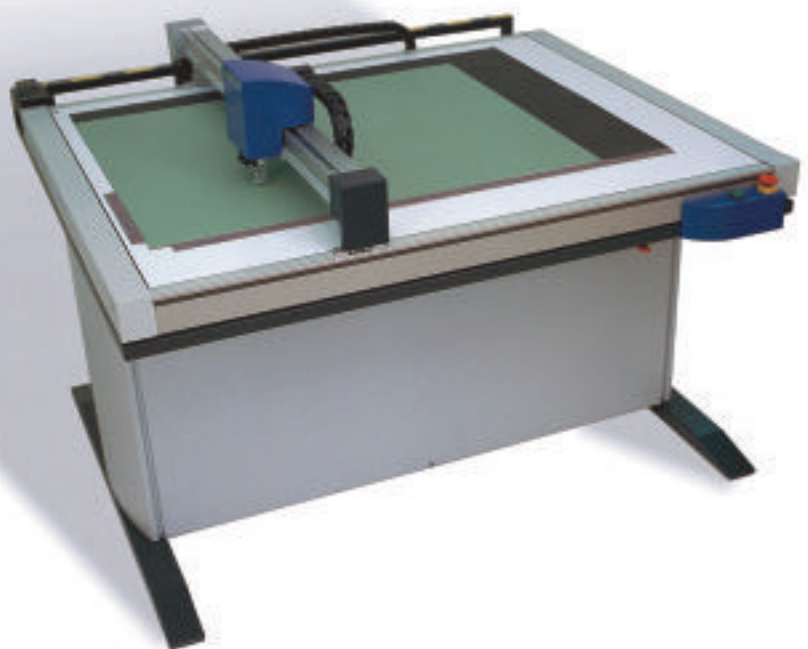

GUNNAR 3001

User Manual

By GUNNAR Weissenberger AG



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Weissenberger AG
Staatsstrasse 119
CH-9445 Rebstein
Tel: +41 (071) 775 82 20
Fax: +41 (071) 775 82 29
Internet: www.gunnar-europe.com

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General information

Introduction

The information contained in this Document corresponds to the latest developments at the time of publication. Printing errors and mistakes cannot be excluded.

We reserve the right to make design modifications or to depart from the designs shown.

Safety advice

Please read the following safety advice before installing, operating, servicing or repairing the machine.

- The installation, servicing and repair of the machine should be carried out solely by a GUNNAR trained service engineer.
- Care should be taken to observe the technical data for the machine, and in particular the ambient conditions.
- The machine should be operated by trained personnel. Your GUNNAR distributor will provide training .
- Any unauthorized modification or opening of the controller will automatically render the product guarantee and the safety guarantee invalid.
- Contact your GUNNAR representative prior to installing accessories.
- For Security the machine can be served exclusively by one person.

Intended purpose

The 3001 has been designed exclusively for cutting cardboard for mounts.

Liability

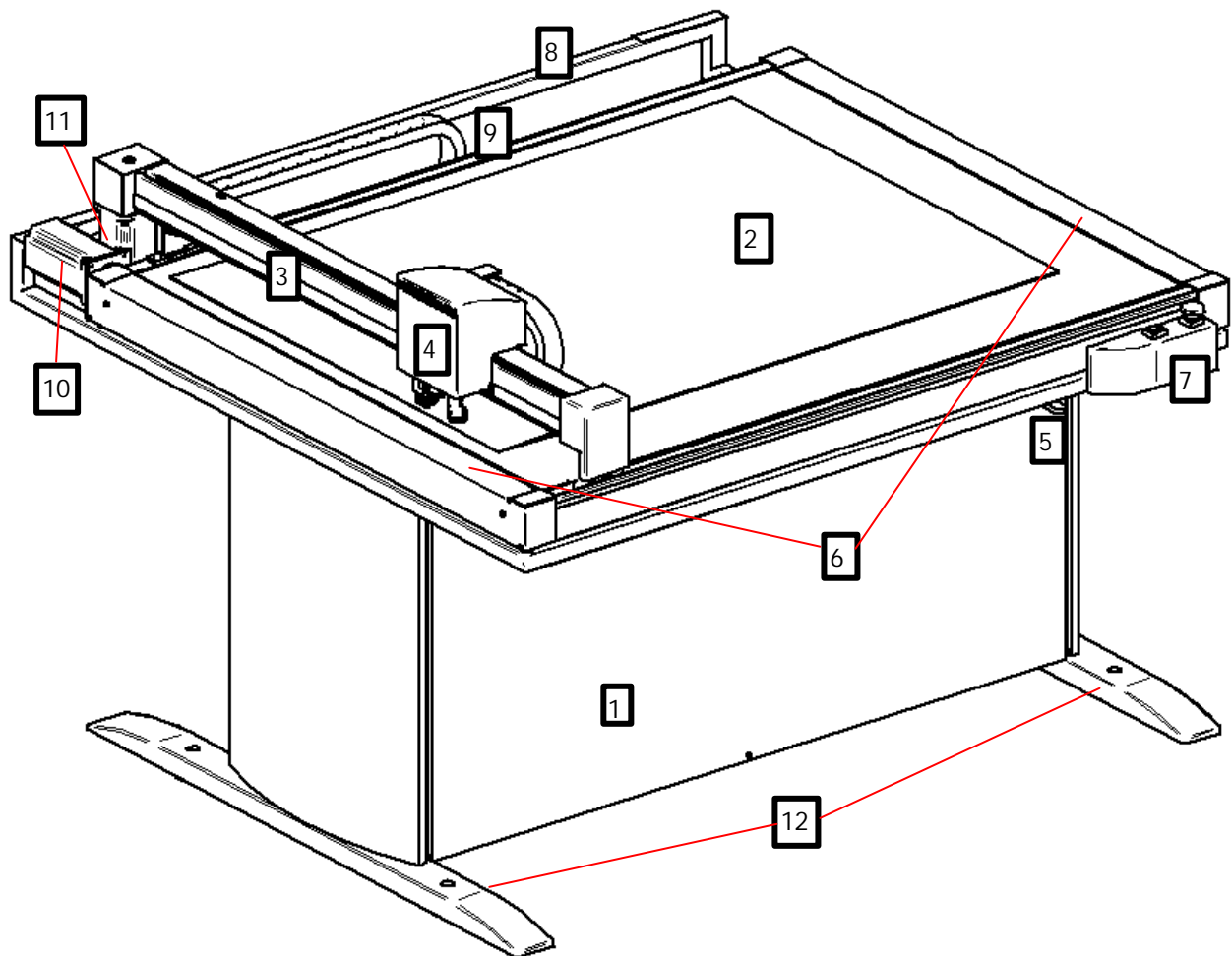
Weissenberger AG will not assume any product liability in the event of incorrect handling or use of the Software, the machine or machine components. Weissenberger AG is additionally not responsible for any loss of data. We recommend that data be backed up on a regular basis.

