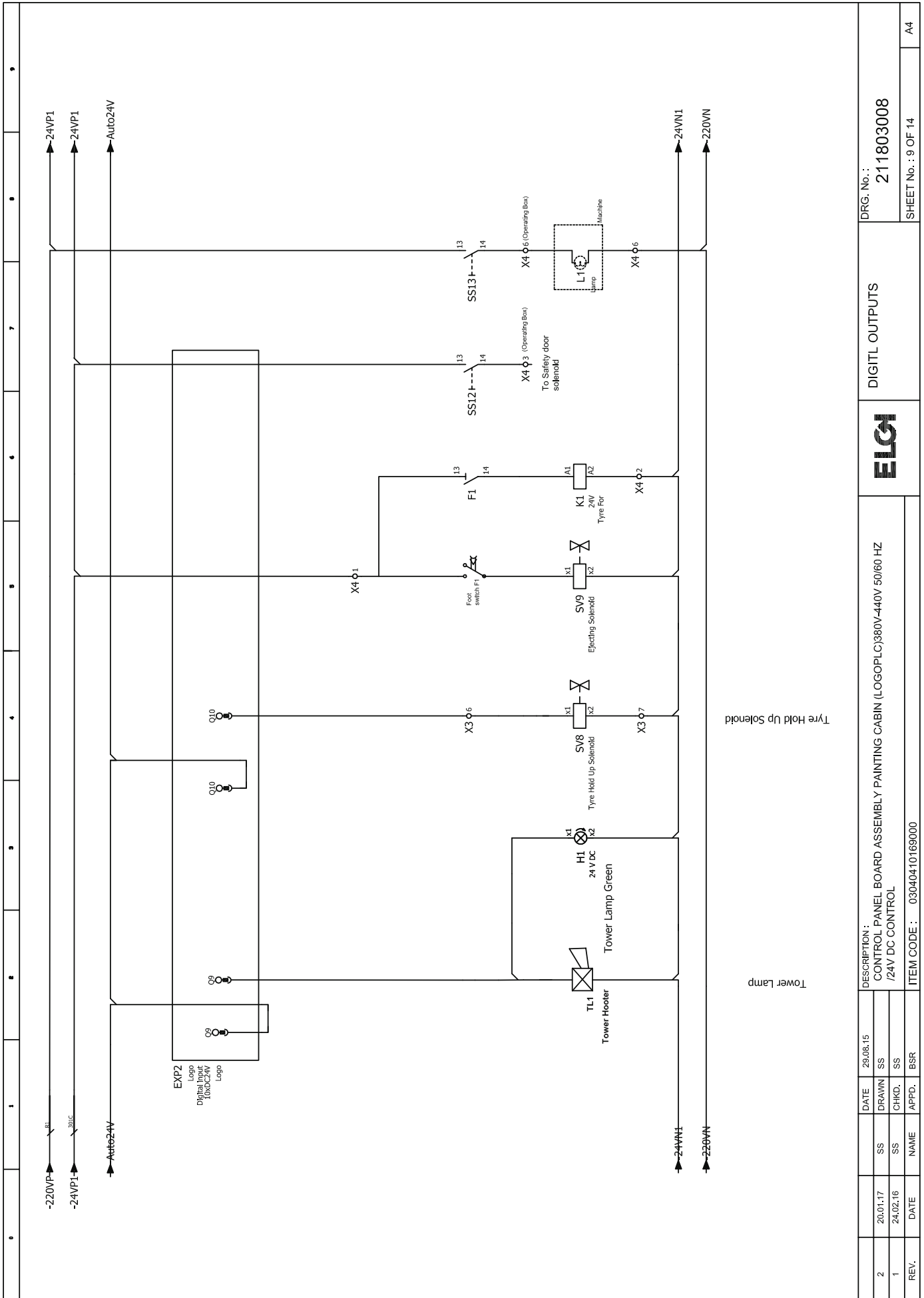
DIGITAL OUTPUTS



DESCRIPTION: CONTROL PANEL BOARD ASSEMBLY PAINTING CABIN (LOGOPLC)380V-440V 50/60 HZ /24V DC CONTROL
ITEM CODE: 03040410169000

