



Spett.le

R.E.M. SRL

Indirizzo: VIA FERRUCCIA 16/A

Comune: PATRICA 03010 (FR)

P. IVA IT02240470605

Milano, 22 giugno 2022

Rif. 22.21452

Analisi Tecnica 21.500.0521

Nuovo Piano Nazionale Transizione 4.0

Legge n. 232 dell'11.12.2016

Legge n. 205 del 27.12.2017

Legge n. 160 del 27.12.2019

Legge n. 178 del 30.12.2020

Oggetto:

N. 1 FORNO PIROLITICO ECONOMY 225

S/N 21.2485_90

**Forno di distruzione pirolitico per eliminazione
mediante combustione pirolitica della resina di
impregnazione degli avvolgimenti dei motori elettrici**



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Società: R.E.M. SRL



Indirizzo Sede Legale: VIA FERRUCCIA 16/A – PATRICA (FR)

Indirizzo PEC: rem-motori@messaggipec.it

Numero REA: FR - 138995

P. IVA: 02240470605

Forma giuridica: SOCIETA' A RESPONSABILITA' LIMITATA

Codice ATECO: 33.14 - Riparazione e manutenzione di apparecchiature elettriche (esclusi gli elettrodomestici)

Indirizzo di installazione: VIA FERRUCCIA 16/A – PATRICA (FR)

Reparto di installazione: PRODUZIONE

Bene Materiale: FORNO PIROLITICO ECONOMY 225

Sistema messo in funzione nel: 2021

Ispezione in data: 09/06/2022

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Beni funzionali alla trasformazione tecnologica e digitale delle imprese

Secondo il modello << Nuovo Piano Nazionale Transizione 4.0 >>

Allegato A annesso alla Legge 11 dicembre 2016, n. 232 e s.m.i.

*** **

Beni strumentali il cui funzionamento è controllato da sistemi computerizzati o gestito tramite opportuni sensori e azionamenti

Sommario:

- 1 Termini e definizioni**
- 2 Breve descrizione del bene inserito nel ciclo produttivo**
- 3 Classificazione del bene**
- 4 Individuazione del costo del bene e dei suoi accessori**
- 5 Esame possesso delle Caratteristiche Obbligatorie del bene in esame**
- 6 Control Check**
 - 6.1 Check List 1 – Beni Allegato A strumentali il cui funzionamento è controllato da sistemi computerizzati o gestito tramite opportuni sensori e azionamenti (Gruppo I)**
- 7 Conclusioni**

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1 Termini e definizioni

Ai fini della presente Analisi Tecnica si applicano i termini e le definizioni riportate al paragrafo 3 del rapporto tecnico UNI/TR 11749:2020.

2 Breve descrizione del bene inserito nel ciclo produttivo

Il Forno pirolitico Economy 225 (denominato come FORNO DI DISTRUZIONE) è destinato all'eliminazione, mediante combustione pirolitica controllata, della resina di impregnazione degli avvolgimenti dei motori elettrici usati. Tale attività viene condotta dalla R.E.M. per l'eliminazione di scorie per il riuso di avvolgimenti usati. Trattasi dunque di macchinario destinato al trattamento di avvolgimenti usati e con lo scopo di riuso nell'ottica di una economia circolare (modello Economy – rif.

<http://www.tecnecoforni.it/wp/wp-content/uploads/2019/11/Forni-pirolitici-per-elettromeccanica.pdf>). In tal senso si ritiene che per tipologia di funzionalità ed utilizzo all'interno del ciclo produttivo aziendale il macchinario sia appartenente alla categoria A1 – voce 1.07 “**Macchine utensili di de-produzione e riconfezionamento per recuperare metalli e funzioni da scarti industriali e prodotti di ritorno a fine vita (ad es. macchine per il disassemblaggio, la separazione, la frantumazione, il recupero chimico)**”. Sono inclusi i dispositivi che, in un'ottica di economia circolare, sono finalizzati al riutilizzo diretto, alla riparazione, al remanufacturing e al riciclo / riutilizzo delle materie prime. Sono da ritenersi escluse le macchine finalizzate allo smantellamento in discarica e finalizzate al recupero energetico”

Per maggiori dettagli si rimanda all'offerta tecnica allegata ed alla scheda tecnica reperibile al seguente link: <http://www.tecnecoforni.it/wp/wp-content/uploads/2019/11/Forni-pirolitici-per-elettromeccanica.pdf>.

DATI IDENTIFICATIVI DELLA MACCHINA

Denominazione del costruttore: TECFLAM SRL VIA CURIEL 3 42025 (CONTE TEGGE) CAVRIAGO (RE)

Denominazione commerciale: ECONOMY 225

Tipologia di Macchina: FORNO PIROLITICO DI DISTRUZIONE

Configurazione Macchina comprensiva di: NESSUN ACCESSORIO (es. nastro di trasporto in ingresso e in uscita, pesatrice, dispositivo hot melt, sistema a raggi x, marcatore, ecc.)

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Numero di matricola: 21.21485.001

Anno di fabbricazione: 2021

Principali funzionalità svolte dalla macchina, prendendo spunto dalle brochure e dalle schede tecniche.

Il Forno pirolitico Economy 225 (denominato come FORNO DI DISTRUZIONE) è destinato all'eliminazione, mediante combustione pirolitica controllata, della resina di impregnazione degli avvolgimenti dei motori elettrici con lo scopo di procedere ad una pulitura controllata ed efficiente finalizzata al riuso degli avvolgimenti.

Il forno è dotato, come richiesto dalle Regioni per l'autorizzazione alle emissioni in atmosfera, ai sensi del D.Lvo n.152/06 e successivi aggiornamenti, di:

- camera di postcombustione operante a 850°C per la completa ossidazione delle sostanze organiche volatili presenti nei fumi che si sviluppano durante il processo di combustione, dimensionata per garantire un tempo di permanenza dei fumi di 2 secondi con una concentrazione di ossigeno di almeno il 6%;
- sistema di registrazione delle temperature in camera di combustione e di postcombustione.

Sono previsti i seguenti dispositivi di sicurezza:

- portello di sicurezza in camera di trattamento che si apre automaticamente in caso di sovrappressione interna;
- finecorsa con blocco sulla porta che impedisce l'accensione del bruciatore della camera di trattamento se la porta non è perfettamente chiusa;
- sistema di emergenza con spruzzamento d'acqua nel caso di aumento eccessivo della temperatura nella camera di trattamento.

Il forno è dotato dei seguenti bruciatori:

- il bruciatore BR1 in camera di trattamento è di tipo monoblocco, a funzionamento bi-stadio, avente potenza termica di 40.000 kcal/h;
- Il bruciatore BR2 in camera di postcombustione è di tipo monoblocco, a funzionamento bi-stadio, avente potenza termica di 55.000 kcal/h.

Il comando del forno è effettuato dal quadro elettrico, fissato sul lato sinistro o destro del forno (in base alle esigenze), sul quale sono inseriti:

- interruttore generale;

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- pulsanti di marcia, arresto e di emergenza;

- PLC Siemens avente ingressi/uscite digitali con pannello operatore Siemens 7" integrato per la gestione ed il controllo del processo, delle sicurezze e della funzione di termoregolazione per la gestione dei bruciatori. È in grado di salvare programmi differenti, per personalizzare il ciclo in base al tipo di materiale e vernice da trattare. Consente inoltre la registrazione delle temperature in camera di trattamento e di postcombustione per la successiva stampa tramite PC esterno.

Di seguito le foto del macchinario



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3 Classificazione del bene

Al fine della classificazione, il bene risulta essere dotato di diverse “Tecnologie abilitanti Industria 4.0”, ovvero nuove tecnologie produttive per migliorare le condizioni di lavoro, i modelli di business, la produttività e la qualità produttiva degli impianti, quali:

N°	Tecnologia	Descrizione
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1	<i>Advanced Manufacturing Solution</i>	Robot collaborativi interconnessi e rapidamente programmabili	<input type="checkbox"/>
2	<i>Additive Manufacturing</i>	Stampanti in 3D connesse a software di sviluppo digitali	<input type="checkbox"/>
3	<i>Augmented Reality</i>	Realtà aumentata a supporto dei processi produttivi	<input type="checkbox"/>
4	<i>Simulation</i>	Simulazione tra macchine interconnesse per ottimizzare i processi	<input type="checkbox"/>
5	<i>Horizontal/Vertical Integration</i>	Integrazione informazioni lungo la catena del valore dal fornitore al consumatore	<input type="checkbox"/>
6	<i>Industrial Internet</i>	Comunicazione multidirezionale tra processi produttivi e prodotti	<input type="checkbox"/>
7	<i>Cloud</i>	Gestione di elevate quantità di dati su sistemi aperti	<input type="checkbox"/>
8	<i>Cyber-security</i>	Sicurezza durante le operazioni in rete e su sistemi aperti	<input type="checkbox"/>
9	<i>Big Data and Analytics</i>	Analisi di un'ampia base dati per ottimizzare prodotti e processi produttivi	<input type="checkbox"/>
10	<i>Altro</i>	Automazione dei processi attraverso l'applicazione dei concetti di robotica ed altre tecnologie abilitanti Tecnologie per la trasmissione e per l'elaborazione dei dati raccolti dalle macchine durante le lavorazioni programmate	<input checked="" type="checkbox"/>

La macchina FORNO PIROLITICO ECONOMY 225 soddisfa il criterio dell'Allegato A della Legge 11 dicembre 2016, n. 232 in quanto rientra nella voce:

Beni strumentali il cui funzionamento è controllato da sistemi computerizzati o gestito tramite opportuni sensori e azionamenti per recuperare metalli e funzioni da scarti industriali e prodotti di

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ritorno a fine vita ovvero dispositivi che, in un'ottica di economia circolare, sono finalizzati al riutilizzo diretto, alla riparazione, al remanufacturing e al riciclo / riutilizzo dei prodotti o parti di essi, in quanto trattasi di forno pirolitico (denominato come FORNO DI DISTRUZIONE) destinato all'eliminazione, mediante combustione pirolitica controllata, della resina di impregnazione degli avvolgimenti dei motori elettrici con lo scopo di procedere al recupero ed al riuso di detti avvolgimenti.

In riepilogo:

sulla base di tali valutazioni, si ritiene, che il cespite in parola, sia assimilabile, agli effetti della disciplina delle agevolazioni previste per il piano Industria 4.0 a Beni strumentali il cui funzionamento è controllato da sistemi computerizzati o gestito tramite opportuni sensori e azionamenti, voce 7, **“Macchine utensili di de-produzione e riconfezionamento per recuperare metalli e funzioni da scarti industriali e prodotti di ritorno a fine vita (ad es. macchine per il disassemblaggio, la separazione, la frantumazione, il recupero chimico)”. Sono inclusi i dispositivi che, in un'ottica di economia circolare, sono finalizzati al riutilizzo diretto, alla riparazione, al remanufacturing e al riciclo / riutilizzo delle materie prime. Sono da ritenersi escluse le macchine finalizzate allo smantellamento in discarica e finalizzate al recupero energetico”.**

4 Individuazione del costo del bene e dei suoi accessori

Sulla base della documentazione prodotta e delle dichiarazioni rese dall'impresa risulta che:

Il valore complessivo dell'investimento è pari a € 33.600,00 + iva

Cfr. fattura n 351 del 27/05/2021, n. 902 del 07/12/2021, n. 922 del 10/12/2021 emesse da TECFLAM SRL (vedi Allegato n. 1).

L'impresa R.E.M. SRL dichiara inoltre che intende considerare quali componenti e accessori del bene i seguenti elementi:

Nessuno

5 Esame possesso delle Caratteristiche Richieste del bene in esame

Si esaminano di seguito le caratteristiche del bene al fine di accertare il rispetto dei Requisiti Obbligatori.

Il bene risulta dotato nel complesso delle seguenti caratteristiche:

a) Controllo per mezzo di CNC (Computer Numerical Control) e/o PLC (Programmable Logic Controller)

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Il forno ECONOMY 225 prodotto da TECFLAM è un macchinario caratterizzato da una unità di controllo PLC Siemens SIMATIC HMI che ne gestisce la funzionalità ed i parametri. Il PLC Siemens ha ingressi/uscite digitali con pannello operatore Siemens 7" integrato per la gestione ed il controllo del processo, delle sicurezze e della funzione di termoregolazione per la gestione dei bruciatori. È in grado di salvare programmi differenti, con lo scopo di personalizzare il ciclo in base al tipo di materiale e vernice da trattare. Consente inoltre la registrazione delle temperature in camera di trattamento e di postcombustione per la successiva stampa tramite PC esterno.

