

Part Numbers				Includes				
US - Plug Type A	EU - Plug Type C	UK - Plug Type G	AU - Plug Type I	CWSR0640T	Case / Storage Tubes	3.0 Ah Battery	Battery Charger	Pull Rod & Positioning Washer Set
SR-0640TA3PW	SR-0640TC3PW	SR-0640TG3PW	SR-0640TI3PW	1	1/6	2	1	3
SR-0640TA3	SR-0640TC3	SR-0640TG3	SR-0640TI3	1	1/6	1	1	0
SR-0640T0	SR-0640T0	SR-0640T0	SR-0640T0	1	1/6	0	0	0

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- damaged, altered, or in poor condition.
- There are no serviceable parts in these assemblies. If any equipment is damaged or faulty, contact EST Group for service or replacement.
- These instructions are intended for the end-user or operator of this equipment. For additional information or parts lists contact an EST Group facility.
- Inspect all components for wear or damage prior to each use. Do not use any equipment that is not in proper working order. If any equipment is damaged or faulty, contact EST Group for service or replacement.
- Replace any worn or damaged safety decals.
- There are no user modifiable parts or components in the Curtiss-Wright Smart Ram package.
- Keep all components of the system clean at all times.
- Changes or modifications made to the equipment that are not expressly approved by Curtiss-Wright EST Group may void the FCC authorization to operate this equipment.

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Note: Check and comply with all regulations and laws when transporting or shipping lithium-ion batteries.



Powering on the Smart Ram:

Install a Makita 18v Li-ion battery, or equivalent, and momentarily press the trigger. This also operates the LED light:



Operating the Smart Ram:

Press and hold the trigger. The hydraulic pump motor will run, and the cylinder will stroke while the trigger is pressed. Releasing the trigger stops the pump, and the piston will remain in position until the piston is manually retracted.



The Smart Ram (SR) will either operate until it senses the breaking of a Breakaway (correct installation), or if it reaches the maximum pressure limit setting. In either case the SR will automatically stop the pump motor.



Service is recommended either after 10,000 operations or once every 3 years, whichever comes first. Contact EST Group Customer Service for Curtiss-Wright Smart Ram service and maintenance.

SERVICE			When/Wann/Quand/Quando/	Why/Warum/Pourqoui/Porquê/				
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			nach Arbeitsvorgang					
			après opération de travail					
			Después del proceso de trabajo					
20 500			após o processo de trabalho					
20 360			na bedrijfscyclus					
			после цикла опрессовки					
			po zakończeniu pracy					
			dopo il processo di lavoro					
			after working cycle					
			nach Arbeitsvorgang					
			apres operation de travail					
			Despues del proceso de trabajo	SERVICE				
20 sec/2Hz			apos o processo de trabalho					
20 300/2112			na bedrijfscyclus					
			после цикла опрессовки					
			po zakonczeniu pracy					
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20 sec/5Hz			durante a temperatura excessiva	ferramenta demasiado quente				
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			superando il limite di temperatura					
			superando il limite di temperatura					

RAM INSERT

HEX PULL ROD

POSITIONING WASHEE

THUMB SCREW

CHANNEL PULL ROD

PULLING STUD

PLUG POSITIONER

COMP TUBE

STANDOFF RING

# Preparing the Smart Ram Extended Pull Rod Assembly (SREPA/SREPRA):

KNURLED NUT

A general arrangement of the SREPA is shown.

- 1. Remove standard knurled nut, positioning washer, and pull rod from Smart Ram if necessary.
- 2. Fully thread Ram Insert into Smart Ram piston; finger tighten.
- 3. Fully thread Knurled Nut onto Smart Ram cylinder; do not tighten.
- Position Standoff Ring so that it collides with tube face when tool reaches installation depth, then finger tighten Thumb Screw to hold Standoff Ring in place.

Do not break the permanent adhesive in the threaded connection between Hex Pull Rod and Channel Pull Rod.

# Installing Tube Stabilizers with SREPA/SREPRA:

- 1. Unthread Pulling Stud from Channel Pull Rod. Hold Positioning Washer in place while rotating Pulling Stud.
- 2. Thread Stabilizer Breakaway into Channel Pull Rod by rotating Positioning Washer clockwise and holding Stabilizer steady.
- 3. Proceed with installation as per DC1050.

