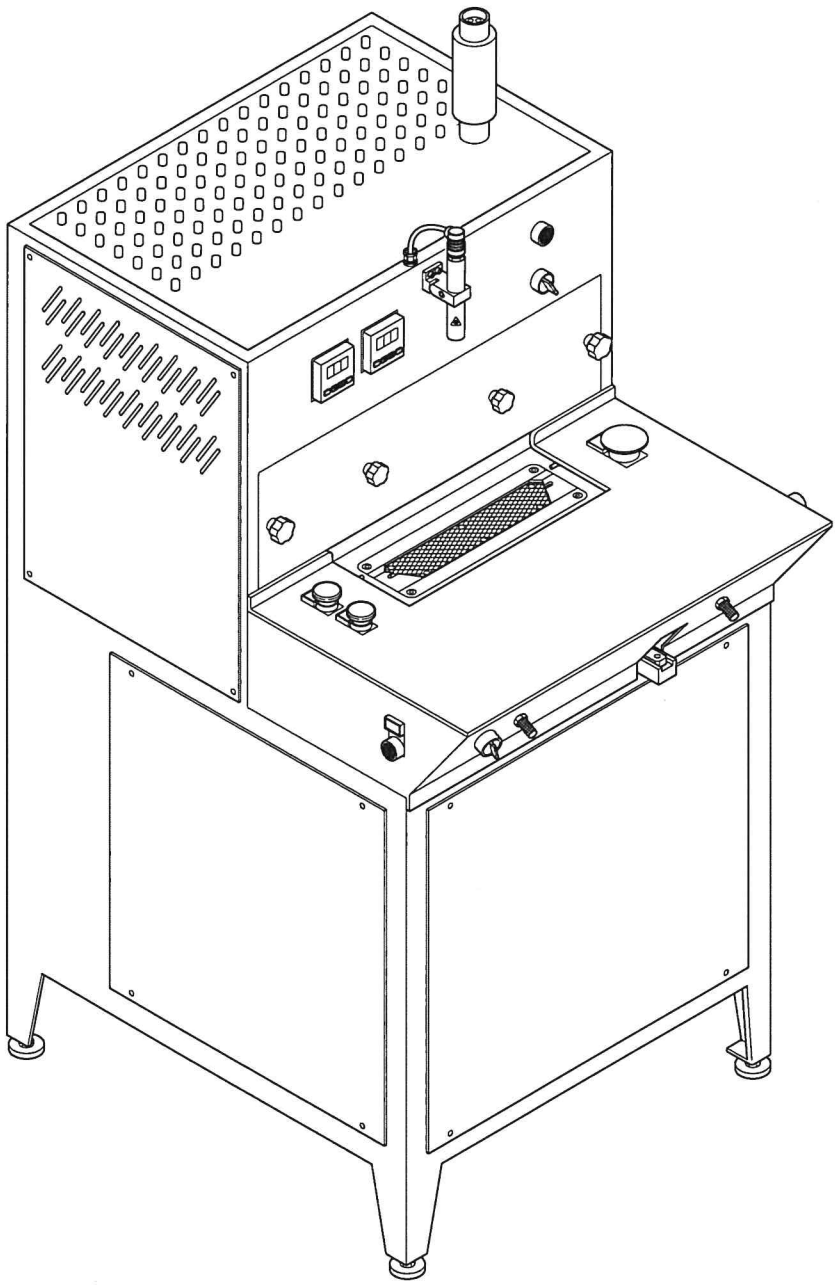
PRESSING MACHINE FOR VENT FACINGS mod. 1003

CE

Operating and maintenance instructions



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AREA DEALER AUTHORIZED FOR CUSTOMER ASSISTANCE

EEC CONFORMITY STATEMENT

We hereby declare that the **Pressing machine mod. 1003** described in this manual complies with the standards set forth in the EEC directives described below:

UNI EN 292-1	Machinery safety. Fundamental concepts.
UNI EN 292-2	Machinery safety. Fundamental concepts.
UNI EN 294	Machinery safety. Safety distances for upper limbs.
UNI EN 349	Machinery safety. Minimum safety distances for crushing.
UNI EN 418	Machinery safety. Emergency stop devices.
pr EN 563	Machinery safety. Contact surface temperatures. Ergonomic data.
pr EN 574	Machinery safety. Two-handed control device.
pr EN 953	Machinery safety. Guard design and construction.
pr EN 1088	Machinery safety. Interlock devices with or without guard block.
EN 60204-1	Electric equipment for industrial machinery. Part 1: General regulations.
EN 60529	Protection levels provided by fences (code IP).
EN 60825	Laser device radiation safety, plant classification, requirements and user's guide.

La Ditta Costruttrice:
M.AI.C.A. S.r.l.

01 - GENERAL INFORMATION

CHARACTERISTICS AND FIELD OF USE

The new Mod. 1003 vent facing pressing machine has been designed for shirt manufacturers who aim at high quality while cutting down sewing time of the vent facings of shirtsleeves.

The vent facings are pressed in pairs, i.e. right and left, and are folded in half ready for sewing.
The machine is equipped with a stacking device where the ready-folded parts are stacked up.

Creasing and pressing of the parts is carried out following a new system, without sheets or stiffeners during pressing.

Different styles of vent or polo collar facings can be pressed simply by changing the frames, an easy operation.

Equipped with a new PLC-based control system.

RECOMMENDATIONS FOR MACHINE USE

The Model 1003 pressing machine is **to be used exclusively** for the pressing of vent and polo collar facings. We disclaim all responsibility for damages resulting from incorrect use of the machine or any use other than the one described in this manual.

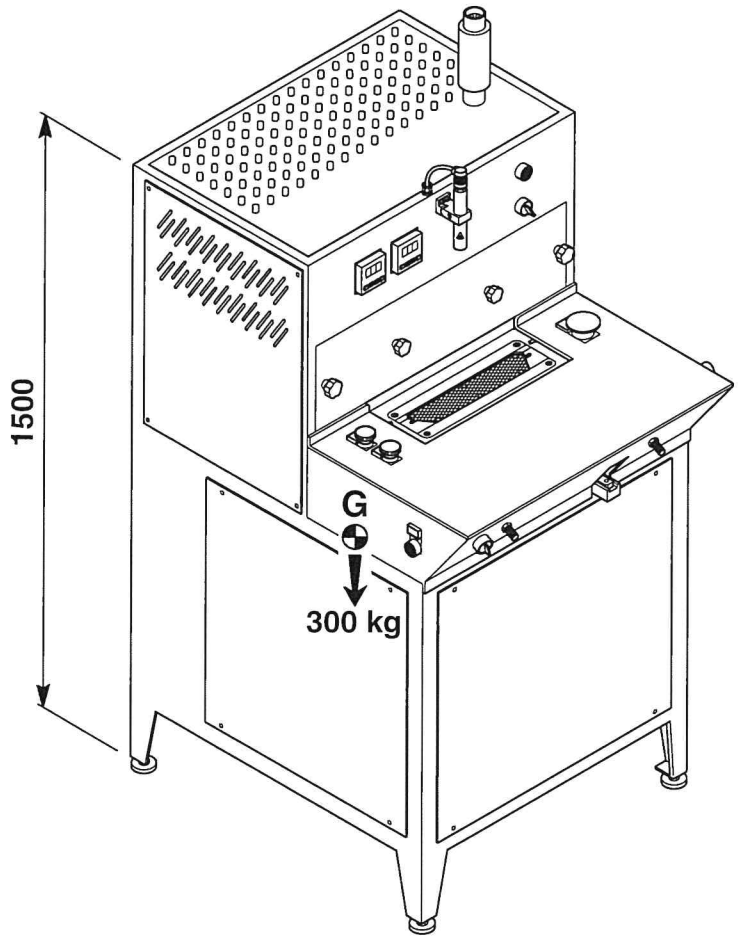
The symbol  is used to indicate a risk or a situation that endangers the operator's safety. Pay particular attention.

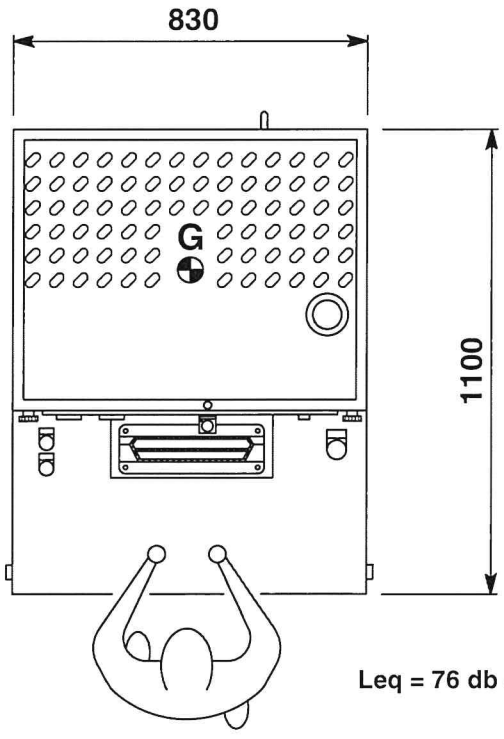
The machine is equipped with a pressing assembly which can reach temperatures exceeding 70° C during the pressing process. Exercise extreme caution when getting close to these components.

Before performing adjustment, replacement or maintenance operations, disconnect the machine from the power supply, disconnect the compressed air and wait for the areas involved in the pressing process to cool down.

The machine **should not be** exposed to atmospheric agents such as rain, sun, etc.

