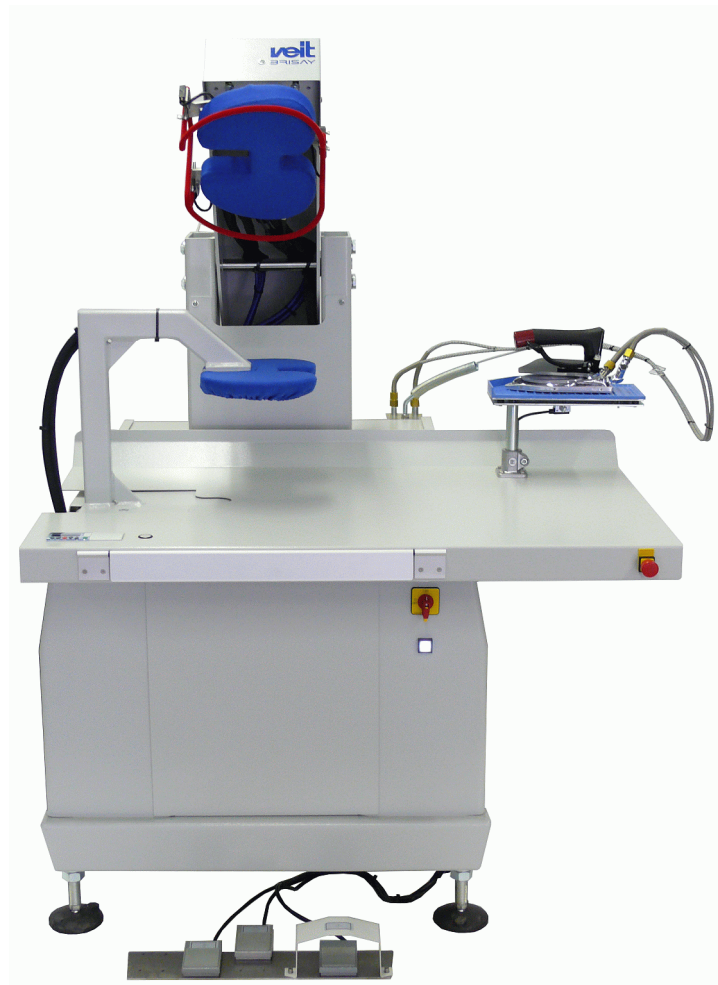


Operating instructions

Translation of the original operating instructions



Manual armhole creasing machine

BRI-2065SC



Read the manual carefully before starting work! Please retain the manual for future use!

VEIT GmbH
Justus-von-Liebig-Str. 15
86899 Landsberg am Lech
GERMANY
Telephone: +49 (8191) 479-0
Fax: +49 (8191) 479-149
Email: info@veit.de
Internet: www.veit-group.com

Copyright

This document as well as the information contained in it are protected by copyright and must not be copied as a whole or in parts or made available to third parties without the written consent of the editor.

Table of contents

1	General information.....	5
1.1	Type plate.....	5
1.2	Declaration of conformity.....	6
2	Intended use.....	7
2.1	Overview of the machine.....	8
2.2	Function.....	8
2.3	Technical data.....	9
2.3.1	Technical data of the machine.....	9
2.4	Scope of delivery.....	11
3	Safety.....	12
3.1	Safety instructions.....	12
3.2	Warning symbols and danger signs.....	13
3.2.1	Designation of the machine.....	14
3.3	Built-in safety systems.....	15
3.3.1	Instructions.....	18
3.4	Safety measures.....	19
4	Potential dangers.....	20
4.1	Danger zones on the machine.....	22
4.2	Duties of the operating company.....	23
4.3	Operating and maintenance personnel.....	24
4.4	Shutdown procedures.....	25
5	Transport and packaging.....	26
5.1	Delivery.....	26
5.2	Unloading and transport to the place of installation....	27
5.2.1	Lifting points.....	30
5.3	Transport safeguard.....	31
6	Installation.....	33
6.1	Setup.....	33
6.2	Installation.....	35
6.3	Commissioning.....	40
6.3.1	Setting instructions for the steam valve.....	41
6.3.2	Setting instructions for the suction valve (single-stage).....	42
6.3.3	Setting of the steam iron.....	43
6.3.4	Setting instructions for the oil brake.....	43
7	Operation.....	45
7.1	Controls and indicators.....	45
7.1.1	Control panel.....	46
7.1.2	Pedal strip.....	47
7.2	Starting the machine.....	48
7.2.1	Emergency stop button was activated.....	49
7.2.2	Safety frame was activated.....	49

7.3	Pressing in manual mode.....	50
7.4	Pressing in automatic mode.....	52
7.5	Pressing using the steam iron (option).....	52
7.6	Switching off the machine.....	53
8	Maintenance.....	54
8.1	Safety frame.....	54
8.2	Changing the pressing covers.....	55
8.3	Placing the cover on the lower buck.....	57
8.4	Placing the cover on the upper buck.....	58
9	Maintenance/cleaning.....	60
9.1	Cleaning.....	62
9.2	Maintenance and inspection table.....	63
9.3	Lubrication.....	64
9.4	Fill level check of oil brake.....	64
9.5	Checks on the machine.....	66
10	Remedy of faults/elimination of defects.....	67
10.1	Fault, cause, remedy.....	68
10.2	Defect, cause, remedy.....	68
10.3	Recommendations for pressing operations.....	71
11	Emergency.....	73
12	Disassembly and disposal.....	74
13	Spare parts lists.....	75
13.1	Spare parts list.....	76
13.2	Spare parts list, steam iron.....	85
13.3	Steam and condensate diagram.....	86
13.4	Cover material.....	88
14	Index.....	90

1 General information

1.1 Type plate

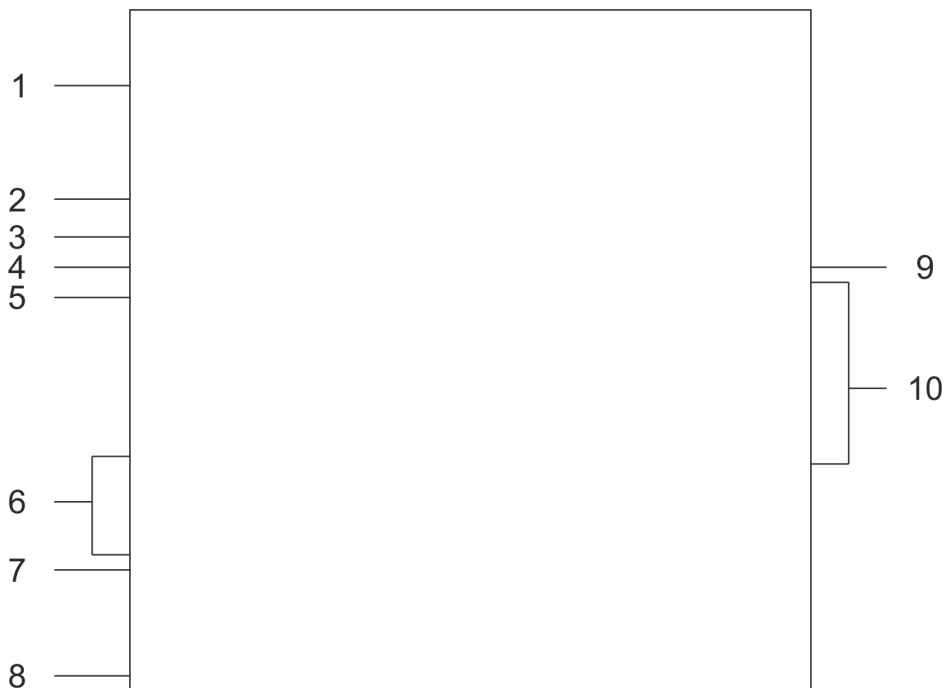


Fig. 1: Typenschild

- | | |
|--------------------------|-------------------------------|
| 1 Address | 6 Diagram numbers, PLC number |
| 2 Designation of machine | 7 Buck number |
| 3 Type of machine | 8 Serial number |
| 4 Version | 9 Order number |
| 5 Year of construction | 10 Weight, connected loads |

General information

Declaration of conformity

1.2 Declaration of conformity


EU-Konformitätserklärung / EU declaration of conformity / Déclaration UE de conformité	
Manufacturer:	VEIT GmbH / Justus-von-Liebig-Str. 15 / D-86899 Landsberg
Model:	Manuelle Ärmelbeistell-Bügelmaschine Manual Arm Hole Creasing Machine
Type: BRI-2065SC	serial number: _____
machine number: _____	CE marking affixed: _____
<p>Die alleinige Verantwortung für die Ausstellung dieser Konformitätserklärung trägt der Hersteller. This declaration of conformity is issued under the sole responsibility of the manufacturer. La présente déclaration de conformité est établie sous la seule responsabilité du fabricant.</p>	
<p>Hiermit erklären wir, dass die Bauart des genannten Produkts in der gelieferten Ausführung folgenden einschlägigen Richtlinien entspricht: Herewith we declare that the supplied model complies with the following provisions applying to it: Par la présente, nous déclarons, que le modèle fourni correspond aux dispositions pertinentes suivantes:</p> <p>Directive 2006/42/EC (L 157/24 - 09.06.2006 - MD)</p> <p>Directive 2014/30/EU (L 96/79 - 29.03.2014 - EMCD)</p>	
<p>Angewandte harmonisierte Normen, insbesondere: Applied harmonized standards, in particular: Normes harmonisées utilisées, notamment:</p> <p>EN ISO 12100:2010 EN 55014-1:2006 + A1:2009 + A2:2011</p> <p>EN 60204-1:2018 EN 55014-2:2015</p>	
<p>Bevollmächtigter für die Zusammenstellung der technischen Unterlagen: Authorized representative for the compilation of the technical documents: Fondé de pouvoir pour l'établissement des documents techniques:</p>	<p>VEIT GmbH Justus-von-Liebig-Straße 15 D-86899 Landsberg Tel: +49 (8191) 479-0</p>
<p>VEIT GmbH Justus-von-Liebig-Straße 15 D-86899 Landsberg Tel: +49 (8191) 479-0 Fax: +49 (8191) 479-199</p> <p>Landsberg, 20.07.2021</p>	
<p> Sascha Oehl (Director Product and Innovation)</p>	

Fig. 2: Declaration of conformity

2 Intended use

This machine has been developed, designed and built for industrial and commercial use only. The machine is intended for operation in closed rooms only.

The BRI-2065SC armhole creasing machine is used to press armholes and sleeves using steam and pressure including a subsequent cooling phase.



NOTICE!

The machine is intended for treating textiles only. The manufacturer will not assume any responsibility for modifications and changes. If the place of installation does not comply with the intended use, rebuilding measures must be taken to ensure a higher protection class (see chapter "Technical data").



WARNING!

This machine is exclusively designed for the purpose mentioned above. Any other or further use as well as any rebuilding or retrofitting of the machine without the written consent of the manufacturer will be deemed as not in accordance with the intended use. The manufacturer shall not be held liable for damages caused by such use. The user alone bears the risk. This also applies to the installation and setting up of safety devices and valves as well as to any changes to load-bearing parts of the machine.

Intended use also includes adherence to operating instructions and compliance with the inspection and maintenance intervals prescribed by VEIT.

2.1 Overview of the machine

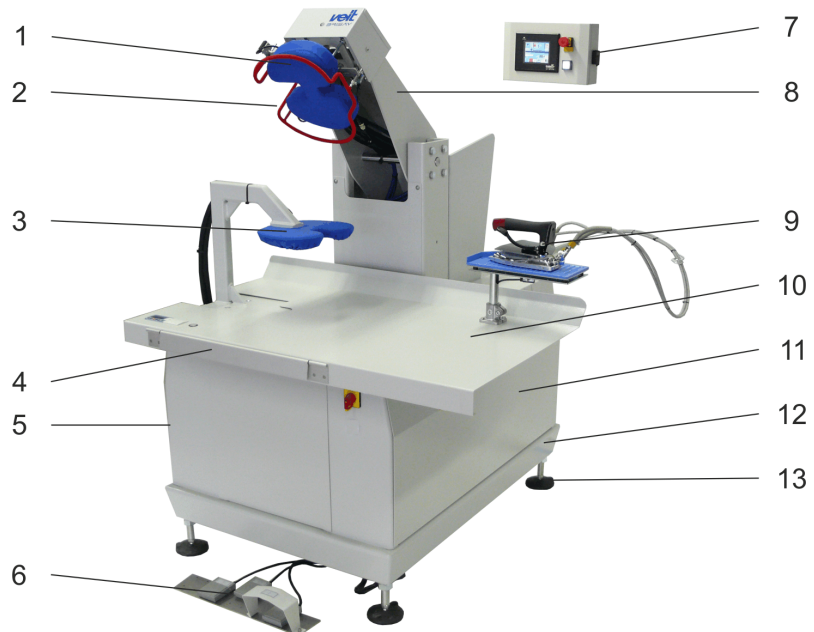


Fig. 3: Overview of the machine

- 1 Upper buck
- 2 Safety frame
- 3 Lower buck
- 4 Switching strip
- 5 Distribution cabinet for steam and suction
- 6 Pedal strip
- 7 Machine control system
- 8 Folding arm
- 9 Steam iron with add-on set (option)
- 10 Table top
- 11 Switch cabinet
- 12 Basic frame
- 13 Machine foot

Not shown:
Garment fall protection

2.2 Function

The armhole creasing machine is used for pressing the armhole and sleeve by applying steam and pressure including a subsequent cooling phase.

Pressing can be done manually or automatically.

All movements of the machine are controlled electropneumatically. The process is controlled by the machine control system.

Operating workflow

- The garment has to be inserted and aligned by the operator.
- The garment is fixed on the lower buck by means of suction. After activating the suction function, the operating cycle can be started.
- The upper buck swivels down.
- The suction function is switched off.
- The steam supply is switched on. Steam is applied to the garment via the steam exhaust ports in the upper buck.
- Once the steam supply is switched off, the upper buck swivels up.
- Due to subsequent suction of the lower buck, the temperature of the garment is reduced and the pressing result is fixed.
- The garment is removed by the operator.

2.3 Technical data



NOTICE!

The machine is intended for treating textiles only. The manufacturer will no assume any responsibility for modifications and changes.