# Air-Cooled Heat Exchanger (fin-fan) plugging and pull-to-pressure operations with SREPA/SREPRA:

1. Ensure that the Smart Ram is set as close as possible to the correct maximum force. The required force value for the plugs can be found in the top right corner of the Certificate of Test & Inspection and Table 1.

Note: Kits of same size plugs and materials may have differing Breakaways and thereby need different pull force settings. Always verify the proper pull force setting is being used based on the BAW number of serrations for the plug being installed.

### Setting maximum force:

From unit selection (step 3b, page 5), press and hold both buttons to select the current set maximum force. Use the left and right buttons to adjust to the desired value, then press and release the trigger to confirm and return to the main menu. Ram cycle will stop automatically when installation force has reached the set maximum. For traditional Breakaway installations, set maximum force as high as possible.



- 2. Remove Breakaway from the Pop-A-Plug and thread the plug onto the Pulling Stud finger tight, then back off by one-quarter turn to make the Pulling Stud easier to remove from the Pop-A-Plug after installation. Hold the Positioning Washer in place while rotating the Pop-A-Plug.
- 3. Unthread Knurled Nut enough to remove all slack from the system.

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4. Continue with the installation procedure as standard. See DC1220 (for CPI plugs) or DC4010 (for P2 plugs) for detailed instructions for plugging. QR Code links below.



5. After Ram cycle stops and the plug is installed, retract the piston, then rotate the Positioning Washer counterclockwise to unthread the Pulling Stud from the installed plug.

Note: Installation is complete and acceptable once Ram stops, even if sensor displays a value different from the set maximum force.



If the Pulling Stud needs to be replaced, remove and replace with PS-XXX-YYY (See Table 1). Apply a non-permanent thread locker (such as Loctite 242 or equivalent) to the threaded connection between the new Pulling Stud and Channel Pull Rod.



CPI AND P2 PLUG	BAW IDENTIFICATION	INSTALLATION FORCE		PULLING STUD	
51215	(# OF GROOVES)	lbf	kN		
	1	2122	9.44		
P2-400 - P2440	2	2519	11.21	PS-440-460	
	4	3023	13.45		
	1	2785	12.39		
V471 - V555	2	3580	15.92	PS-490-560	
P2-460 - P2-580	0	3978	17.70		
	4	4774	21.24		
	0	2100	9.34	PS 500 600	
V584 - V735	1	4111	18.29		
P2-600 - P2-860	2	5304	23.59	1 0-090-090	
	4	6365	28.31		
	3	4111	18.29		
	0	5304	23.59		
	1	7028	31.26	PS-730-1220	
PZ-000 - PZ-1100	2	8752	38.93		
	4	9680	43.06		