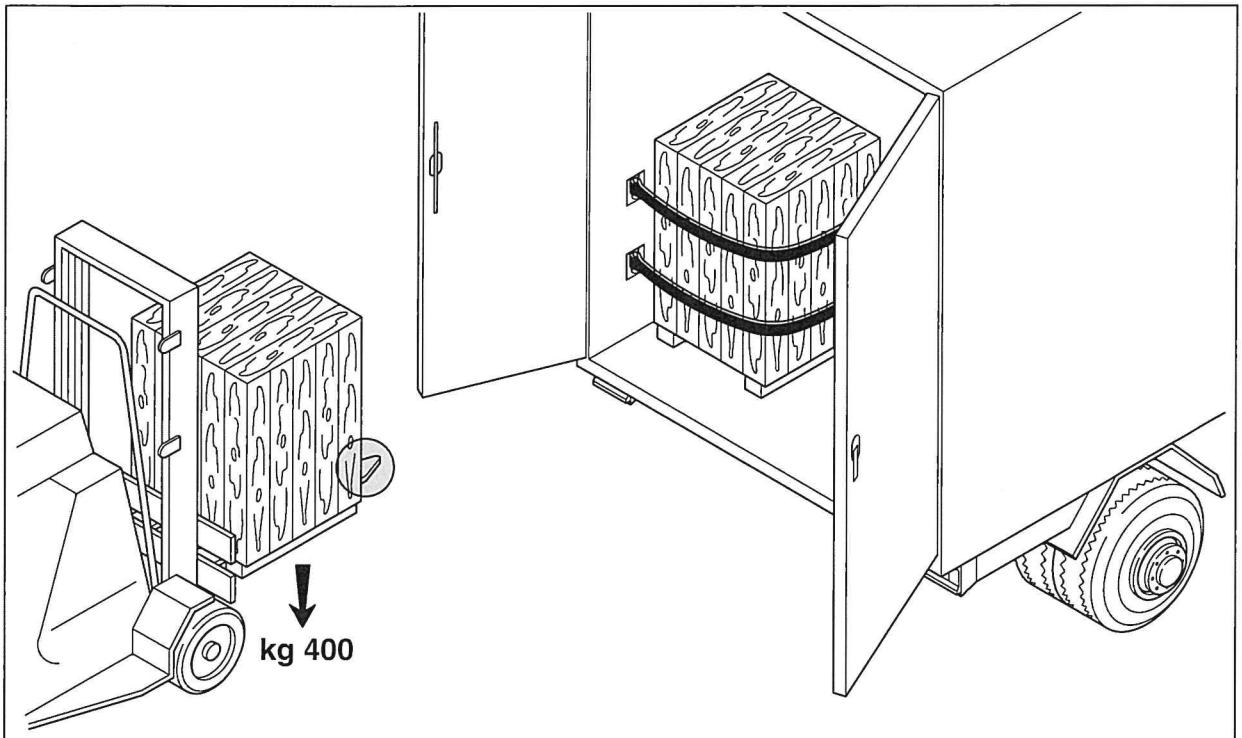
02 - PRESSING MACHINE 1003 TECHNICAL DATA





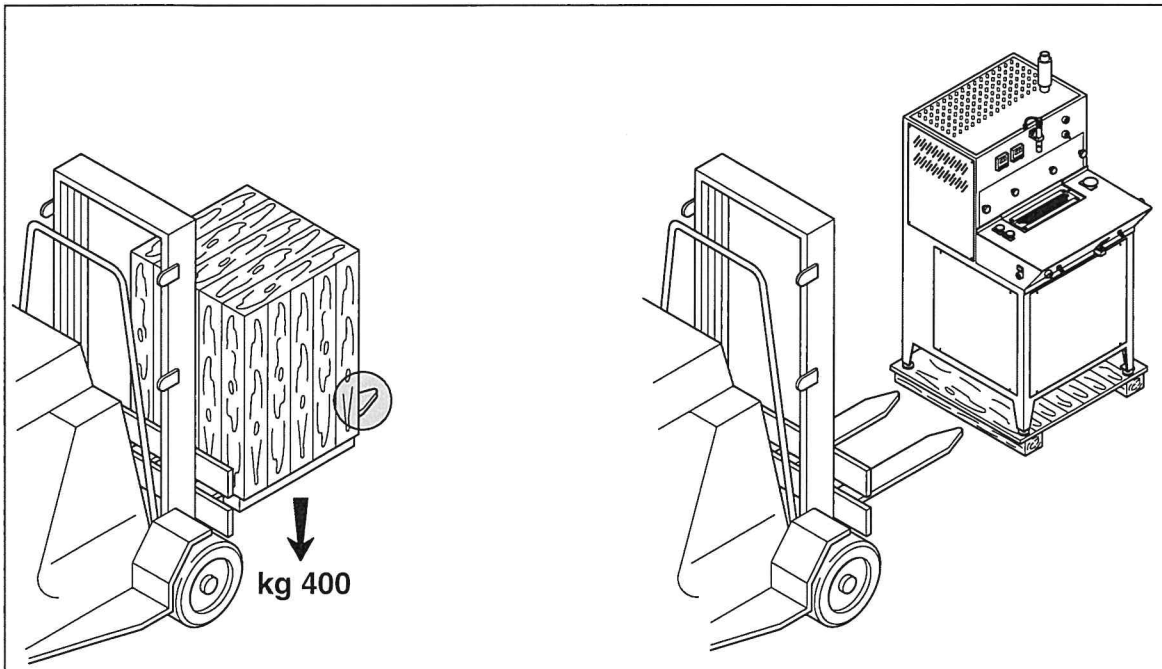
Leq = 76 db (A)

03 - LIFTING AND TRANSPORTATION



The 1003 can be transported with or without a packing case.
In both cases, check that the forks of the fork-lift truck bear the full weight of the machine.
To move the machine without the packing case, insert the forks of the fork-lift truck under the machine, with the side of the machine facing the fork-lift truck. Place in the lorry or van and secure with ropes or belts.

04 - LOADING AND UNLOADING



Make sure that the forks of the fork-lift truck bear the full weight of the machine during movement.
Remove the packing case and lift the machine with the side facing the fork-lift truck as shown in the figure.
Place on a solid and even surface, not exposed to the weather.

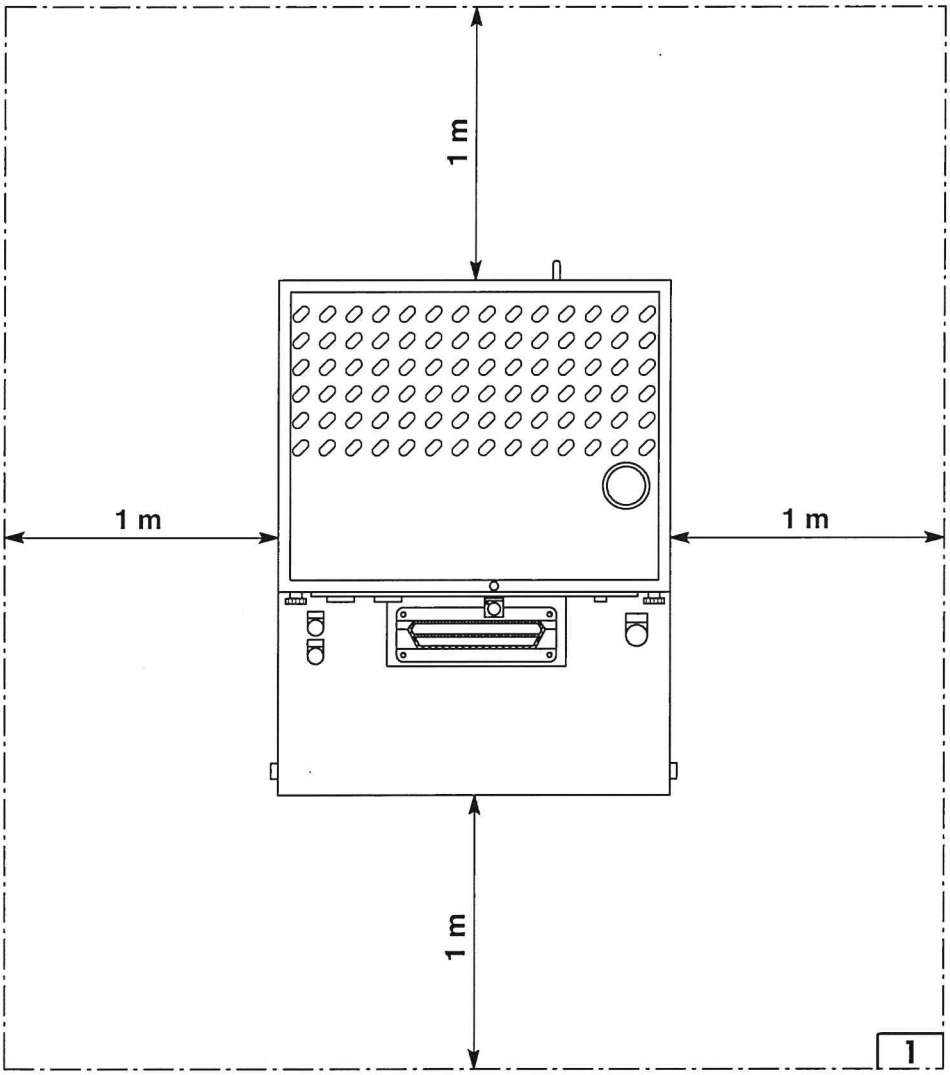
05 - INSTALLATION

ATTENTION: This machine must only be installed by specialized personnel.

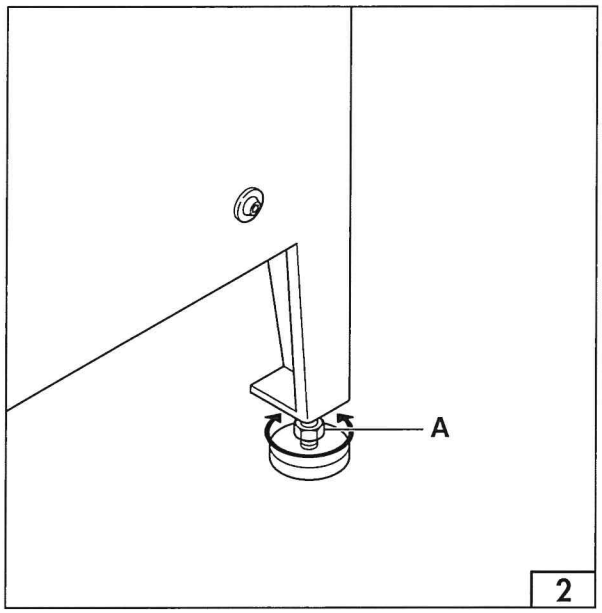
The manufacturer cannot be held liable for any damage to persons or to property arising from incorrect installation not in accordance with these instructions and connection to a mains supply that does not meet the necessary requirements.

⚠ If the machine is installed on a suspended surface, check that the surface can withstand the weight of the machine. This machine must not be installed in areas where there are explosive or inflammable materials and substances.

Make sure that the distances shown in figure **1** below are respected as these are necessary for the maintenance and operation of the machine.



The machine must be placed on a solid and even surface. Turn the nuts "**A**" (fig. **2**) on the leveling feet to adjust the height.