2.3.1 Technical data of the machine

Tab. 1: Dimensions and weight of the machine

Width	1100 mm	
Depth	1300 mm	
Height	1600 mm	
Weight	340 kg	

Tab. 2: Power supply

Supply voltage	230 V, 1P/N/PE	
Power	0.15 kW	
Current consumption	0.7 A	
Frequency	50/60 Hz	
Control voltage	24 V DC	
Protection class	IP43	

Intended use

Technical data > Technical data of the machine

Tab. 3: Compressed air supply

	Machine	
Connected load	6 bar / 0.6 MPa	
Consumption	60 l/min	
Connection (1 x)	12 mm / 0.47 inches	

Tab. 4: Steam supply

Connected load	4.5-6 bar / 0.45-0.6 MPa
Consumption	8 kg/h
Connection (1 x)	1/2"

Tab. 5: Suction

Connected load	120 mbar / 0.012 MPa, minimum	
Consumption	2000 l/min	
Connection (1 x)	1 1/2"	

Tab. 6: Condensate

Connected load	0.5 bar / 0.05 MPa, maximum
Connection (2x)	3/8"

Tab. 7: General data

Ambient temperature	+5°C to +45°C
Noise level	<= 70 dB(A)

2.4 Scope of delivery

The scope of delivery comprises:

1. → BRI-2065SC armhole creasing machine

Standard:

- Steam for upper buck
- Suction for lower buck
- Machine control system
- Garment fall protection

Options:

- Steam iron with add-on set
- Suction via switching strip (only if steam iron is available as an option)
-

2. → Operating instructions

3. → Technical documentation



These operating instructions cover the maximum scope of delivery.

The individual scope of delivery is detailed in the purchase contract.

3 Safety

3.1 Safety instructions

In these operating instructions, warnings and notes are indicated by a symbol and a signal word.

The warning notes are structured hierarchically:



WARNING!

WARNING indicates a potentially hazardous situation which could result in death or serious injury.



CAUTION!

CAUTION indicates a potentially hazardous situation which could result in minor or moderate injury.



NOTICE!

NOTE indicates a potentially harmful situation which could result in damage to the machine and the surrounding area.

3.2 Warning symbols and danger signs

On the machine and in these operating instructions, the following designations or symbols are used for particularly important information:



WARNING!

Electric shocks may lead to death or serious injuries.



WARNING!

Symbol indicating risk of **hand injuries**.



WARNING!

Symbol indicating **risk of burns** caused by hot surfaces.



WARNING!

Symbol indicating risk of **eye injuries** caused by a laser.



CAUTION!

Protection against ESD

Before touching the printed circuit board, make sure that the person is earthed (ESD protection).



NOTICE!

Request to pay particular attention.



Reference to external **operating instructions**.



This symbol labels the connection points for the **protective conductor connection**.

3.2.1 Designation of the machine

The information given in these operating instructions only applies to machines with the order number indicated in chapter "Type plate".

The type plate with the order number is located on the switch cabinet or the basic frame.

For extensive repairs, servicing or relocation of the machine, please contact the VEIT service department. For all enquiries or orders in writing or on the phone, please always quote:

- Type of machine
- Order number of the machine
- Order number of the relevant component (see chapter "Spare parts lists")

Address

Manufacturer

VEIT GmbH
Justus-von-Liebig-Str. 15
D-86899 Landsberg am Lech
GERMANY
Phone +49 8191 479 0
Fax +49 8191 479 149
E-mail: info@veit.de
www.veit-group.com

Service hotline

Germany:	+49 8191 479 133
Europe:	+49 8191 479 252
America:	+1 770 8688060
Asia:	+852 2111 9795
E-Mail:	service@veit.de

Spare parts

Germany:	+49 8191 479 100
America:	+1 770 8688060
Asia:	+852 28349986

3.3 Built-in safety systems

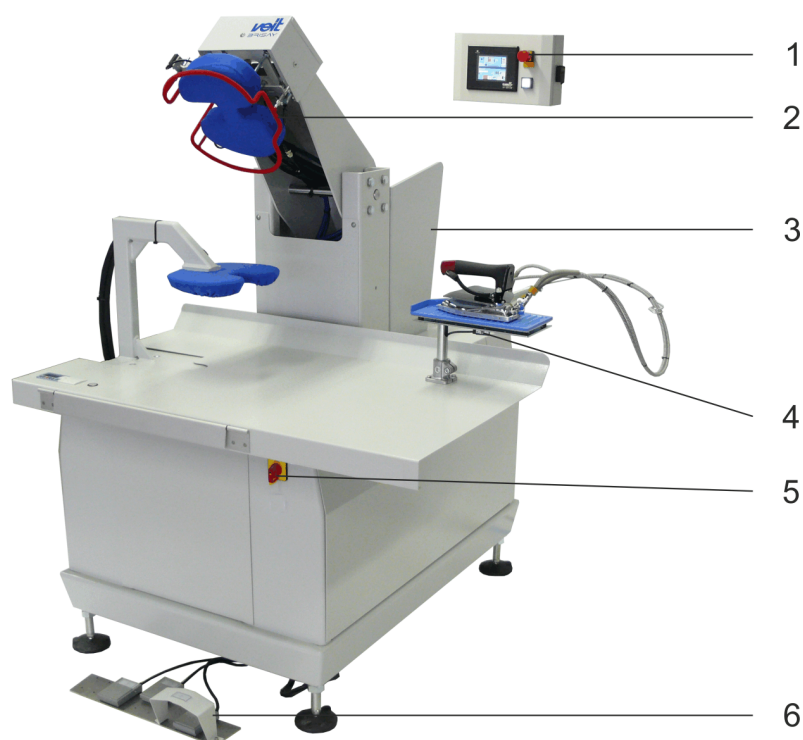


Fig. 4: Safety systems on the machine

- 1 Emergency stop button
- 2 Safety frame
- 3 Guard plate
- 4 Stand for iron
- 5 Main switch
- 6 Hoop guard

Prior to commissioning, the safety systems must be checked as follows at the specified intervals.

Tab. 8: Interval

t	Every day
w	Every week
m	Every month
j	Every year

Tab. 9: Inspection

S	Visual inspection
F	Function check
M	Measurement

Tab. 10: The machine is provided with the following safety devices:

Safety device	Interval	Inspection
Main switch It disconnects/connects the machine from/to the power supply and is located on the switch cabinet on the side of the machine.	t	S/F



WARNING!

During maintenance and repair work, the main switch has to be padlocked in the OFF position to ensure that it cannot be switched on again.

Safety device	Interval	Inspection
Emergency stop button The machine has an emergency stop button which is located on the control panel. Pressing the emergency stop button starts the following sequence: <ul style="list-style-type: none"> ■ The steam supply is cut off ■ The upper buck moves to home position The emergency stop button can be released by pulling it out.	t	S/F
Safety frame A safety frame is mounted around the upper buck at a defined distance. Activating the safety frame starts the following sequence: <ul style="list-style-type: none"> ■ The steam supply is cut off ■ The upper buck moves to home position 	t	S/F
Stand for iron A safety switch is provided below the stand for the iron to prevent unintentional start-up of the machine if the iron is not on its stand.	t	S/F

Safety device	Interval	Inspection
Hoop guard A hoop guard is mounted on the start pedal to prevent unintentional start-up of the machine.	t	S
Guard plate The swivelling range of the cylinder is covered with a guard plate to prevent persons from reaching inside.	t	S



WARNING!

The electric switch cabinet is provided with a special key. It should be kept safe by an authorised person only.



CAUTION!

These operating instructions are a part of the machine and must be available to operating personnel at all times.

The safety instructions they contain must be followed.

It is strictly forbidden to take safety devices out of service or to modify their function.

3.3.1 Instructions

Operating and maintenance personnel will be instructed on site by personnel of VEIT GmbH unless otherwise agreed in the purchase contract.

In case of questions or uncertainties, please contact VEIT GmbH.



WARNING!

The operating company undertakes to introduce any new operating and maintenance personnel to the operation and maintenance of the machine as well as to all safety instructions to the same extent and with the same care.

We recommend that operating and maintenance personnel attend appropriate training at VEIT. Please contact the VEIT service department for further information on training opportunities.

3.4 Safety measures

(To be carried out by the operating company)

The operating company is responsible for:

- Training their operating and maintenance personnel in the use of the machine's safety devices
- Monitoring their operating and maintenance personnel to adhere to the safety measures
- Ensuring that unauthorised persons (i.e. no operating or maintenance personnel) are prevented from entering the danger zone of the machine.

The statutory minimum age for operating and maintenance personnel must be observed.

These operating instructions must be retained for future use.

The prescribed frequency of inspection and control measures must be observed.

In these operating instructions, the operations to be carried out are described in such a way that

- An **instructed person** can understand the instructions given in chapter OPERATION
- An **authorised person** can understand the instructions given in chapter MAINTENANCE
- A **qualified person** can understand the instructions given in chapters TRANSPORT, INSTALLATION, SETTING UP and MAINTENANCE

In the REMEDY OF FAULTS/ELIMINATION OF DEFECTS chapter, the responsible person/qualified person is specified depending on the type of fault.

Instructed person

A person who has been introduced to the tasks assigned to him/her and the possible dangers that can result from improper behaviour, who has been appropriately trained and who has been instructed in the necessary safety devices and safety measures.

Authorised person

A person who operates the machine on a regular basis and who has been instructed by a qualified person from VEIT GmbH, particularly with regard to setting up and servicing the machine, unless agreed otherwise in the purchase contract.

Qualified person

A person who, because of her/his education, knowledge and experience and their knowledge of relevant standards, has been authorised to carry out any operations and who is able to recognise any possible dangers.

The definition follows EN 60204-1:2006+A1:2009.

4 Potential dangers

The safety systems and safety instructions described in these operating instructions must be observed.

The machine is operated from the front.

The operating area and the access area to the machine must be kept free of tools and other objects. Make sure that the operating area at and around the machine is clean and tidy.

We strongly recommend not to change the premises around the machine. The emergency-stop devices as well as the safety devices must be kept accessible at any time. The same applies to escape routes. Boxes and other objects can narrow or even block escape routes and therefore pose a risk to these routes.

Never place tools or other objects on the machine. Due to vibrations, these objects may fall into the machine and cause severe damage.



WARNING!

Risk of crushing!

There is a **risk of crushing** caused by closing and moving of the pressing buck(s).

Particular care must be taken when setting up and servicing the machine. **Risk of crushing.**

- Safety shoes must be worn when adjusting and maintaining the machine in order to avoid crushing.



WARNING!

Risk of burns!

There is a **risk of burns** caused by closing and moving of the pressing buck(s).

Particular care must be taken when setting up and servicing the machine. **Risk of burns.**

- Safety gloves must be worn when adjusting and maintaining the machine on hot machine parts in order to avoid burns.

There is an increased **risk of burns** with all parts connected to steam and condensate (e.g. buck plates, buck plate supports, hoses, hose connections, steam valves, steam distributors, steam injection system).



WARNING!

Never leave the machine unattended. If a buck remains closed over a longer period during operation, there is a **risk of fire**.

Do not wear open, long hair, loose clothes or jewellery. When hair or jewellery gets caught or is heated up, there is a **risk of injuries**.



WARNING!

Risk of eye injuries!

When using positioning lights, make sure that you do not look into the laser beam. **Risk of eye injuries!**



WARNING!

Danger of falling down!

Do not mount on any components of the machine. **Danger of falling down!**

- When carrying out installation work above body height, use the ladders or working platforms provided or a ladder/working platform that meets the required safety standards.
- A safety harness should be worn during maintenance work at heights.



WARNING!

Risk of fire and explosion

Welding, burning, and grinding work on the machine must only be carried out, if this work has been explicitly approved. There may be a **risk of fire and explosion**.

Remove any dust and inflammable material from the machine and the area around it and provide sufficient ventilation before carrying out welding, burning and grinding work. **Risk of explosion!**

Potential dangers

Danger zones on the machine

4.1 Danger zones on the machine

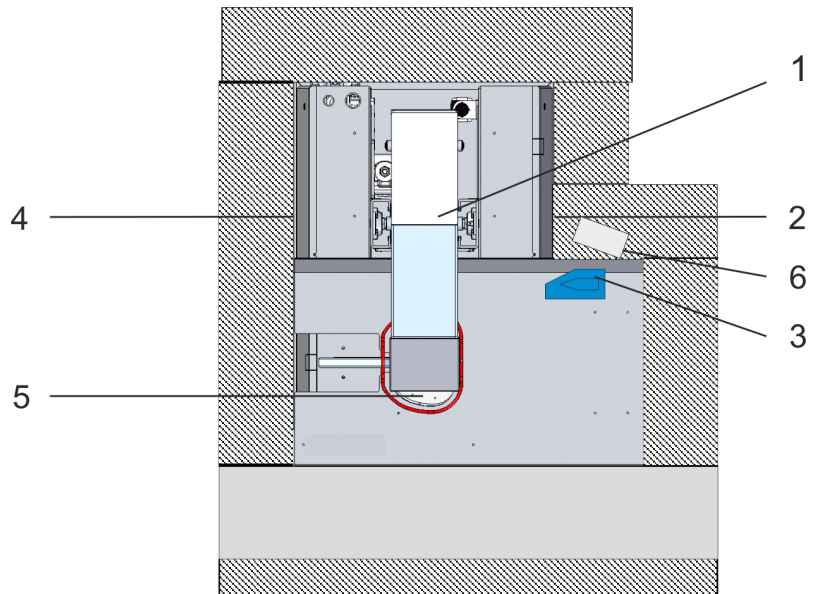
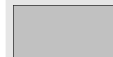


Fig. 5: Danger zones of the machine

- 1 Swivel arm
- 2 Switch cabinet
- 3 Steam iron (option)
- 4 Distribution cabinet for steam and suction
- 5 Bucks
- 6 Machine control system

Operating area



Danger zone during commissioning, servicing, maintenance and repair



CAUTION!

Danger zone

The danger zone is at 1 m around the machine.

The risk of injuries is increased during maintenance work.

4.2 Duties of the operating company

The operating company has to obtain the operating license and must observe the associated obligations.

In addition, the company has to comply with the local regulations on

- Safety of personnel (accident prevention regulations)
- Safety of equipment (protective equipment and maintenance)
- Disposal of products (waste management law)
- Disposal of materials (waste management law)
- Cleaning (cleaning agents and disposal)
- Environmental obligations

**NOTICE!**

Prior to commissioning the machine, the operating company must ensure that the local regulations, e.g. on electric and pneumatic connections, are complied with if the company itself is responsible for setup and installation.

4.3 Operating and maintenance personnel

All persons (operating and maintenance personnel only) who are involved in setting up, installing, commissioning, operating or maintaining the machine must act safely when handling the machine.