Data protection

Weissenberger AG holds all the rights. Neither the machine data nor any of the Software may be made available to third parties.

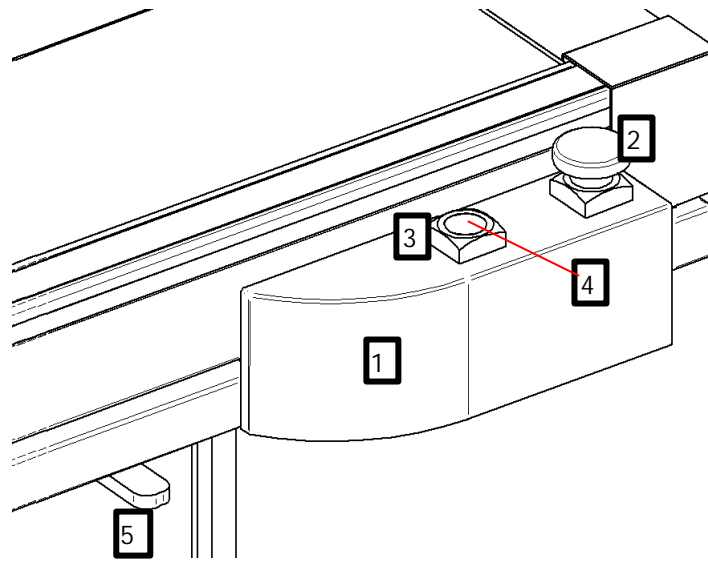
Overview

Overall view of the 3001, Fig .01



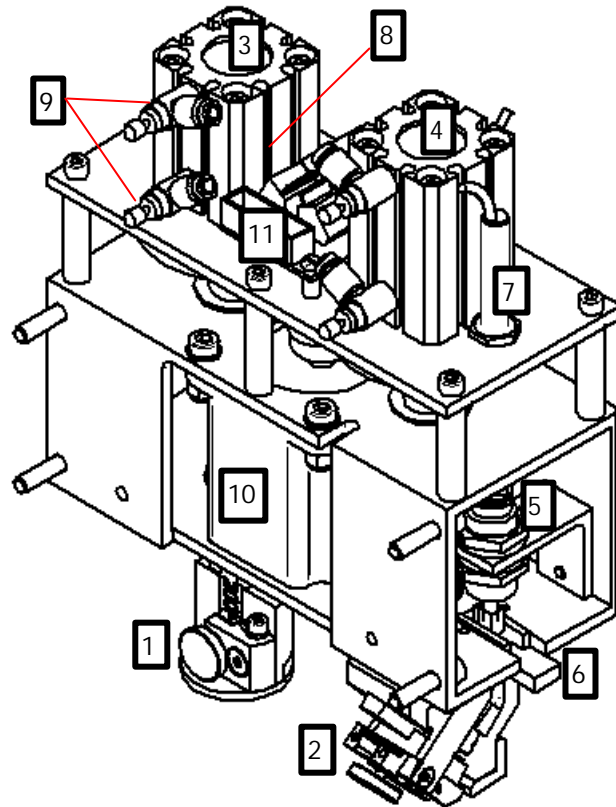
- | | |
|--------------------|----------------|
| 1. Stand | 7. Panel |
| 2. Vacuumtable | 8. Frame |
| 3. Y - Arm | 9. Cablechain |
| 4. Z - Head | 10. X - Motor |
| 5. Vacuum adjuster | 11. Y - Motor |
| 6. Sidecovers | 12. Table legs |