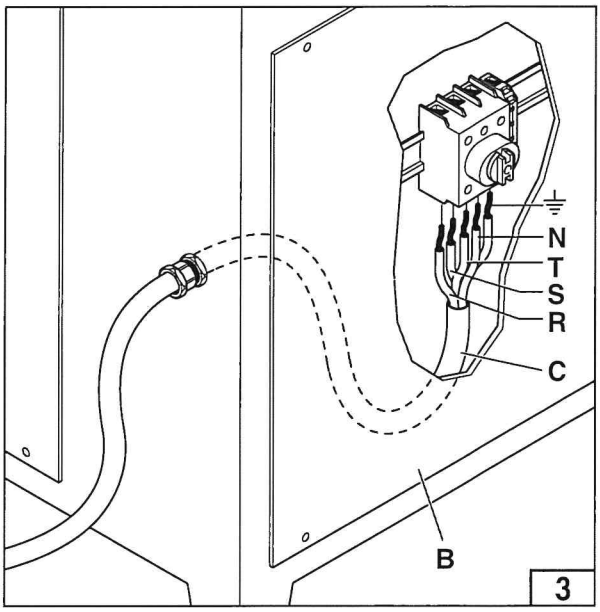


ELECTRICAL CONNECTIONS

The machine is usually delivered with the power cable wired inside the electrical panel. Therefore, all that needs to be done is to connect it to a 380V-50Hz three-phase power outlet.

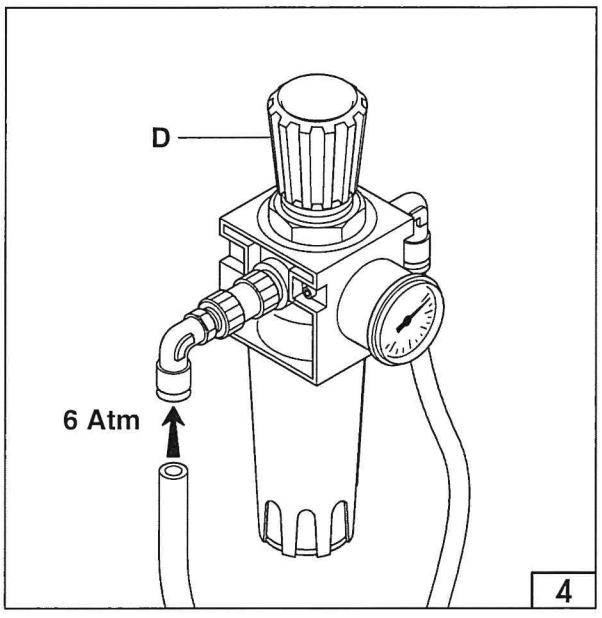
If this is not the case, proceed as follows (fig. **3**):

- Open the rear panel "**B**" by removing the screws.
- Pass the power cable "**C**" through the core hitch on the machine.
- Connect phases **R** - **S** - **T** - **N** and the earth ⏚ to the corresponding terminals of the main switch.
- Before installation, check the efficiency of the earthing system to which the machine is connected.
- Power the machine with 380V-50Hz.

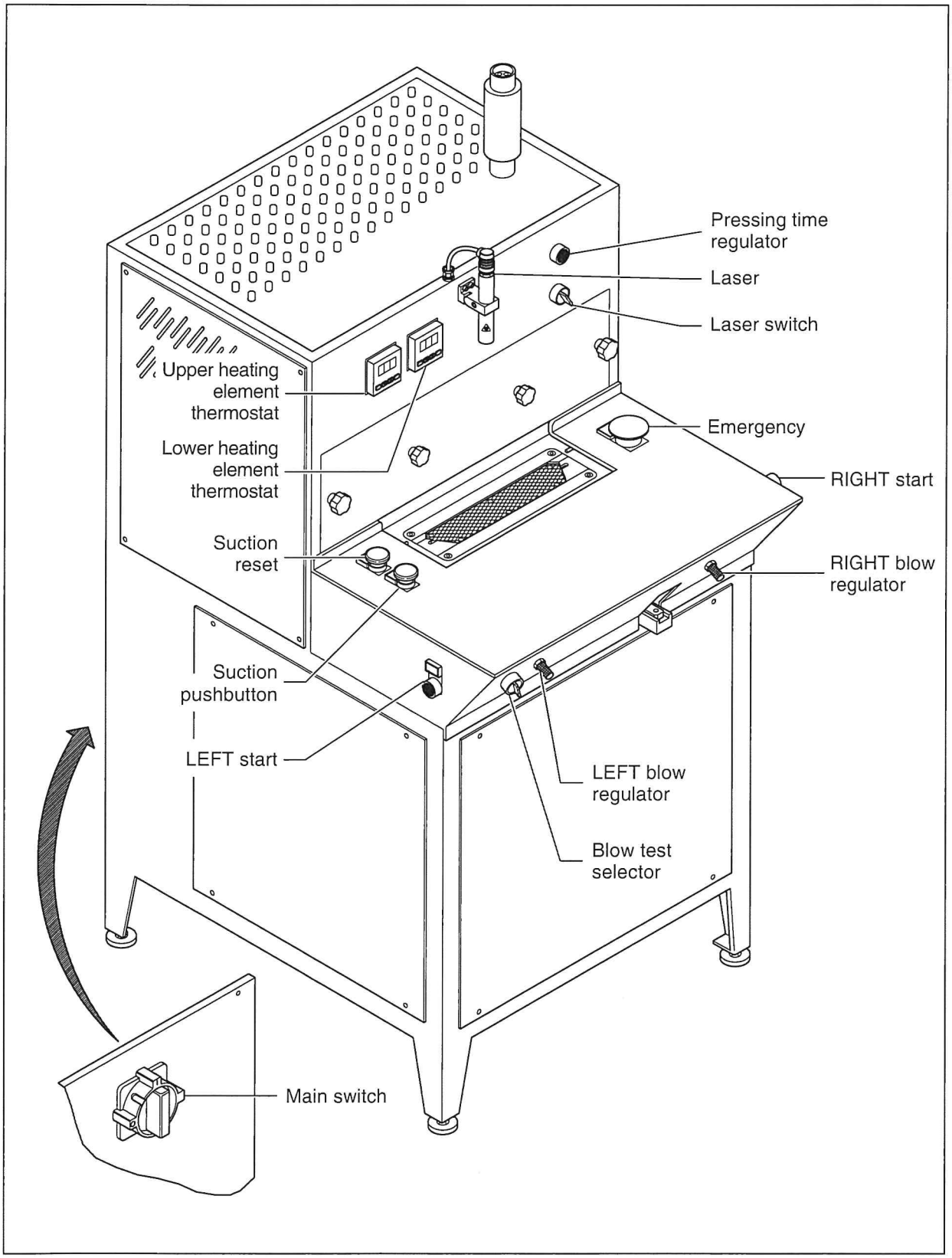


PNEUMATIC CONNECTION

- Connect the machine to the compressed air outlet and make sure that the air flow is sufficient to allow for operation with a constant rate of pressure of 6 Atm.
- Calibrate pressure regulator "**D**" at between 6 Atm (fig. **4**).



06 - MACHINE CONTROLS



07 - OPERATION

START-UP

Turn the main power switch to position **I** (Fig. **1**).
The pressing unit's upper and lower electrical heating element will begin heating up.
Make sure that the preset temperature is appropriate for the use foreseen.

Use the arrow keys ▲ + ▼ - on the respective thermostat (Fig. **2**) for temperature regulation.

Once the required working temperature has been reached, set the ironing time as follows:

1 - Take the machine to its starting position by pressing the two **Start** pushbuttons until the plate has completed its stroke (fig. **3**).
2 - Press the **Ironing time setting** pushbutton "**A**" (fig. **4**): the set time increases by 1 second every time this is pressed.

N.B.: The pushbutton flashes at 0 ironing seconds and goes off at 8 seconds (max. time).

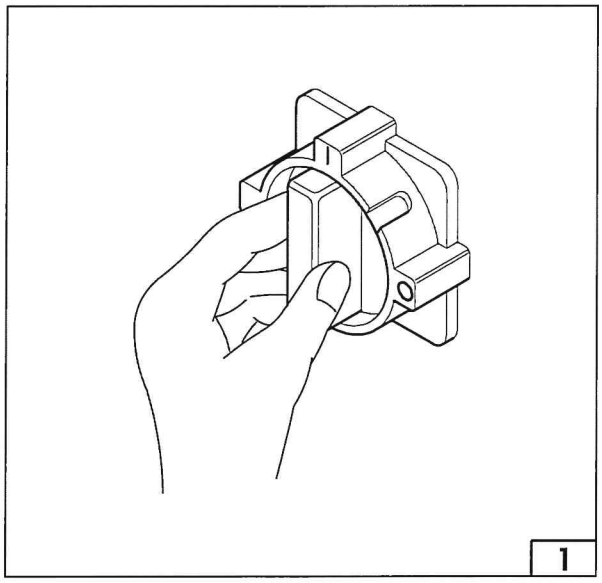
To reset the ironing time, press **Emergency** pushbutton "**B**" (fig. **4**) and hold down the **Ironing time setting** pushbutton for at least 10 seconds. Then release the **Emergency** pushbutton and check whether:

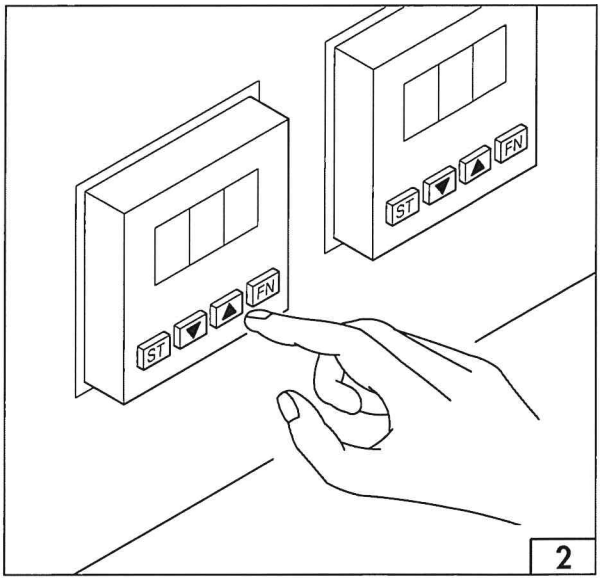
- the pushbutton flashes = reset OK;
- the pushbutton is either on or off = repeat the operation.

To check the set time:

1 - Press either of the two **Start** pushbuttons (right or left).
2 - Count the number of pulsed flashes on the luminous **Ironing time setting** pushbutton: each pulse equals one second.

In order to obtain perfect alignment whenever a striped fabric is used, the laser light must be switched on using the switch "**C**" (fig. **4**).