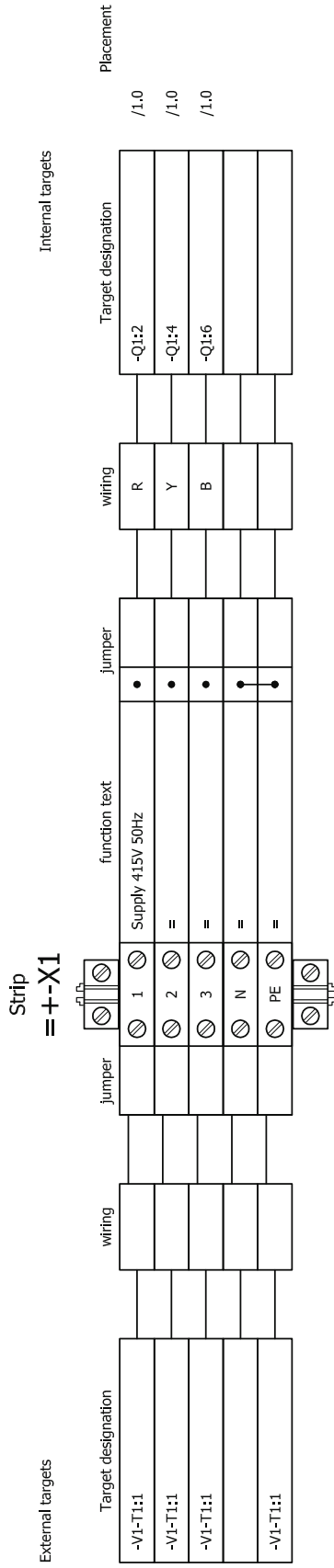
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2	20.01.17	SS	DRAWN	SS
1	24.02.16	SS	CHKD.	SS





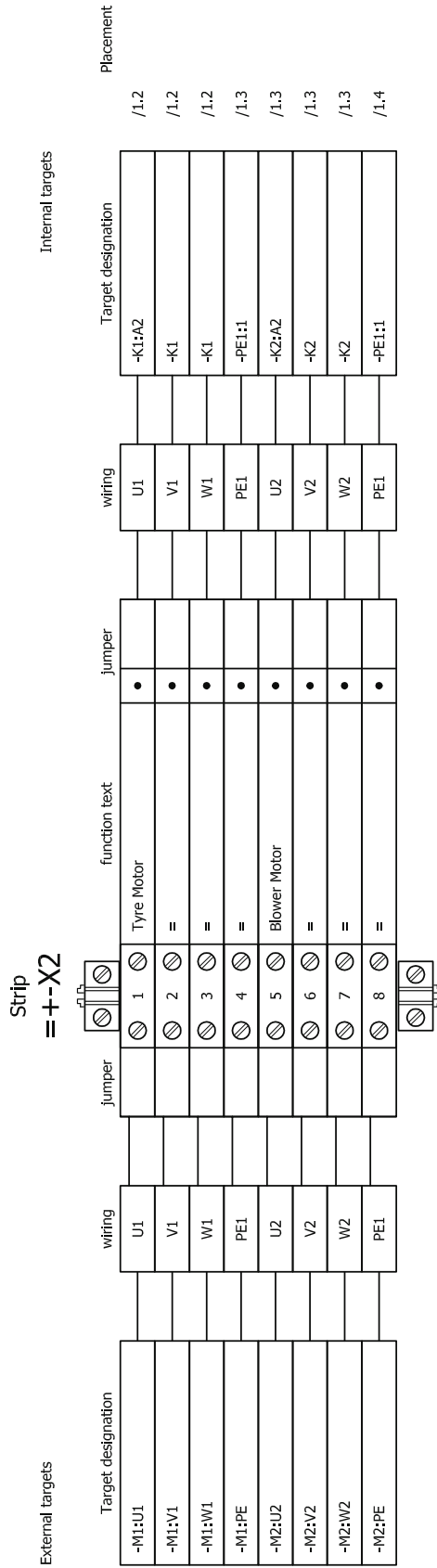
2	20.01.17	SS	DATE	29.08.15	DATE	29.08.15	DRG. No. :	211803008
1	24.02.16	SS	CHKD.	SS	SS	SS	DIGITL OUTPUTS	
REV.	DATE	NAME	APPD.	BSR	DESCRIPTION : CONTROL PANEL BOARD ASSEMBLY PAINTING CABIN (LOGOPLC)380V-440V 50/60 HZ /24V DC CONTROL			
					ITEM CODE : 03040410169000			
					SHEET No. : 9 OF 14			
					A4			