This applies in the following cases:

- The machine is operated, serviced and maintained by trained and authorised persons. Personnel who are to be trained, instructed or those who are undergoing general training are only allowed to work on the machine under the constant supervision of an experienced person.
- Responsibility for operating the machine is clearly defined and adhered to when being operated by several persons in order to avoid uncertain competences with regard to safety.
- Shutdown procedures referred to in the operating instructions are always observed during work on the machine (operation, maintenance, repair, etc.).
- Unauthorised people are kept away from the working area of the machine.
- Compliance with safety-conscious and risk-conscious work as described in the operating instructions is checked on a regular basis.
- The operating company only operates the machine while in proper working order.
- In case of malfunctions, the machine is stopped and locked immediately. The relevant department/person has to be informed and the fault has to be remedied immediately by the responsible department.
- The operator immediately informs the responsible department/person about any changes on the machine which might impair safety.

4.4 Shutdown procedures



CAUTION!

Before starting cleaning, maintenance or repair work (by qualified personnel only), the following disconnect procedure must be observed:

Disregarding these procedures presents a risk of death or injury of the personnel.

1. ➤ Cut off the steam supply
 - Cut off the valve for steam supply.
 - Depressurise the steam system by starting the machine.
 - Make sure that no steam emerges from the machine.
2. ➤ Disconnecting the machine from the power supply
 - Set the main switch on the switch cabinet to "0".
 - Padlock the main switch to ensure it cannot be switched on again.
 - Unplug the mains connector.
 - Make sure that no voltage is present.
3. ➤ Cutting off the pneumatic system
 - Cut off the compressed air valve.
 - Exhaust the air from the compressed air lines.
 - **Attention!** The upper buck moves down.
 - Make sure that the machine is depressurised.

5 Transport and packaging

Although machines of VEIT GmbH are carefully checked and packed before being delivered, damages during transport cannot be ruled out.

5.1 Delivery

(Also applies to spare parts and replacement parts)

- Incoming inspection
 - Check the scope of delivery for completeness using the delivery note.
 - Check the delivery for damages (visual inspection).
- Objections

Take the following measures if the delivery has been damaged during transport:

 - Immediately contact the carrier.
 - Retain the packaging (for possible examination by the carrier or for return shipment).
- Packaging for return shipment

Use the original packaging and the original packaging material, if possible.
If it is not available:

 - Engage a packaging company with qualified personnel.
 - Place the machine on a pallet and fasten it using a securing device. (The pallet must be designed to carry the weight of the machine.)

For questions on the packaging and securing device, please contact VEIT GmbH.



NOTICE!

The machine is transported in an upright position.

- Make sure that there is no water in the steam pipe system since this might cause damage to the machine.
- Add a drying agent when packing the electrical equipment.

- Overland shipment
The machine is delivered by truck or train.
- Overseas shipment
In case of overseas shipment, the machine will be welded into a plastic sheet and provided with a drying agent. The machine will be shipped in a sea freight container.



NOTICE!

The drying agent is designed for storage of 3 months and has to be renewed if the machine is stored for a longer time.



Prior to shipment, a transport insurance contract may be concluded following consultation.

- Storage conditions
Closed and dry room with a room temperature between +5°C and +45°C.

Upon delivery, the packaging of the machine and spare or replacement parts is designed for storage of 3 months.

5.2 Unloading and transport to the place of installation



WARNING!

- Make sure that the lifting equipment is designed to carry the weight of the machine. Chains, ropes, hooks, lifting eyes and cross members must be designed to carry the weight of the machine as well.
- If no lifting equipment is available, a transport company has to be engaged for unloading and transporting the machine.
- Pay attention to the machines centre of gravity. The machine must be secured before being transported.
- Avoid shocks and pay attention to hoses on the earthing plate. **There is a risk of injury and machine damage.**
- It is forbidden to stay under suspended loads!

If the machine is delivered in a transport container (ISO container), the information required for unloading (lifting eyes, crane load) is marked on the container.

When unloading, proceed as follows:

Transport and packaging

Unloading and transport to the place of installation

- Unload the machine from the truck using the appropriate means of transport.
- Remove the transport material.
- Remove all loose and additional parts and transport them separately.
- Lift up the machine and transport it to the place of installation.

In case of subsequent deliveries or repairs, the machine must only be transported by qualified personnel using the appropriate means of transport.

Transport using a forklift truck

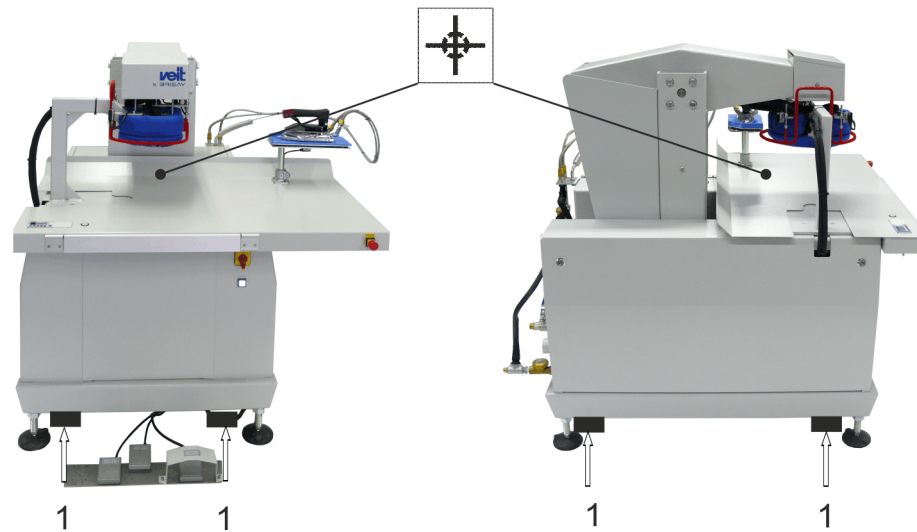



Fig. 6: Transport using a forklift truck, centre of gravity, lifting points

-  Centre of gravity
- 1 Fork lifting points

Lift up the machine using a forklift truck.

- Adjust the width of the fork according to the basic frame dimensions.
- Make sure that the fork reaches entirely underneath the machine and, for safety reasons, protrudes on the other end.
- Make sure that the pedal strip, cables, hoses etc. are not damaged during transport.
- If required, remove the "pedal strip mounting device" as follows:

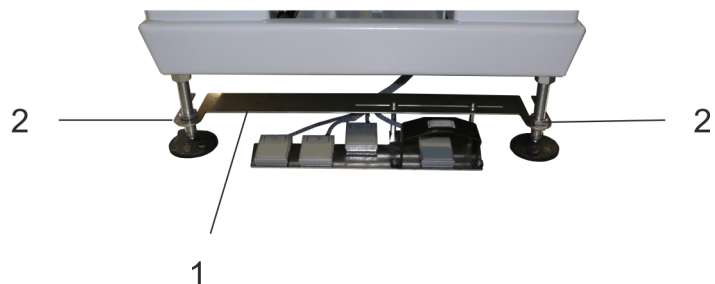


Fig. 7: Pedal strip mounting device

- 1 Pedal strip mounting device
- 2 Hexagon nut

1. ➔ Loosen the upper hexagon nut on the left and right machine foot.
2. ➔ Pull the "pedal strip mounting device" off the machine feet to the front.

Make sure that the cables and hoses are not damaged.

5.2.1 Lifting points

Assembly	Weight	Centre of gravity	Lifting point	Lifting equipment
Entire machine	340 kg, approx.	See chapter "Transport and packaging"	Beneath the basic frame (see chapter "Transport and packaging")	Forklift truck

5.3 Transport safeguard

Prior to transport, the machine has to be secured as follows:

1. ➔



CAUTION!

Cut off the steam supply.

- Cut off both valves for the steam supply.
- Depressurise the steam system by starting the machine.
- Make sure that no steam emerges from the machine.

2. ➔



CAUTION!

The power supply and compressed-air supply remain switched on.



WARNING!

Risk of burns

Make sure that all bucks as well as all parts connected to steam and condensate have cooled down.



NOTICE!

The machine control system is described in separate operating instructions.



Fig. 8: Start screen

3. ➔

After starting the machine, the start screen is displayed.



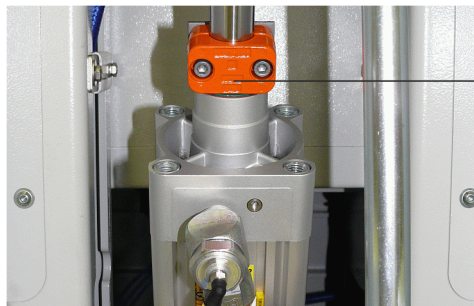
NOTICE!

Safety test necessary!

Carry out the safety test as follows:

- Press the unlock button.
- Activate the safety frame.
- Press the unlock button.

4. ➤ Select "Pressure level 2 bar" in the "Set single track" multi-functional track supervisor function.
5. ➤ Press the "start" pedal. The upper buck closes.



1

Fig. 9: Transport safeguard

6. ➤ Secure the pivoting cylinder using the transport safeguard (see Pos. 1).
7. ➤ Cut off the compressed air supply, and exhaust air from the compressed air lines via the maintenance unit.
8. ➤ Set the main switch on the switch cabinet to "0" and unplug the mains connector.
9. ➤ Remove the connection lines for compressed air, suction, steam and condensate drain provided by the customer.
10. ➤ Pack the steam iron (option).

6 Installation

6.1 Setup

The machine will be set up, assembled and installed by qualified personnel of VEIT GmbH or by qualified personnel provided by the customer. In case of subsequent deliveries, the subassemblies must be disassembled or assembled by qualified personnel only.

- Make sure that the statics of the building are designed to carry the weight of the machine.
- The machine has to be set up on an even surface.
- The energy supply (electric and compressed air connections, connection for steam supply) as well as the connections for condensate and suction must be available.
- Make sure that there is enough space around the machine to carry out service and maintenance work.

**NOTICE!**

If the place of installation does not comply with the intended use, rebuilding measures must be taken to ensure a higher protection class (see chapter "Technical data").

Alignment



NOTICE!

Working height

The working height for the operating personnel can be adjusted from 95 cm to 105 cm.

- Move the forks of the forklift truck underneath the machine (see chapter "Transport"). Lift up the machine to the desired working height.
- Open the counter nuts (Pos. 1) and put the machine feet (Pos. 2) on the ground.

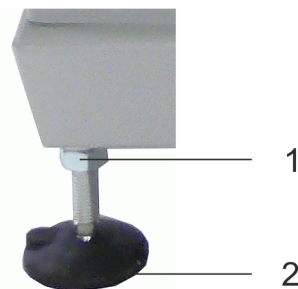


Fig. 10: Height adjustment

- After putting the machine down, place the spirit level onto the machine frame. Align the machine in X and Y direction by adjusting the machine feet (Pos. 2).
- Tighten the counter nuts (Pos. 1) firmly.
- Mount the pedal strip according to the required operating position. Proceed as follows:

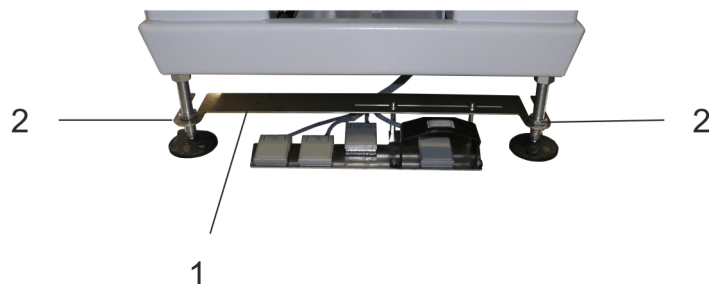


Fig. 11: Pedal strip mounting device

- 1 Pedal strip mounting device
- 2 Hexagon nut

1. ➔ Slide the "pedal strip mounting device" over the lower nut on the threaded rod of the left and right machine foot.
2. ➔ Tighten the upper hexagon nut on the left and right machine foot.

- Remove the steam iron (depending on the setup of the machine or as an option) from the packaging and place it on the stand.
- Remove the transport safeguards (see chapter "Transport safeguards").



NOTICE!

Degrease all the guiding shafts and/or linear travelling frames prior to commissioning.

6.2 Installation

Power supply connection

The machine is provided with a connector. The connector must be freely accessible and must not be blocked. Direct connection without connector is not permissible.

Connection to the mains must be protected on site. The regulations of the local distribution system operators (DSO) must be observed. For the connection and protection on the line side, please refer to the data in the circuit diagram or on the type plate.

The connection cable must be laid in order not to contact hot steam and condensate lines and such that operating persons cannot trip over.



CAUTION!

Observe the input voltage.

The machine must only be operated with the voltage and current indicated on the type plate.

Make sure to observe the mains frequency.



WARNING!

Work on electric supply lines must only be carried out by a qualified electrician. Unplug the mains disconnecting device prior to opening the machine. Danger to life.



WARNING!

Mains disconnecting device

The mains disconnecting device of the machine is the connector of the mains connection cable.

Unplug the mains disconnecting device (unplug the connector) to switch off the machine in the event of danger.

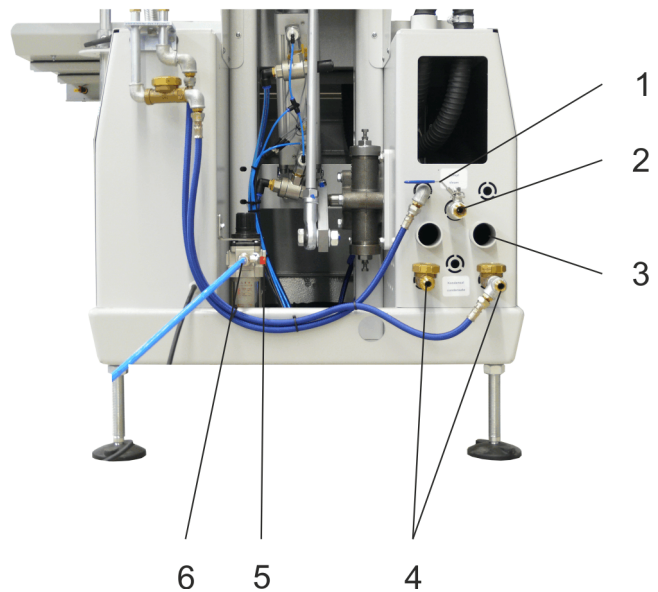


Fig. 12: Supply connections on the machine back side

- 1 Stop valve for steam supply
- 2 Steam supply connection
- 3 Suction connection
- 4 Condensate drain connection
- 5 Stop valve for "machine control system" compressed air supply
- 6 "Machine control system" compressed air connection

Compressed air supply connection

- Connect the compressed air connection (Pos. 6) to the compressed air supply provided by the customer.

Suction connection

- Connect the suction line (Pos. 3) to the suction system provided by the customer.

Condensate drain connection

- Connect the condensate drain connection (Pos. 4) to the appropriate connection line provided by the customer.