1



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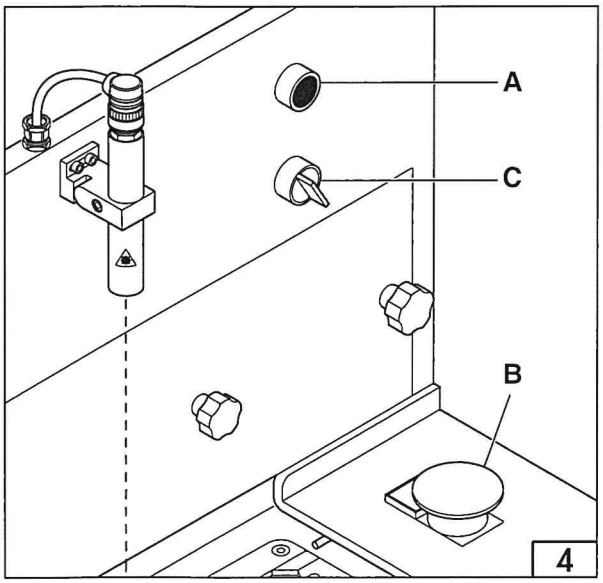

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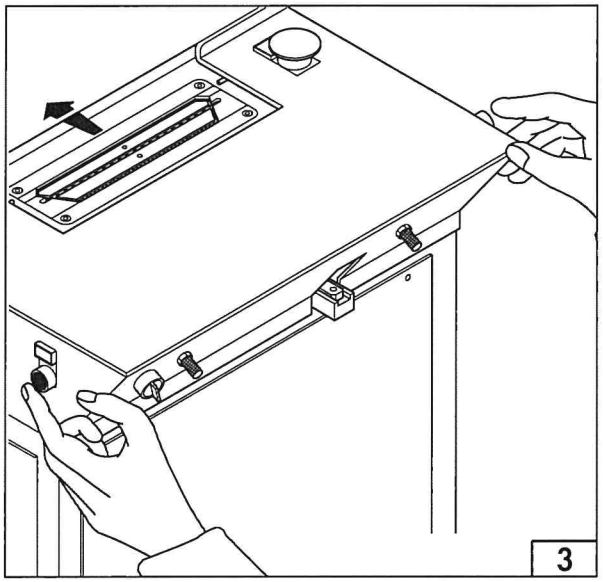
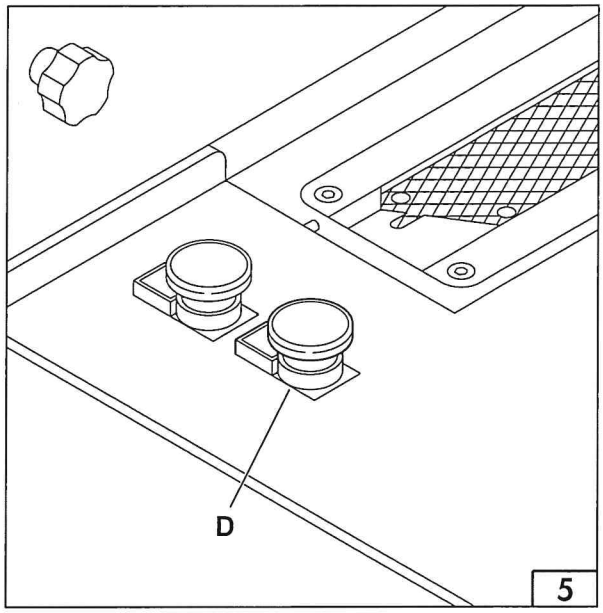

3

Press **Suction** pushbutton "**D**" (fig. **5**) to start up the motor.

NOTE: Whenever the machine is not used for more than 5 minutes, the motor switches off automatically.

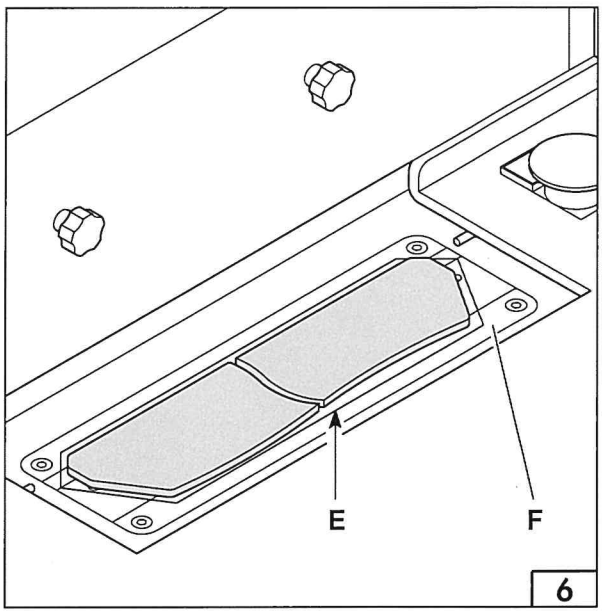


Centre and align the fabric in respect to the outline "**E**" on the centring plate "**F**" (Fig. **6**).

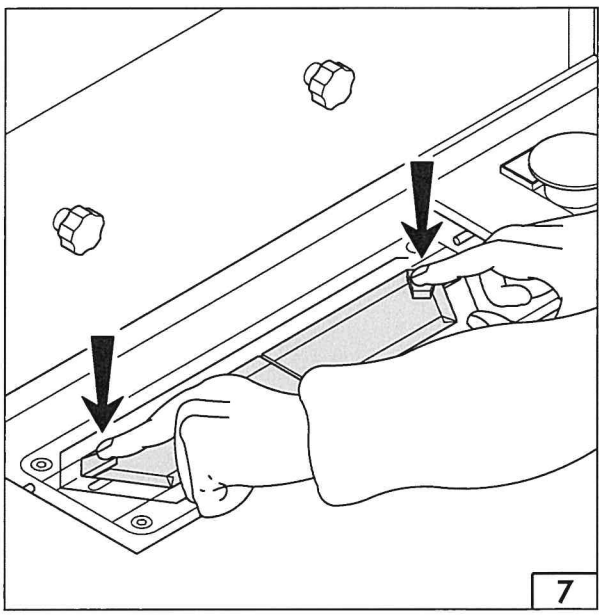
Press the pushbutton "**D**" (Fig. **5**) in order to have the fabric sucked.

NOTE: If the motor has switched off in the meantime, the pushbutton must be pressed twice in order to start suction.

If the fabric is not sucked, invert the motor's phase wires.

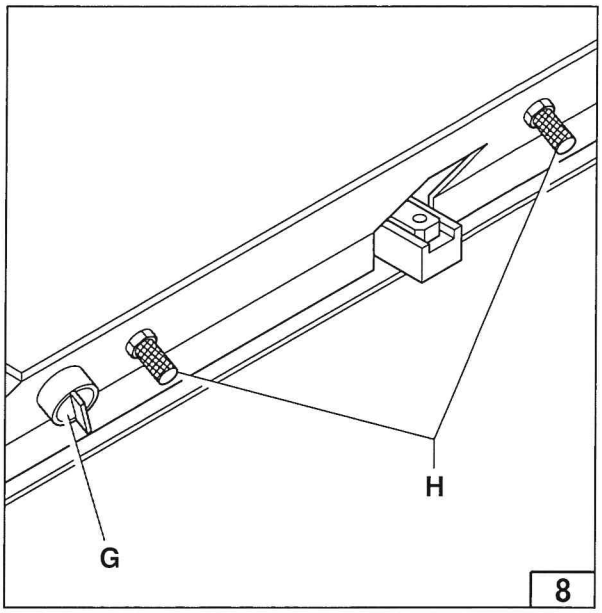


Make sure that the fabric is well folded; in particular, fold the upper corners as shown in Figure **7**.

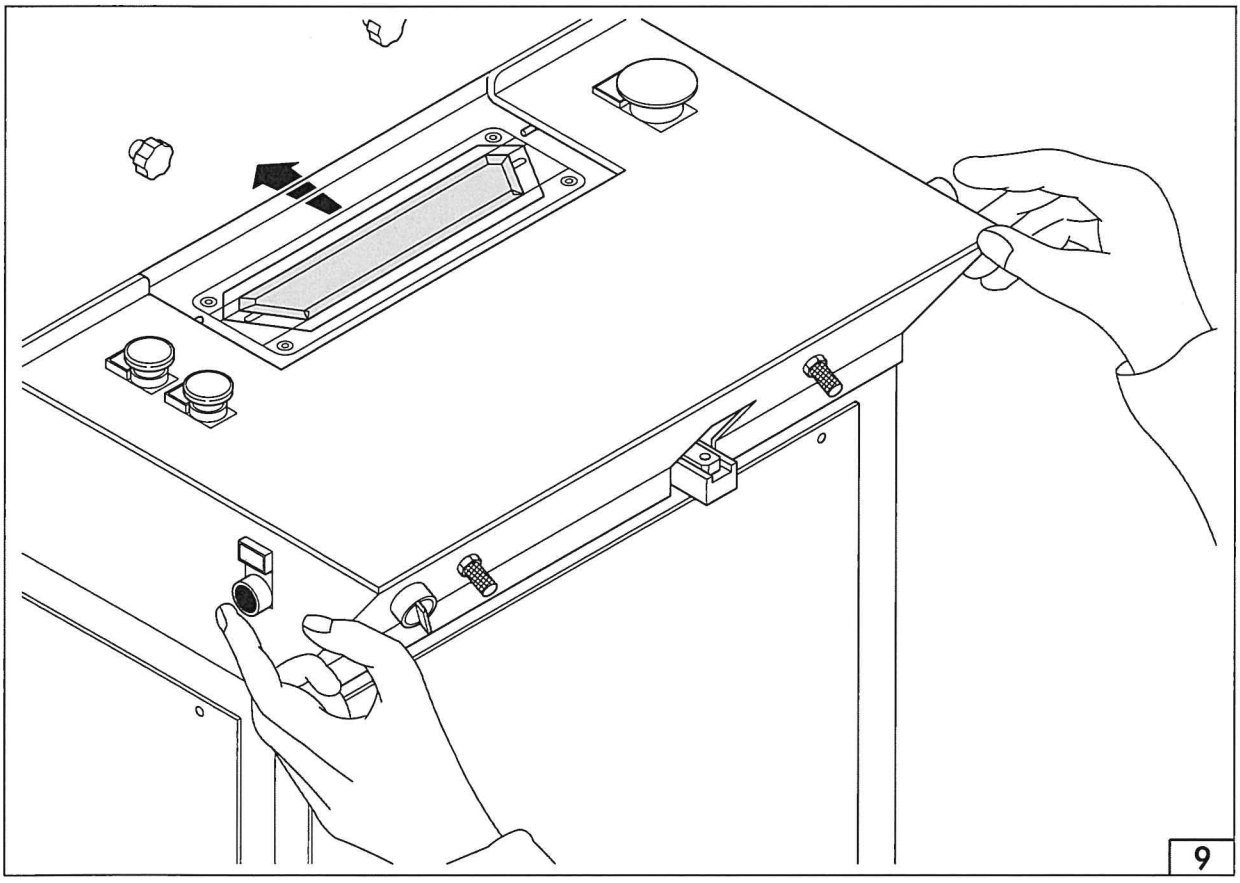


The same corners are held in position by two jets of air.
Proceed as follows to check or adjust the intensity of these jets of air (Fig. **8**):