Terminal diagram



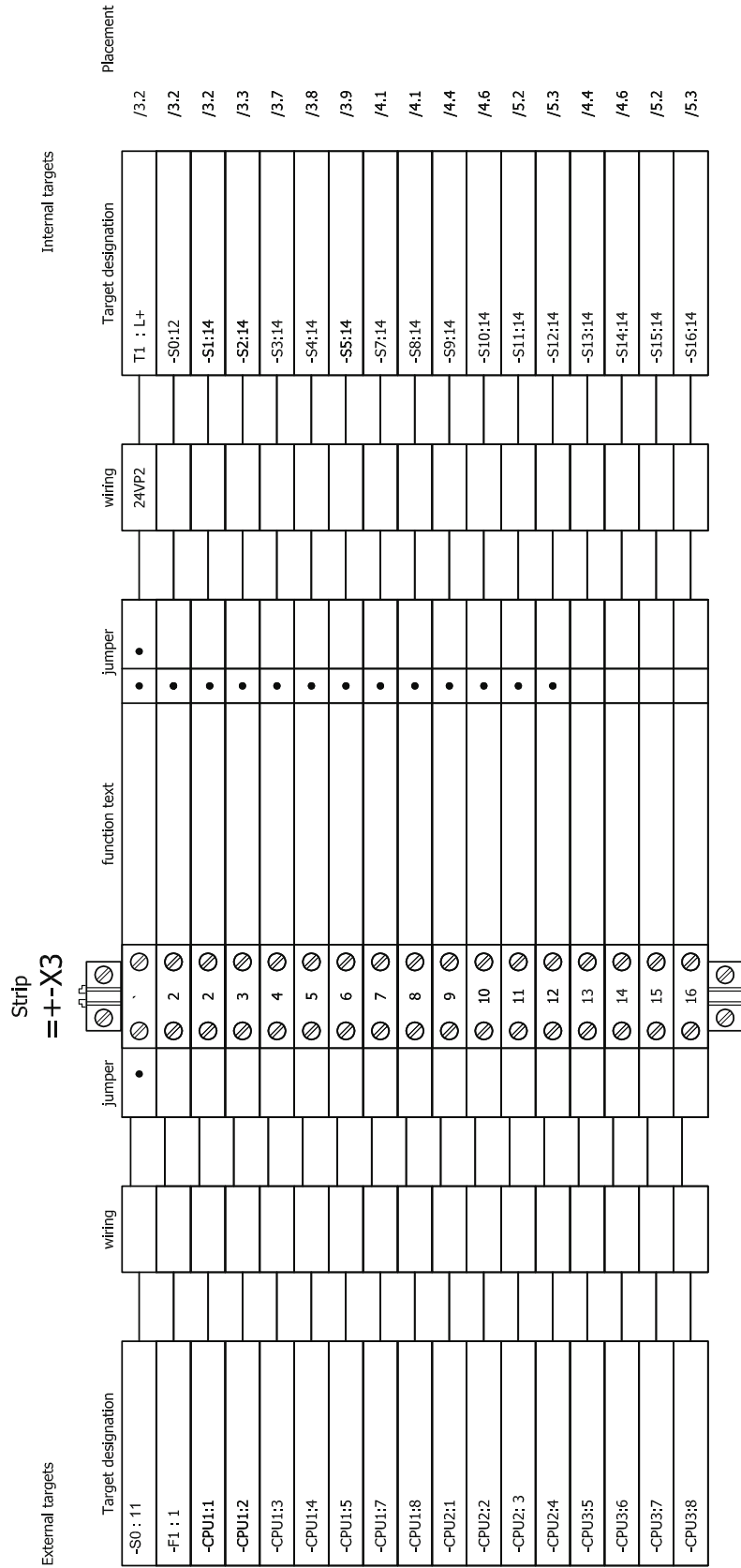
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DRAWN	SS	CHKD.	SS	SUPPLY TERMINALS	
1	29.03.16	NAME	BSR	ELGI	
REV.	DATE	APPD.	BSR	ITEM CODE :	03040410169000
				SHEET No. :	10 OF 14
				A4	