Trattasi dunque di apparato a logica programmabile che consente di impostare le seguenti funzionalità:

- la rampa di salita (incremento) della temperatura in camera di trattamento: temperatura e tempi
- la durata totale del ciclo
- la temperatura minima nel postcombustore che abilita l'inizio del ciclo
- la temperatura di intervento del sistema di sicurezza ad acqua ed il suo arresto
- la temperatura di fine ventilazione ed abilitazione all'apertura della porta del forno

Il PLC consente di modificare ed impostare, sia in locale che in remoto mediante idonea interconnessione a gestionale di produzione, i dati seguenti: data e ora, temperatura della camera di trattamento, set point della camera di trattamento, temperatura camera di post combustione, numero del gradino attivo, durata del gradino attivo, durata del ciclo dal comando di start. Il PLC registra inoltre le ore di lavoro totali del forno ed il numero totale di cicli del forno. L'unità di controllo consente di impostare le "ricette", di salvarle ed avviare i cicli di produzione. Consente inoltre di monitorare costantemente lo stato del forno, le valvole, le bobine, i cicli di lavoro; permette di rilevare le anomalie e gli allarmi, segnalandoli repentinamente.

Il PLC si interfaccia con l'operatore mediante display a colori a bordo macchina che ne consente un utilizzo semplice ed efficiente.

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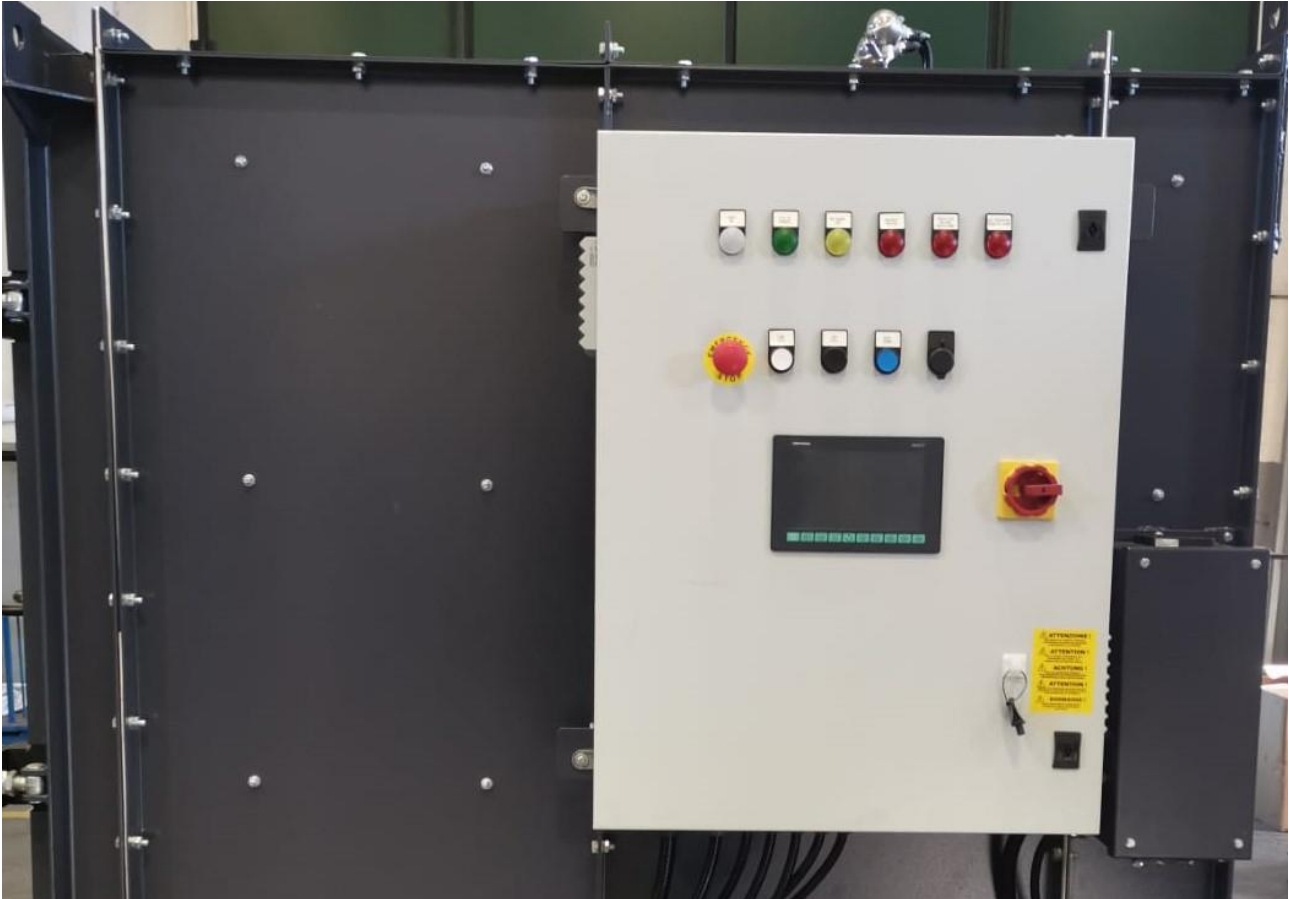
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Di seguito una foto esemplificativa del display acceso:



Di seguito una schermata, acquisita da PC connesso in remoto con il forno, con evidenza delle funzionalità dello stesso:



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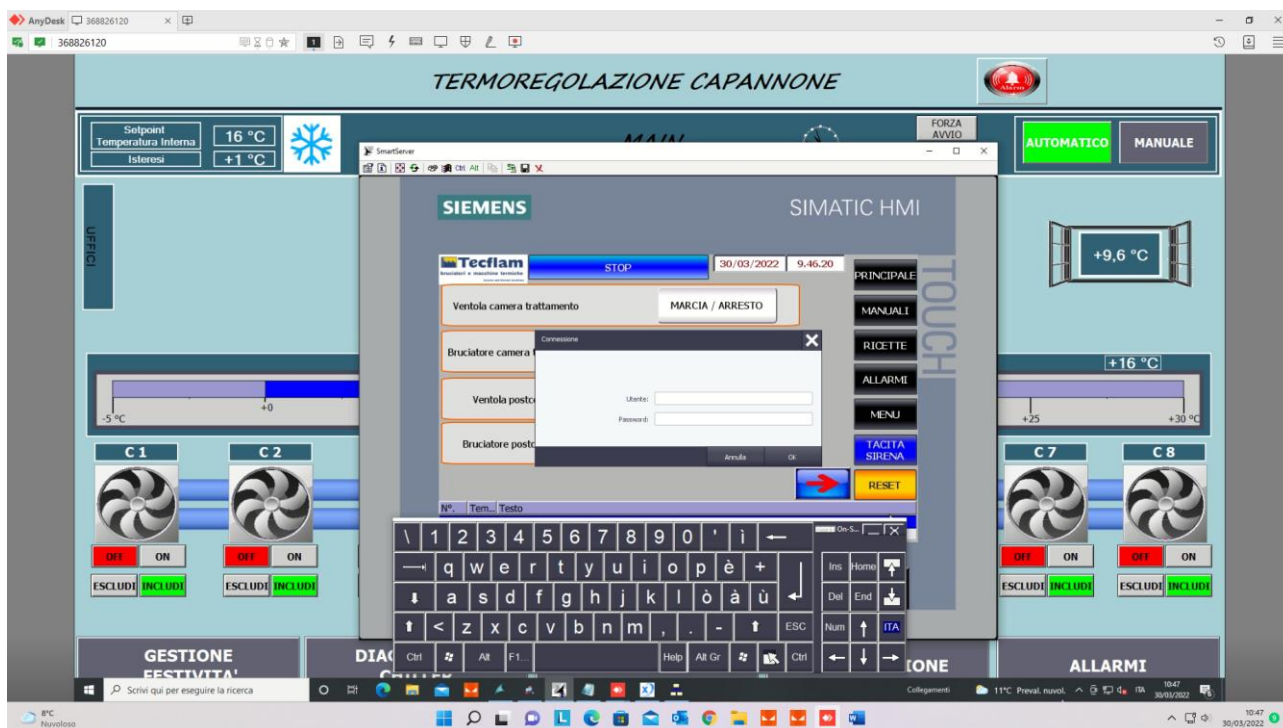
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Il bene soddisfa il requisito obbligatorio RO1.

b) Interconnessione ai sistemi informatici di fabbrica con caricamento da remoto di istruzioni e/o part program.

Il Forno pirolitico Economy 225 (denominato come FORNO DI DISTRUZIONE) è destinato all'eliminazione, mediante combustione pirolitica controllata, della resina di impregnazione degli avvolgimenti dei motori elettrici. Il suo PLC comunica mediante protocollo Profinet con il PLC master Siemens Step7 che gestisce la comunicazione bidirezionale tra l'azienda e gli apparati di produzione. A sua volta il PLC Master è connesso alla rete ethernet aziendale. Tramite tale strutturazione è possibile inviare part program al forno Economy 225 e ricevere i dati di produzione grazie all'interfacciamento con la piattaforma appositamente creata su Sw TIA PORTAL v. 16, che

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opera con linguaggio MySql express 2018. Tale piattaforma, appositamente creata in azienda per l'automazione dei processi, funge da gestionale di produzione, consentendo di inviare i dati al forno (ricette); al contempo essa riceve e rielabora i dati di produzione con lo scopo di attuare una perfetta integrazione automatizzata tra macchina ed azienda.

La comunicazione messa in atto tramite tale architettura informatica è di tipo bidirezionale, rendendo inoltre possibile monitorare costantemente l'attività e ricevere segnalazioni di anomalie ed allarmi.

Il sistema consente di:

- Creare un ordine di lavoro da remoto da parte del Responsabile di officina
- Tale ordine di lavoro viene associato ad un numero commessa che lo identifica univocamente
- A tale ordine di lavoro viene associata una ricetta di lavoro (mediante impostazioni di set di parametri che governeranno il processo)
- L'ordine di lavoro, associato alla commessa ed al processo, è visualizzato sulla macchina
- La macchina fa partire il ciclo di lavoro, dietro la supervisione del Responsabile di Produzione
- Il sistema è predisposto per la verifica di anomalie circa la correttezza di avvio dei cicli nel rispetto dell'Odi inviato. Tale aspetto risulta fondamentale in quanto un eventuale errore di sistema potrebbe produrre distruzione del prodotto inserito nel forno o altri rischi correlati.
- La macchina termina il ciclo
- Il sistema consente di monitorare costantemente i dati real time di lavoro (set parametri, tempo di avvio, numero cicli, etc.)
- Il PLC trasmette al PLC master ed al gestionale di produzione i dati di lavoro che vengono elaborati ed archiviati nel server aziendale
- In qualsiasi momento è possibile verificare parametri, date e orari, oltre che ricette e impostazioni di ogni commessa registrata e univocamente identificata mediante numero specifico.

Di seguito una sintesi dei dati in Ingresso ed in Uscita:

Dati in ingresso:

- impostazione commessa/ordine (numero identificativo)
- impostazione ricetta (ghisa / alluminio)
- impostazione rampa di salita (incremento) della temperatura in camera di trattamento: temperatura e tempi
- impostazione durata totale del ciclo
- impostazione temperatura minima nel postcombustore che abilita l'inizio del ciclo

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- impostazione temperatura di intervento del sistema di sicurezza ad acqua ed il suo arresto
- impostazione temperatura di fine ventilazione ed abilitazione all'apertura della porta del forno
- impostazione set point della camera di trattamento
- impostazione numero del gradino attivo
- impostazione durata del gradino attivo, durata del ciclo dal comando di start

Dati in uscita

- monitoraggio costante dello stato del forno
- monitoraggio delle valvole e delle bobine
- verifica cicli di lavoro
- verifica avanzamento commesse
- rilevazione anomalie e gli allarmi
- segnalazione repentina degli allarmi
- verifica trend
- verifica cicli e commesse concluse con indicazione ricetta utilizzata, data e ora di avvio, data e ora di fine

Elenco Indirizzi IP

Il forno risulta identificato dal seguente indirizzo IP: 192. 168.1.112.

Di seguito si rimettono le schermate di collegamento al "forno di distruzione Economy 225" tramite portale di gestione del processo.

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Ricette

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COMMESSA	2022 0384	<input type="text"/>

GHISA

ELENCO RICETTE

ALLUMINIO

GHISA

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SETPOINT TC2	+870,0	
NOME RICETTA	GHISA	ALLUMINIO
COMMESSA	2022 0384	2022 0384

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TEMPO CICLO	+0	
TC1 CAMERA TRATTAMENTO	+28,1	
TC2 POSTCOMBUSTORE	+27,1	
SETPPOINT TC1	+460,0	
SETPPOINT TC2	+870,0	
NOME RICETTA	GHISA	
COMMESSA	2022 0384	

RICETTA INCONGRUENTE
COMMESSA INCONGRUENTE

ALLUMINIO

2022 039

CHECK

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Si segnala che il sistema è dotato di check che consente di verificare la correttezza del ciclo avviato o in avvio a seguito dell'inoltro dell'ODL.