Steam supply connection

- Connect the steam connection (Pos. 2) to the steam supply provided by the customer.



NOTICE!

For the connection data, please refer to chapter "Technical data".

For proper machine connection, we recommend using original connections from VEIT GmbH (available as an option).

» Continued on the next page

Prior to commissioning the machine, the operating company must ensure that the local regulations, e.g. on electric and pneumatic connections, are complied with if the company itself is responsible for setup and installation.

Notes on compressed air quality



NOTICE!

Use clean compressed air which is free from oil and condensate.

Compressed air quality requirements:



CAUTION!

Use clean air (quality class 3 according to DIN ISO 8573-1) or higher with the following properties:

Class	Particles		Water		Oil
	Max. particle size in μm	Max. particle density in mg/m^3	Pressure dew point in $^{\circ}\text{C}$	Water content in mg/m^3	Residual oil content in mg/m^3
3	5	5	-20	880	1

Clean and condensate-free compressed air prevents machine downtimes and increased maintenance costs.



NOTICE!

Unclean compressed air

Using compressed air that contains chemicals, synthetic oils with organic solvents, salts, caustic gases, etc. could lead to damage or malfunctions of the machine.

Do not use compressed air that contains chemicals, synthetic oils with organic solvents, salts, caustic gases, etc.

1. ➔ Install air filters as close as possible to the valves on the input side. Select a filtration grade of 5 μm or smaller.
2. ➔ Install an aftercooler, air dryer or water separator (condensate drain) or similar. Compressed air containing high amounts of condensate may lead to malfunctions of the valves or other pneumatic equipment. To prevent damage of this nature, an air dryer, aftercooler, water separator, or similar should be installed.
3. ➔ Remove excessive coal dust by installing a microfilter on the input side of the valve. Large amounts of coal dust generated by the compressor may deposit in the valve and lead to malfunctions.

6.3 Commissioning

When commissioning the machine, proceed as follows:

1. ➤



CAUTION!

Remove the transport safeguards (see chapter "Transport safeguards").

2. ➤

Slowly open the stop valve of the "machine control system" compressed air supply (see chapter "Installation").



CAUTION!

The upper buck opens.

3. ➤

Switch on the main switch on the switch cabinet.

4. ➤

Release the emergency stop button by pulling it out.

5. ➤

Press the unlock button.

6. ➤

Press once to activate the safety frame (checking the safety devices).

7. ➤

Press the unlock button.

8. ➤

Open the customer's condensate stop valve.

9. ➤

Slowly open the stop valve of the steam supply (see chapter "Installation").

10. ➤

Adjust the steam and suction valves, if required (see chapter "Setting instructions for the steam valve" and "Setting instructions for the suction valve").

11. ➤

Adjust the steam iron (see chapter "Setting of the steam iron").

6.3.1 Setting instructions for the steam valve



WARNING!

Setting must only be carried out by a **qualified person**. This person has to ensure that the machine cannot be started during the setting procedure.



Fig. 13: Steam valve

Turn the setting screw

- To **the right** to reduce the steam volume
- To **the left** to increase the steam volume

6.3.2 Setting instructions for the suction valve (single-stage)



WARNING!

Setting must only be carried out by a **qualified person**. This person has to ensure that the machine cannot be started during the setting procedure.

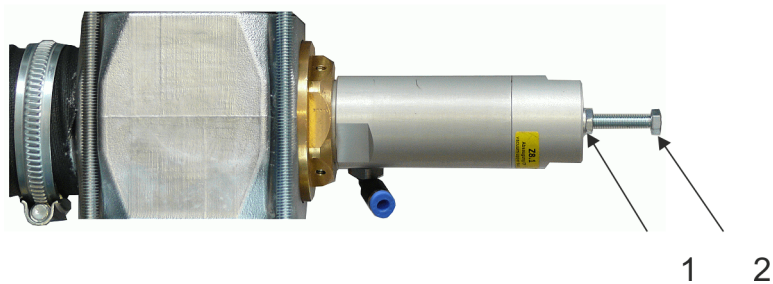


Fig. 14: Suction valve (single-stage)

1. ➤ Loosen the counter nut (Pos. 1).
2. ➤ Turn the setting screw (Pos. 2)
 - To **the right** to reduce the suction volume
 - To **the left** to increase the suction volume
3. ➤ Tighten the counter nut (Pos. 1).

6.3.3 Setting of the steam iron



CAUTION!

With all parts connected to steam and condensate, there is an increased **risk of burns**.

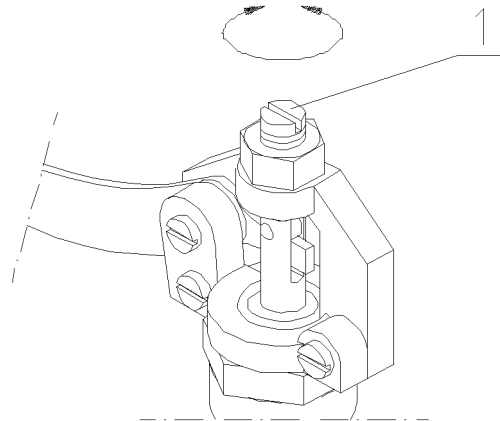


Fig. 15: Setting the steam iron

The steam volume emerging from the Teflon sole can be controlled.

1. To increase the steam volume, loosen the plastic nut on the top of the valve and turn the setting screw (Pos. 1) counter-clockwise.
2. Turning the setting screw (Pos. 1) clockwise reduces the steam volume.
3. After setting, secure the setting screw using the counter nut.



Please observe that only the steam volume emerging from the Teflon sole can be adjusted using this setting method. It is not connected to the steam pressure setting of the steam supply system.

6.3.4 Setting instructions for the oil brake



WARNING!

Setting must only be carried out by a **qualified person**. This person has to ensure that the machine cannot be started during the setting procedure.

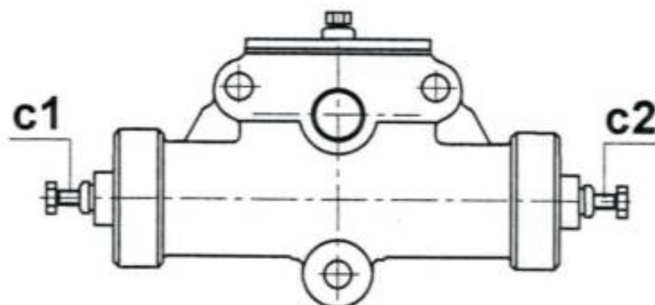


Fig. 16: Oil brake

c1 Open

c2 Close

Set the braking force and braking duration again using screws c1 and c2.



NOTICE!

The speed of the moving components should be set such that any hard stops can be avoided.

7 Operation

7.1 Controls and indicators

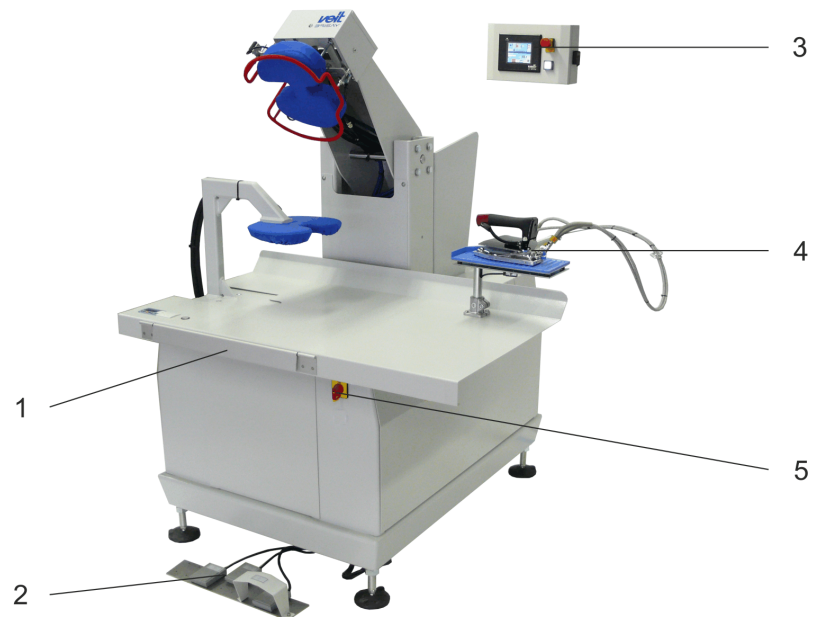


Fig. 17: Controls and indicators

1	Switching strip, suction When pressing the switching strip, the "suction" function for the lower buck is started and remains active as long as the switching strip is pressed.
2	Pedal strip (see chapter "Pedal strip")
3	Control panel with emergency stop button (see chapter "Control panel")
4	Steam iron (option) When pressing the pressure lever, the steam supply is activated.
5	Main switch The main switch disconnects/connects the machine from/to the power supply.



WARNING!

During maintenance and repair work, the main switch has to be padlocked in the OFF position to ensure that it cannot be switched on again.

7.1.1 Control panel

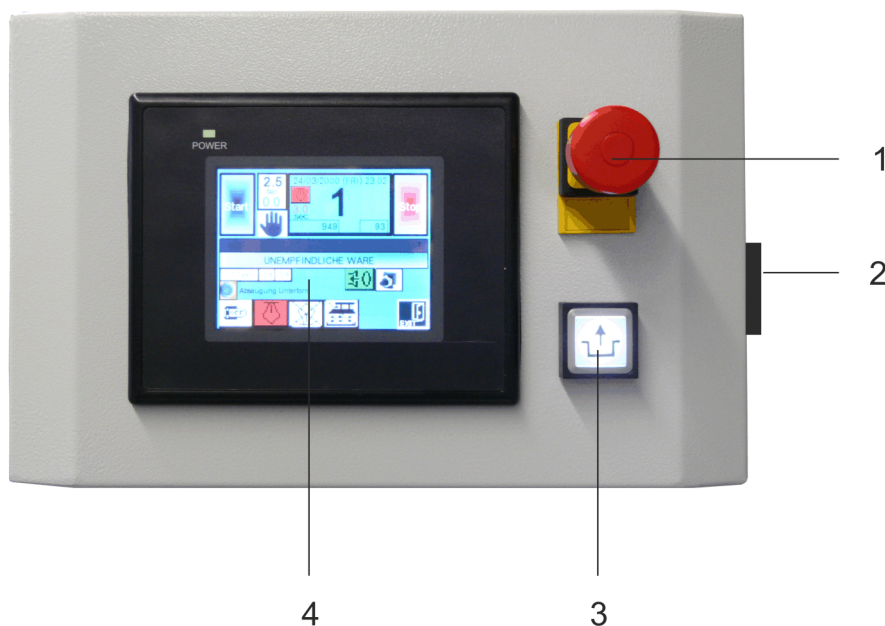


Fig. 18: Control panel

- 1 Emergency stop button
- 2 USB interface
- 3 Unlock
- 4 Function buttons

1	Emergency stop button (mushroom-headed pushbutton) Pressing the emergency stop button starts the following sequence: <ul style="list-style-type: none"> ■ The upper buck moves up ■ The steam supply is switched off The emergency stop button can be released by pulling it out.
2	USB interface
3	Unlock (illuminated pushbutton) Pressing the button activates the machine control system, and the button lights up.
4	Function buttons



NOTICE!

The machine control system is described in separate operating instructions.

7.1.2 Pedal strip

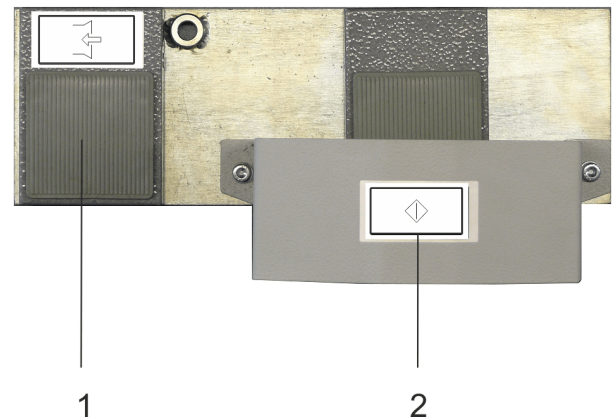




Fig. 19: Pedal strip

- 1 Suction
- 2 Start


Tab. 11: Suction

	Short tap (1st time <0.4 s)	When pressing the pedal shortly for the first time, the suction function is switched on. The suction function is switched off automatically with the start of the program.
	Short tap (2nd time <0.4 s)	When pressing the pedal for the second time, the suction function is switched off.
	Long press (<0.4 s)	The suction function is switched on and remains active as long as the pedal is pressed.

Tab. 12: Manual start

	Long press 1st stage (first switching contact)	The upper buck closes with a distance; the steam supply is switched on and off again after the steaming time set has elapsed or after the pedal is released.
	Long press 2nd stage (second switching contact)	The upper buck closes with the preselected pressing pressure; the steam supply is switched on and off again after the steaming time set has elapsed or after the pedal is released.

Tab. 13: Automatic start

	Short tap (<0.4 s)	The operating cycle is started.
---	-----------------------	---------------------------------

7.2 Starting the machine

- Switch on the main switch on the switch cabinet.
- Release the emergency stop button by pulling it out.
- The start screen is displayed:



Fig. 20: Start screen



NOTICE!

Safety test necessary!

Carry out the safety test as follows:

- Press the unlock button.
- Activate the safety frame.
- Press the unlock button.

- The machine is ready to operate.

7.2.1 Emergency stop button was activated

If the emergency stop button was activated, the machine must be started as follows:

- Release the emergency stop button by pulling it out.
- The start screen is displayed:



Fig. 21: Start screen



NOTICE!

Safety test necessary!

Carry out the safety test as follows:

- Press the unlock button.
- Activate the safety frame.
- Press the unlock button.

- The machine is ready to operate.

7.2.2 Safety frame was activated

If the safety frame was activated, the machine must be started as follows:

- Press the unlock button.
- The machine is ready to operate.

7.3 Pressing in manual mode



CAUTION!

Pay attention to the potential dangers indicated in chapter 4 when operating the machine.



NOTICE!

The machine control system is described in separate operating instructions.