Panel Fig.02



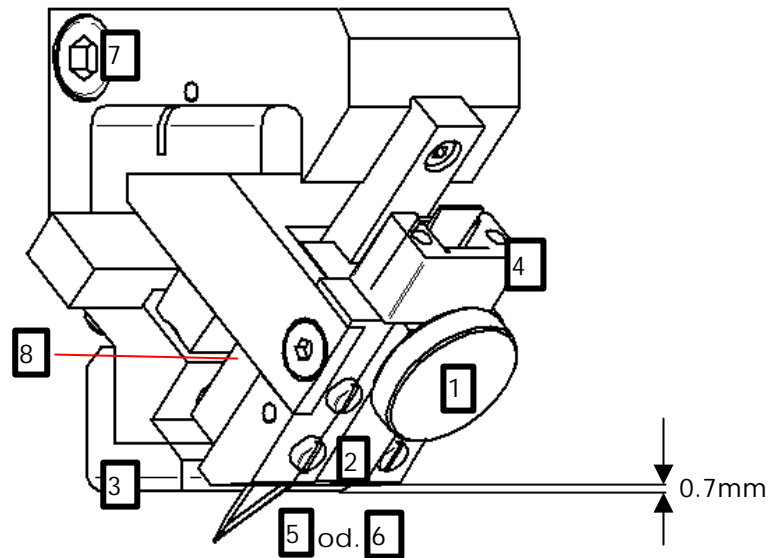
Article	Number
1. Switchbox	300051
2. Emergency Stop	300091
3. Startbutton	300093
4. Status lamp	
5. Vacuum adjuster	

Z-Head Fig.03



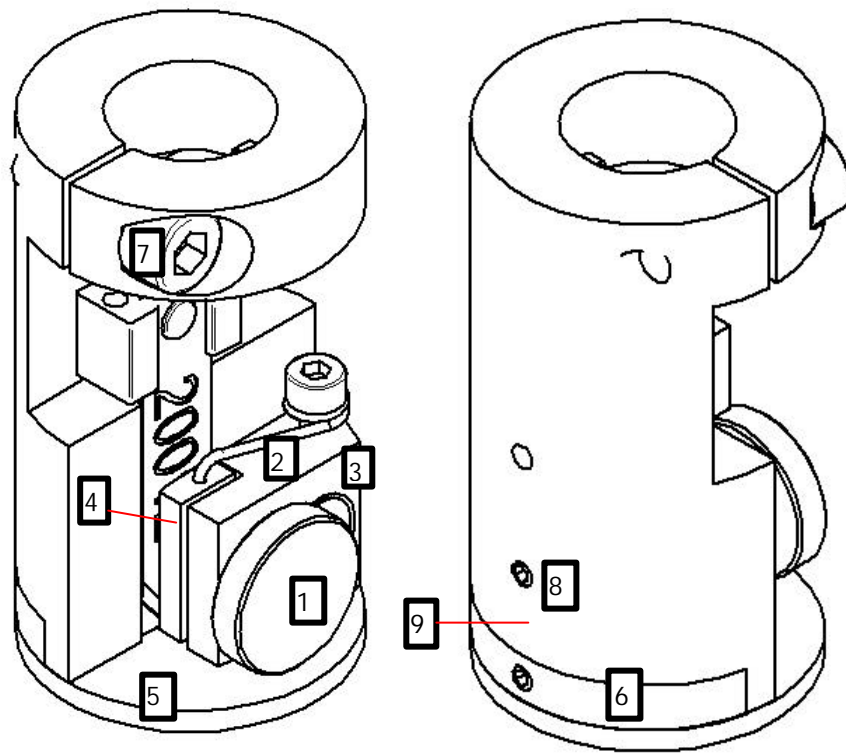
Article	Number
1. Bladehead 90°	300043
2. Bladehead 45°	300042
3. Cylinder for 90°	SMC_CQSB_20_25D
4. Cylinder for 45°	SMC_CDQSB_20_25D
5. Cylinder for dynamic Blade depth	SMC_CJPB10_15
6. Dynamic Blade Depth regulation	300087
7. Z Index - Sensor	ZJ1,5-M8EB-DPO-X0409
8. Cylinder pos. Sensor	SMC_D-A93
9. One way restrictor	SMC_AS1201F-M5-04
10. Z Motor	VRDM366-50LHA
11. Connector Board	300116

Bladehead 45° Fig.04



Article	Number
1. Knurled Screw	100058
2. Clamping part	300015
3. Sliding part	300011
4. Blade Holder	100086
5. Blade thick	20011
6. Blade Thin	20012
7. Locking Screw	Allen screw M5 x 16
8. Pressure spring	Feder 44_2_3

Bladehead 90° Fig. 5



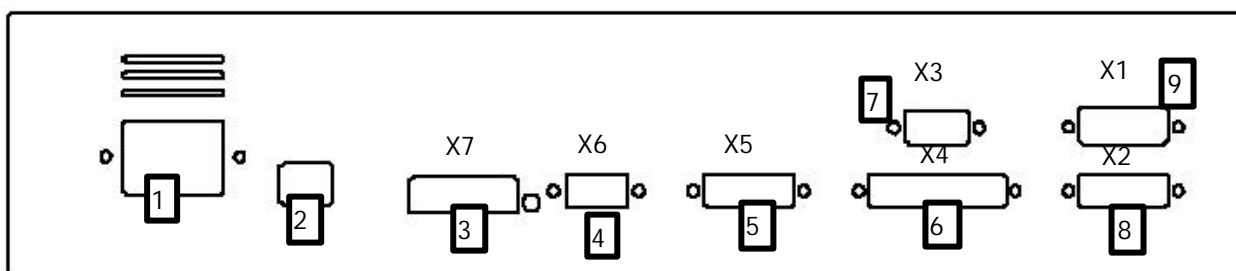
Article

1. Knurled Screw
2. Spring
3. Clamping arm
4. Clamping plate
5. Sliding part 90°
6. Sliding part holder 90°
7. Locking screw
8. Setscrew
9. Sliding part axis