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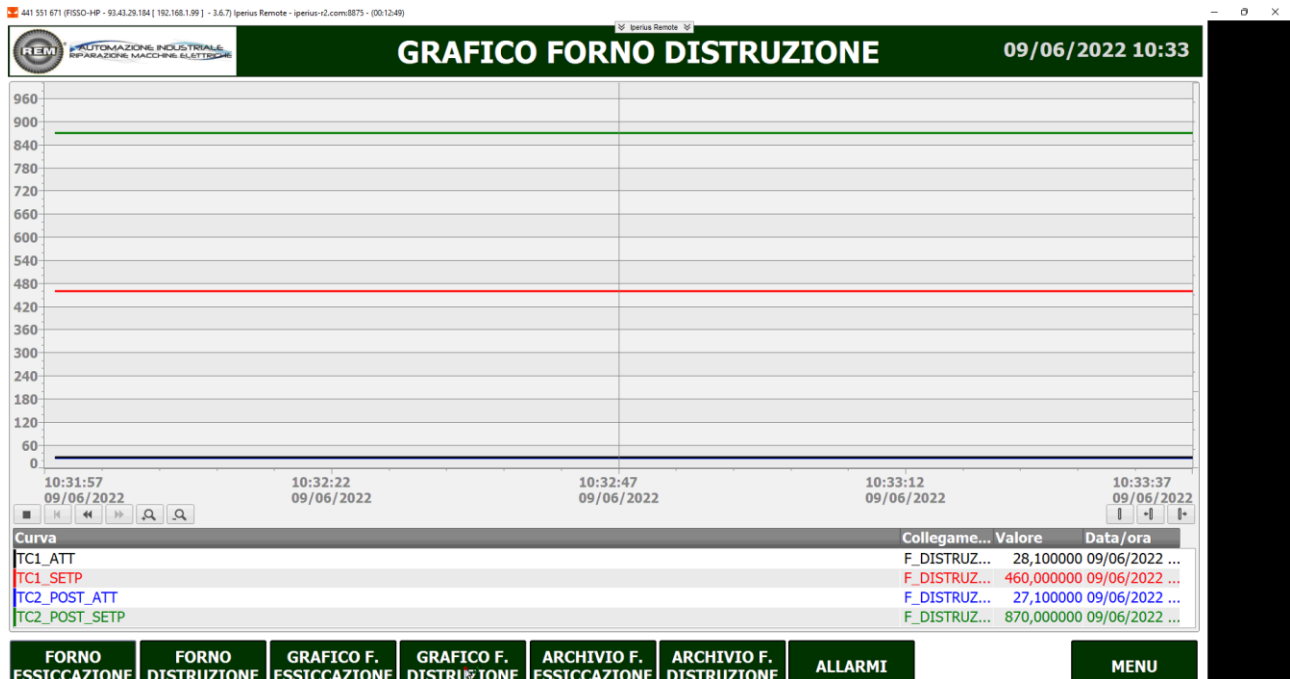
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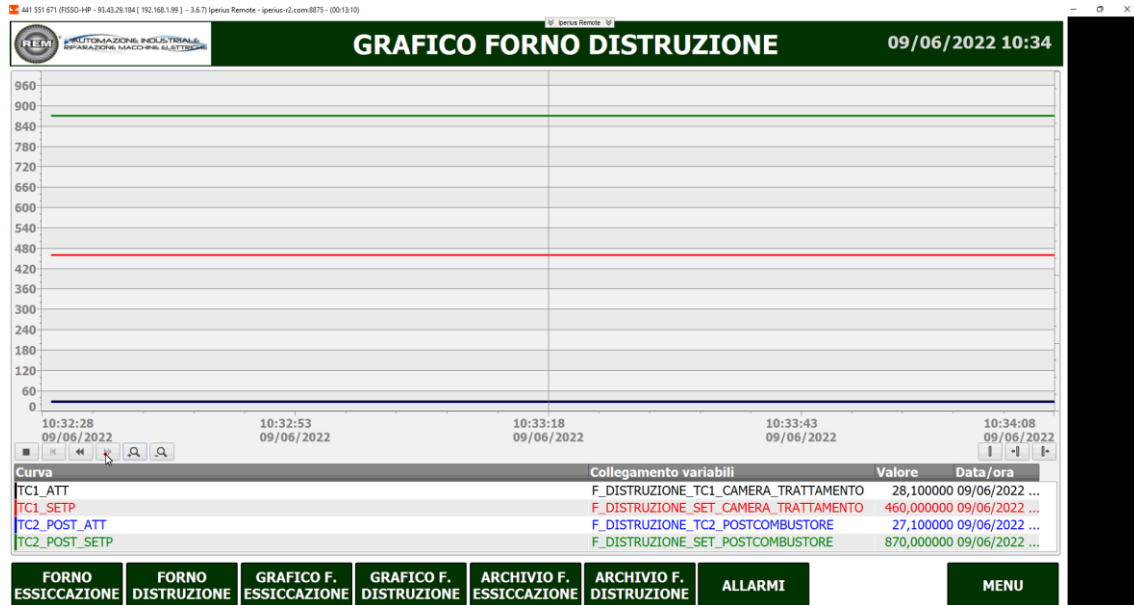
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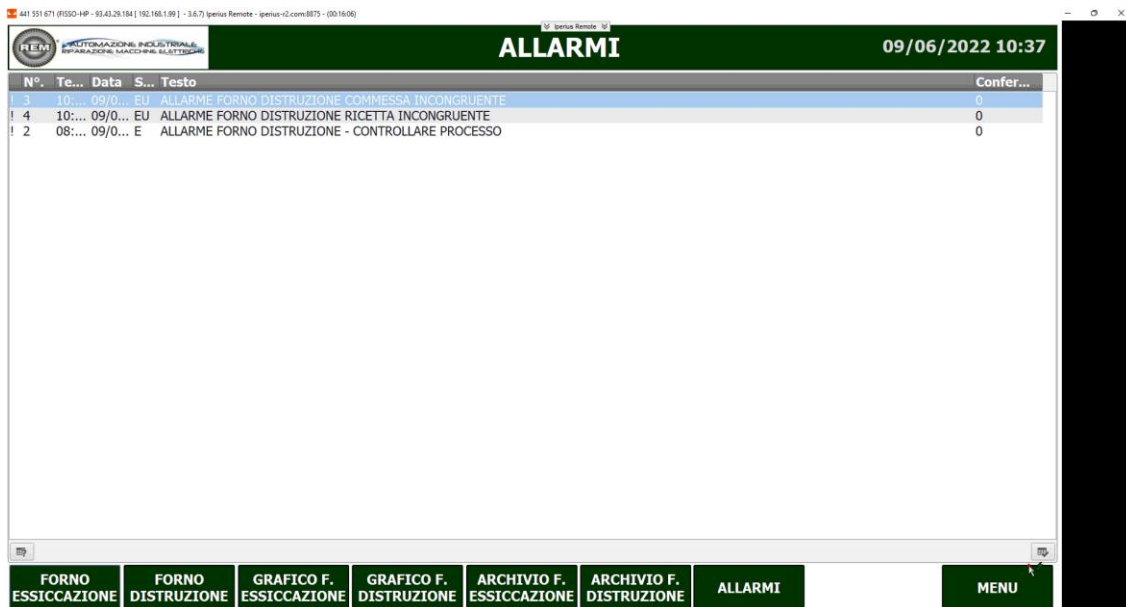
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ANALISI TECNICA No. 21.500.0521

Data: 22.06.2022

Rif. 22.21452

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Allarmi


N°	Te...	Data	S...	Testo	Confer...
3	10:...	09/0...	EU	ALLARME FORNO DISTRUZIONE COMMESSA INCONGRUENTE	0
4	10:...	09/0...	EU	ALLARME FORNO DISTRUZIONE RICETTA INCONGRUENTE	0
2	08:...	09/0...	E	ALLARME FORNO DISTRUZIONE - CONTROLLARE PROCESSO	0

Menu items: FORNO ESSICCAZIONE, FORNO DISTRUZIONE, GRAFICO F. ESSICCAZIONE, GRAFICO F. DISTRUZIONE, ARCHIVIO F. ESSICCAZIONE, ARCHIVIO F. DISTRUZIONE, ALLARMI, MENU

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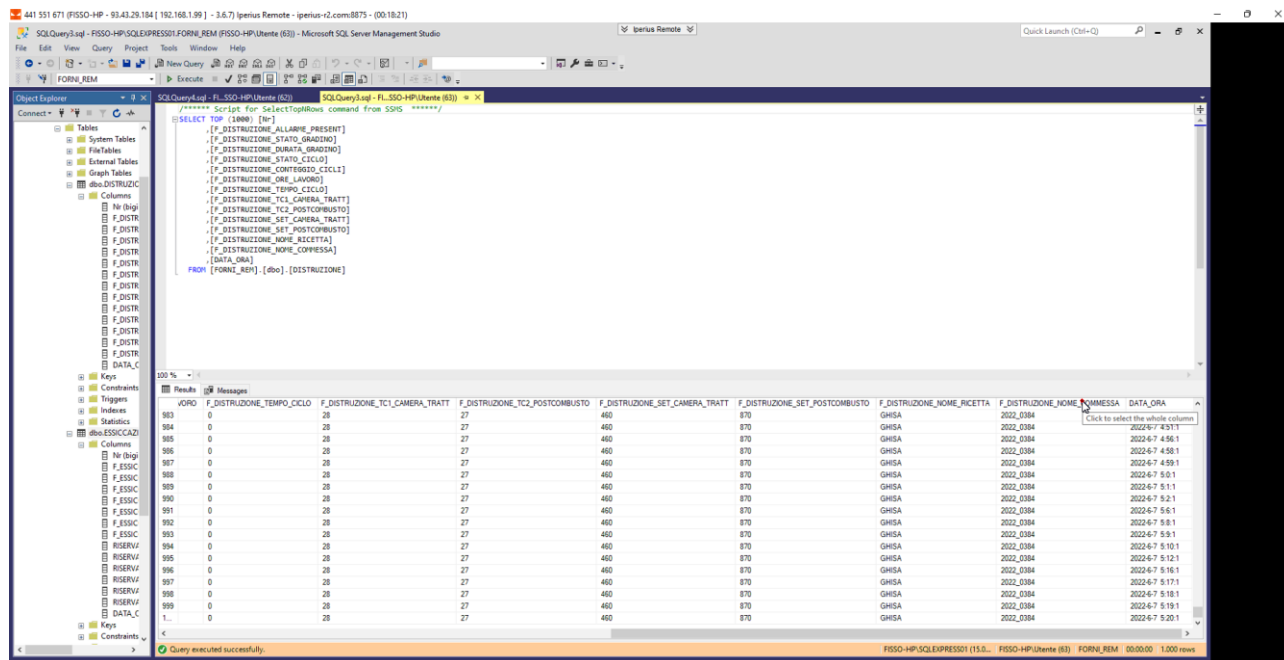
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Archiviazione dati in riferimento alla commessa sul server



ROWID	F_DISTRIZIONE_TEMPO_CICLO	F_DISTRIZIONE_TCI_CAMERA_TRATT	F_DISTRIZIONE_TCI_POSTCOMBUSTO	F_DISTRIZIONE_SET_CAMERA_TRATT	F_DISTRIZIONE_SET_POSTCOMBUSTO	F_DISTRIZIONE_NOME_RICETTA	F_DISTRIZIONE_NOME_COMMESA	DATA_ORA
983	0	28	27	460	870	GHISA	2022_0384	2022-6-7 4:56:1
984	0	28	27	460	870	GHISA	2022_0384	2022-6-7 4:56:1
985	0	28	27	460	870	GHISA	2022_0384	2022-6-7 4:56:1
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989	0	28	27	460	870	GHISA	2022_0384	2022-6-7 5:1:1
990	0	28	27	460	870	GHISA	2022_0384	2022-6-7 5:2:1
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1.	0	28	27	460	870	GHISA	2022_0384	2022-6-7 5:20:1