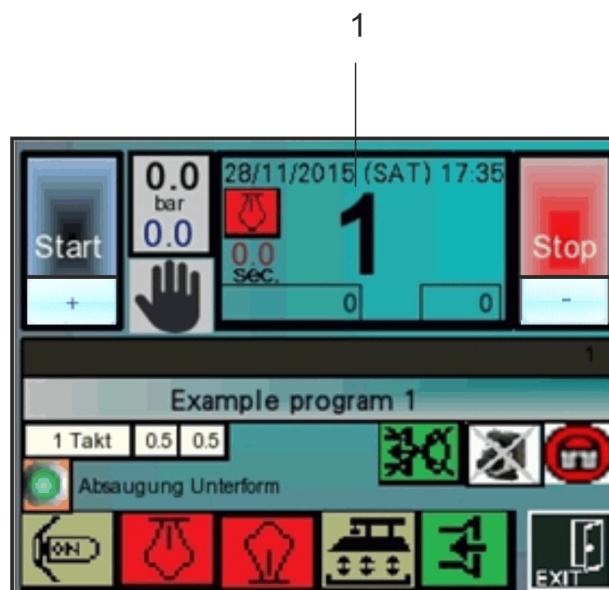


Fig. 22: Manual mode

- Select the required program (Pos. 1). The values and functions stored in the program are loaded for manual mode.
- Change the steaming time, if required.
- Change the pressing pressure, if required.
- Use the function button to switch the "steam for upper buck" on or off, if required.
- Use the function buttons to switch the "suction for the steam iron" on or off, if required.
- Place and align the garment on the lower buck.
- Shortly (<0.4 s) tap on the "suction" pedal, if required. The garment is fixed on the lower buck by means of suction.



- Press the "start" pedal until reaching the 1st stage (first switching contact). The upper buck closes with a distance.
- Press the "start" pedal until reaching the 2nd stage (second switching contact). The upper buck closes with the preset pressing pressure as long as the pedal is activated.



NOTICE!

Once the upper buck is closed, the set steaming time starts.

- After the steaming time has elapsed, activate the
 - Suction function via the pedal or
 - Suction function via the switching strip

The functions remain active as long as the pedal or the switching strip is activated.

- Remove the garment from the lower buck.

7.4 Pressing in automatic mode



CAUTION!

Pay attention to the potential dangers indicated in chapter 4 when operating the machine.



NOTICE!

The machine control system is described in separate operating instructions.

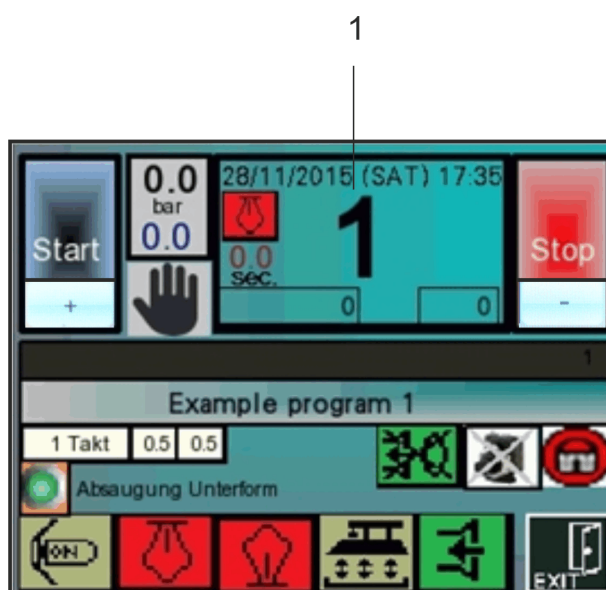


Fig. 23: Automatic mode



- Select the required program (Pos. 1).
- Use the function buttons to switch the "suction for the steam iron" on or off, if required.
- Place and align the garment on the lower buck.
- Shortly (<0.4 s) tap on the "suction" pedal, if required. The garment is fixed on the lower buck by means of suction.
- Shortly (<0.4 s) tap on the "start" pedal. The upper buck closes. The program starts according to the set parameters.
- Remove the garment from the lower buck upon completion of the operating cycle.

7.5 Pressing using the steam iron (option)

- Press the pressure lever on the steam iron to activate the steam supply.
- To cool down the garment, activate the "suction" pedal (or the switching strip) to additionally switch on the "suction" function.

7.6 Switching off the machine

- Switch off the main switch on the switch cabinet.

8 Maintenance



CAUTION!

Maintenance must only be carried out by an **authorised person**.

This authorised person will be instructed at the installation location of the machine by personnel of VEIT GmbH unless otherwise agreed in the purchase contract.

Do not forget that the risk of injury is increased during maintenance.

8.1 Safety frame

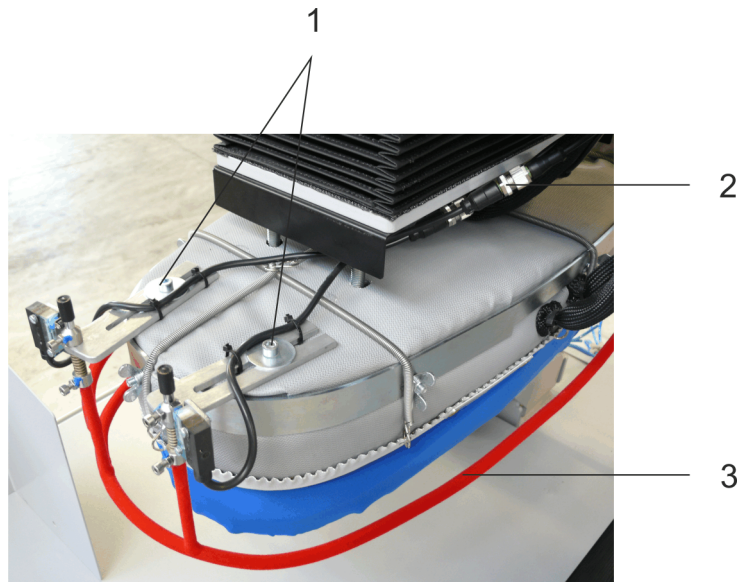


Fig. 24: Safety frame (example: BRI-235VC)

- 1 Fixing points
- 2 Plug-in connection
- 3 Safety frame

Removal of safety frame

- Remove covers/protective hoods from the upper buck, if required.
- Disconnect the plug-in connections of the safety switches.
- Unscrew the safety frame (fixing points) from the upper buck.



WARNING!

The positions of the switching cams, springs, and safety frame holders are preset and provided with a sealing wax. Their position must not be changed
-> Risk of loss of safety.

Installation of safety frame

- Install the safety frame again properly.
- Re-connect the safety switches.
- Install all the covers/protective hoods again.



WARNING!

Function check

Before commissioning the machine, check the safety frame for proper function.

8.2 Changing the pressing covers

Wear of the pressing covers depends on the number of parts being pressed as well as on the pressing parameters. We recommend that pressing covers be changed at least every three months.



CAUTION!

Use the appropriate original cover material of VEIT GmbH since cover material, cover composition and fitting cannot be guaranteed otherwise.

When not using original cover material, observe the cover material and cover composition recommended by VEIT GmbH. Templates can be ordered from VEIT GmbH.

The manufacturer shall not be held liable for damages caused by non-observance. The user alone bears the risk.

Observe the local regulations when disposing of worn pressing covers.

When ordering material, please always quote the VEIT machine number and shape number.

Maintenance

Changing the pressing covers

Service hotline

Germany:	+49 8191 479 133
Europe:	+49 8191 479 252
America:	+1 770 8688060
Asia:	+852 2111 9795
E-Mail:	service@veit.de

Spare parts

Germany:	+49 8191 479 100
America:	+1 770 8688060
Asia:	+852 28349986



CAUTION!

- Cut off the steam supply before changing the pressing covers.
- Cut off the valve for the steam supply.
- Depressurise the steam system by starting the machine.
- Make sure that no steam emerges from the machine.
- The power supply and compressed-air supply remain switched on.



WARNING!

Risk of burns

Make sure that the upper buck, lower buck as well as all parts connected to steam and condensate have cooled down.

8.3 Placing the cover on the lower buck



CAUTION!

Maintenance must only be carried out by an authorised person (definition see chapter "Safety measures").

This authorised person will be instructed at the installation location of the machine by personnel of VEIT GmbH unless otherwise agreed in the purchase contract.

Do not forget that the risk of injury is increased during maintenance.



Fig. 25: Replacing the pressing cover (lower buck)

1 Drawstring

1. ➤ Open the drawstring and remove the worn cover from the lower buck.
2. ➤ Pull the new pressing cover onto the lower buck according to the cover composition (see chapter "Cover material").
3. ➤ Stretch the pressing cover and knot the drawstring.



NOTICE!

Make sure that the cover seams are not on the pressing surface.

8.4 Placing the cover on the upper buck



CAUTION!

Maintenance must only be carried out by an authorised person (definition see chapter "Safety measures").

This authorised person will be instructed at the installation location of the machine by personnel of VEIT GmbH unless otherwise agreed in the purchase contract.

Do not forget that the risk of injury is increased during maintenance.

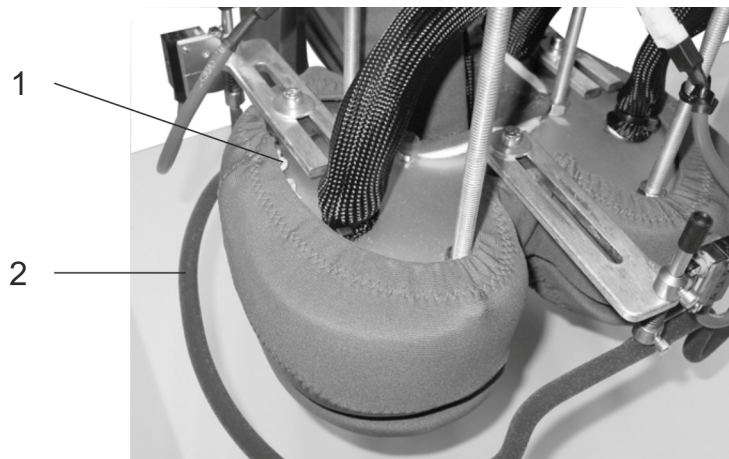


Fig. 26: Replacing the pressing cover (upper buck)

- 1 Upper buck
- 2 Safety frame



NOTICE!

Make sure that the cover seams are not on the pressing surface.

1. Select "Single track" in the supervisory function.
2. Log in via the user login.
3. Select the "Change covers" function.
4. Unscrew the safety frame (Pos. 2) from the upper buck. Proceed as is described in chapter "Safety frame".



CAUTION!

Make sure that no safety functions are active.

5. ➤ Open the drawstring (Pos. 1) and remove the worn cover from the upper buck.
6. ➤ Place the new pressing cover on the lower buck according to the cover composition and align it (see chapter "Cover material").



NOTICE!

Make sure that the cover seams are not on the pressing surface.

7. ➤ Select "Pressure level 0 bar" in the "Set single track" multi-functional track supervisor function.
8. ➤ Press the "start" pedal. The upper buck closes.
9. ➤ Realign the pressing cover, if necessary.
10. ➤ Select the pressure level with the highest pressure value in the "Set single track" multi-functional track supervisor function.
11. ➤ Stretch the pressing cover and knot the drawstring.
12. ➤ Press the "Exit" button to quit the "Single track" supervisor function. The upper buck opens.
13. ➤ Mount the safety frame. Proceed as is described in chapter "Safety frame".



WARNING!

Function check

Before commissioning the machine, check the safety frame for proper function.

9 Maintenance/cleaning

Maintenance and cleaning



CAUTION!

The **maintenance and cleaning** chapter is intended for qualified personnel only. Maintenance, cleaning and repair work must only be carried out by qualified personnel (definition see chapter "Safety measures"). Operating and maintenance personnel will be instructed on site by personnel of VEIT GmbH unless otherwise agreed in the purchase contract.

Qualified person

A person who is capable of assessing the tasks assigned to him/her and of identifying dangers due to his/her technical training, knowledge and experience as well as knowledge of the relevant industrial standards.

The definition follows EN 602041:2006+A1:2009.

To assure faultless operation of the machine, it is indispensable that the machine is cleaned and maintained at regular intervals.

Appropriate workshop equipment is always required for any kind of maintenance work.

During operation, the machine is subject to vibration which might cause screwed and clamped connections to loosen. To prevent damage, the machine must be checked at regular intervals for loose connections (recommendation: every three months).



CAUTION!

- When carrying out installation work above body height, use the ladders or working platforms provided or a ladder/working platform that meets the required safety standards. Do not mount on any components of the machine. A safety harness should be worn during maintenance work at heights.
- Secure the maintenance area ensuring the provision of adequate space.
- Inform operating personnel before starting maintenance work. Specify a person to supervise the work.
- The exchange parts must be disposed of in accordance with the local environmental regulations.



WARNING!

Risk of burns

Make sure that the upper buck, lower buck as well as all parts connected to steam and condensate have cooled down.



CAUTION!

Before starting cleaning, maintenance or repair work (by qualified personnel only), the following shutdown procedure must be observed:

1. ➤ Cut off the steam supply
 - Cut off the valve for the steam supply.
 - Depressurise the steam system by starting the machine.
 - Make sure that no steam emerges from the machine.
2. ➤ Disconnecting the machine from the power supply
 - Set the main switch on the switch cabinet to "0".
 - Padlock the main switch to ensure it cannot be switched on again.
 - Unplug the mains connector.
 - Make sure that no voltage is present.
3. ➤ Cutting off the pneumatic system
 - Shut off the compressed air valve.
 - Exhaust the air from the compressed air lines.
 - Make sure that the machine is depressurised.

Disregarding these procedures presents a risk of death or injury of the personnel.

9.1 Cleaning

Remove oil and grease from the machine at regular intervals, in particular before carrying out maintenance and repair work.



CAUTION!

Do **not** use the following:

- Chlorinated hydrocarbon, e.g. PER or TRI
- Inflammable, easily gasifying or caustic liquids

Do not clean the machine with compressed air or a steam or water jet **under any circumstances**. Violations of the above instructions may lead to malfunctions of the machine, in particular with regard to the safety functions. This might result in a machine damage or injuries.

Clean the machine using a lint-free cloth.

9.2 Maintenance and inspection table

Tab. 14: Inspection and maintenance schedule

Interval	Part to be inspected	Work to be carried out	Remarks
8 hrs	Safety devices	Function check	See chapter "Built-in safety systems"
40 hrs	Compressed air maintenance unit	Visual inspection	Drain off water/oil, if necessary; pressure range: 6 bar Once a year , replace clogged air filter.
	Fine filter upstream of electronic pressure regulator	Visual inspection	Once a year , replace clogged fine filter.
	Entire machine	Clean	Wipe using a clean, lint-free cloth.
	Main switch	Function check	Check and replace, if necessary.
	Switch and switch fasteners		
160 hrs	Pressing pressure of pressure gauge	Visual inspection	Check the pressure levels
	Pneumatic valves	Leak test	Check and replace, if necessary. If leaks are detected on the bucks, the VEIT service department must be informed.
	Cylinders		
	Steam valves		
	Suction valves		
	Hoses and screw connections		
	Bucks		
6 months	Oil level of oil brake	Visual inspection	Check and top up oil, if necessary.