Number

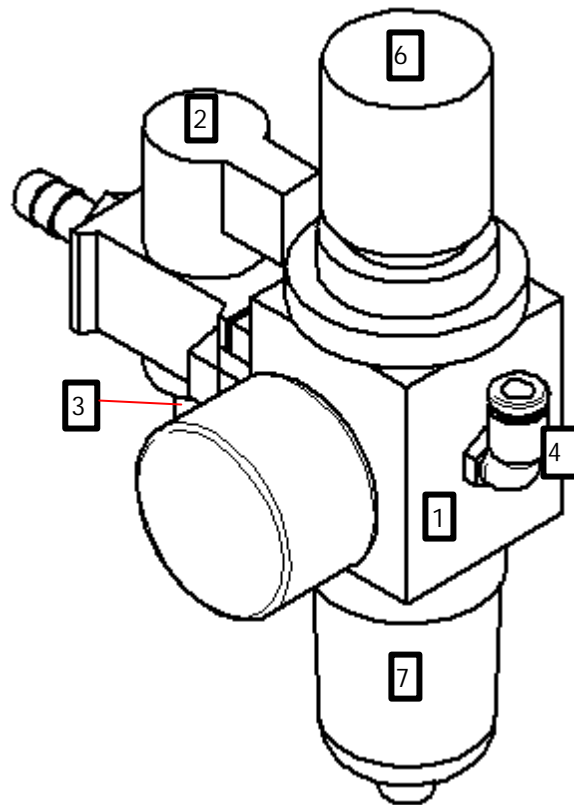
- 300023
- 300128
- 300013
- 300014
- 300012
- 300114
- Allen screw M5 x 16
- M3 x 4
- 300115

Controller Fig.06



- | | |
|----------------------------------|----------------------------|
| 1. Socket for current | 7. X3 = Comport – PC RS232 |
| 2. Power supply selection switch | 8. X2 = Y-axis |
| 3. X7 = Motor Z-axis | 9. X1 = X-axis |
| 4. X6 = Signals stand | |
| 5. X5 = Z-Head | |
| 6. X4 = reserve | |