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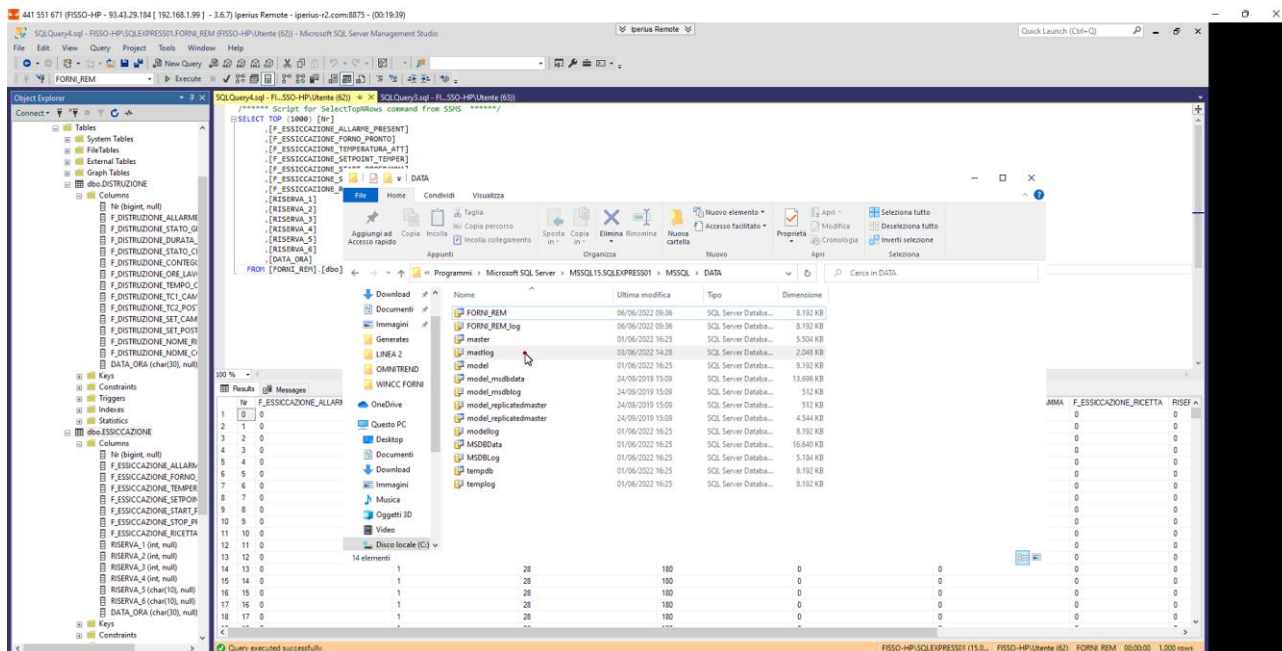
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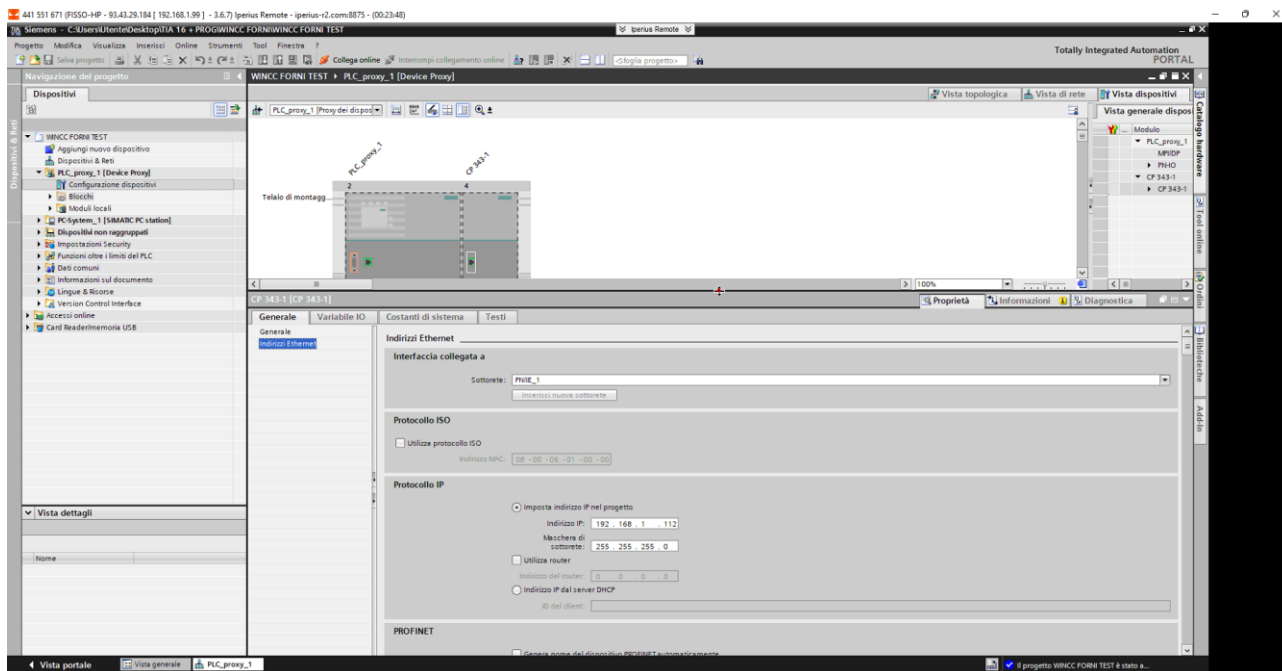
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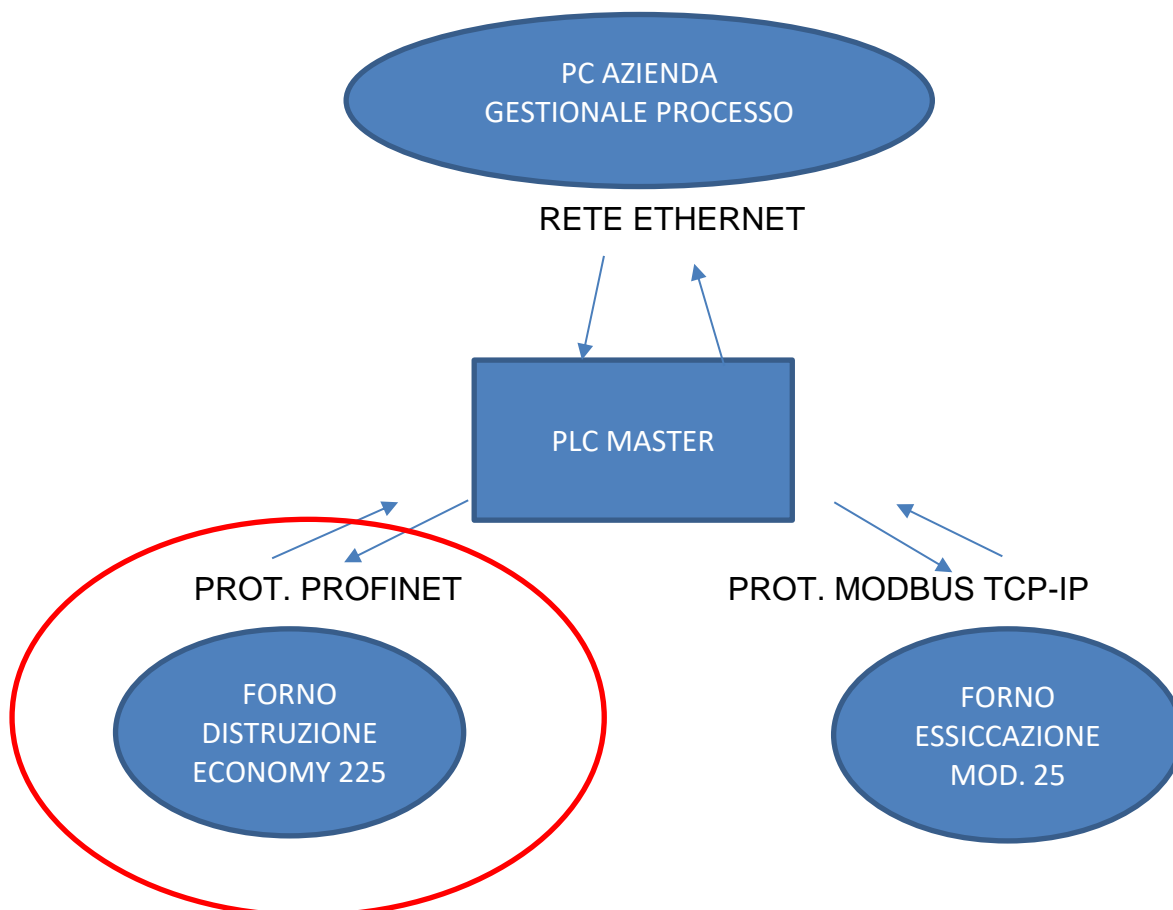
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Di seguito una schematizzazione dell'interconnessione



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Di seguito nella seguente checklist sono indicate le caratteristiche di interconnessione:

N°	Descrizione	
1.a	Scambia informazioni con sistemi interni (sistema gestionale, sistemi di pianificazione, sistemi di progettazione. ecc.) oppure	<input checked="" type="checkbox"/>
1.b	Scambia informazioni con sistemi esterni (clienti, fornitori, partner nella progettazione e sviluppo, altri siti di produzione, ecc.)	<input checked="" type="checkbox"/>
2	Lo scambio di informazioni non richiede l'intervento dell'operatore, se non a livello di selezione, supervisione e controllo delle operazioni	<input checked="" type="checkbox"/>
3.a	Lo scambio di informazioni è bidirezionale (cd. "interconnessione forte")	<input checked="" type="checkbox"/>
3.b	Lo scambio di informazioni è unidirezionale (vd.Circolare MiSE del 1 agosto 2018, n.295485 -cd. "interconnessione debole")	<input type="checkbox"/>
4	Lo scambio di informazioni avviene per mezzo di un collegamento basato su specifiche documentate	<input checked="" type="checkbox"/>
5	Lo scambio di Informazioni avviene per mezzo di un collegamento basato su specifiche disponibili pubblicamente	<input checked="" type="checkbox"/>
6	Lo scambio di informazioni avviene per mezzo di un collegamento basato su specifiche internazionalmente riconosciute o (TCP-IP, HTIP, MOTI, ecc.)	<input checked="" type="checkbox"/>
7.a	Lo scambio di Informazioni avviene per mezzo di protocolli riconducibili a standard "de jure"	<input checked="" type="checkbox"/>
7.b	Lo scambio di informazioni avviene per mezzo di protocolli riconducibili a standard "de facto" o "market-driven" per uno o specifico comparto industriale	<input type="checkbox"/>
8	È identificato univocamente, mediante utilizzo di standard di indirizzamento riconosciuti internazionalmente (Indirizzo IP, Mac o Address, IMEI, ecc.)	<input checked="" type="checkbox"/>

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9.a	La modalità di scambio dati avviene attraverso tecnologie wired	<input checked="" type="checkbox"/>
9.b	La modalità di scambio dati avviene attraverso tecnologie wireless	<input type="checkbox"/>
10	Il requisito di interconnessione si realizza attraverso la guida automatica o semiautomatica delle cd. "macchine mobili" (vd. circolare MiSE 23 maggio 2018, n. 177355)	<input type="checkbox"/>
11	La modalità di scambio informativo avviene tramite dispositivi quali gateway, blackbox, router o simili	<input checked="" type="checkbox"/>
12	Sono presenti control room, o comunque funzioni centralizzate di monitoraggio e/o controllo, per la verifica in tempo reale dei parametri operativi	<input checked="" type="checkbox"/>
13	Sono presenti sensori, eventualmente "embedded", con rilevazione singola o multipla dei parametri operativi	<input checked="" type="checkbox"/>
14	Sono presenti sensori "evoluti" per warning e alert, che possono anche proporre la gestione di eventi (per esempio sensori che prevedono in modo intelligente possibili errori e/o malfunzionamenti in base al raffronto tra parametro storico e parametro attuale)	<input checked="" type="checkbox"/>

Il bene soddisfa il requisito obbligatorio RO2.