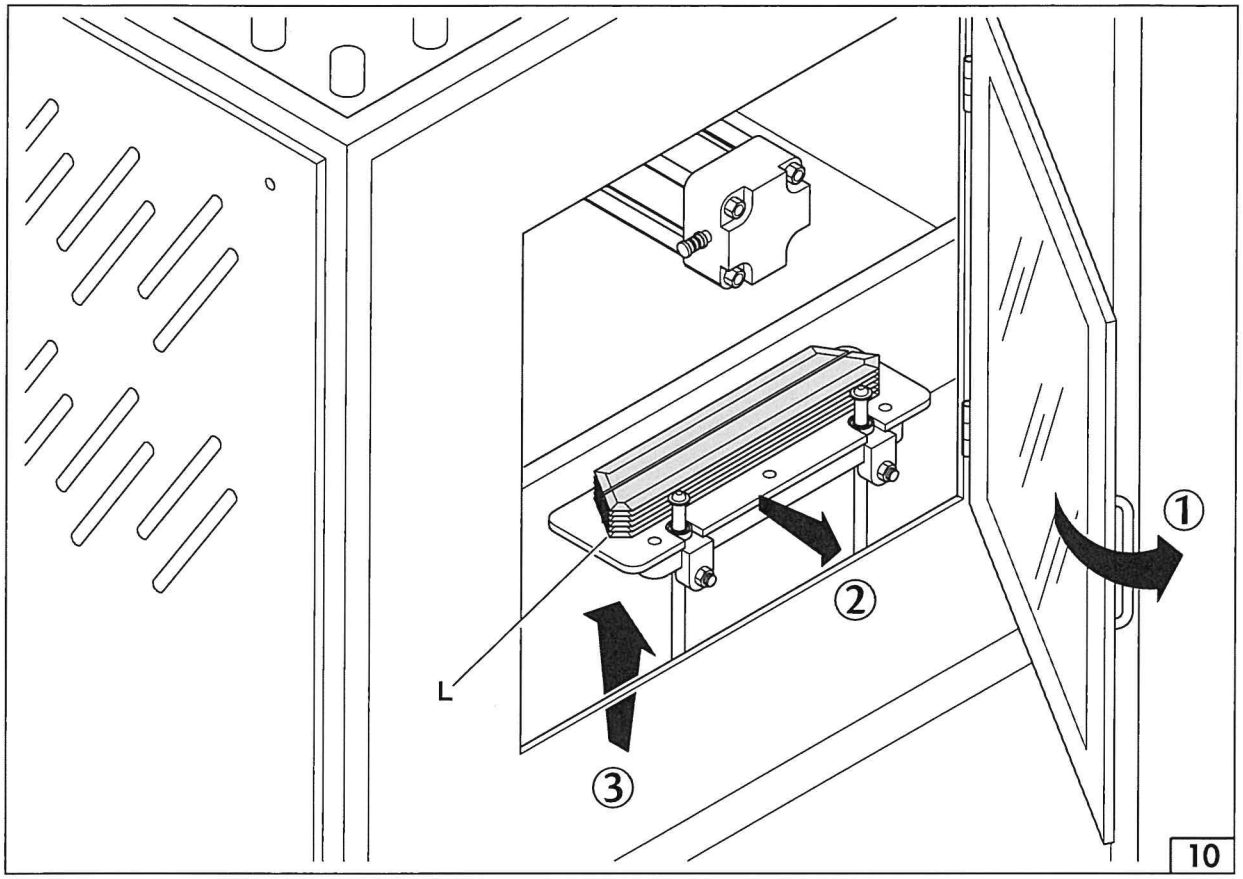
- turn the blow test selector "**G**";
- increase or decrease air pressure using the regulators "**H**";
- then return the selector "**G**" to its initial position.



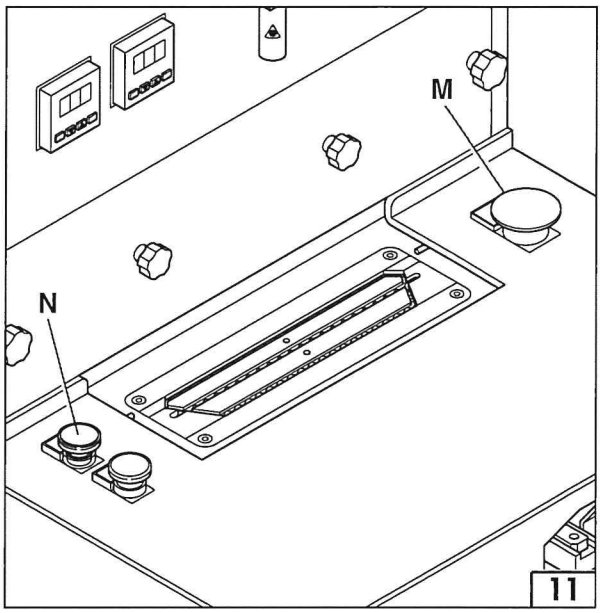
Press the two start buttons and keep them pressed until the plate completes its stroke (Fig. **9**).



The vent and polo collar facings are pressed and deposited on a rear stacker that automatically lowers after each deposit.
Open the rear door "**I**" (Fig. **10**) to remove the vent and polo collar facings and then unload the pressed pieces; manually raise the stacker's support surface "**L**", and then close the rear door.



In case of malfunction, the machine can be brought to a complete stop by pressing the emergency button "**M**" (Fig. **11**).
In order to remove the emergency, press and rotate the same emergency button.
If only suction must be interrupted, press the suction reset button "**N**" (fig. **11**).



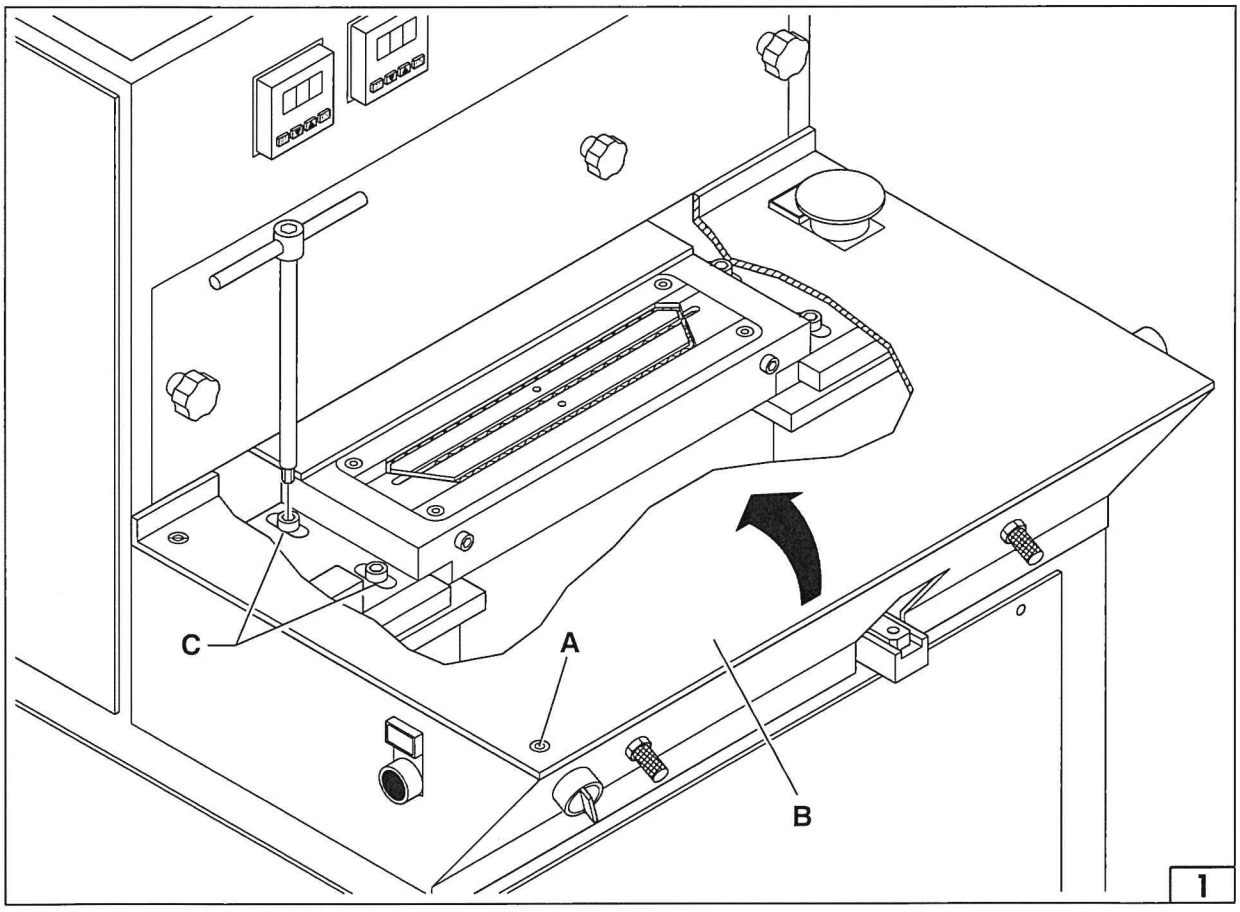
08 - ADJUSTMENTS

⚠ Before performing adjustment, replacement or maintenance operations, disconnect the machine from the power supply, disconnect the compressed air and wait for the area involved in the pressing process to cool down. The operations hereinafter described must be performed only by specialized personnel.