# TABLE 1: Installation Force and Pulling Stud Sales Number



#### TABLE 2: Pop-A-Plug CPI/Perma Kits for Air Cooled Heat Exchangers (ACHE) and Fin-Fan Plugging with SREPA

	Tube ID		005014		SREXT	
CPI/Perma Plug Kit	(in)	(mm)	SREPA*	Positioner	Sub-Assembly	
V-471-B	0.472 - 0.515	11.99 - 13.08	SREPA-0471B	P-471	SREXT-00	
V-471**	0.472 - 0.515	11.99 - 13.08	SREPA-0471	P-471		
V-491	0.492 - 0.540	12.50 - 13.72	SREPA-0491	P-491	SREXT-01	
V-512	0.513 - 0.562	13.03 - 14.27	SREPA-0512	P-512		
V-524	0.525 - 0.585	13.34 - 14.86	SREPA-0524	P-524		
V-555	0.556 - 0.616	14.12 - 15.65	SREPA-0555	P-555		
V-584	0.585 - 0.649	14.86 - 16.48	SREPA-0584	P-584		
V-621	0.622 - 0.689	15.80 - 17.50	SREPA-0621	P-621		
V-649	0.650 - 0.713	16.51 - 18.11	SREPA-0649	P-649		
V-670	0.671 - 0.740	17.04 - 18.80	SREPA-0670	P-670	SREXT-02	
V-712	0.713 - 0.777	18.11 - 19.74	SREPA-0712	P-712		
V-735	0.736 - 0.810	18.69 - 20.57	SREPA-0735	P-735		
V-774	0.775 - 0.838	19.69 - 21.29	SREPA-0774	P-774		
V-804	0.805 - 0.890	20.45 - 22.61	SREPA-0804	P-804		
V-837	0.838 - 0.902	21.29 - 22.91	SREPA-0837	P-837	SREXT-03	
V-853	0.854 - 0.949	21.69 - 24.10	SREPA-0853	P-853		
V-899	0.900 - 0.963	22.86 - 24.46	SREPA-0899	P-899		
V-919	0.920 - 1.019	23.37 - 25.88	SREPA-0919	P-919		
V-962	0.963 - 1.027	24.46 - 26.09	SREPA-0962	P-962		
V-979	0.980 - 1.079	24.89 - 27.41	SREPA-0979	P-979		
V-1024	1.025 - 1.088	26.04 - 27.64	SREPA-1024	P-1024		
V-1054	1.055 - 1.154	26.80 - 29.31	SREPA-1054	P-1054		
V-1087	1.088 - 1.152	27.64 - 29.26	SREPA-1087	P-1087		
V-1103	1.104 - 1.203	28.04 - 30.56	SREPA-1103	P-1103		
V-1149	1.150 - 1.213	29.21 - 30.81	SREPA-1149	P-1149		
V-1171	1.172 - 1.270	29.77 - 32.26	SREPA-1171	P-1171		
V-1212	1.213 - 1.336	30.81 - 33.93	SREPA-1212	P-1212		

Notes:

*SREPA includes Positioner and SREXT Sub-Assembly

** All materials except -B

# TABLE 3: Pop-A-Plug P2 Kits for Air Cooled Heat Exchangers (ACHE) and Fin-Fan Plugging with SREPRA

	Tube ID		60500 A *	Beellineer	SREXT	
Pop-A-Plug P2 Plug Kit	(in)	(mm)	SREPRA*	Positioner	Sub-Assembly	
P2-400	0.400-0.420	10.19–10.68				
P2-420	0.421-0.440	10.69–11.19	SREPRA-400-440	PP-400-440	SREXT-00	
P2-440	0.441-0.460	11.20–11.70				
P2-460	0.461-0.480	11.71–12.21		PP-460-500		
P2-480	0.481-0.500	12.22-12.72	SREPRA-460-500			
P2-500	0.501-0.520	12.73–13.22				
P2-520	0.521-0.540	13.23–13.73			SREXT-01	
P2-540	0.541-0.560	13.74–14.24		PP-520-580		
P2-560	0.561-0.580	14.25–14.75	3REFRA-320-360			
P2-580	0.581-0.600	14.76-15.26				
P2-600	0.601–0.620	15.27–15.76				
P2-620	0.621-0.640	15.77–16.27				
P2-640	0.641-0.660	16.28–16.78	SREPRA-600-680	PP-600-680		
P2-660	0.661–0.680	16.79–17.29				
P2-680	0.681-0.700	17.30–17.80				
P2-700	0.701–0.720	17.81–18.30		PP-700-780	SREXT-02	
P2-720	0.721-0.740	18.31–18.81				
P2-740	0.741-0.760	18.82–19.32	SREPRA-700-780			
P2-760	0.761–0.780	19.33–19.83				
P2-780	0.781–0.800	19.84–20.34				
P2-800	0.801–0.820	20.35–20.84		PP-800-860		
P2-820	0.821-0.840	20.85–21.35	SREPRA-800-860			
P2-840	0.841-0.860	21.36–21.86				
P2-860	0.861–0.880	21.87–22.37				
P2-880	0.881-0.900	22.38–22.88				
P2-900	0.901-0.920	22.89-23.38		PP-880-960	SREXT-03	
P2-920	0.921-0.940	23.39–23.89	SREPRA-880-960			
P2-940	0.941-0.960	23.90-24.40				
P2-960	0.961-0.980	24.41–24.91				
P2-980	0.981-1.000	24.92-25.42		PP-980-1060 PP-1080-1160		
P2-1000	1.001-1.020	25.43–25.92	SREPRA-980-1060			
P2-1020	1.021-1.040	25.93–26.43				
P2-1040	1.041-1.060	26.44-26.94				
P2-1060	1.061-1.080	26.95–27.45				
P2-1080	1.081–1.100	27.46-27.96				
P2-1100	1.101–1.120	27.97-28.46				
P2-1120	1.121–1.140	28.47–28.97	SREPRA-1080-1160			
P2-1140	1.141–1.160	28.98-29.48				
P2-1160	1.161–1.180	29.49–29.99				