- c) Integrazione automatizzata con il sistema logistico della fabbrica e/o altre macchine
Integrazione automatizzata con il sistema logistico della fabbrica o con la rete di fornitura e/o con altre macchine del ciclo produttivo

L'infrastruttura informatica realizzata rende possibile la comunicazione bidirezionale tra azienda e FORNO DI DISTRUZIONE ECONOMY 225, dando la possibilità di integrare i dati provenienti dal macchinario e derivanti dal processo con i sistemi aziendali. Tale integrazione avviene in modalità completamente automatica e riguarda la comunicazione mediante protocollo PROFINET tra PLC Siemens del forno e PLC master aziendale che, ricevendo i dati di produzione, li elabora in formato SQL e li rende visibili all'interno del gestionale di processo opportunamente predisposto. Tali dati

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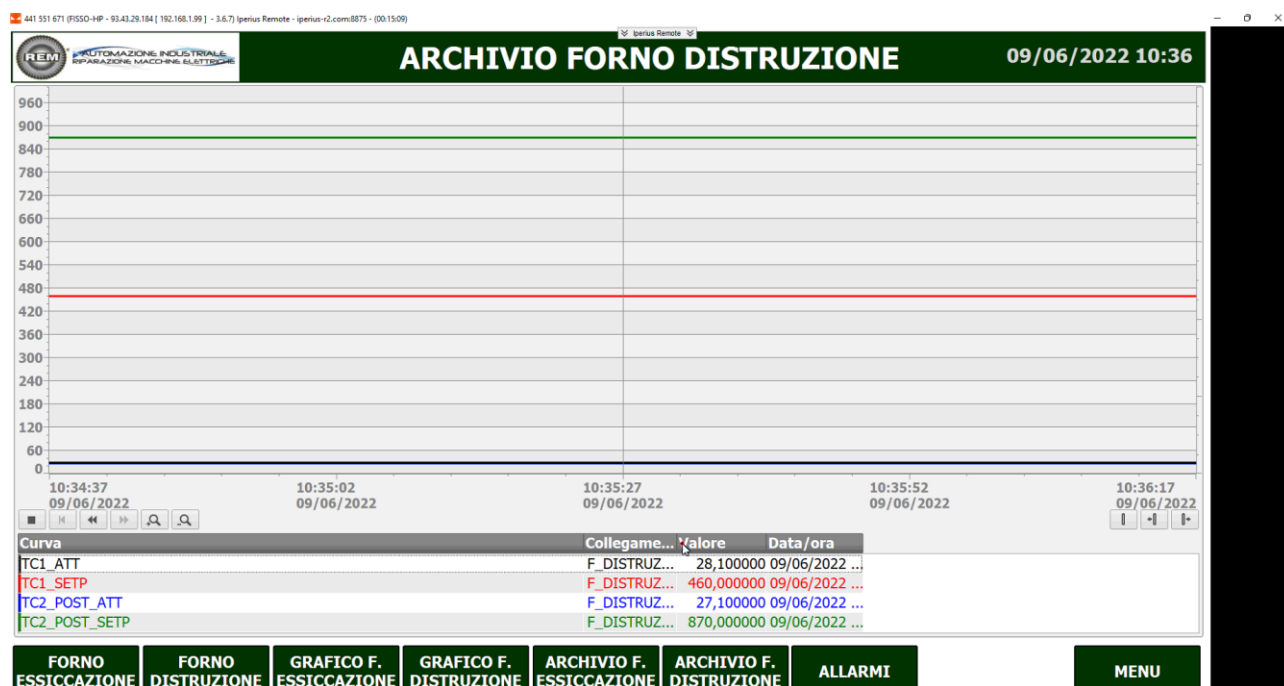
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vengono poi archiviati nel server aziendale, con possibilità di lettura anche storicizzata ed associata ad ogni singola commessa. Nel dettaglio i dati riguardano:

- monitoraggio costante dello stato del forno
- monitoraggio delle valvole e delle bobine
- verifica cicli di lavoro
- verifica avanzamento commesse
- rilevazione anomalie e allarmi
- segnalazione repentina degli allarmi
- verifica trend
- verifica cicli e commesse concluse con indicazione ricetta utilizzata, data e ora di avvio, data e ora di fine

Di seguito le schermate attestanti l'integrazione automatizzata mediante gestionale di processo e report grafici di produzione:



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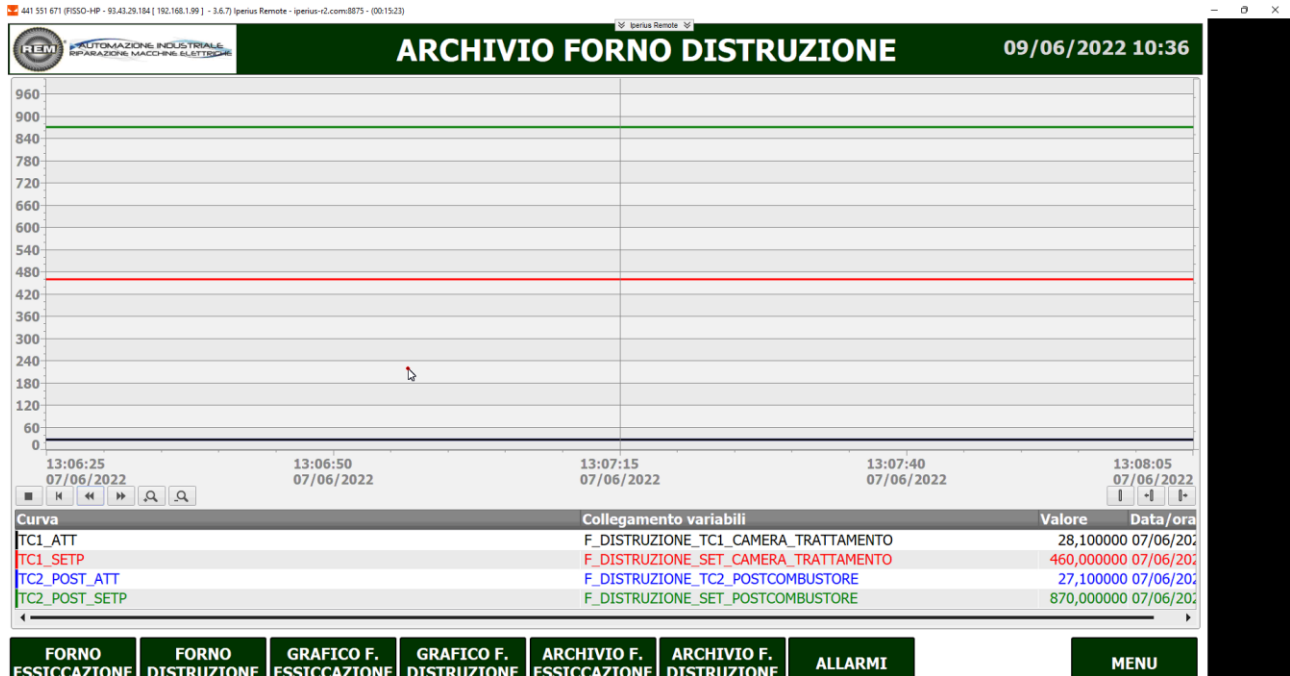
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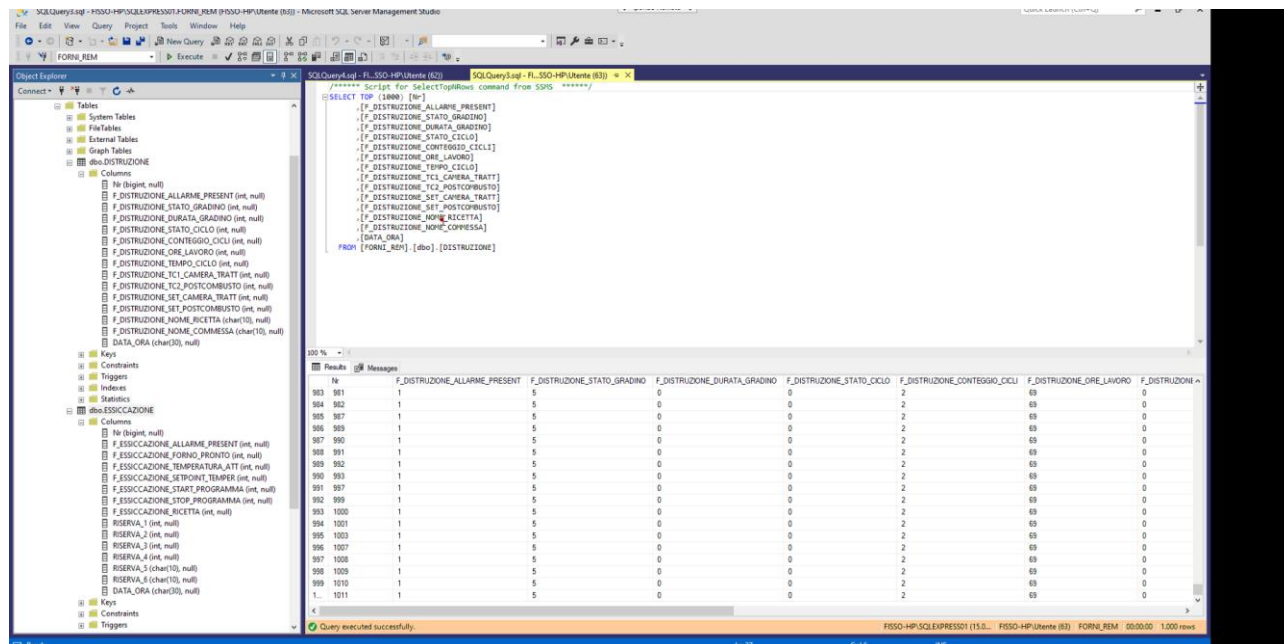
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Report analitici di produzione:



Nr	F_DISTRUZIONE_ALLARME_PRESENT	F_DISTRUZIONE_STATO_GRADINO	F_DISTRUZIONE_DURATA_GRADINO	F_DISTRUZIONE_STATO_CICLO	F_DISTRUZIONE_CONTEGGIO_CICLI	F_DISTRUZIONE_ORE_LAVORO	F_DISTRUZIONE_TCT_CAMERA_TRATT	F_DISTRUZIONE_TCT_POSTCOMBUSTO	F_DISTRUZIONE_SET_CAMERA_TRATT	F_DISTRUZIONE_SET_POSTCOMBUSTO	F_DISTRUZIONE_NOME_RICETTA	F_DISTRUZIONE_NOME_COMMESSA	DATA_ORA
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985 987	1	5	0	0	2	69	0	0	0	0			
986 989	1	5	0	0	2	69	0	0	0	0			
987 990	1	5	0	0	2	69	0	0	0	0			
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991 997	1	5	0	0	2	69	0	0	0	0			
992 999	1	5	0	0	2	69	0	0	0	0			
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997 1008	1	5	0	0	2	69	0	0	0	0			
998 1009	1	5	0	0	2	69	0	0	0	0			
999 1010	1	5	0	0	2	69	0	0	0	0			
1 - 1011	1	5	0	0	2	69	0	0	0	0			

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Anche i dati archiviati sul server possono essere verificati con evidenza del numero della commessa:

SQL Server Enterprise Edition (64-bit) - Microsoft SQL Server Management Studio

File Edit View Query Tools Window Help

New Query Execute

Object Explorer

- Server: MSSQLSERVER
- Databases:
 - dbo:
 - F_DISTRUZIONE
 - F_DISTRUZIONE_TEMP_CICLO
 - F_DISTRUZIONE_TCI_CAMERA_TRATT
 - F_DISTRUZIONE_TC2_POSTCOMBUSTO
 - F_DISTRUZIONE_SET_CAMERA_TRATT
 - F_DISTRUZIONE_SET_POSTCOMBUSTO
 - F_DISTRUZIONE_NOME_RICETTA
 - F_DISTRUZIONE_NOME_COMMESSA
 - DATA_ORA

Query Editor - [F:\SSD\HP\Utere (83)]

```
***** Script for SelectTopRows command from SSRS *****
SELECT TOP (1000) [N]
(
    F_DISTRUZIONE_ALLARME_PRESENTI
    ,F_DISTRUZIONE_STATO_GRADINO
    ,F_DISTRUZIONE_DURATA_GRADINO
    ,F_DISTRUZIONE_STATO_CICLO
    ,F_DISTRUZIONE_CONFIGGIO_CICLI
    ,F_DISTRUZIONE_OME_LAVORO
    ,F_DISTRUZIONE_TEMPO_CICLO
    ,F_DISTRUZIONE_TCI_CAMERA_TRATT
    ,F_DISTRUZIONE_TC2_POSTCOMBUSTO
    ,F_DISTRUZIONE_SET_CAMERA_TRATT
    ,F_DISTRUZIONE_SET_POSTCOMBUSTO
    ,F_DISTRUZIONE_NOME_RICETTA
    ,F_DISTRUZIONE_NOME_COMMESSA
    ,DATA_ORA
)
FROM [FORNI_REMI].[dbo].[DISTRUZIONE]
```

Results

IDROW	F_DISTRUZIONE_TEMP_CICLO	F_DISTRUZIONE_TCI_CAMERA_TRATT	F_DISTRUZIONE_TC2_POSTCOMBUSTO	F_DISTRUZIONE_SET_CAMERA_TRATT	F_DISTRUZIONE_SET_POSTCOMBUSTO	F_DISTRUZIONE_NOME_RICETTA	F_DISTRUZIONE_NOME_COMMESSA	DATA_ORA
983	0	28	27	460	870	GHSIA	2022_0384	
984	0	28	27	460	870	GHSIA	2022_0384	
985	0	28	27	460	870	GHSIA	2022_0384	
986	0	28	27	460	870	GHSIA	2022_0384	
987	0	28	27	460	870	GHSIA	2022_0384	
988	0	28	27	460	870	GHSIA	2022_0384	
989	0	28	27	460	870	GHSIA	2022_0384	
990	0	28	27	460	870	GHSIA	2022_0384	
991	0	28	27	460	870	GHSIA	2022_0384	
992	0	28	27	460	870	GHSIA	2022_0384	
993	0	28	27	460	870	GHSIA	2022_0384	
994	0	28	27	460	870	GHSIA	2022_0384	
995	0	28	27	460	870	GHSIA	2022_0384	
996	0	28	27	460	870	GHSIA	2022_0384	
997	0	28	27	460	870	GHSIA	2022_0384	
998	0	28	27	460	870	GHSIA	2022_0384	
999	0	28	27	460	870	GHSIA	2022_0384	
1	0	28	27	460	870	GHSIA	2022_0384	

Query executed successfully.