FOLD CENTRING ADJUSTMENT

In order to adjust the position of the fold more or less at the centre of the vent and polo collar facing, proceed as follows (Fig. **1**):

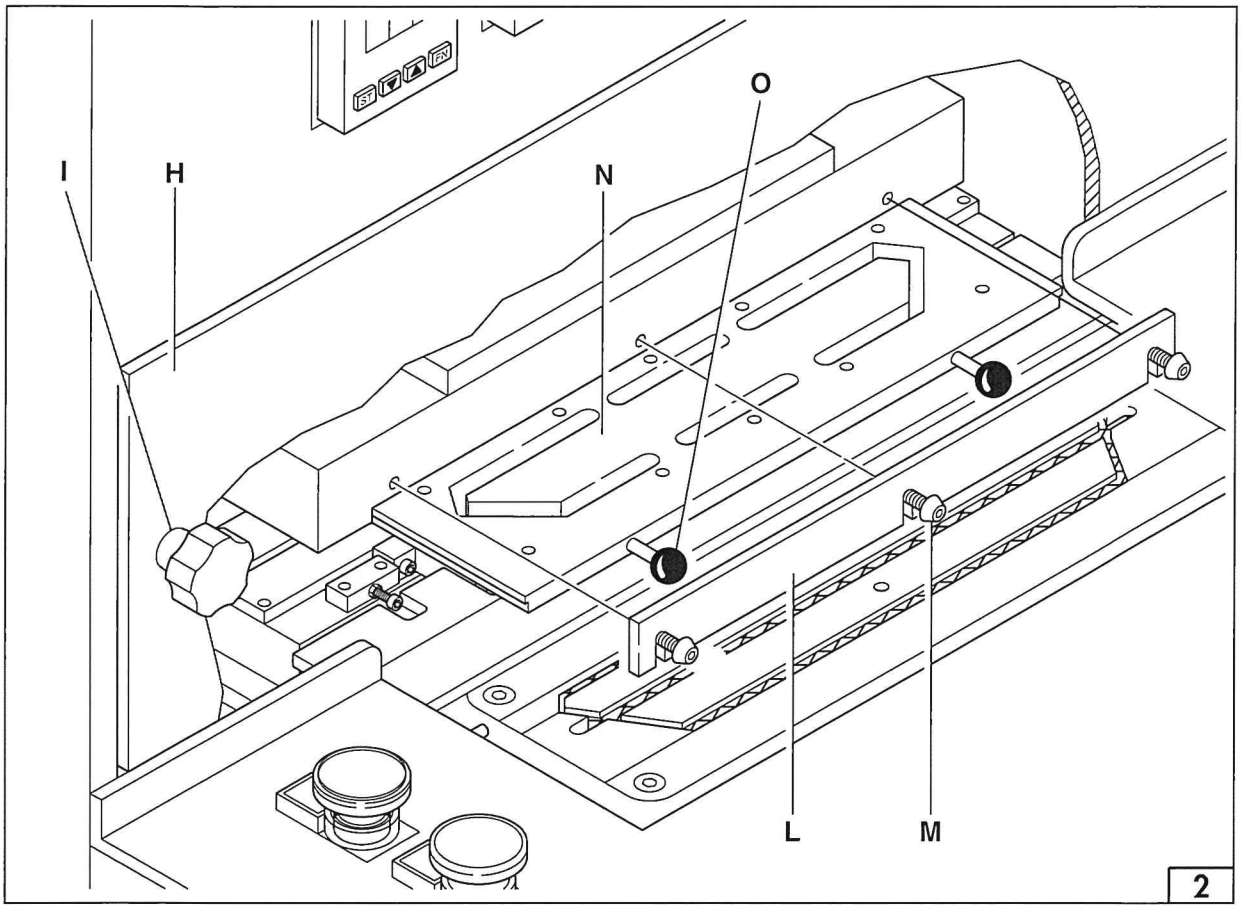
- unscrew the protection case fixing screws "**A**";
- raise the protection case "**B**" upwards as shown by the arrow in the figure;
- loosen the 4 screws "**C**" and adjust the position of the plate;
- re-position the protection case "**B**".



STITCHING REFERENCE MARKADJUSTMENT

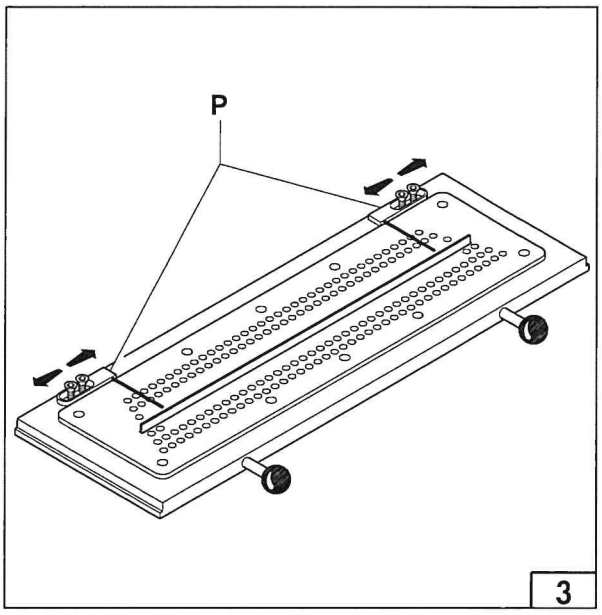
A reference mark that indicates where the stitching must begin can be put on the pressed vent and polo collar facings. To adjust this setting, follow these steps (fig. **2**):

- wait until the machine cools off or use the appropriate protection gloves;
- remove front protection cover "**H**" by unscrewing the two side knobs "**I**";
- remove the "**L**" retainer plate by unscrewing the "**M**" screws;
- remove the upper mould "**N**" by using the two "**O**" knobs screwed into the holes in the mould.



2

- tilt the plate by 180° and adjust the position of the supports using cylindrical bar "**P**" (fig. **3**);
- remount the upper plate repeating the above steps in the reverse order.

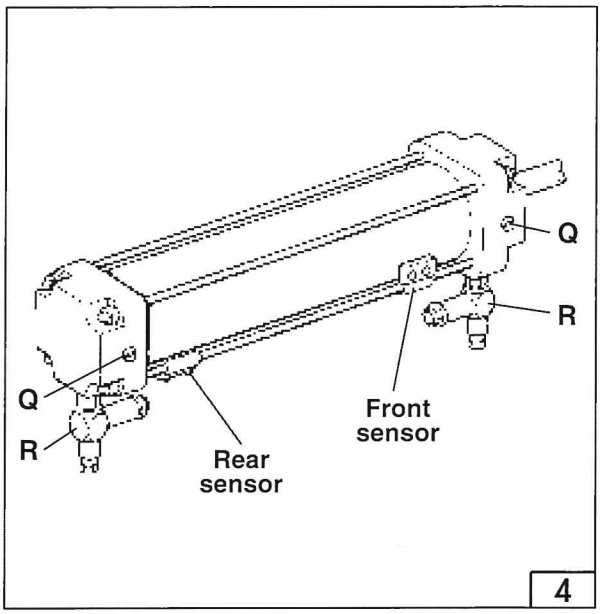


3

DRIVE CYLINDER ADJUSTMENT

The vertical and longitudinal drive cylinders are equipped with the regulators "**R**" (Fig. **4**) that permit the speed to be increased or reduced. In addition, the regulator also acts on the longitudinal cylinder as a stop valve.

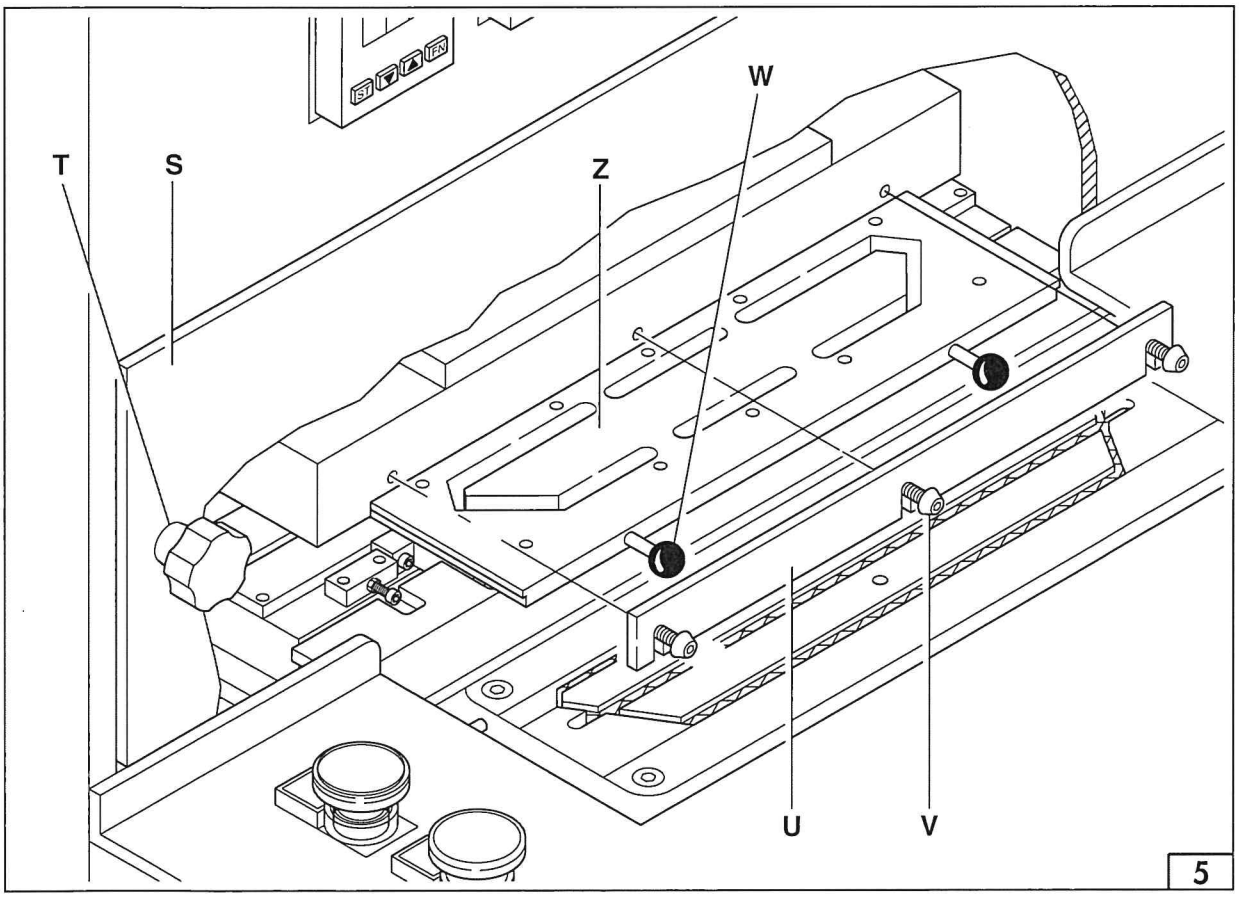
Impacts can be avoided and the cylinder stroke can be absorbed by working on the screws "**Q**" (Fig. **4**).