Maintenance unit Fig.07

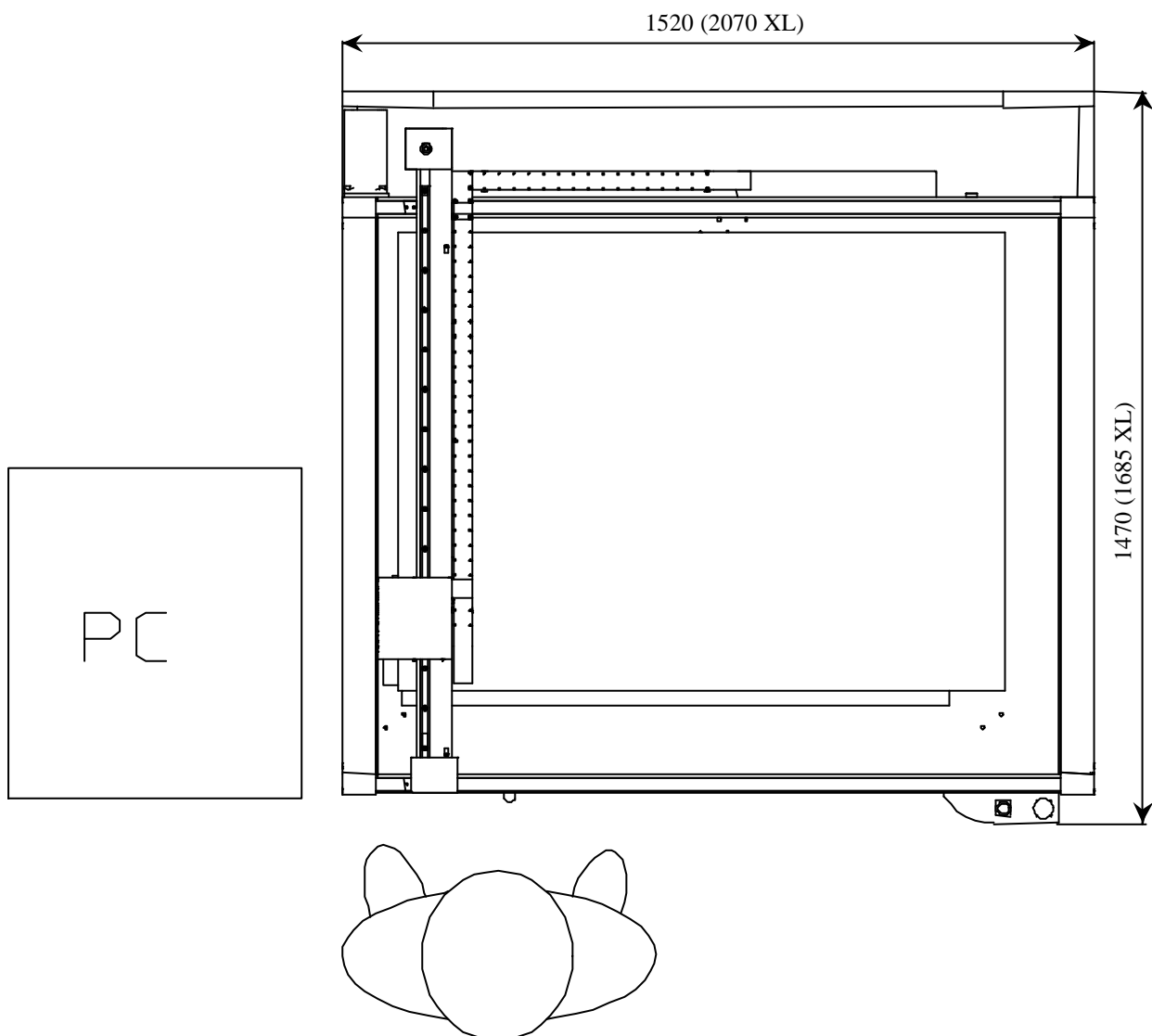


Article	Number
1. Maintenance-unit compl.	EAW2000 – F01 +
2. Stopvalve	EVHS2000 – F02
3. Exhaust silencer	AN103-01
4. Connector	KJL04 – M5
5. Hose Connection	
6. Pressure reduction	
7. Water trap	

Technical Data

Space Requirements

The 3001 is operated from the front.



Measure and Weight

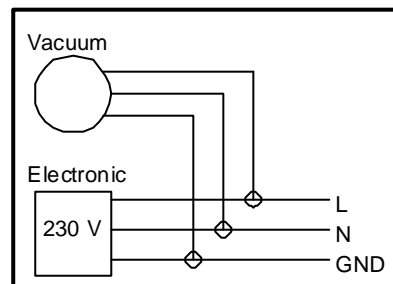
	GUNNAR 3001 M	GUNNAR 3001 XL
Max. Matboard size	1200 x 900 mm 47.25 x 35.5 “	1630 x 1120mm 64.25 x 44.00 “
Dimensions L/W/H	1520/1465/1110 mm 59.75 x 57.75 x 43.75 “	1950/1685/1110 mm 76.75/66.25/43.75 “
Weight	168 Kg 369.6 lbs	210 Kg 462 lbs

Electrical connection

The 3001 requires a flawless electrical installation with an earth connection (GND) before it can be connected. Please review the electrical diagram below.

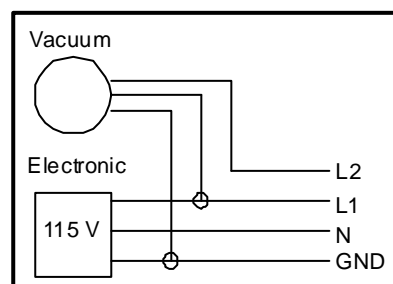
Power consumption without vacuum pump 230 V = 2 A
115 V = 4 A

Single Phase installation (European style)



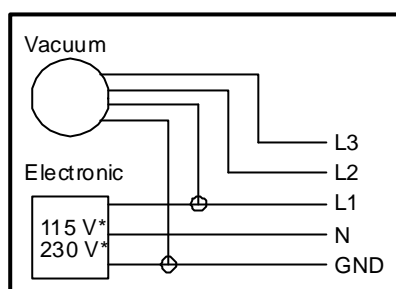
50 Hz 230 V +/- 13%
 Power consumption of the vacuum pump 4.8 A +/- 13%

Dual Phase installation (North America)



60 Hz 115 V +/- 13%
 Power consumption of the vacuum pump 5.8 A +/- 13%

Three Phase installation



60 Hz	200 – 240 V / 400 – 480 V
Power consumption of the vacuum pump	6.9 – 6.2 A / 3.4 – 3.1 A
50 Hz	190 – 230 V / 380 – 460 V
Power consumption of the vacuum pump	5.2 – 5.4 / 2.6 – 2.7 A

Please review the vacuum pump connection diagram delivered with the machine.

Power supply for electronic



NB: The power level must not fall short at any circumstances (not even for short terms).

Power supply voltage	230V +/- 13%
	115V +/- 13%

(Capture also „Connecting up the 3001“ page 15)

Vacuum installation

Environment

Ambient temperature	10 - 35 °C / 50 - 95 °F
Relative humidity	30 - 70 %

Exhaust

The exhausted air have to be lead out of the machine cabinet.

The maximum length of the exhaust hose (1" diameter) is 1.5 m (5 feet). If you like to enlarge the exhaust hose you have to increase the diameter of the exhaust hose to min. 2". On this type a max. length of 10 m (33 feet) is allowed. The exhaust hose has to be laid out as flat and straight as possible. Please make sure there are no sharp inflections.



Please note: As shorter and straighter the exhaust hose as better the vacuum suction.

PC connection / settings

The 3001 should be connected to COM1 if possible, using the RS232 cable supplied and, if necessary, the RS232 9 pole > 25 pole adapter (also supplied).

The PC must have at least one free COM interface with a FIFO UART 16550 module.

Operating system: Windows 95/98, Windows ME, NT4.0 or Win2000™.