Terminal diagram



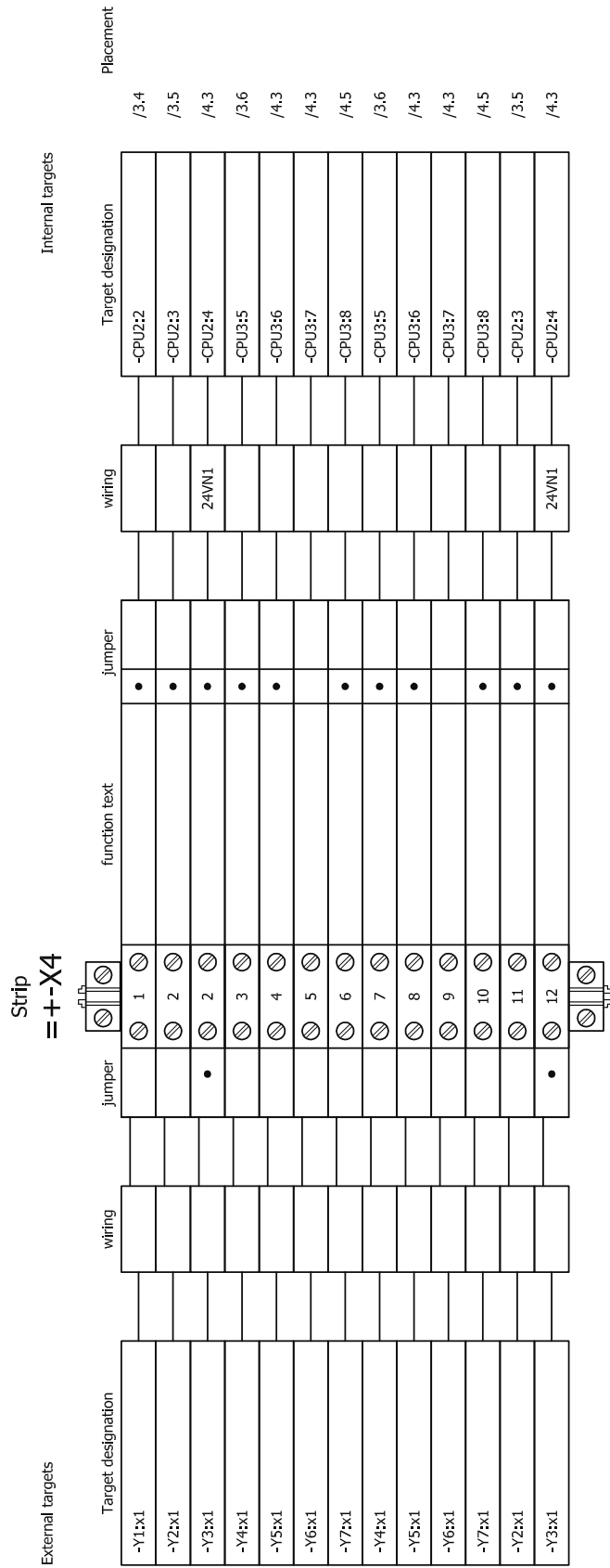
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1	24.02.16	SS	/24V DC CONTROL	SHEET No. : 11 OF 14
REV.	DATE	NAME	APPD.	BSR
			ITEM CODE : 03040410169000	A4
			ELGI	TERMINAL DIAGRAM =+-X1

Terminal diagram



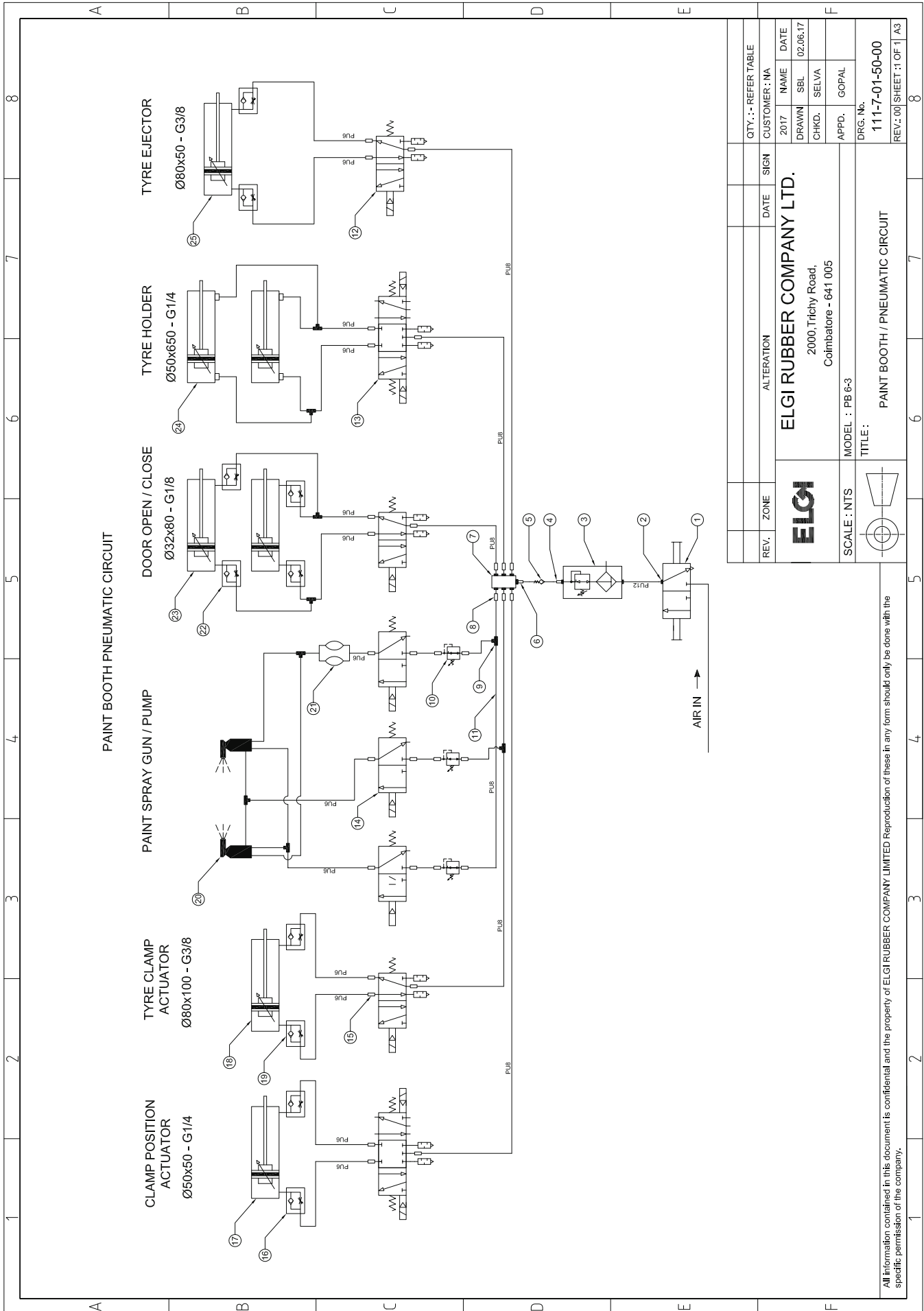
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1	24.02.16	SS	DRAWN	SS	CHKD.	SS	TERMINAL DIAGRAM=+-X2	
REV.	DATE	NAME	APPD.	BSR	ITEM CODE :	03040410169000	SHEET No. : 12 OF 14	A4
					DESCRIPTION :		ELGI	
					CONTROL PANEL BOARD ASSEMBLY PAINTING CABIN (LOGOPLC)380V-440V 50/60 HZ			
					/24V DC CONTROL			