9.3 Lubrication

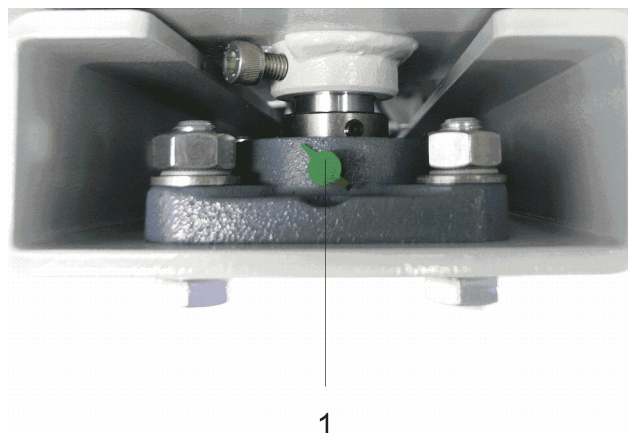


Fig. 27: Lubrication points

1 Lubrication point

Tab. 15: Maintenance schedule for bearing unit

Interval	Part to be inspected	Work to be carried out	Remarks
Once a year	Bearing unit (Pos. 1) on the right and left	Lubrication	Only use grease types recommended by VEIT.

Tab. 16: Recommended grease types

Manufacturer	Brand	Temperature range
Shell	Alvania R2	-35°C to +130°C
Aral	HL2	-35°C to +120°C
BP	Energrease LS2	-35°C to +120°C
Esso	Beacon 2	-30°C to +120°C
Mobil	Mobilux 2	-30°C to +120°C

9.4 Fill level check of oil brake



WARNING!

Work on the oil brake may only be carried out by a **qualified person**. This person has to ensure that the machine cannot be started when work is carried out on the machine.

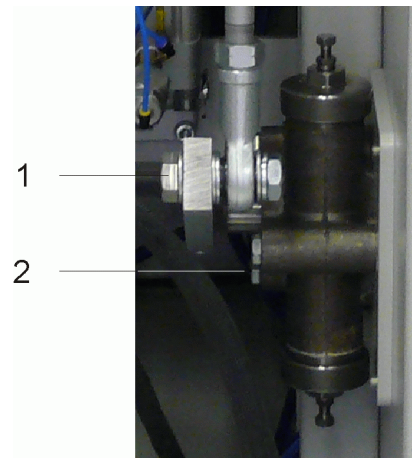


Fig. 28: Removal of oil brake

- 1 Bolt
- 2 Hexagon screw (3 pieces)

To check the fill level, the oil brake must be removed.

Proceed as follows:

1. ➤ Remove the bolt.
2. ➤ Remove the 3 hexagon screws.
3. ➤ Place the oil brake on an even surface.
4. ➤ Check the fill level.

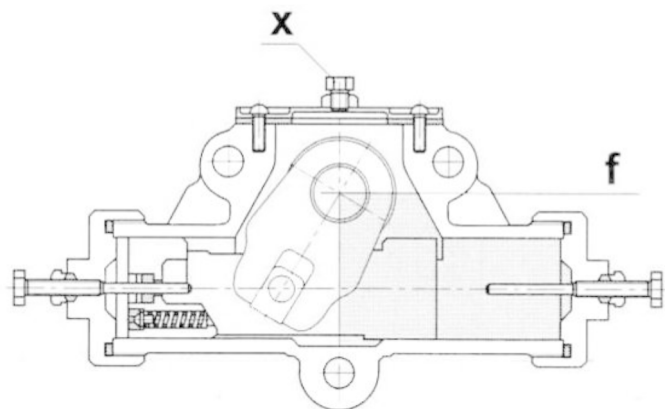


Fig. 29: Fill level check of oil brake

Tab. 17: Maintenance schedule for oil brake

Interval	Part to be inspected	Work to be carried out	Remarks
6 months	Oil brake	Visual inspection	Only use oil types recommended by VEIT.

Tab. 18: Recommended oil types

Hydraulic oil	Viscosity 32
---------------	--------------

Open locking screw "X" and top up oil to marking "f". Close the filling opening using locking screw "X".

Mount the oil brake in reverse order.

9.5 Checks on the machine

If all functions are working properly, the machine is handed over to the operator.



CAUTION!

After replacement of worn parts, check all safety devices for proper serviceability.

After completion:

- Check the machine for loose connections of the supply lines (compressed air, steam, condensate, oil)
- Check the machine for abrasion or damage and remove, if necessary
- Check the earth connections of the machine
- Make sure that the work carried out is complete
- Make sure that there are no tools in the machine
- Make sure that the switch cabinet is closed
- Check the safety frame for proper serviceability

10 Remedy of faults/elimination of defects

Remedy of faults/elimination of defects



CAUTION!

The facts and information listed as **fault** in this chapter are detailed in such a way that they may be remedied by an instructed person.

If a fault cannot be remedied, a **qualified person** must be informed.

The **alarm messages** on the display as well as the facts and information listed as **defects** in this chapter, are detailed in such a way that they may be eliminated by a **person qualified** in

- Electrics/electronics
- Mechanics/maintenance

The facts and information listed as **recommendations for pressing operations** in this chapter, are detailed in such a way that they may be eliminated according to column "**Person in charge**" by

- An instructed person
- An authorised person
- A qualified person

(see definitions in chapter "Safety measures")

These members of personnel must be provided with the necessary tools and test equipment.

Before starting maintenance and repair work, the shutdown procedures (see chapter "Potential dangers") have to be carried out.

If the remedial measures described here are not successful, please contact the VEIT service department.

Remedy of faults/elimination of defects

Defect, cause, remedy

10.1 Fault, cause, remedy



CAUTION!

The facts and information listed as **fault** in this chapter, are detailed in such a way that they may be eliminated by an **instructed person**. If a fault cannot be remedied, a **qualified person** must be informed.

Fault	Cause	Remedy
No function on the machine.	No compressed air available	Check the compressed air supply provided by the customer.
	Main switch switched off	Switch on the main switch.
	Emergency stop button pressed	Release the emergency stop button.
	"Unlock" button not pressed	Press the "unlock" button.
	Safety frame was activated	
	Steam iron is not on the deposit table	Put the steam iron on the deposit table.

10.2 Defect, cause, remedy



WARNING!

The facts and information listed as **defect** in this chapter, are detailed in such a way that they may be eliminated by a **person qualified in**

- Electrics/electronics
- Mechanics/maintenance

The machine components mentioned in the "Cause" column are detailed in the supplied electric circuit and pneumatic diagrams.

Standard machine

Defect	Cause	Remedy
No function on the machine	No mains voltage available	Establish the mains connection and check.
	No compressed air available	Connect the compressed air supply.
	Switches on the safety frame S1.1, S1.2, S1.3 defective	Check and replace, if necessary.
	Safety relay K1 defective	Check and replace, if necessary.
	Unlock button S4 defective	Check and replace, if necessary.
	Power supply unit T1 defective	Check and replace, if necessary.
	Main switch Q1 defective	Check and replace, if necessary.
	Machine control system defective	Check and replace, if necessary.
No machine start	"Start" pedal S11.0, 11.1 defective	Check and replace, if necessary.
	Solenoid switch S15 defective	Check and replace, if necessary.
	Machine control system defective	Check and replace, if necessary.
(With steam iron option)	Detection of steam iron S25	Check and replace, if necessary.
Upper buck does not swivel in	No compressed air available	Connect the compressed air supply.
	"Start" pedal S11.0, S11.1 defective	Check and replace, if necessary.
	Solenoid switch S15 defective	Check and replace, if necessary.
	5/2-way valves Y4, Y5 defective	Check and replace, if necessary.
	Stop valve Y4.1, 4.2 defective	Check and replace, if necessary.
	Steam iron deposit table S25 set incorrectly or defective	Check and replace, if necessary.
Upper buck does not swivel in/ open properly	Insufficient compressed air supply	Check the compressed air supply provided by the customer.
	End position damping set incorrectly	Readjust end positions at cylinder Z1 or replace sealing.
	Oil brake set incorrectly or oil level too low	Check, set again or top up oil, if necessary.
	Cylinder Z1 leaking	Check for leaks, and replace, if necessary.
	Solenoid switch S15 defective	Check and replace, if necessary.
Upper buck does not open with a distance	Solenoid switch S15 defective	Check and replace, if necessary.
	5/2-way valve Y4 defective	Check and replace, if necessary.
	Stop valve Y4.1, 4.2 defective	Check and replace, if necessary.

Remedy of faults/elimination of defects

Defect, cause, remedy

Defect	Cause	Remedy
No pressing pressure	Pressure levels not programmed	Check pressing program.
	Cylinder Z1 leaking	Check for leaks, and replace, if necessary.
	5/2-way valves Y4, Y5 defective	Check and replace, if necessary.
	Stop valve Y4.1, 4.2 defective	Check and replace, if necessary.
	Pressure sensor S30 defective	Check and replace, if necessary.
	Machine control system defective	Check and replace, if necessary.
Oil brake set incorrectly	Oil brake	Check and set again or replace, if necessary.

Machine-specific defects

Defect	Cause	Remedy
No steam	No steam or not enough steam available	Check the steam supply provided by the customer.
	Steam valves Y2, Y3 set incorrectly or defective	Check and set again or replace, if necessary.
	Relay K2, K3 defective	Check and replace, if necessary.
No suction function	No negative pressure available	Check suction function provided by the customer.
	Suction valve Z2 (lower buck) defective	Check and replace sealing or entire valve, if necessary.
	Pedal S10 defective	Check and replace, if necessary.
	5/2-way valve Y8 defective	Check and replace, if necessary.
	Switching strip S20 defective	Check and replace, if necessary.

10.3 Recommendations for pressing operations



CAUTION!

The facts and information listed as **recommendations for pressing operations** in this chapter, are detailed in such a way that they may be eliminated according to column **person in charge** by

- An instructed person
- An authorised person
- A qualified person

Pressing result	Cause	Remedy	Person in charge
Creases	Cover composition not according to the specification	Adapt the cover composition according to the specification	Authorised person
	Cover composition too high		
	Garment has not been inserted correctly	Observe the method	Instructed person
Poor pressing result	Steam valve incorrectly set or defective	Set the steam valve again	Authorised person
		Replace the steam valve	Qualified person
	Pressing cover soiled/worn	Change the pressing cover	Authorised person
	Steam hose kinked or defective	Remove the kink	Authorised person
		Replace hose	Qualified person
Waves	Cover composition too high or too low	Adapt the cover composition according to the specification	Authorised person
	Steam valve not set optimally	Change the pressing cover	Authorised person
	Steam volume too high	Set the steam valve again	Authorised person
	Pressing pressure too high	Set the pressing pressure again	Instructed person
Distortion	Cover composition too high	Adapt the cover composition according to the specification	Authorised person
Soiled garment	Pressing cover soiled	Change the pressing cover	Authorised person

Remedy of faults/elimination of defects

Recommendations for pressing operations

Pressing result	Cause	Remedy	Person in charge
	Stains due to oil in the compressed air	Compressed air supply provided by the customer defective Empty the maintenance unit	Qualified person
Marks/shine	Pressing pressure too high	Set the pressing pressure again	Instructed person
	The pressing cover is pressed flat and no longer has the elastic force to counteract the pressing pressure	Change the pressing cover	Authorised person
	The pressing cover is soiled, the blowing air hardly or no longer reaches the garment	Change the pressing cover	Authorised person
	Blowing air too low	Increase the hose connection size (provided by the customer)	Qualified person
	Suction power too high	Set the suction valve	Qualified person

11 Emergency

In the event of danger the machine must be shut down safely. In case of emergency:

- Press the emergency stop button. Depending on the machine model it is located
 - On the control panel or
 - On the basic frame on the right-hand side
- Switch off the main switch on the switch cabinet.
- Unplug the mains connector.

The following procedure is triggered:

- The upper bucks move up.
- The steam supply is cut off.

The emergency stop button can be released by pulling it out.

In **the event of fire** switch off the machine and unplug the mains connector.

Disconnect all energy supply lines:

- Steam
- Compressed air



CAUTION!

Before operating the machine:

- Be sure that you know where the fire extinguisher is located
- Learn how to use the fire extinguisher
- Make sure you know how to report a fire quickly

There is a risk of fire caused by flammable liquids and liquid/gas mixtures (e.g. oil/oxygen mixture), for example.

Extinguishers that can be used according to fire class DIN EN 2:

- Powder extinguisher with ABC extinguishing powder for solids, liquids and gases
- Powder extinguisher with D extinguishing powder for flammable metals
- Carbon dioxide extinguisher for liquids, gases and solids

12 Disassembly and disposal

The finishing machine is mainly made of steel (except for the electrical components) and must be disposed of in accordance with the applicable local environmental regulations. Oils and solvents must be disposed of in accordance with the local regulations. Any residues from production and cover material must be disposed of in accordance with the instructions of the material manufacturer or the local regulations.

13 Spare parts lists



CAUTION!

We would like to state explicitly that spare parts and accessories that are not supplied by us neither tested nor released by us. The fitting and/or use of such products may therefore, under certain circumstances, have a negative effect on the construction characteristics of the machine.

Veit GmbH cannot be held liable for damages resulting from using non-genuine accessories and non-genuine parts.