PC	min. Pentium 200
RAM	min. 32Mb
CD ROM	min. 4x Speed
Screen resolution	min. 800 x 600 Pixels

Pneumatic connection

min. Line pressure	6 Bar / 90psi
max. compressed air consumption	40L / min

Environment

Ambient temperature	10 - 35 °C / 50 - 95 °F
Relative humidity	30 - 70 %



The machine must be free of water contact. Furthermore, no explosive dust – air or gas – air mixture is allowed to reach the machine.

Cutting data

max. cutting speed	1000 mm (40 Inch) / Second
max. cuttable matboard thickness	3.5 mm (0.14 Inch)
min. cutting radius	0.5 cm (0.2 Inch)

Installation

Supplied with machine

Article	Number
User Manual	
Vacuum Manual	
Allen key 1.3 mm	
Allen key 2 mm	
Allen key 4 mm	
Allen key 5 mm	
10 Blade holder	100086
2 Underlay sheet	300030
1 Set replacement Stops	300155
200 Blade 20012 thin	20012
3 m Exhausting Hose	300140
Data cable RS232 Link 3m	11.01.9030
4 Covers for Legs	278272
4 Rubber buffer for Legs	300109
Configuration disk	
1 Installation CD	
Test mats	

Accessories

The following accessories are available at extra cost.

Article	Number
Blades 0.62mm thick	A-20011
Blades 0.5 mm thick	A-20012
Underlay sheets cardboard for Vacuum	
Underlay sheets felt for Vacuum 120 x 90 (47" x 35")	300030
Underlay sheets felt for Vacuum 175 x 112,5 (68,8" x 44")	301030

Further information is available from your GUNNAR dealer or from the Internet, under www.gunnar-europe.com.

Unpacking

1. Open the machine packaging and remove the box with accessories. Check the delivery capacity.
2. Lift up the box from the palette.
3. Remove the 4 screws which fixes the machine legs onto the palette (SW 13).
4. Lift the 3001 directly to the mounting device.
5. The original packaging should be kept for the duration of the guarantee period.

Put up the machine

In order to guarantee the best Quality, make sure that the machine will be placed on an even and strong (preferably concrete)ground.

1. Clean the ground carefully.
2. Adjust the machine exactly so as you would like to work with it then.
3. Mark through the holes in the table-feet (Abb01 No., 12) the exact position for the bracing-screws
4. Put down intended positions an anchor or dowels at all 4 for it.
5. Screw together the machine with the underground solidly.
6. Check now whether the machine has a strong stand and test with help of a level whether the machine is absolutely even put.

Installation of the machine

Connecting up the 3001

1. Connect the compressed air to the Ø8 mm connection sleeve (see Fig.07, No.04). The consumption and the necessary pressure are specified in the technical data.



NB: Before working on the controller, the main cable must first be unplugged in order to avoid electrical shocks.


2. Check the main voltage. If the main voltage switch (Fig.06 No.02) is not already set to the standard voltage for your country, then you must change this now.



NB: If the input voltage is incorrectly set, this can destroy the controller. Such damage is not covered by the guarantee.

3. Connect up the main voltage (Fig.06 No.01). using the main cable, article No. 12.03.6510, which is supplied (the plug required for your country must be affixed by a suitably qualified person).
4. Connect the data cable RS232 Art. Nr. 11.01.9030. Connect the plug "X3" (Abb.06 Nr.07) at the controller with the COM port at the PC (prefer COM1).

First Installation of the SPT32 Software

1. Start your PC
2. Insert the SPT32 Installationdisk 1 into drive a: or CD ROM into CD ROM drive and do the following:
3. Press **Start** button
4. **Run**
5. Type in **A:\setup** (or name of CD ROM drive:\setup)
6. **Enter**
7. Follow the instructions in the setup program
8. The setup program will ask for "**Machine Adjustment**". Please insert this disk into floppy drive A:.
9. Please configure Windows  "Chapter, PC connection / settings"

Update SPT32 Software

1. Start your PC
2. Insert SPT32 Installationdisk 1. into drive A: or CD ROM into CD ROM drive and do as follows:
3. Press **Start** button
4. **Run**
5. Type in **A:\setup**(or name of CD ROM drive:\setup)
6. **Enter**
7. Follow the instructions in the setup program
8. **During the installation, setup will ask for the "Machine Adjustment" disk. Do not fit the disk into drive A:, just click OK. (If you do insert a disk you will overwrite the actual machine setting)**
9. **The SPT32 readme.txt file in the "SPT32" directory contains special instructions. This informative text file must be read once the installation is complete.**

Operating the GUNNAR 3001

Starting the SPT32 Software


Follow the steps below to start the SPT32 Software

1. Start the PC.
2. After starting Windows 95 or Windows 98.
3. Switch on the GUNNAR 3001 by turning the Main-switch/Emergency stop (Fig.02 Nr.02) right to get loose.
4. Click the **Start** button.
5. Then open **Programs**
6. **SPT32 (Programgroup)**
7. **SPT32 (Icon)**

Operating instructions and register information for the SPT32 Software may be found in the SPT32 Help program. This can be started from inside SPT32 by pressing the "F1" key, or "?" for direct help. Without SPT32, the help program can be started from within the SPT32 program group.

Switching off the system

To switch off the system, proceed as follows:

1. To instantly exit SPT32 press the "Alt" + "F4" keys or via the menu, with End.  "SPT32 Help, Chapter Switching off".
2. Switch off your GUNNAR 3001 by pressing the Main switch / Emergency stop (Fig.02 Nr.02)
3. Now close down WIN95 or WIN98.
4. Switch off the PC. Newer PCs may switch off automatically or be left on.
5. If the RAPIDO is not to be used for a considerable period of time, then the compressed air should similarly be switched off and machine covered.