Terminal diagram



2	20.01.17	SS	DATE	29.08.15	DATE	29.08.15	DRG. No. :	211803008
1	24.02.16	SS	DRAWN	SS	CHKD.	SS	TERMINAL DIOGRAM=+-X3	
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			/24V DC CONTROL			ELGI		

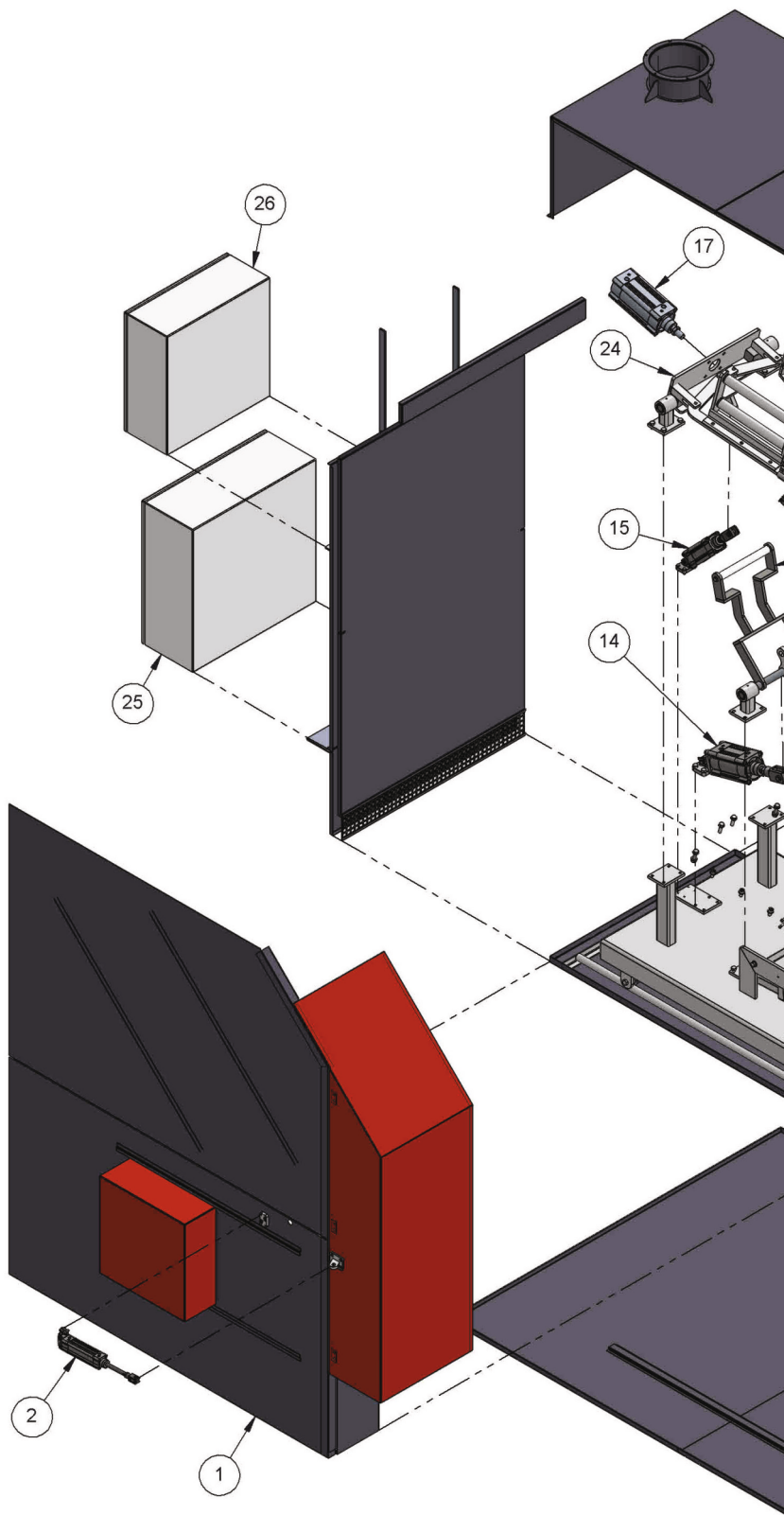
11 Pneumatic Circuit

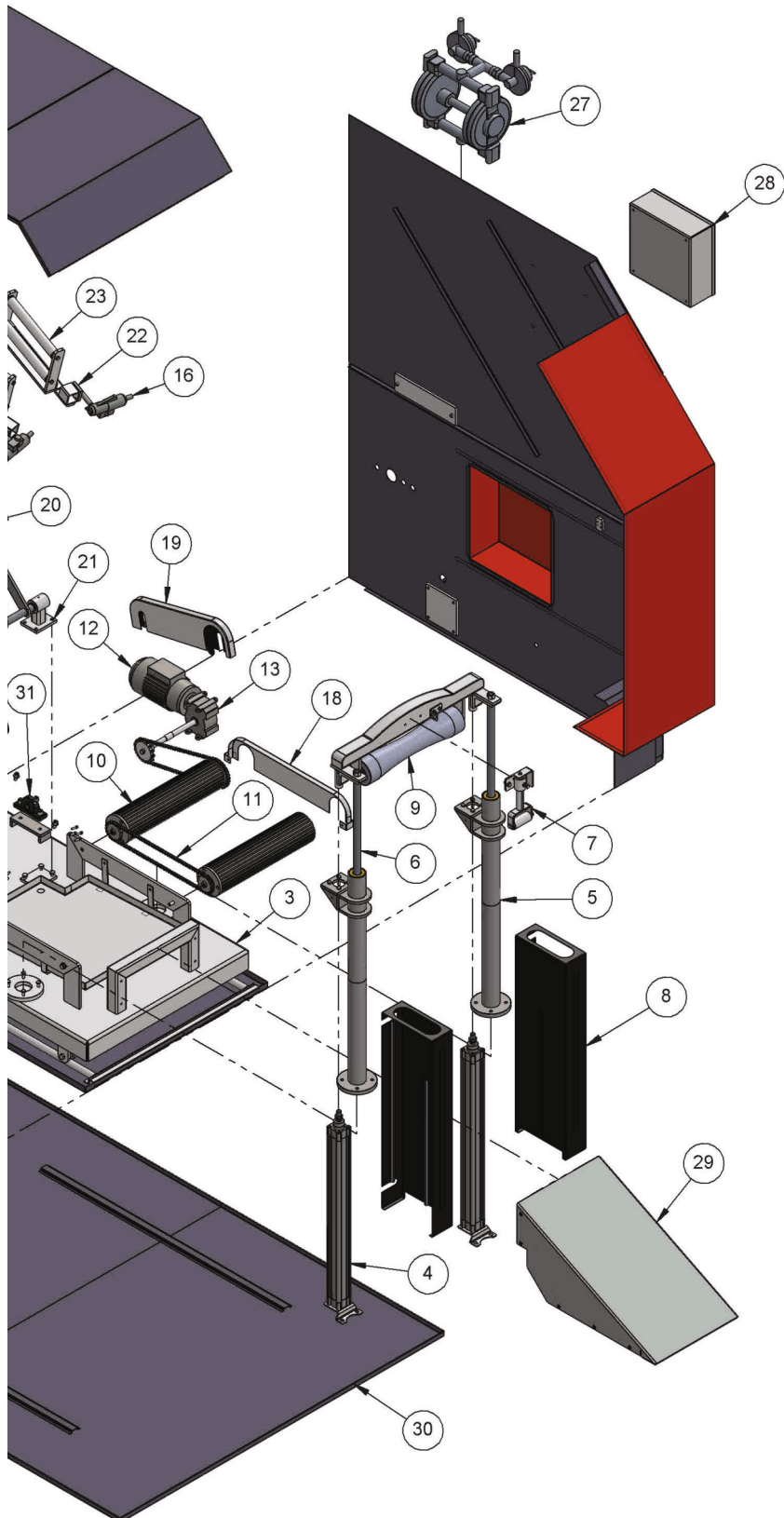


Pneumatic Circuit - BOM

S. No.	Description	UOM	Qty.
1	HAND SLIDE VALVE 1/2" / P.NO:2342 / FESTO	Nos	1
2	SWIVEL ELBOW 1/2" x PU14 / FESTO	Nos	2
3	FILTER CUM REGULATOR 1/2" / P.NO:159584 / FESTO	Nos	1
4	REDUCER NIPPLE 1/2" x 1/2"	Nos	1
5	NON RETURN VALVE - 1/2" / P.NO: GV163 / JANATICS	Nos	1
6	REDUCER NIPPLE 1/2" x 3/8"	Nos	1
7	JUNCTION BOX-3/8" x 1/4" P.NO:WJ03066261 / JANATICS	Nos	1
8	SWIVEL ELBOW 1/4" x PUB	Nos	20
9	UNION TEE PUB / P .NO :WP2300808 / JANA TICS	Nos	2
10	REGULATOR LR 1/4-D MINI-P.NO:159 625 / FESTO	Nos	3
11	POL YURETHENE TUBING PUN-8 / FESTO	Mtr	-
12	SOLENOID VALVE 5/2 /P.NO:DS255SR61 / JANATICS	Nos	3
13	SOLENOID VALVE 5/3 / P.NO:DS285SC61/JANATICS	Nos	2
14	SOLENOID VALVE 3/2 /P.NO:DS245SR61/JANATICS	Nos	3