For all enquiries or orders in writing or on the phone, please always quote:

- Type of machine (see cover)
- Article number of the machine
- Article number of the relevant component (see chapter "Spare parts lists")

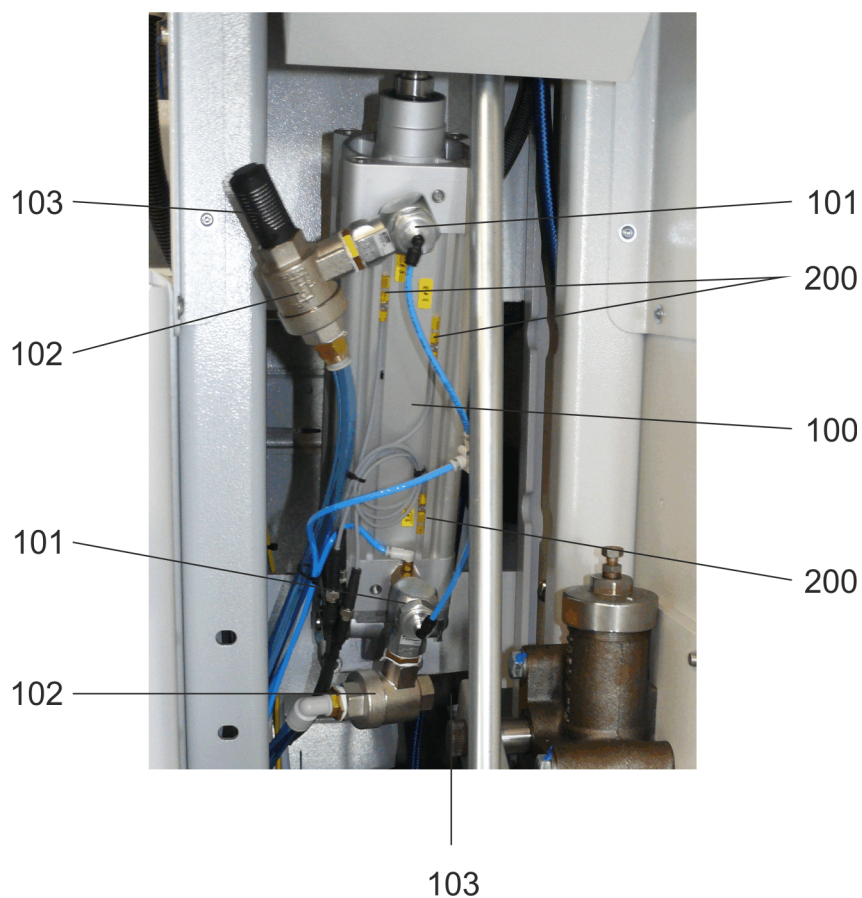
Service hotline

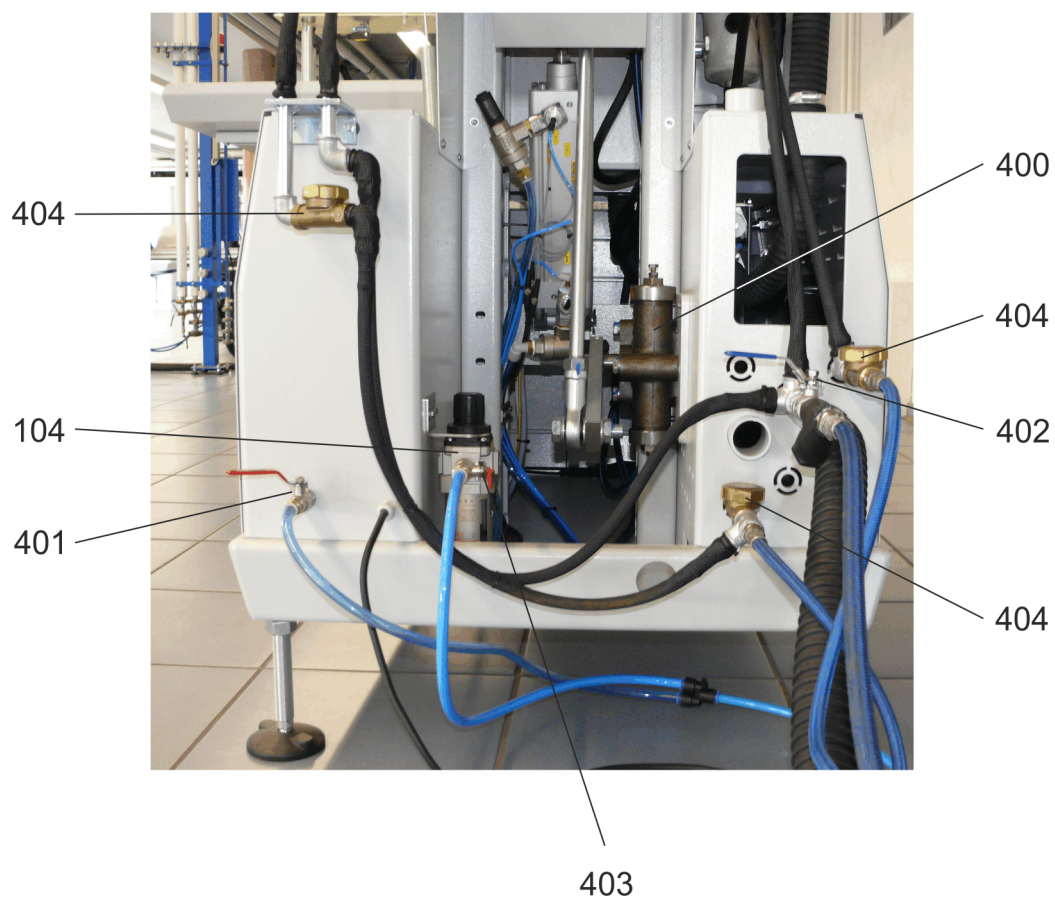
Germany:	+49 8191 479 133
Europe:	+49 8191 479 252
America:	+1 770 8688060
Asia:	+852 2111 9795
E-Mail:	service@veit.de

Spare parts

Germany:	+49 8191 479 100
America:	+1 770 8688060
Asia:	+852 28349986

13.1 Spare parts list

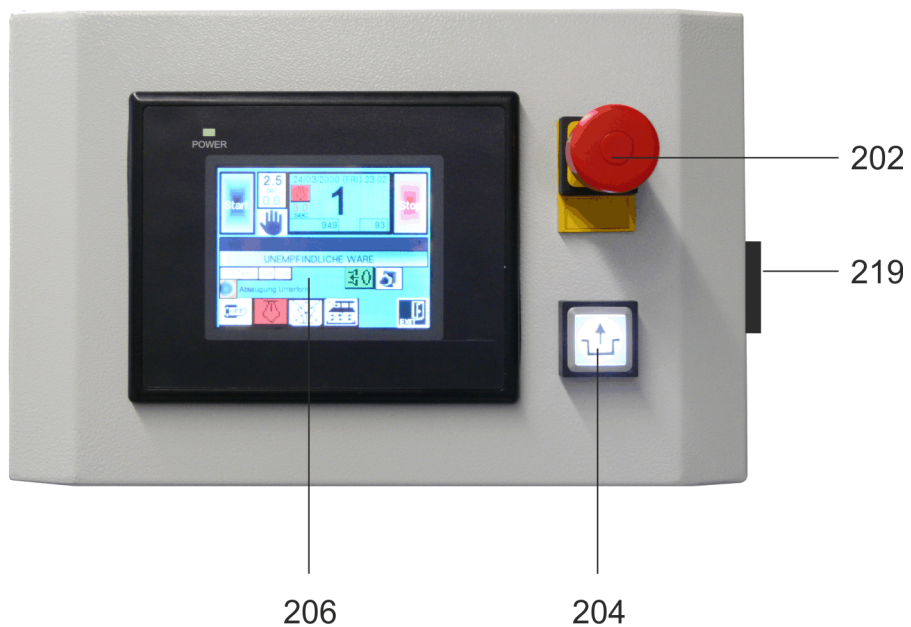
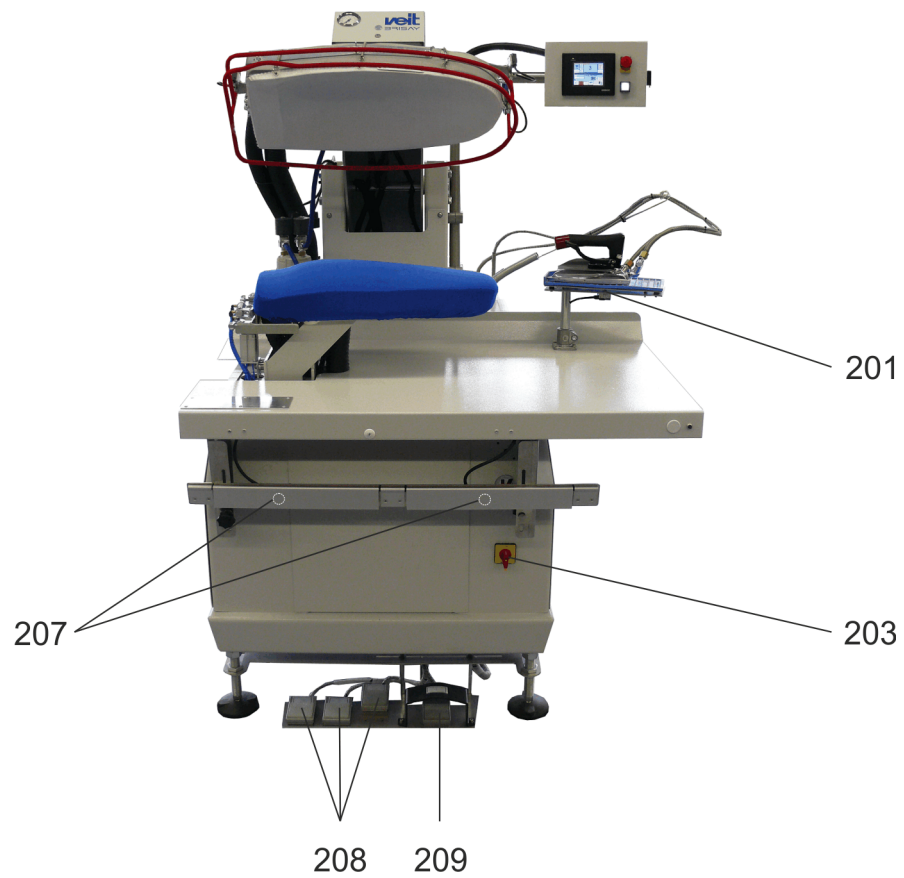


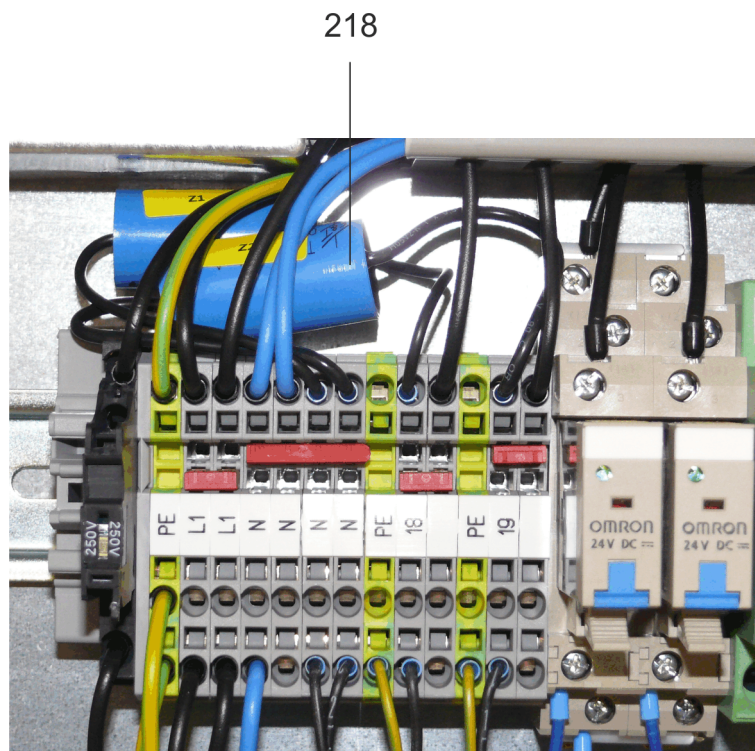
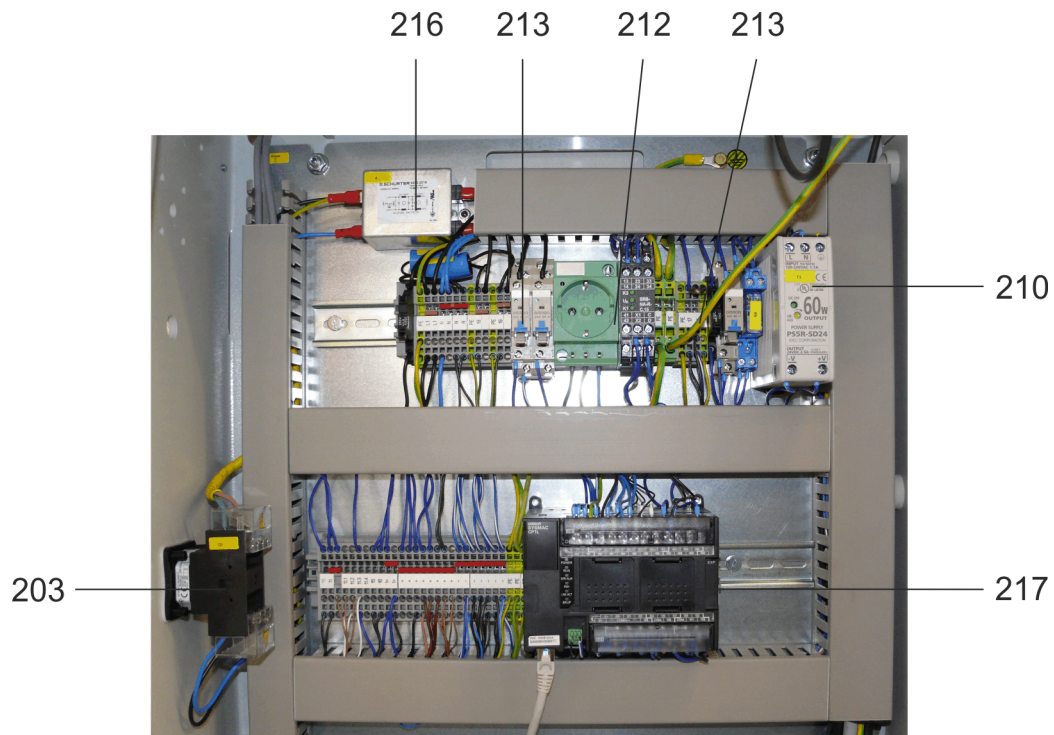