Insert cardboard

To cut a cardboard you have to use underlay sheets. The most suitable underlay sheets you can order at your GUNNAR dealer.



NB: Only porous underlay sheets are suitable. Only these, make vacuum possible to suck in the to be cut material.

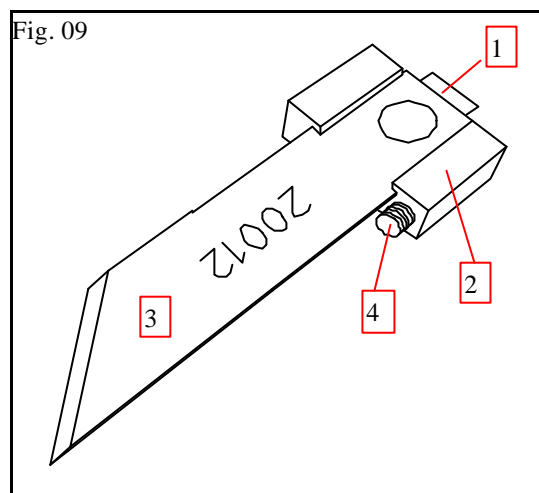
The cardboard to be cut cannot be too strongly waved, otherwise the vacuum is not able to hold the cardboard. If the vacuum does not suck the cardboard completely, do as follows:

1. Press the F3 key to start the vacuum.
2. Smooth the cardboard with the flat hand
3. If the cardboard will be sucked completely now, you can start the cut with Ctrl F9 .

The max. cardboard thickness that can be cut is 3.5 mm (0.14").

Changing blade

When SPT32 is running, press the "Ctrl" + "F5" keys to have the blade heads moved into the "change blade " position, making the clamping screw (Fig.04 Nr 01 and Fig.05 Nr 01) accessible. Turn the clamping screw anti-clockwise to release the blade. The blade can now be pulled out with the blade holder (Fig.04 No.02).




Press on the **tongue** (Fig.09 No.01) on the blade holder to pull the blade out of the blade holder and insert a new one.


Make sure that the blade holder will be pushed down when you insert the blade, then tighten the clamping screw solidly.

Machine settings

Reading in the basic settings

The Software settings are supplied with the GUNNAR 3001 on a diskette labeled "Configuration". Instructions for reading in the data may be found in  "Chapter, Installation of SPT32 Software".

Basic settings

Instructions for implementing the basic settings are given in the Help program. See  "Chapter, Start SPT32 Software".

Compressed air setting

The compressed air setting for the blade head can be adjusted via the pressure reduction (Fig.07 Nr.06) . The basic setting is 3.5 bars. If excessively pronounced pressure marks are left on the cardboard during cutting, it is possible to reduce the blade head pressure to approximately 2.5 bars. If the blade does not fully cut through thick, hard cardboard at the start of a cut, the pressure can be increased to a maximum of 5 bars.


Blade depth setting

The blade depth must be set so that the **backing material is cut into by 0.3 up to 0.5 mm**. To adjust the blade depth follow these instructions.

- 1. Make sure that the initial blade depth is not set too deep (turn set screw on holder in for a more shallow cut) for the first cut. This will avoid damaging the table top.**
2. Cut a rectangle
3. Check the depth of the cut in the underlay sheet.
2. If the cut is too deep, use the 1.3 mm hexagon socket screw key supplied in your installation kit to adjust the blade holder. Turn the screw on holder in (clockwise) for a more shallow cut. If the cut is not deep enough, then unscrew the screw (anti-clockwise). One turn is a app. 0.4 mm (0.015 Inch) dept.
4. Repeat steps 2 to 4 until the cut is some 0.3 to 0.5mm deep.
5. It is customary to set up different blade holder for various cardboard thickness' you may be cutting.

Throttle setting

In the case of circles and other shapes, where the blade cannot be inserted in a corner but only in a curve, use is made of the throttle. This ensures that the blade is inserted more slowly and does not leave any insertion marks on the mount.

Further information on this setting may be found in  "SPT32 Help, Chapter Throttle".

Servicing

Cleaning

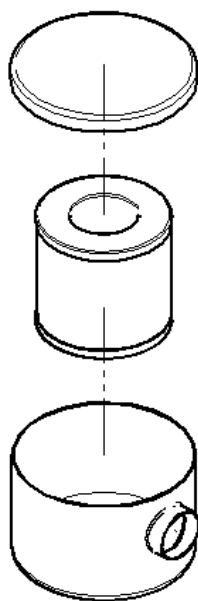


NB: All cleaning and maintenance work must be conducted with the machine switched off and the main plug pulled out. Just dry cleaning is allowed on the machine.

General cleaning

Cleaning the GUNNAR 3001 is an essential part of servicing. The cleaner it is kept, the longer its service life will be. The GUNNAR 3001 should always be kept dust-free and free from bits of cardboard and fibers. This is best done by sucking up the dust. Dust should only be **blown out** when cleaning the **guides**. Please read the following chapter.