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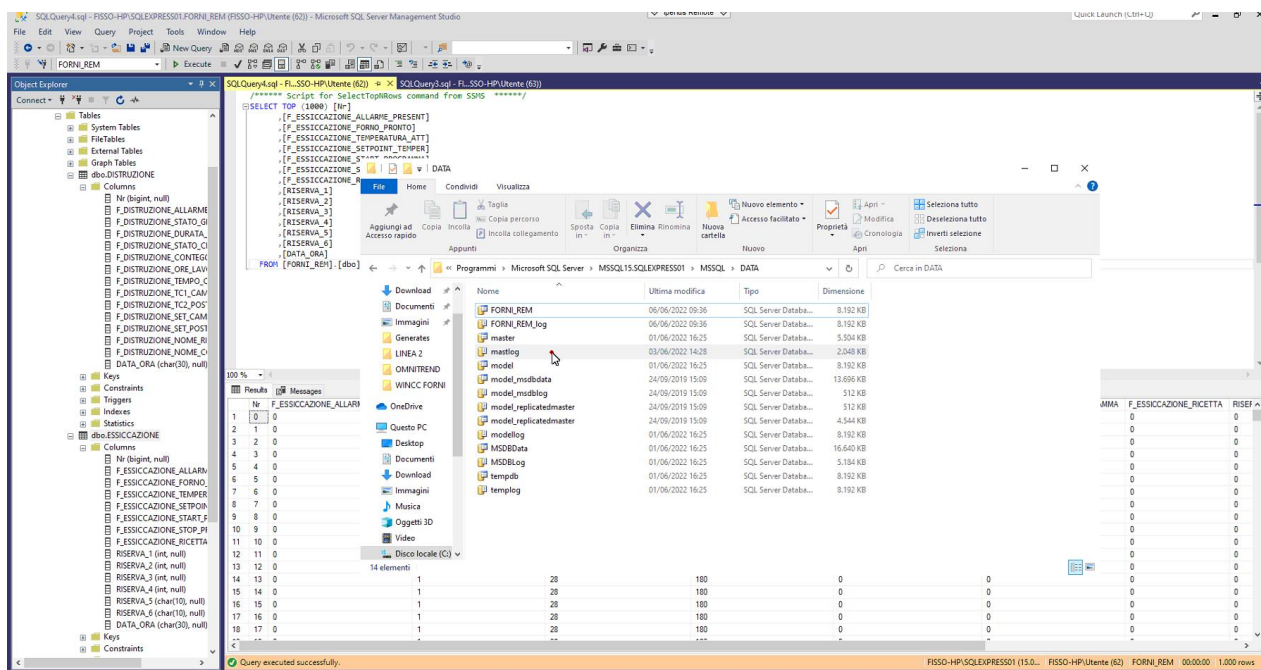
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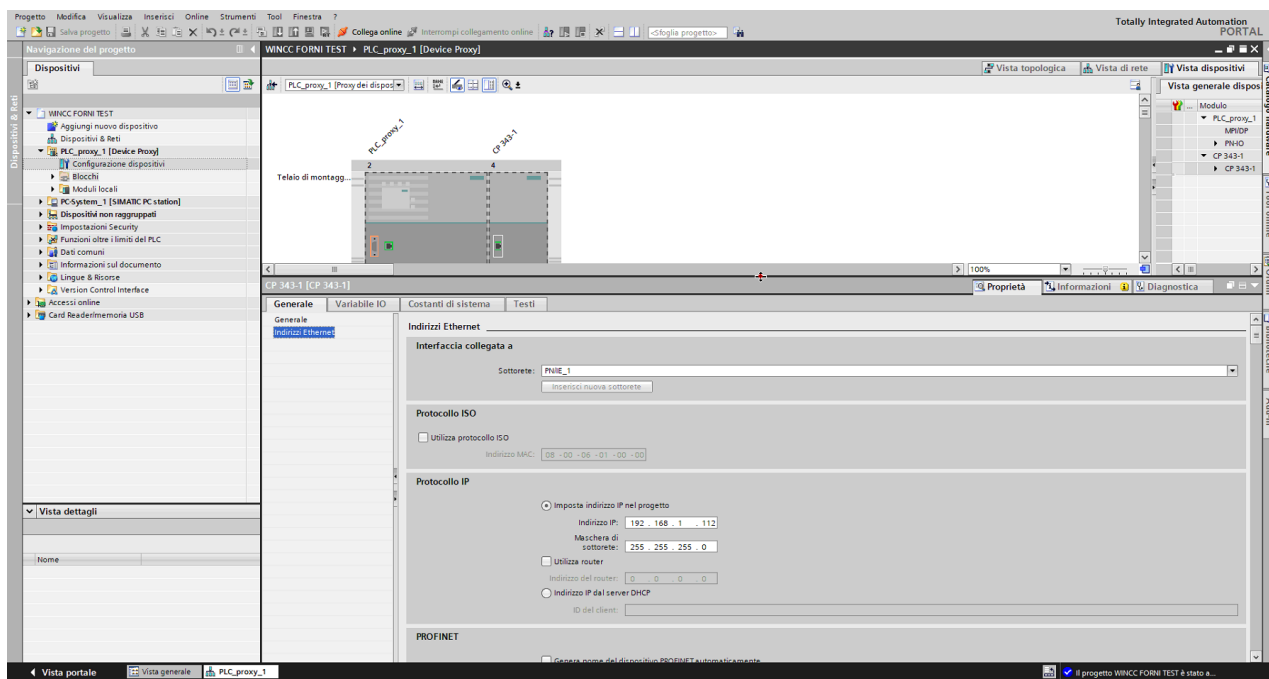
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Il bene soddisfa il requisito obbligatorio RO3.

d) Interfaccia uomo macchina semplice ed intuitiva

Il forno di distruzione ECONOMY 225 risulta dotato di HMI a bordo macchina destinato all'utilizzo ed al controllo della stessa. Trattasi di LCD a colori 7" in grado di monitorare le attività e di visualizzare i cicli di lavoro in relazione alle commesse.

Il pannello risulta semplice ed intuitivo e rende possibile:

- l'utilizzo in sicurezza in ogni situazione ambientale e con indosso i DPI;
- la lettura senza errori in qualsiasi situazione ambientale del reparto produttivo;
- la memorizzazione di dati;
- la ricerca dati;

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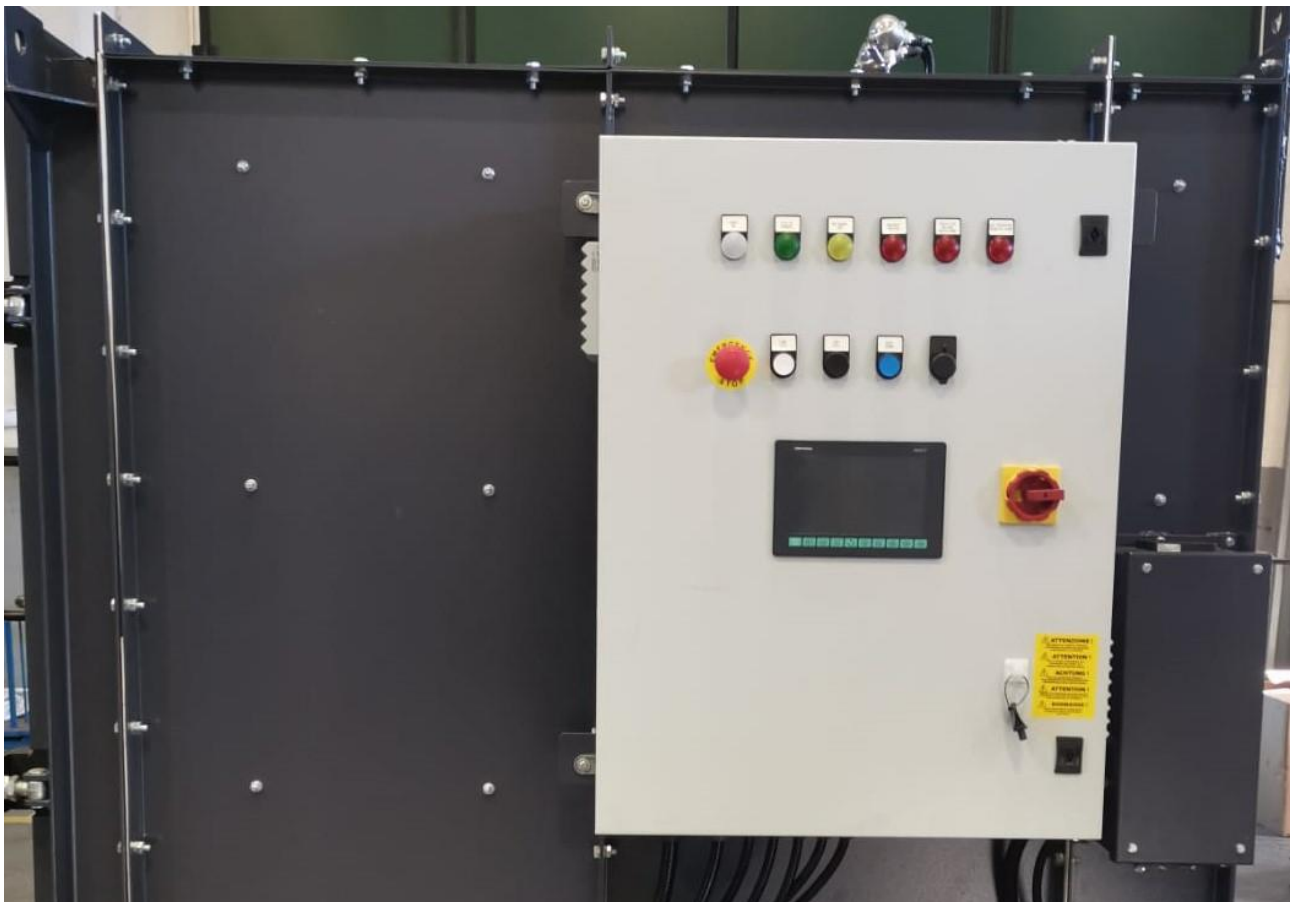
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- presentazione dei dati in schermate successive strutturate per tipo di attività;
- funzionalità di "help";
- Presenza di icone rappresentative dello stato della macchina;
- Presenza di icone rappresentative della schermata;
- Evidenza degli allarmi emergenti e funzioni di diagnostica.

Di seguito la foto dell'interfaccia HMI e le schermate con evidenza delle icone e delle funzionalità:



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Di seguito una foto esemplificativa del display acceso:



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Di seguito una schermata, acquisita da PC connesso in remoto con il forno, con evidenza delle funzionalità dello stesso:



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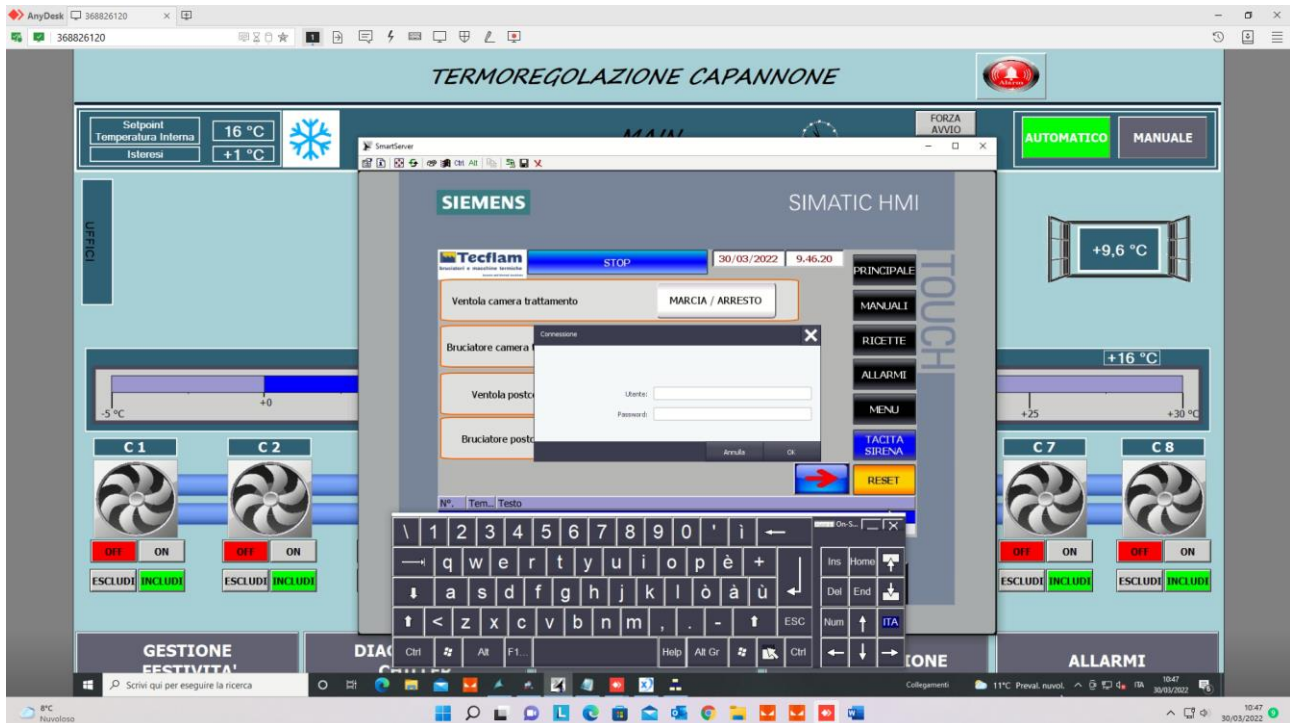
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Il bene soddisfa il requisito obbligatorio RO4.

e) Rispondenza ai più recenti parametri di sicurezza, salute ed igiene sul lavoro

La macchina è marcata CE ai sensi delle direttive di prodotto applicabili ed è accompagnata da:

- Dichiarazione CE di conformità;
- Manuale di istruzioni in italiano.