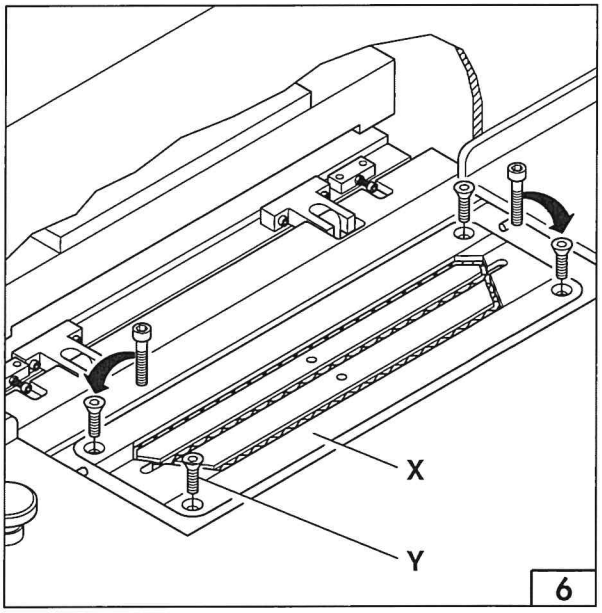
CHANGING THE MOULD

The Model 1003 pressing machine permits the pressing of every vent and polo collar facing size by using an appropriate kit composed as follows: upper mould, lower mould, extractor.
Proceed as follows to change the mould (Fig. **5**):

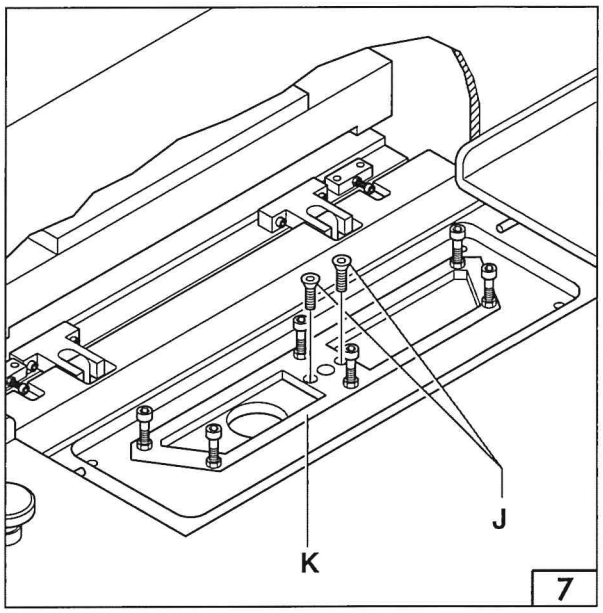
- wait until the machine cools off or use the appropriate protection gloves;
- remove the front casing "**S**" by unscrewing the two side knobs "**T**";
- remove the "**U**" retainer plate by unscrewing the "**V**" screws;
- remove the upper mould "**Z**" by using the two "**W**" knobs screwed into the holes in the mould.



- Remove the lower mould "**X**" (Fig. **6**) by unscrewing the four screws "**Y**" and then inserting two screws of adequate length into the threaded holes in order to extract the mould subsequently.



- Remove the "**K**" extractor by using the screws "**J**" (fig. **7**).
- Install the new mould by repeating the operations above in inverse order.



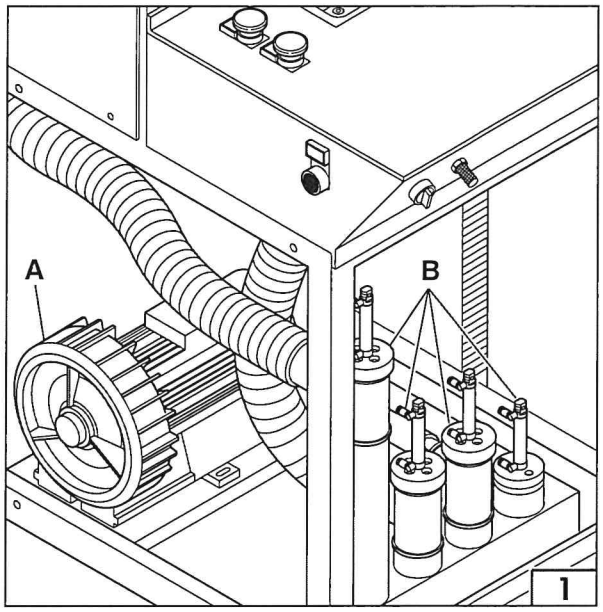
09 - MAINTENANCE

⚠ Always disconnect the machine from the mains supply, the compressed air supply and wait for the ironing parts to cool down before undertaking any adjustment, replacement or maintenance work.
The operations described below must only be carried out by specialized personnel.

The 1003 does not require any special maintenance during use thanks to its rational design.
We recommend lubricating the joints regularly and following all instructions in this manual very carefully to keep this machine in good and reliable working condition.

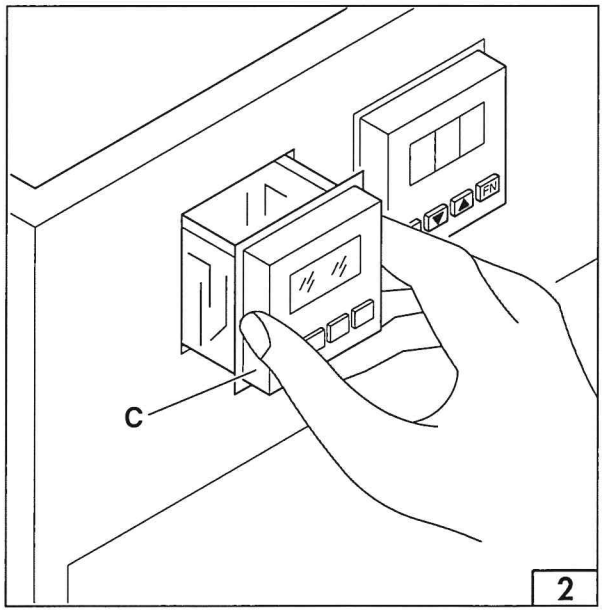
REGULAR CLEANING

Remove the lower protection cover on the left-hand side of the machine and clean motor "**A**" and safety valves "**B**" using a jet of compressed air (fig. **1**).



THERMOSTAT REPLACEMENT

Remove the faulty thermostat "**C**" as shown in fig. **2** and insert a new thermostat.

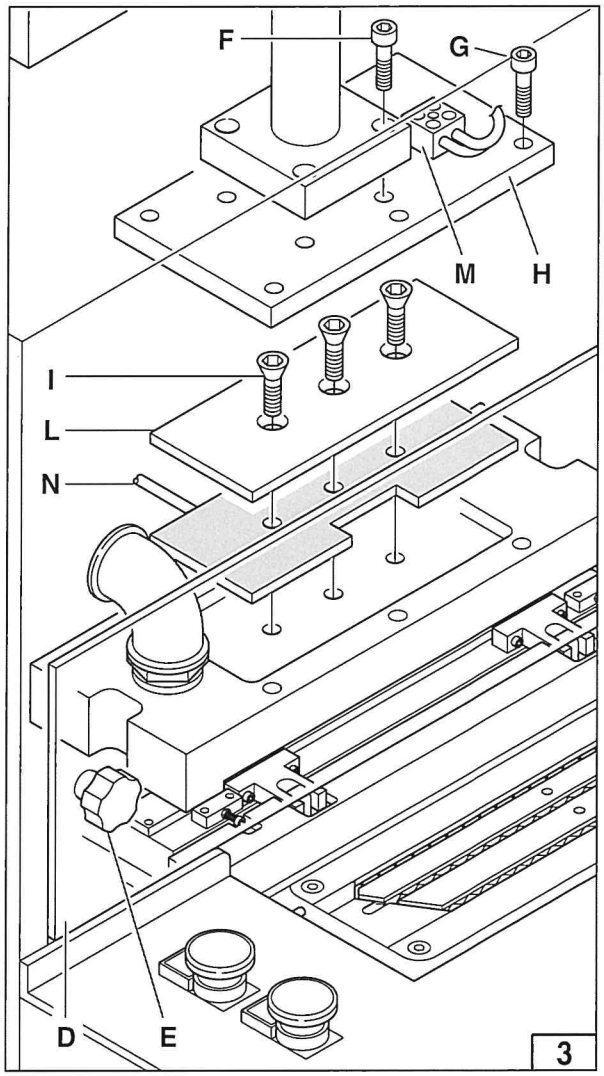


HEATING ELEMENT REPLACEMENT

Proceed as follows whenever a heating element must be replaced:

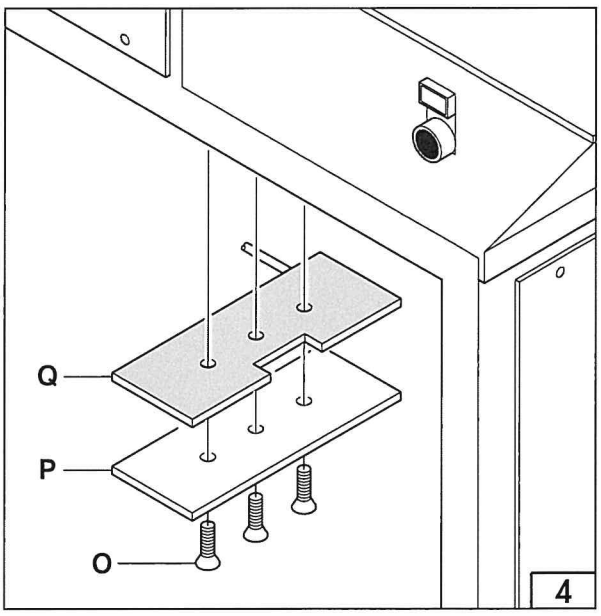
Upper heating element (Fig. 3)

- remove the front casing "**D**" by unscrewing the two side knobs "**E**";
- unscrew the screws "**F**" on the vertical cylinder attachment;
- unscrew the screws "**G**" and remove the plate "**H**";
- unscrew the screws "**I**" and remove the plate "**L**";
- disconnect the heating element wires from the block "**M**";
- remove the heating element "**N**";
- insert the new heating element and repeat the operations above in inverse order.



Lower heating element (Fig. 4)

- Remove one of the lateral protection casings in order to gain access to the lower part of the machine;
- unscrew the screws "**O**" and remove the plate "**P**";
- remove the heating element "**Q**";
- insert the new heating element and repeat the operations above in inverse order.