Notes:

(D) CE-'16 - Konformitätserklärung. Wir erklären in alleiniger Verantwortlichkeit, daß dieses Produkt mit den folgenden Normen oder normativen Dokumenten übereinstimmt: EN 62841-1. EN ISO 12100. EN ISO 13857. EN ISO 13854, EN 28662-1, EN 61000-6-3, EN 61000-6-2, EN 60529, EN 1037 gemäß den Bestimmungen der Richtlinien 2006/42/EG, 2014/30/EU, 2011/65/EU

(GB) CE-'16 - Declaration of conformity. We declare under our sole responsibility that this product is in conformity ith the following standards or normative documents: EN 62841-1, EN ISO 12100, EN ISO 13857, EN ISO 13854, EN 28662-1, EN 61000-6-3, EN 61000-6-2, EN 60529, EN 1037 in accordance with the regulations of directives 2006/42/EG, 2014/30/EU, 2011/65/EU

(F) CE-'16 - Déclaration de conformité. Nous déclarons sous notre seule reponsabilité que ce produit est en conformité avec les normes ou documents normatifs suivants: EN 62841-1. EN ISO 12100. EN ISO 13857. EN ISO 13854. EN 28662-1, EN 61000-6-3, EN 61000-6-2, EN 60529, EN 1037 conformément aux réglementations des directives 2006/42/EG, 2014/30/EU, 2011/65/EU

(E) CE-'16 - Declaración de conformidad. Declaramos bajo nuestra sola responsabilidad que este producto està en conformidad con las normas o documentos normativos siguientes: EN 62841-1, EN ISO 12100, EN ISO 13857, EN ISO 13854. EN 28662-1. EN 61000-6-3. EN 61000-6-2. EN 60529. EN 1037 de acuerdo con las regulaciones de las directivas 2006/42/EG, 2014/30/EU, 2011/65/EU

(I) CE-'16 - Dichiarazione di conformità Dichiariamo sotto la nostra esclusiva responsabilità che questo prodotto è conforme alle sequenti norme e documenti normativi: EN 62841-1. EN ISO 12100. EN ISO 13857. EN ISO 13854. EN 28662-1, EN 61000-6-3, EN 61000-6-2, EN 60529, EN 1037 conformemente alle disposizioni delle direttive 2006/42/EG. 2014/30/EU. 2011/65/EU

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(NL) CE-'16 - Konformiteitsverklaring. Wij verklaren en wij stellen ons er alleen voor verantwoordelijk dat dit produkt voldoet aan de volgende normen of normatieve documenten: EN 62841-1, EN ISO 12100, EN ISO 13857, EN ISO 13854, EN 28662-1, EN 61000-6-3, EN 61000-6-2, EN 60529, EN 1037 overeenkomstig de bepalingen van de richtlijnen 2006/42/EG, 2014/30/EU, 2011/65/EU

(GR) CE-'16 -  $\Delta H \Lambda \Omega \Sigma H \Sigma \Sigma M MOP \Phi \Omega \Sigma H \Sigma$  Me analyfy sunolikys dylonome oti to πορού προίου συμφωνεί με τα παρακάτω ποοτυπά και με τα ηρότυπα ηου αναφερονται στα σχεπκό εγγραφα ΕΝ 62841-1, ΕΝ ISO 12100, ΕΝ ISO 13857, ΕΝ ISO 13854, ΕΝ 28662-1, ΕΝ 61000-6-3, EN 61000-6-2, EN 60529, EN 1037 sumpwar me tocs kononismous 2006/42/EG, 2014/30/EU, 2011/65/EU