15	SWIVEL ELBOW 1/4" x PU6 / P.NO:153047 / FESTO	Nos	17
16	FLOW CONTROL VALVE -1/4" x PU6	Nos	2
17	PNEUMATIC CYLINDER DSBC 50 50 PPVA-N3 / P.NO:1366950	Nos	1
18	PNEUMATIC CYLINDER DSBC 80 100 PPVA-N3 / P.NO:1383337	Nos	1
19	FLOW CONTROL VALVE -3/8" x PU6	Nos	4
20	PNEUMATIC PILOT SPRAY GUN	Nos	2
21	PAINT PUMP/DIAPHRAGM TYPE/MODEL: DPSM - 904E/ANEST IWATA	Nos	1
22	FLOW CONTROL VALVE - 1/8" x PU6 / P.NO:GR1105006/JANATICS	Nos	2
23	PNEUMATIC CYLINDER DSBC 32 80 PPVA-N3 / P.NO:1376425	Nos	1
24	PNEUMATIC CYLINDER DSBG - 50 - 650 PPVA- N3/P.NO:1646708/FESTO	Nos	1
25	PNEUMATIC CYLINDER DSBC 80 50 PPVA-N3 / P.NO:1383335	Nos	1

12 Parts List





Parts List - BOM

S. No.	Order Code	Description	UOM	Qty
1	MA8163/1	CABINET ASSEMBLY FOR PAINT BOOTH	NOS	1
2	MA8163/2	PNEUMATIC CYLINDER - FESTO P.NO-1376425_DSBC_32_80_PPVA_N3	NOS	2
3	MA8163/3	BASE FRAME ASSEMBLY - PAINTBOOTH	NOS	1
4	MA8163/4	PNEUMATIC CYLINDER DSBC-50-650-PPVA-N3/ FESTO P.No.1463766	NOS	2
5	MA8163/5	GUIDE POST ASSEMBLY - PAINT BOOTH	NOS	2
6	MA8163/6	GUIDE SHAFT - PAINT BOOTH	NOS	2
7	MA8163/7	POSITION ROLLER ASSEMBLY	NOS	1