Cleaning and changing of the air filter



1. Air filter cover
2. Air filter
3. Air filter box

The Air filter should be cleaned approx. all 100 running-hours. To clean the filter do like follows:

1. Switch off the machine and pull out the main plug.
2. Remove the front side-cover of the stand.
3. Open the clamps of the air filter cover.
4. Remove the cover and take out the filter carefully. Make sure that it is impossible that whether dust or other particles can be fallen into the vacuum pump.



NB: Impurities in the suction pipe can lead to the destruction of the vacuum-pump.

5. Shake the impurities as good as possible out of the air filter. Then blow out the filter from the inside to the outside with compressed air.
6. With a vacuum cleaner you can clean the air filter box.
7. Put the air filter centric back into the air filter box.
8. Fix the air filter cover with the clamps.
9. Replace the front side cover again.
10. Connect the main plug.

Cleaning the table

The table top can additionally be cleaned with a glass-cleaning agent or detergent.

Do not use solvents.

Lubrication

The bearing bushes, that are used for the leadership of the cylinder-shafts, must be lubricated intermittently all 15 000 cuts .

Water trap

The pneumatic water trap (Fig.07 No.07) must be emptied at regular intervals.

If there is any liquid in the transparent container, pull on the plastic nozzle (at the bottom of the container). Make sure that the compressed air system is under pressure.



NB: Not emptying the water trap can lead to corrosion in the pneumatic system and could potentially cause damage.

Replacing parts



NB: All cleaning and maintenance work must be conducted with the machine switched off and the main plug pulled out.

Felt stopper

If the felt stopper are worn out do the following to change them:

1. Remove the old felt stopper.

2. Clean the table with pure gas. ATTENTION: Never use solvent. This can damage the lacquer of the table.
3. Plug in the machine and start SPT32.
4. Put an absolute rectangular cardboard onto the marks on the table.
5. Press the F3 key to start the vacuum.
6. Glue the new felt stopper exactly onto the edges of the cardboard.



NB: With the replacement of the felt stopper the border size can move. Please check and do a new adjustment if necessary.

Bladehead


1. Shut the Machine off.
2. Turn the blade head and Undo the locking screw with the 4 mm hexagon socket screw key (Fig.04. Nr.07 or Fig.05. Nr.07) .
3. Pull the blade head down and insert the new one.
4. Tighten the locking screw again.



NB: Replacing the blade head can alter the boarder and opening dimensions on the mount. Check these dimensions and adjust them if necessary..

Sliding part

If the sliding part attains its **minimum thickness** of **4.4 mm** at the base, then it must be replaced as follows.



1. Remove the blade head as described in  "Chapter, Blade head".
2. Undo the screw located in the sliding part (Fig.04. Nr.03 or Fig.05. Nr.07)
3. Remove the sliding part and screw on the new one.
4. At the 45° bladehead adjust the bit stop screw to 0.7mm (Abb.04)
5. Attach the blade head again.



NB: Replacing the sliding part can alter the boarder and opening dimensions on the mount. Check these dimensions and adjust them if necessary.



Pressure spring 45° blade head

The pressure spring (Fig.04. No.03) is a part subject to wear. If it breaks, then it must be replaced. The procedure for replacing it is as follows

1. Remove the blade head as in  "Chapter, Blade head"
2. Pull out the broken spring and insert a new one. Take care to ensure that the spring is located in the recess provided for it.
3. Attach the blade head again as in  "Chapter, Blade head"

Pressure spring 90° blade head

The pressure spring is a part subject to wear. If it breaks, then it must be replaced. The procedure for replacing it is as follows

1. Remove the blade head as in  "Chapter, Blade head"
2. Loose the setscrew (Fig.04. Nr.03) and pull out the sliding part axis (Fig.04. Nr.03) .
3. Pull out the broken spring and insert a new one.
4. Replace the setsrew so again that the sliding part axis itself can move in the pretended lifting .
5. Attach the blade head again as in  "Chapter, Blade head"

Repairs

Most repairs can be performed by the customer, simply by replacing parts.

If a service or a major repair is necessary, then this must be performed by a specialist. Contact your authorized GUNNAR dealer.

Error removal

Errors and removal

Status lamp doesn't light

If the status lamp (Abb.04. Nr.03) does not light do the following:

- ◇ Check the power supply at the plug and the controller
- ◇ Is the main switch on?
- ◇ Is the emergency stop off?

Machine does not work – green lamp is on

- ◇ Check the connection of the data cable from PC to machine.
- ◇ Switch off the machine and close SPT32 again.
- ◇ Switch on machine and wait until the controller has booted (Beeping noise), then start SPT32 again.

Guarantee

Guarantee provisions

The guarantee on the GUNNAR RAPIDO runs for one year as of the date of delivery or for a maximum of 300.000 mount cuts (holes). The guarantee covers defects due to material faults or production errors.

Damage due to negligent and incorrect handling is not covered by the guarantee.

Normal wear is similarly excluded from the guarantee (assessment by us). Kindly observe our general terms and conditions in this respect. Within the guarantee period, repairs will be carried out at our expense, following prior agreement with us.

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Registry Form

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Machine No.:

Controller No.:

Company name:

Contact person:

Street:

City:

Zip Code:

Country:

Fax-no:

Email Address:

Key number:

(You will get this number during the first start of SPT32)

Please Mail or Fax this form to:

Weissenberger AG
GUNNAR
Staatsstrasse 119
CH-9445 Rebstein
SWITZERLAND

Fax:

+41 71 775 82 29