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(GB) CE-'16 - Declaration of conformity RED. We declare under our sole responsibility that this product is in conformity with the following standards or normative documents: EN 62368-1, EN 301489-1, EN 301489-17, EN 300328 V2.2.2, EN 62479 in accordance with the regulations of directives 2014/53/EU, 2011/65/EU

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(I) CE-'16 - Dichiarazione di conformità RED. Dichiariamo sotto la nostra esclusiva responsabilità che questo prodotto è conforme alle seguenti norme e documenti normativi: EN 62368-1, EN 301489-1, EN 301489-17, EN 300328 V2.2.2, EN 62479 conformemente alle disposizioni delle direttive 2014/53/EU, 2011/65/EU

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(GR) CE- 16 -  $\Delta H \Lambda \Omega \Sigma H \Sigma Y M M OP \Phi \Omega \Sigma H \Sigma M$  Red.  $\varepsilon$  analyfy sunolikys dylanomed oti to porner of the second seco προιον συμφωνει με τα παρακατω ποοτυπα και με τα ηροτυηα ηου αναφερονται στα σχεπκο εγγραφα∞ EN 62368-1, EN 301489-1, EN 301489-17, EN 300328 V2.2.2, EN 62479 συμφωνα με τοχς κονονισμους 2014/53/EU, 2011/65/EU

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(FIN) CE-'16 - Todistus slandardinmukaisuudesta. Asiasta vastaavana todistamme täten, että tämä tuote on seuraavien standardien ja standardoimisasiakirjojen vaatimusten mukainen: EN 62841-1, EN ISO 12100. EN ISO 13857, EN ISO 13854, EN 28662-1, EN 61000-6-3, EN 61000-6-2, EN 60529, EN 1037 ja vastaa säädoksiä 2006/42/EG, 2014/30/EU, 2011/65/EU

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(PL) CE-'16 - Zgodnosc z dyrektywami CE. Swiadomi odpowiedzialnosci oswiadczamy, ze niniejszy produkt jest zgodny z nastepujacymi normami lub dokumentacja normatywna: EN 62841-1, EN ISO 12100, EN ISO 13857, EN ISO 13854, EN 28662-1, EN 61000-6-3, EN 61000-6-2, EN 60529, EN 1037 zgodnie z postanowieniami wytycznych 2006/42/EG, 2014/30/EU, 2011/65/EU

(CZ) CE-'16 - Prohlášeni o shode. Prohlašujeme na vlastni zodpovednost, ze tyto produkty splnuji následujici normy nebo normativni listiny: EN 62841-1, EN ISO 12100, EN ISO 13857, EN ISO 13854, EN 28662-1, EN 61000-6-3. EN 61000-6-2. EN 60529. EN 1037: Ve shode se smernicemi 2006/42/EG. 2014/30/EU. 2011/65/EU.

(SLO) CE-'16 - Izjava o skladnosti. S tem potrjujemo splošno odgovornost, da je ta izdelek narejen v skladu z navedeimi normami in standardi: EN 62841-1, EN ISO 12100, EN ISO 13857, EN ISO 13854, EN 28662-1, EN 61000-6-3, EN 61000-6-2, EN 60529, EN 1037 ter določbami in smernicami 2006/42/EG, 2014/30/EU, 2011/65/EU

(HR) CE-'16 - Izjava o sukladnosti. Pod punom odgovornošću izjavljujemo da je proizvod naveden u naslovu ovog dokumenta sukladan sa primijenjenim normama i normativnim dokumentima : EN 62841-1, EN ISO 12100, EN ISO 13857, EN ISO 13854, EN 28662-1, EN 61000-6-3, EN 61000-6-2, EN 60529, EN 1037 u skladu sa odredbama preporuka 2006/42/EG, 2014/30/EU, 2011/65/EU

(H) CE-'16 - Megfelelőségi nyilatkozat. Kéziműködtetésű elektromos kéziszerszámok: Teljes felelősségel kijelentjük, hogy ezek a termékek a következő szabványokkal és irányelvekkel összhangban vannak: EN 62841-1, EN ISO 12100, EN ISO 13857, EN ISO 13854, EN 28662-1, EN 61000-6-3, EN 61000-6-2, EN 60529, EN 1037; és megfelelnek a rendeltetés szerinti 2006/42/EG, 2014/30/EU, 2011/65/EU irányelveknek