8	MA8163/8	CYLINDER COVER	NOS	2
9	MA8163/9	TOP ROLLER ASSEMBLY	NOS	1
10	MA8163/10	DRIVE ROLLER - IS5	NOS	2
11	MA8163/11	INDUSTRIAL CHAIN 1/2" x 5/16" - ROLLON	NOS	1
12	MA8163/12	MOTOR	NOS	1
13	MA8163/13	GEAR BOX	NOS	1
14	MA8163/14	PNEUMATIC CYLINDER DSBC_80_50_PPVA_N3/FESTO P.No.1383335	NOS	1
15	MA8163/15	PNEUMATIC CYLINDER DSBC-50-50-PPVA-N3/FESTO P.No. 1366950	NOS	1
16	MA8163/16	NOZZLE	NOS	2
17	MA8163/17	PNEUMATIC CYLINDER - FESTO 1383337 DSBC-80-100-PPVA-N3	NOS	1
18	MA8163/18	DRIVEN CHAIN GUARD	NOS	1
19	MA8163/19	DRIVE CHAIN GUARD	NOS	1
20	MA8163/20	EJECTING ARM ASSEMBLY	NOS	1
21	MA8163/21	BEARING SUPPORT BLOCK	NOS	4
22	MA8163/22	NOZZLE MOUNTING BRACKET	NOS	2
23	MA8163/23	SUPPORT ROLLER ASSEMBLY	NOS	2
24	MA8163/24	SWIVEL PLATE ASSEMBLY	NOS	1
25	MA8163/25	PNEUMATIC PANEL BOX ASSY	NOS	1
26	MA8163/26	ELECTRICAL PANEL BOX ASSY	NOS	1
27	MA8163/27	PAINT BOOTH PUMP ASSY	NOS	1
28	MA8163/28	OPERATING PANEL BOX ASSY	NOS	1
29	MA8163/29	RAMP PAINT BOOTH	NOS	1
30	MA8163/30	SS. TRAY - PB1	NOS	1
31	MA8163/31	BEARING PILLOW BLOCK UCP204D1 / NTN	NOS	1