Spare parts lists

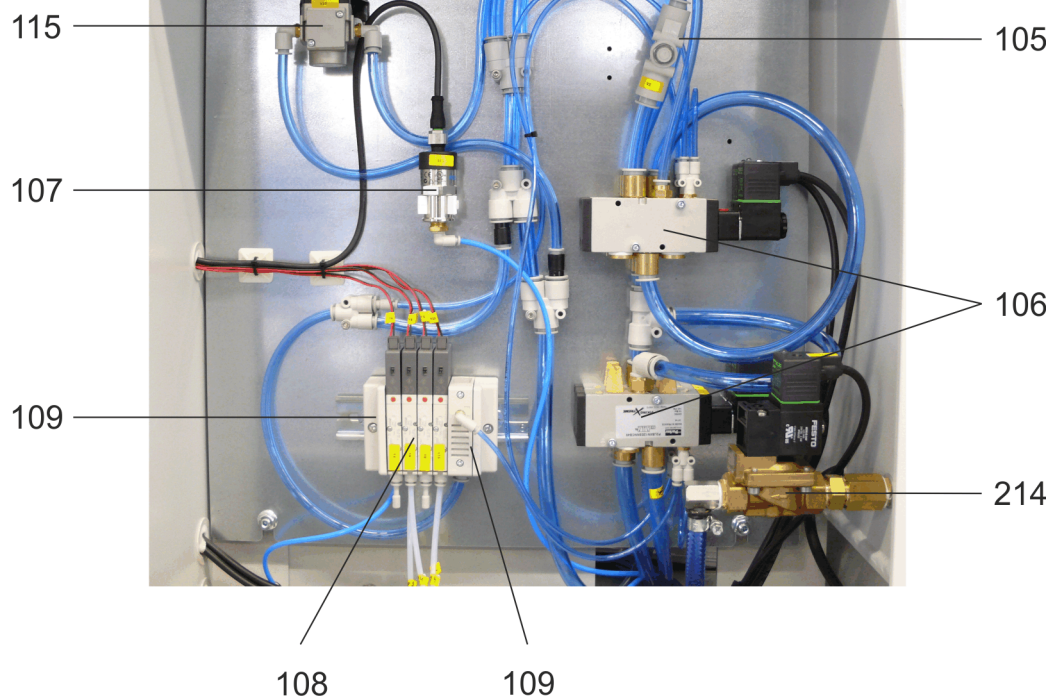
Spare parts list





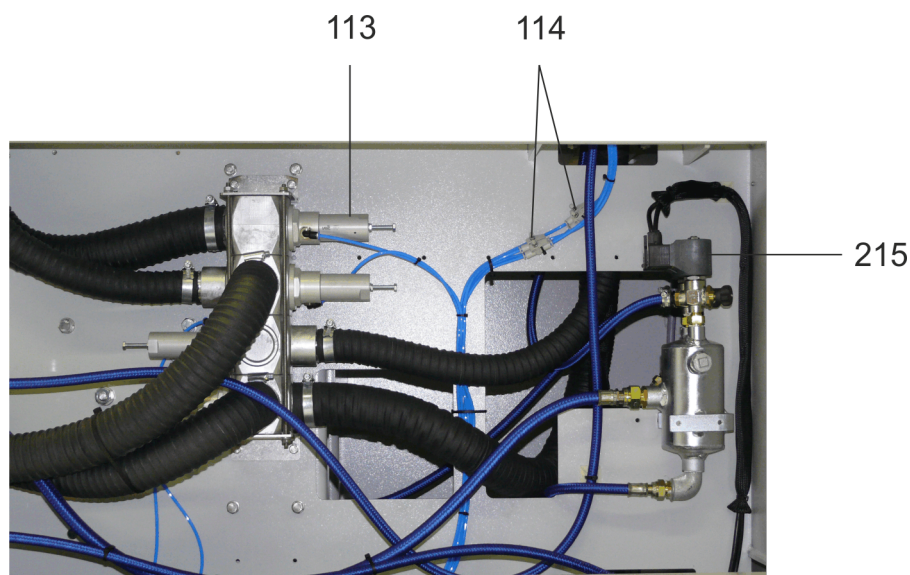


220



Spare parts lists

Spare parts list



Tab. 19: Spare parts, pneumatics

Position	Article number	Designation	Identifier on pneumatics diagram
100	138401	Cylinder DSBC 80-200	Z1
	136582	Bearing block	
	136172	Swivel flange	
101	KV00501	Stop valve	Y4.1, Y4.2
102	KV09687	Quick exhaust valve	V8, V9
103	KD00050	Silencer	
104	154437	Maintenance unit	A1
105	KV01395	Throttle check valve	V2
106	112012	5/2-way valve 1/4"	Y5, Y6, Y7, Y16
107	139967	Pressure sensor	S30
	KE02538	Cable	
108	107529	5/2-way valve	Y4, Y8, Y9, Y10, Y13, Y14
109	107530	Valve connection set	
113	140817	Suction valve insert 1 1/2"	Z2, Z3, Z4, Z4.1

Position	Article number	Designation	Identifier on pneumatics diagram
114	KV01370	Throttle check valve	V4, V5, V6, V7
115	KU02001	Pressure reducer	V10

Tab. 20: Spare parts, electrics

Position	Article number	Designation	Identifier on circuit diagram
200	119445	Proximity switch	S7, S12, S15
	KE02535	Cable	
201	137659	Safety switch	S1.1, S1.2, S1.3
	137661	Cable	
202	KE51000	Emergency stop mushroom button	S0
	KE51030	Contact element	
203	KE50150	Main switch	Q1
204	KE51010	Illuminated pushbutton	S4
	KE51020	Contact element	
	KE51011	Light-emitting diode	
206	151541	Touch screen BRI-248SC ET	SPS1
	151542	Touch screen BRI-388SC ET	
	151543	Touch screen BRI-550SC ET	
	151544	Touch screen BRI-880SC ET	
	151545	Touch screen BRI-2001SC ET	
	151546	Touch screen BRI-2065SC ET	
	151547	Touch screen BRI-2068SC ET	
	151548	Touch screen BRI-231SC ET	
	155496	Touch-screen BRI-410SC ET	
207	140891	Pushbutton	S20, S21
208	KE10055	Pedal with 1 switch	S7, S10, S16, S18
209	KE10065	Pedal with 2 switches	S11.0, S11.1
210	154917	Power supply unit	T1

Spare parts lists

Spare parts list

Position	Article number	Designation	Identifier on circuit diagram
211	KE01690	Fuse	F1
212	133418	Safety relay	K1
213	KE00274	Print relay	K2, K3, K4, K5
	KE00273	Holder for print relay	
214	KV09603	Solenoid valve 3/8"	Y15
	KD12679	Membrane	
	KE01270	Cable connector	
215	142462	Solenoid valve 1/4"	Y2, Y3
	149288	Valve connector	
	4283210000	Coil 200-254/50-60Hz	
	KV02181	Core	
	KV02180	Complete core	
	KV02183	Steam regulator device	
	KV02185	Hand wheel separately	
216	135821	Mains filter	A2
217	151639	PLC BRI-SC ET (CP1L)	SPS2
218	9280150140	ESD protection	R1, R2
219	148270	USB 2.0 adapter	
	148271	Sealing cap	

Tab. 21: Spare parts, mechanics

Position	Artikelnummer	Bezeichnung
400	152637	Oil brake
401	KV00038	Ball valve
402	132976	Ball valve
403	KV10038	Ball valve
404	KV00510	Condensate drain
405	111980	Bearing
	KS52035	Suction hose 1"
	KS52050	Suction hose 1 1/2"

13.2 Spare parts list, steam iron

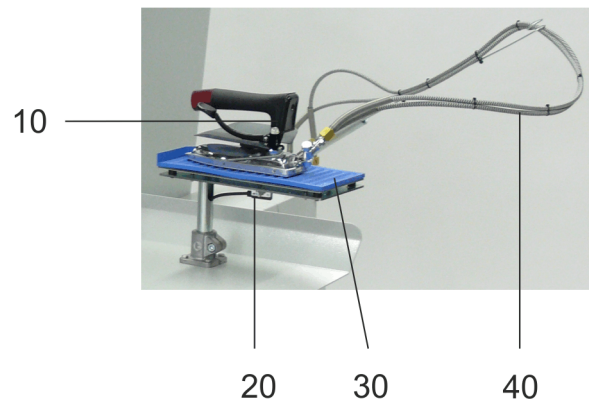









Fig. 30: Spare parts, steam iron

Tab. 22: Spare parts, steam iron

Position	Order number	Designation	Identifier on pneumatics diagram
10	BO01221	BRI-1 steam iron, spare parts see operating instructions for stainless steel iron	
	BO01223	BRI-3 steam iron, spare parts see operating instructions for stainless steel iron	
20	137659	Safety switch	S14, S25
	137661	Cable	
30	2210200250	Stand, silicone	
40	KS41501	Hose for iron	

Fig. 31: Steam and condensate diagram

Tab. 23: Key

Symbol	Description	Article number
	Steam valve	
	Condensate valve (eMotion)	
	Condensate drain (standard)	
	Ball valve	
	Steam	
	Steam injection	
	Option	
1	Upper buck	
2	Lower buck	
11	Steam distributor	
12	Steam connection	
13	Condensate connection	
14	Steam connection	
15	Add-on set for steam iron (option)	
20	Tetraflex hose, with fitting	KS30900
21	Tetraflex hose, with fitting	KS30900
22	Tetraflex hose, with fitting	KS31500
23	Tetraflex hose, with fitting	KS31200
24	Tetraflex hose, with fitting	KS32000
25	Tetraflex hose, with fitting	KS30800
26	Tetraflex hose, with fitting	KS30900
40	Tetraflex hose, without fitting	KS30012
41	Tetraflex hose, without fitting	146155
42	Tetraflex hose, without fitting	146154
50	Terylene hose	KS41501
51	Terylene hose	KS41501

13.4 Cover material

Bezugsmaterial für BRISAY Bügelmaschinen Cover material for BRISAY pressing machines

BRI-2065SC Manuelle Ärmelbeistellmaschine (Spezialform zum Ärmelbeistellen)

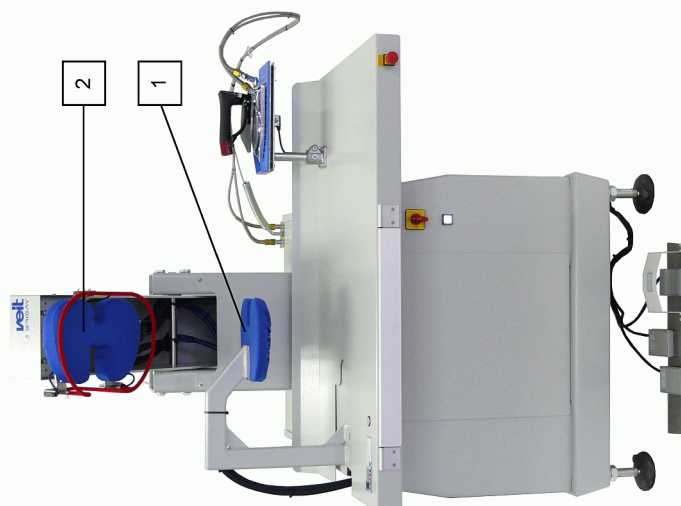
BRI-2065SC Manuel armhole creasing machine (special buck for armhole creasing)

Bitte geben sie bei jeder Bestellung von
Fertigware die Maschinen Nr. und Form Nr. an.

Please give us the machine no. and buck no.
for every order of ready made parts.

Maschinen Nr. : _____
Machine no. : _____

Form Nr. : _____
Buck no. : _____



BRISAY Maschinen GmbH, Mittelweg 4, D-63762 Grossostheim-Ringheim,
Tel. ++49 (0) 6026/ 9 97-0, Fax ++49 (0) 6026/ 9 97-100

Bezugsmaterial für BRISAY Bügelmaschinen Cover material for BRISAY pressing machines

BRI-2065SC Manuelle Ärmelbeistellmaschine (Spezialform zum Ärmelbeistellen
BRI-2065SC Manuel armhole creasing machine (special buck for armhole creasing)

	Artikelbezeichnung der Bezugslagen, beginnend auf der Metall-Bügelform	description of the layers, starting at the metal-iron buck	Metenware / yard goods	Fertigware einzel / ready-made single goods	Fertigware komplett / ready-made complete set	Fertigware Verschleiß Set / ready-made wear and tear kit	Warenbreite / width of material cm	Verbrauch lrm. / qty. linear meter. m
1	1. Kupferdrahtgewebe 2. Nomex Nadelfilz 6mm 3. Polyesterweb (dünn) 4. Stretch blau	1. copper wire 2. nomex needle felt 6mm 3. polyester fabric (thin) 4. stretch blue	2570100230 2570100110 111934 2570100040	L11 L12 L13 L14	C713XX01 • • • •	C713XX02 • • • •	130 180 160 140	0,70 0,50 0,50 0,50
2	1. Kupferdrahtgewebe 2. Nomex Nadelfilz 6mm 3. Polyesterweb (dünn) 4. Stretch blau	1. copper wire 2. nomex needle felt 6mm 3. polyester fabric (thin) 4. stretch blue	2570100230 2570100110 111934 2570100040	L21 L22 L23 L24	C713XX03 • • • •	C713XX03 • • • •	130 180 160 140	

Bitte geben Sie bei jeder Bestellung von Fertigware die Maschinen Nr. und Form Nr. an.
Please give us the machine no. and buck no. for every order of ready made parts.

BRISAY Maschinen GmbH, Mittelweg 4, D-63762 Grossostheim-Ringheim,
Tel. ++49 (0) 6026/ 9 97-0, Fax ++49 (0) 6026/ 9 97-100

14 Index

A		General information	5
Address	14	I	
Alignment	34	Installation	33, 35
Automatic start	47	Installation of safety frame	55
B		Instructed person	19
Built-in safety systems	15	Instructions	18
C		Intended use	7
Cause	68	L	
Changing the pressing covers	55	Lifting points	30
Cleaning	60	Lubrication	64
Commissioning	40	M	
Compressed air supply	10	Maintenance	54, 60
Condensate	10	Maintenance and inspection table	63
Control panel	46	Manual start	47
Controls and indicators	45	O	
Cover material	88	Operating workflow	9
D		Operation	45
Danger signs	13	Overview of the machine	8
Danger zones on the machine	22	P	
Declaration of conformity	6	Pedal strip	47
Defect	68	Person in charge	71
Delivery	26	Placing the cover on the lower buck	57
Designation of the machine	14	Placing the cover on the upper buck	58
Dimensions	9	Potential dangers	20
Duties of the operating company	23	Power supply	9
E		Pressing in automatic mode	52
Elimination of defects	67	Pressing in manual mode	50
Emergency	73	Pressing using the steam iron	52
Emergency stop button was activated	49	Q	
F		Qualified person	19
Fault, cause, remedy	68	R	
Fill level check of oil brake	64	Recommendations for pressing operations	71
G		Remedy	68
General data	10	Remedy of faults	67

Removal of safety frame 55

S

Safety 12
Safety frame 54
Safety frame was activated 49
Safety instructions 12
Safety measures 19
Scope of delivery 11
Setting instructions for the oil brake 44
Setting instructions for the steam valve 41
Setting instructions for the suction valve
(single-stage) 42
Setting of the steam iron 43
Setup 33
Shutdown procedures 25
Spare parts list 76
Spare parts list, steam iron 85
Spare parts lists 75
Start 47
Starting the machine 48
Steam and condensate diagram 86
Steam supply 10
Suction 10, 47
Switching off the machine 53

T

Technical data 9
Technical data of the machine 9
Transport and packaging 26
Transport safeguard 31
Type plate 5

U

Unloading and transport to the place of installation 27

W

Warning symbols 13
Weight 9