(RO) CE-'16 - Declarație de conformitate. Noi declarăm pe propria răspundere că acest produs este în conformitate cu următoarele norme și documente normative: EN 62841-1, EN ISO 12100, EN ISO 13857, EN ISO 13854, EN 28662-1, EN 61000-6-3, EN 61000-6-2, EN 60529, EN 1037; potrivit dispozițiilor directivelor 2006/42/EG, 2014/30/EU, 2011/65/EU

Remscheid, 19.08.2021

John - Chinistoph bling

Dipl.-Ing. Joh.-Christoph Schütz, CE-Representative

med følgende standarder eller standard-dokumenter: EN 62368-1, EN 301489-1, EN 301489-17, EN 300328 V2.2.2, EN 62479 i henhold til bestemmelsene i direktive ne 2014/53/EU, 2011/65/EU

(FIN) CE-'16 - Todistus slandardinmukaisuudesta RED. Asiasta vastaavana todistamme täten, että tämä tuote on seuraavien standardien ja standardoimisasiakirjojen vaatimusten mukainen: EN 62368-1, EN 301489-1, EN 301489-17, EN 300328 V2.2.2, EN 62479 ja vastaa säädoksiä 2014/53/EU, 2011/65/EU

(SK) CE-'16 - Prehlásenie o zhode RED. Prehlasujeme na vlastnú zodpovednosť, že tieto produkty sú v súlade s nasledovnými normami: EN 62368-1, EN 301489-1, EN 301489-17, EN 300328 V2.2.2, EN 62479 a v zhode so smernicemi 2014/53/EU, 2011/65/EU

(PL) CE-'16 - Zgodnosc z dyrektywami RED. Swiadomi odpowiedzialnosci oswiadczamy, ze niniejszy produkt jest zgodny z nastepujacymi normami lub dokumentacja normatywna: EN 62368-1, EN 301489-1, EN 301489-17, EN 300328 V2.2.2, EN 62479 zgodnie z postanowieniami wytycznych 2014/53/EU, 2011/65/EU

(CZ) CE-'16 - Prohlášeni o shode RED. Prohlašujeme na vlastni zodpovednost, ze tvto produkty splnuji následujici normy nebo normativni listiny: EN 62368-1, EN 301489-1, EN 301489-17, EN 300328 V2.2.2, EN 62479 Ve shode se smernicemi 2014/53/EU, 2011/65/EU

(SLO) CE-'16 - Izjava o skladnosti RED. S tem potrjujemo splošno odgovornost, da je ta izdelek narejen v skladu z navedenimi normami in standardi EN 62368-1, EN 301489-1, EN 301489-17, EN 300328 V2.2.2, EN 62479 ter določbami in smernicami 2014/53/EU, 2011/65/EU

(HR) CE-'16 - Izjava o sukladnosti RED. Pod punom odgovornošću izjavljujemo da je proizvod naveden u naslovu ovog dokumenta sukladan sa primijenjenim normama i normativnim dokumentima : EN 62368-1, EN 301489-1, EN 301489-17, EN 300328 V2.2.2, EN 62479 u skladu sa odredbama preporuka 2014/53/EU, 2011/65/EU

(H) CE-16 - Megfelelőségi nyilatkozat RED. Kéziműködtetésű elektromos kéziszerszámok. Teljes felelősségel kijelentjük, hogy ezek a termékek a következő szabványokkal és irányelvekkel összhangban vannak: EN 62368-1, EN 301489-1, EN 301489-17, EN 300328 V2.2.2, EN 62479 és megfelelnek a rendeltetés 2014/53/EU, 2011/65/EU irányelveknek.

(RO) CE-'16 - Declaratie de conformitate RED. Noi declarăm pe propria răspundere că acest produs este în conformitate cu următoarele norme și documente normative: EN 62368-1, EN 301489-1, EN 301489-17, EN 300328 V2.2.2, EN 62479 potrivit dispozițiilor directivelor 2014/53/EU, 2011/65/EU

Remscheid, 01.06.2021

Dipl. - Chin Stoph bling

#### Questions? Contact EST Group Customer Service at any of the following locations.

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