13 Essential Spares List

S. No.	Order Code	Description	UOM	Qty
1	MA8163/ES/1	Seal Kit for Pneumatic Cylinder DSBC-50-50-PPVA-N3 / Festo	Nos	1
2	MA8163/ES/2	Seal Kit for Pneumatic Cylinder DSBC-80-100-PPVA-N3 / Festo	Nos	1
3	MA8163/ES/3	Seal Kit for Pneumatic Cylinder DSBC-32-80-PPV-A / Festo	Nos	2
4	MA8163/ES/4	Seal Kit for Pneumatic Cylinder DSBG -50-650-PPVA -N3 / Festo	Nos	2
5	MA8163/ES/5	Seal Kit for Pneumatic Cylinder DSBC -80-50-PPVA -N3 / Festo	Nos	1
6	MA8163/ES/6	Seal Kit for Solenoid Operated Valve 5/3 x 1/4" / Janatics	Nos	2
7	MA8163/ES/7	Seal Kit for Solenoid Operated Valve 5/2 x 1/4" / Janatics	Nos	3
8	MA8163/ES/8	Seal Kit for Solenoid Operated Valve 3/2 x 1/4" / Janatics	Nos	3
9	MA8163/ES/9	PLC Logo 12/24RC 8DI/4DO With Display 6ED1052-1MD00-0BA8 / Siemens - PLC1	Nos	1
10	MA8163/ES/10	Expansion Module DM8 12/24R 4DI/4DO 6ED1055-1MB00-0BA2 / Siemens - EXP1	Nos	1
11	MA8163/ES/11	Power Supply 2.5 A 6EP13321LA00 / Siemens - PS1	Nos	1
12	MA8163/ES/12	MCCB 63A 3VT1706-2DA36-0AA0 / Siemens - Q1	Nos	1
13	MA8163/ES/13	MCB 6A SP 5SL61067RC / Siemens - Q3	Nos	1
14	MA8163/ES/14	MCB 2A SP 5SL41027RC / Siemens - Q2	Nos	1
15	MA8163/ES/15	Power Contactor 9A 3RT2016-1BB41 / Siemens - K1, K2	Nos	1
16	MA8163/ES/16	Control Contactor 10A 3RH2122-1BB40 / Siemens - CO	Nos	1
17	MA8163/ES/17	OLR(0.9-1.25A) 3RU2116-0KB0 / Siemens - OLR1	Nos	1
18	MA8163/ES/18	Indication Lamp Red 220V AC 3SB5285-6HC03 / Siemens - SL1	Nos	1
19	MA8163/ES/19	Indication Lamp Yellow 220V AC 3SB5285-6HD03 / Siemens - SL2	Nos	1
20	MA8163/ES/20	Indication Lamp Blue 220V AC 3SB5285-6HF03 / Siemens - SL3	Nos	1
21	MA8163/ES/21	Transformer 150VA,415V/220V / Procon - TR1	Nos	1
22	MA8163/ES/22	Single Phase Preventor SM301 L&T - GIC - SPP1	Nos	1
23	MA8163/ES/23	Tower Lamp(Green) With Buzzer 24VDC / Ideal - TL1	Nos	1
24	MA8163/ES/24	Fuse Terminal With Glass Fuse / Connectwell - F1, F2	Nos	2
25	MA8163/ES/25	Emergency Stop + NC 3SB5203-0UC01 / Siemens - EMP	Nos	1
26	MA8163/ES/26	3 Position Selector Switch 3SB5000-2DB01/ Siemens - 3PSS1	Nos	1
27	MA8163/ES/27	2 Position Selector Switch 3SB5000-2AB01 / Siemens - SS1	Nos	1
28	MA8163/ES/28	Push Button Green 3SB50 00-0AE01 / Siemens - PB1	Nos	1
29	MA8163/ES/29	Push Button Red 3SB50 00-0AC01 / Siemens - PB2	Nos	1
30	MA8163/ES/30	No Element 3SB54 00-0C / Siemens - PB1	Nos	1
31	MA8163/ES/31	Push Button Yellow 3SB50 00-0AD01 / Siemens - PB3	Nos	1