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Il bene soddisfa il requisito obbligatorio RO5.

f) Sistemi di telemanutenzione e/o telediagnosi e/o controllo in remoto

Il forno ECONOMY 228 è dotato di sistemi di sensori e allarmi che consentono il controllo costante in termini di mantenimento in efficienza e sicurezza. Il PLC dell'apparecchio risulta dotato di interfaccia ALLARMI in grado di registrare automaticamente tutte le anomalie di sistema verificate dai sensori e dai dispositivi di controllo. Mediante accesso remoto al PLC del forno i tecnici incaricati alla manutenzione possono verificarne costantemente la funzionalità e le eventuali anomalie e criticità, risolvendole mediante l'utilizzo del SW embedded del PLC.

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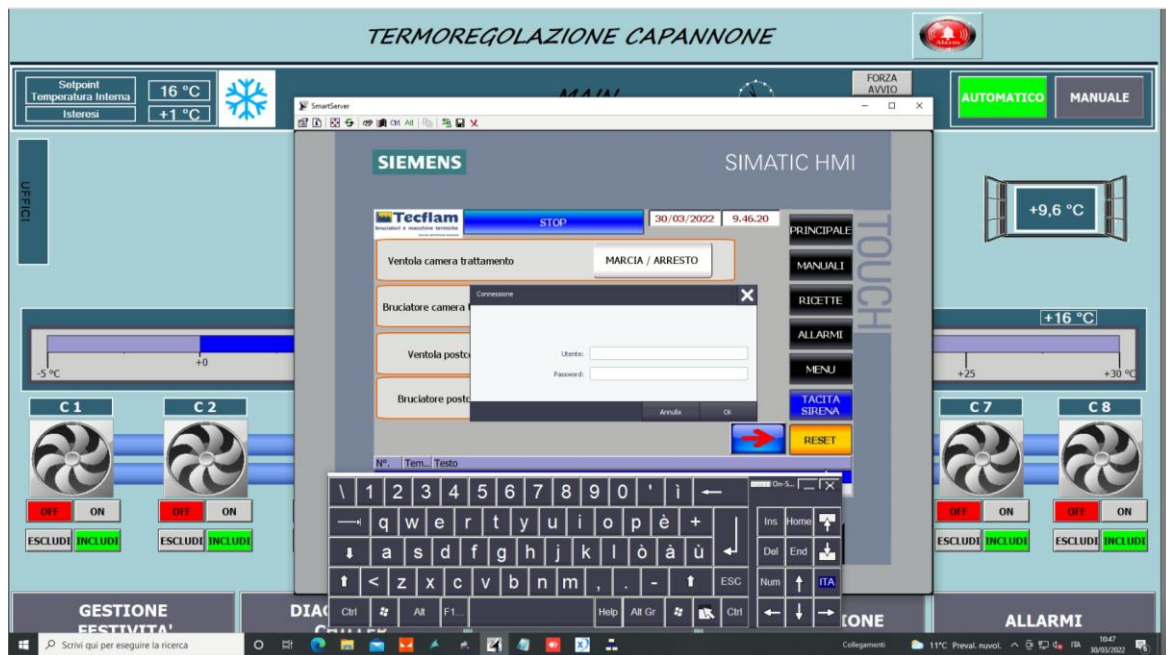
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Allo stesso modo è possibile procedere ad un controllo real time, sia dall'HMI a bordo macchina che da remoto mediante collegamento al PLC, dello stato del bruciatore di combustione, di quello di post-combustione e sullo stato della porta. Tramite tale possibilità, oltre alla verifica delle anomalie e delle criticità è possibile controllare in remoto le impostazioni, le ricette ed i parametri, intervenendo eventualmente in caso di necessità.

ALLARMI/ RICETTE CON ACCESSO PROTETTO da PASSWORD



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REGISTRO ALLARMI


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- ☒ Il bene soddisfa il requisito ulteriore RU1
☐ Il bene NON soddisfa il requisito ulteriore RU1

g) Monitoraggio in continuo

Monitoraggio continuo delle condizioni di lavoro e dei parametri di processo mediante opportuni set di sensori e adattività alle derive di processo

Il forno ECONOMY 225 risulta caratterizzato da un sistema che consente un monitoraggio continuo delle attività, volto sia a garantire il corretto svolgimento dei processi sia la sicurezza e l'efficienza del macchinario. I sensori presenti sul macchinario garantiscono il costante controllo dei sistemi e dei parametri di utilizzo con possibilità di interfacciamento e lettura immediata degli stessi sia a livello

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di HMI locale che da remoto con collegamento da VPN direttamente sul PLC, sia attraverso il gestionale di processo di cui l'azienda si è dotata.

I parametri oggetto di controllo e monitoraggio costante sono rappresentati da:

- temperatura start
- temperatura spegnimento e essiccazione
- temperatura post combustione
- temperatura fine ciclo
- tolleranza spegnimento camera trattamento
- tolleranza apertura acqua
- tolleranza chiusura acqua
- intervallo salvataggio dati
- max temperatura camera trattamento
- temperatura spegnimento post combustione
- temperatura max postcombustione
- temperatura fine raffreddamento
- tempo pausa acqua
- tempo lavoro acqua

Allo stesso modo il gestionale di processo a cui il sistema risulta interconnesso e con il quale comunica in termini di integrazione automatizzata risulta dotato di un sistema di check che consente una verifica del processo prima e durante lo svolgimento delle attività. La verifica riguarda la coerenza e la correttezza tra la ricetta impostata e la commessa di lavoro trasmessa al forno, con sistema che blocca in automatico l'accensione dei bruciatori in caso di anomalia rilevata.

I parametri rilevati e monitorati costantemente dal gestionale di processo sono i seguenti:

- situazione allarmi
- stato gradino
- durata gradino
- stato ciclo
- conteggio cicli
- ore di lavoro totali
- tempo ciclo
- Temperatura camera trattamento

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- Temperatura postcombustione
- Setpoint temperatura TC1 e TC2
- Nome ricetta
- Commessa

Di seguito le schermate:

Visualizzazione dello stato momentaneo (monitoraggio) delle attività del forno tramite **collegamento remoto al PLC del macchinario**:



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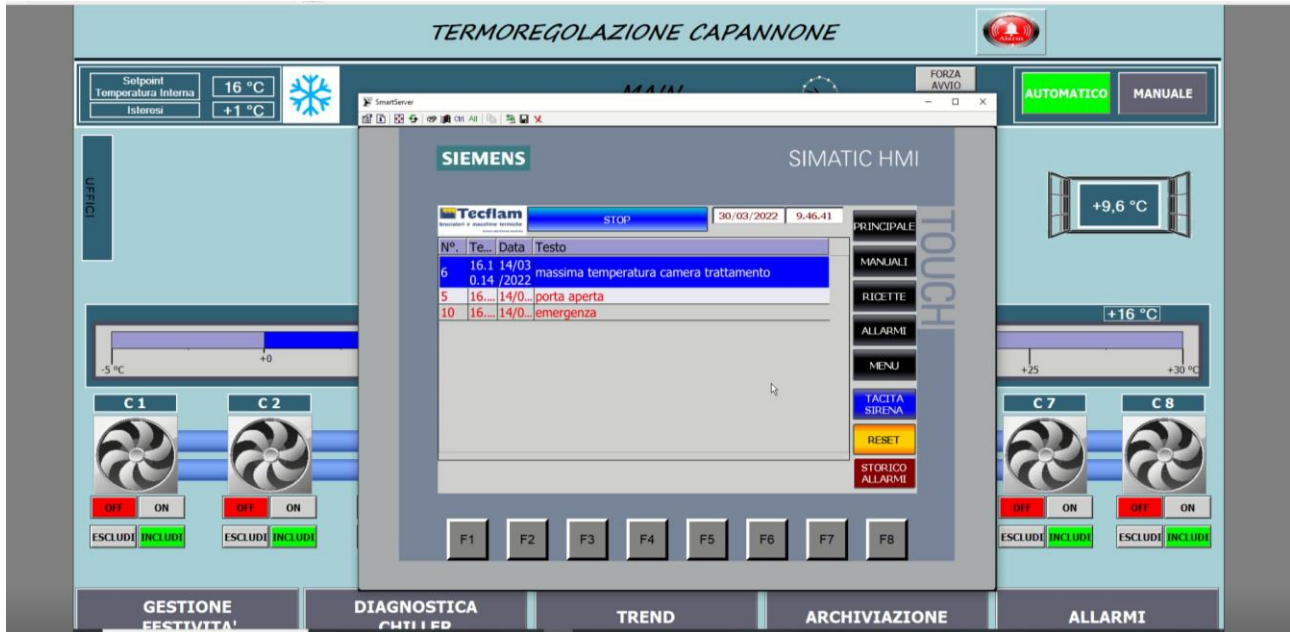
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Visualizzazione situazione allarmi rilevati dai componenti di sistema (Sensori e valvole) tramite **collegamento remoto a PLC del forno:**



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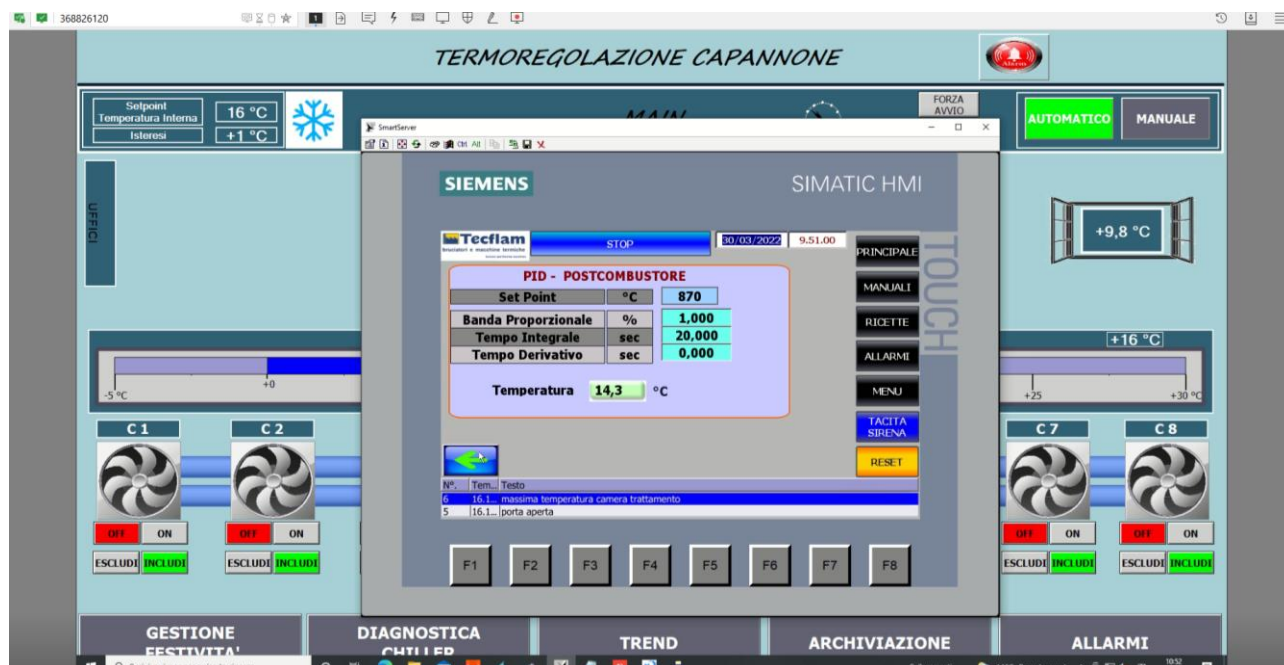
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Visualizzazione set point momentanei tramite collegamento al PLC del forno:



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Parametri di controllo e monitoraggio continuo con collegamento remoto a PLC del forno:


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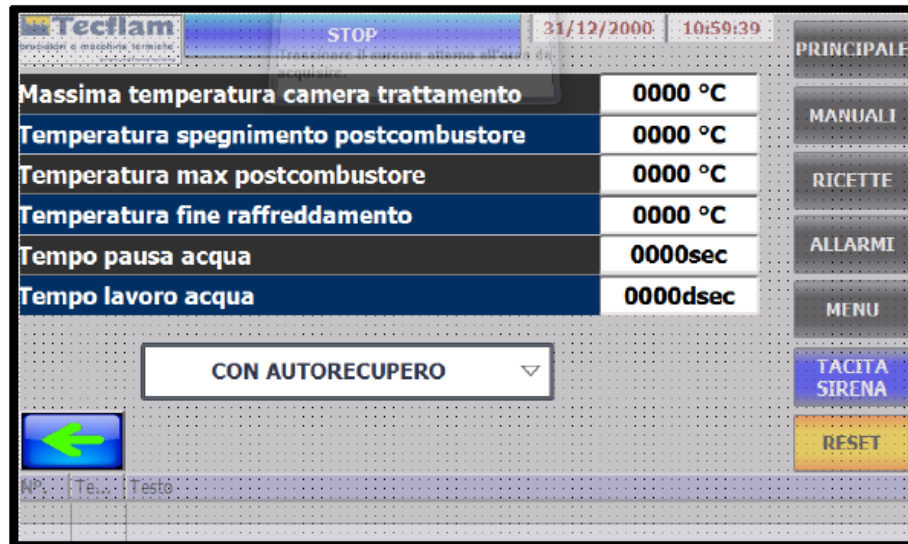
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Tecflam STOP 31/12/2000 10:59:39

Massima temperatura camera trattamento	0000 °C
Temperatura spegnimento postcombustore	0000 °C
Temperatura max postcombustore	0000 °C
Temperatura fine raffreddamento	0000 °C
Tempo pausa acqua	0000sec
Tempo lavoro acqua	0000dsec

CON AUTORECUPERO

←

PRINCIPALE
MANUALI
RICETTE
ALLARMI
MENU
TACITA SIRENA
RESET

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Visualizzazione schermate di monitoraggio continuo da **gestionale di processo**:


441 551 571 (FISIO-HP - 53.43.29.184 [192.168.1.99] - 3.6.7) Iperius Remote - iperius-v2.com/8275 - (00:05:15)

FORNO DISTRUZIONE

09/06/2022 10:25

ALLARME PRESENTE	●	
STATO GRADINO	+5	
DURATA GRADINO	+0	
STATO CICLO	+0	
CONTEGGIO CICLI	+2	
ORE DI LAVORO TOTALI	+69	
TEMPO CICLO	+0	
TC1 CAMERA TRATTAMENTO	+28,1	
TC2 POSTCOMBUSTORE	+27,1	
SETPOINT TC1	+460,0	
SETPOINT TC2	+870,0	
NOME RICETTA	GHISA	<div style="border: 1px solid black; padding: 2px; display: inline-block;"> GHISA ELENCO RICETTE ALLUMINIO GHISA </div> <div style="margin-top: 5px; text-align: center;"> <input type="button" value="CHECK"/> </div>
COMMESSA	2022 0384	

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Check di sistema per verifica non congruità tra ricetta e commessa con conseguente invio di comando di blocco al forno da **gestionale di processo**:

441 551 671 (PSSD-HP - 93.42.26.154 [192.168.1.99] - 3.6.7) (percorso Remote - iperius-v2.com/8875 - 09/05/20)

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ALLARME PRESENTE	●	
STATO GRADINO	+5	
DURATA GRADINO	+0	
STATO CICLO	+0	
CONTEGGIO CICLI	+2	
ORE DI LAVORO TOTALI	+69	
TEMPO CICLO	+0	
TC1 CAMERA TRATTAMENTO	+28,1	
TC2 POSTCOMBUSTORE	+27,1	
SETPOINT TC1	+460,0	RICETTA INCONGRUENTE
SETPOINT TC2	+870,0	
NOME RICETTA	GHISA	ALLUMINIO
COMMESSA	2022 0384	2022 0384

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441 551 671 (PSSO+P - 93.43.26.184 [192.168.1.99] - 3.6.7) (perius Remote - iperius-2.com/8875 - 000540)

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TC2 POSTCOMBUSTORE	<input type="text" value="+27,1"/>	
SETPPOINT TC1	<input type="text" value="+460,0"/>	
SETPPOINT TC2	<input type="text" value="+870,0"/>	
NOME RICETTA	<input type="text" value="GHISA"/>	
COMMESSA	<input type="text" value="2022 0384"/>	

RICETTA INCONGRUENTE
COMMESSA INCONGRUENTE

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MENU

- ☒ Il bene soddisfa il requisito ulteriore RU2
- ☐ Il bene NON soddisfa il requisito ulteriore RU2

h) Caratteristiche di integrazione
Caratteristiche di integrazione tra macchina fisica e/o impianto con la modellizzazione e/o la simulazione del proprio comportamento nello svolgimento del processo (sistema cyberfisico)

Non applicabile

- ☐ Il bene soddisfa il requisito ulteriore RU3
- ☒ Il bene NON soddisfa il requisito ulteriore RU3

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6 Control Check

6.1 Check List 1 – Beni Allegato A strumentali il cui funzionamento è controllato da sistemi computerizzati o gestito tramite opportuni sensori ed azionamenti (Gruppo I)

Voce	Descrizione	
1.01	Macchine utensili per asportazione. In tale contesto si fa riferimento a tutte le macchine atte alla trasformazione di pezzi, indipendentemente dal materiale lavorato (metallo, marmo, polimeri, legno ceramica, ecc) . Ne sono un esempio torni a CN, centri di lavoro, centri di rettifica, ecc	○
1.02	Macchine utensili operanti con laser e altri processi a flusso di energia (ad esempio plasma, waterjet, fascio di elettroni), elettroerosione, processi elettrochimici. Sono comprese, per esempio, macchine per la lavorazione ad ultrasuono (USM), a getto abrasivo (AJM), waterjet (WJM), chimiche (CHM), elettrochimiche (ECM), elettroerosione (EDM), taglio laser (LBM), con fascio di elettroni o di ioni (EBM), plasma (PAM), ecc	○
1.03	Macchine e impianti per la realizzazione di prodotti mediante la trasformazione dei metalli e delle materie prime. In questo caso si intendono macchine e impianti impiegati nell'industria manifatturiera discreta, nell'industria di processo e in quella di trasformazione che devono essere dotati di proprietà di riconfigurabilità, di flessibilità. La voce in elenco è applicabile indipendentemente dal prodotto (o semilavorato) realizzato o trasformato o trattato e dal relativo ciclo tecnologico e indipendentemente dal tipo di realizzazione o trasformazione o trattamento (meccanico, chimico, fisico, ecc) indotto sul prodotto o semilavorato. Per impianto o porzione di impianto si intende un insieme di macchine connesse fisicamente fra loro anche se ogni macchina o attrezzatura funziona in maniera indipendente. L'impianto gode del beneficio fiscale anche nel caso in cui i singoli componenti provengano da fornitori diversi	○
1.04	Macchine utensili per la deformazione plastica dei metalli e altri materiali. Si intendono tutte quelle macchine che eseguono deformazione plastica operanti sia a freddo che a caldo. Ne sono un esempio presse, punzonatrici a CN, laminatoi, pannellatrici, trafilatrici, ecc	○

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1.05	Macchine utensili per l'assemblaggio, la giunzione e la saldatura. In questo caso possono essere compresi anche linee, celle e sistemi di assemblaggio	○
1.06	Macchine per il confezionamento e l'imballaggio. Queste possono includere ad esempio macchine adibite al packaging e all'imbottigliamento	○
1.07	Macchine utensili di de-produzione e riconfezionamento per recuperare metalli e funzioni da scarti industriali e prodotti di ritorno a fine vita (ad es. macchine per il disassemblaggio, la separazione, la frantumazione, il recupero chimico). Sono inclusi i dispositivi che, in un'ottica di economia circolare, sono finalizzati al riutilizzo diretto, alla riparazione, al remanufacturing e al riciclo / riutilizzo delle materie prime. Sono da ritenersi escluse le macchine finalizzate allo smantellamento in discarica e finalizzate al recupero energetico	⊙
1.08	Robot, robot collaborativi e sistemi multi robot	○
1.09	Macchine utensili e sistemi per il conferimento o la modifica delle caratteristiche superficiali dei prodotti o la funzionalizzazione delle superfici. Ne sono un esempio lappatrici, rettificatrici, macchine per trattamenti superficiali, termici e/o chimici, macchine per il coating, macchine per la granigliatura, sabbiatura, pallinatura, vibrofinitura, funzionalizzazione mediante plasma stampa su carta e tessuti, funzionalizzazione con plasma, smaltatura, decorazione della ceramica.	○
1.10	Macchine per la manifattura additiva utilizzata in ambito industriale. Ne sono un esempio le macchine per laser melting / sintering di polveri metalliche o polimeri, ecc.	○
1.11	Macchine anche motrici e operatrici (sono comprese per esempio macchine per l'agricoltura 4.0, quali tutte le trattrici e le macchine agricole portate, trainate e semoventi – che consentono la lavorazione di precisione in campo grazie all'utilizzo di elettronica, sensori e gestione computerizzata delle logiche di controllo; sono inoltre inclusi i dispositivi e macchine di supporto quali , ad esempio, sistemi di sensori in campo , stazioni meteo e droni), strumenti e dispositivi per il carico e lo scarico, la movimentazione , la pesatura e la cernita automatica dei pezzi (ad es. carrelli elevatori, sollevatori, carriponte, gru mobili, gru a portale), dispositivi per il sollevamento e la manipolazione automatizzati (es manipolatori industriali, sistemi di pallettizzazione e dispositivi pick and place), AGV e sistemi di convogliamento e movimentazione flessibili e/o dotati di riconoscimento pezzi (ad esempio sistemi attivi come	○

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	RFID, sistemi passivi come ad esempio QR code, visori e sistemi di visione meccanici). Si precisa che l'espressione macchine motrici non include i veicoli ai sensi della definizione di cui all'articolo 1 della Direttiva 70/156/CEE.	
1.12	Magazzini automatizzati interconnessi ai sistemi gestionali di fabbrica. Si intendono per esempio magazzini automatici asserviti da trasloelevatori o mini loader e software per la gestione delle missioni in/out, i sistemi di selezione prelievo e deposito automatico controllati da software di gestione e/o controllo delle scorte e dei punti di riordino.	○
1.13	Dispositivi, strumentazione e componentistica intelligente per l'integrazione, la sensorizzazione e/o l'interconnessione e il controllo automatico dei processi utilizzati anche nell'ammodernamento o nel revamping dei sistemi di produzione esistenti. Per dispositivi, strumentazione e componentistica si intendono anche package e componenti di impianto purchè assicurino che la macchina o l'impianto oggetto di ammodernamento rispettino, grazie all'ammodernamento, le caratteristiche obbligatorie e le ulteriori caratteristiche. Inoltre, si specifica che, nei casi di revamping di un impianto consegnato prima del 2017, godono del beneficio fiscale solo i beni in oggetto (i dispositivi, la strumentazione, e la componentistica compresi i package e componenti di impianto) e non l'intero impianto ammodernato.	○

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7 Conclusioni

Per quanto sopra indicato con la presente Analisi Tecnica si attesta che il bene << FORNO PIROLITICO ECONOMY 225 S/N 21.2485_90>>

- rientra in una delle categorie definite nell'allegato A che identifica i beni strumentali il cui funzionamento è controllato da sistemi computerizzati o gestito tramite opportuni sensori e azionamenti;
- soddisfa le caratteristiche indicate nell'Allegato A della Legge 11.12.2016 n. 232 e s.m.i.

Il bene pertanto soddisfa tutte le caratteristiche tecniche richieste affinché l'azienda utilizzatrice possa fruire dell'agevolazione fiscale prevista dal Nuovo Piano Nazionale Transizione 4.0.

La presente relazione è stata redatta a titolo confidenziale, fermi i diritti di utilizzo del richiedente per i fini previsti dalla legge e dal contratto.

Fine del documento

Luogo e data di emissione: Milano, 22.06.2022

Ispettore (nome, data e firma):

Ing. Carlo Giussani – 22.06.2022

Resp. operativo (nome, data e firma):

Alessia Michelini – 22.06.2022

On behalf of Business Manager

SGS Italia S.p.A.
On behalf of Business Manager
A. Michelini


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