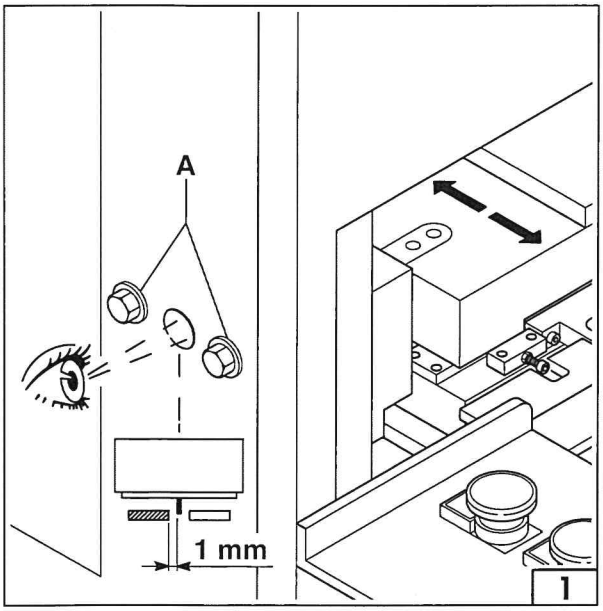


DEMOLITION

In case of machine demolition, separate the different materials making up the machine so that they can be shipped to designated collection sites for re-cycling.

10 - MALFUNCTIONS, CAUSES AND REMEDIES

MALFUNCTION	CAUSE	REMEDY
Machine does not heat up	Burnt-out resistor	Replace (see page 18)
	Thermostat failure	Replace (see page 19)
	Broken thermocouple	Check and/or replace
	Remote switch failure	Check with voltmeter and/or replace
Irregular temperature	Thermostat failure	Replace (see page 19)
	Broken thermocouple	Check and/or replace
Faulty pressing	Insufficient temperature	Raise temperature (see page 9)
	Pressing time too short	Increase pressing time (see Page 9)
The machine fails to start	Magnetic sensors inefficient	Check to make sure that the led for the magnetic sensors on the drive cylinders are on and shift until they light up or replace if necessary
Insufficient suction	Safety valve open	Make sure that the safety valve remains closed during machine operation
No central ironing	Central ironing bar in the wrong position	- Switch off the machine, disconnect the compressed air supply and wait for the ironing area to cool down. - Remove the front protection cover using the two fixing knobs. - Remove the two upper side protection covers. - Use the hole in the frame to check that the space between the ironing bar and the rear plate is ~ 1 mm (fig. **1**). - If this is not the case, loosen screws "**A**" on both sides and move the plate unit so that the central folding bar is ~ 1 mm from the rear plate.



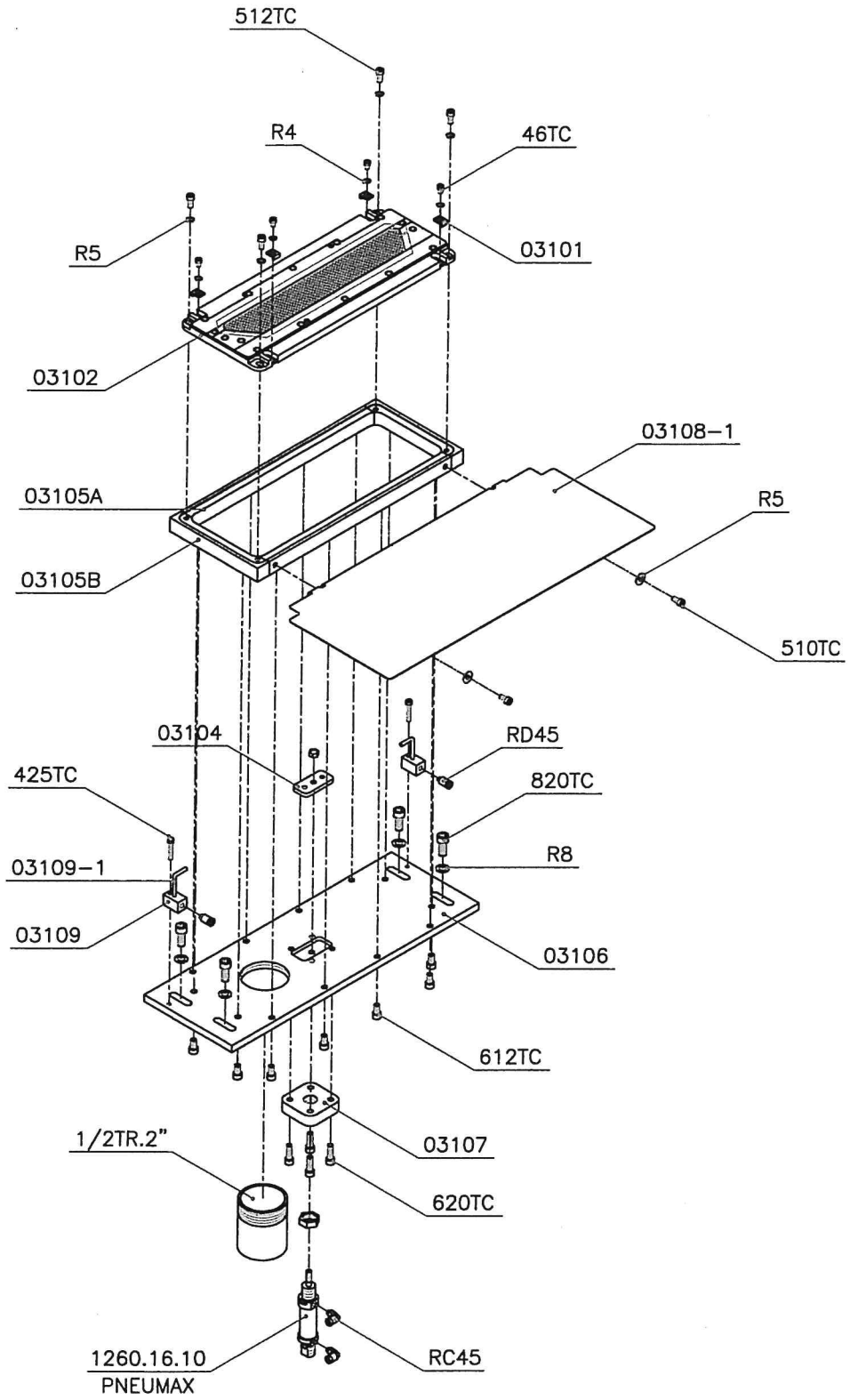
11 - SPARE PART SHEETS

For prompt part identification, the following data must be provided:

1. Machine model and serial number
2. Spare part code
3. Sheet in which the spare part is shown

Example: PRESSING MACHINE mod. 1003 Serial No. ..... Code 0330 Table 1

STIRATRICE 1003	TAV. 1
M.A.I.C.A.	



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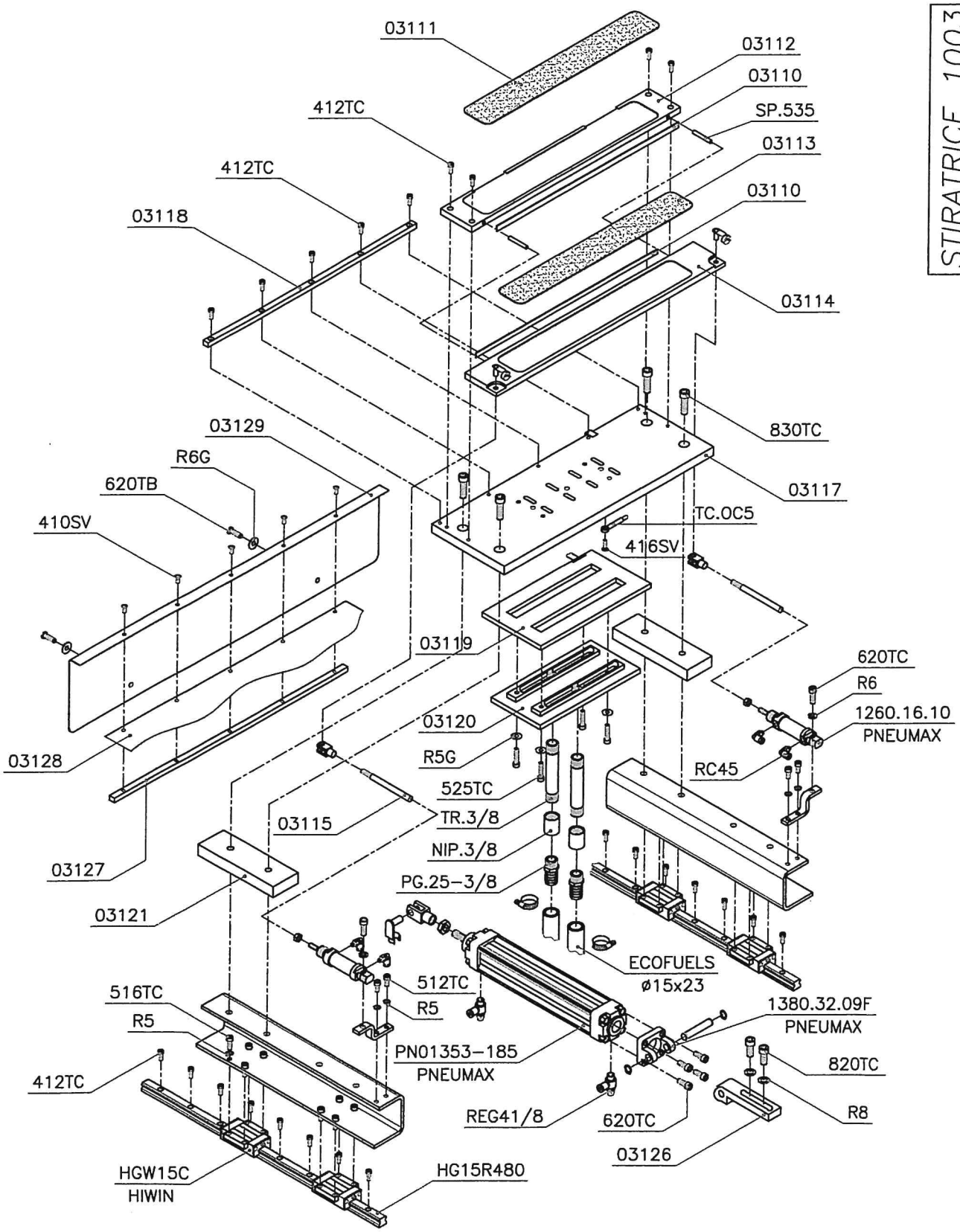
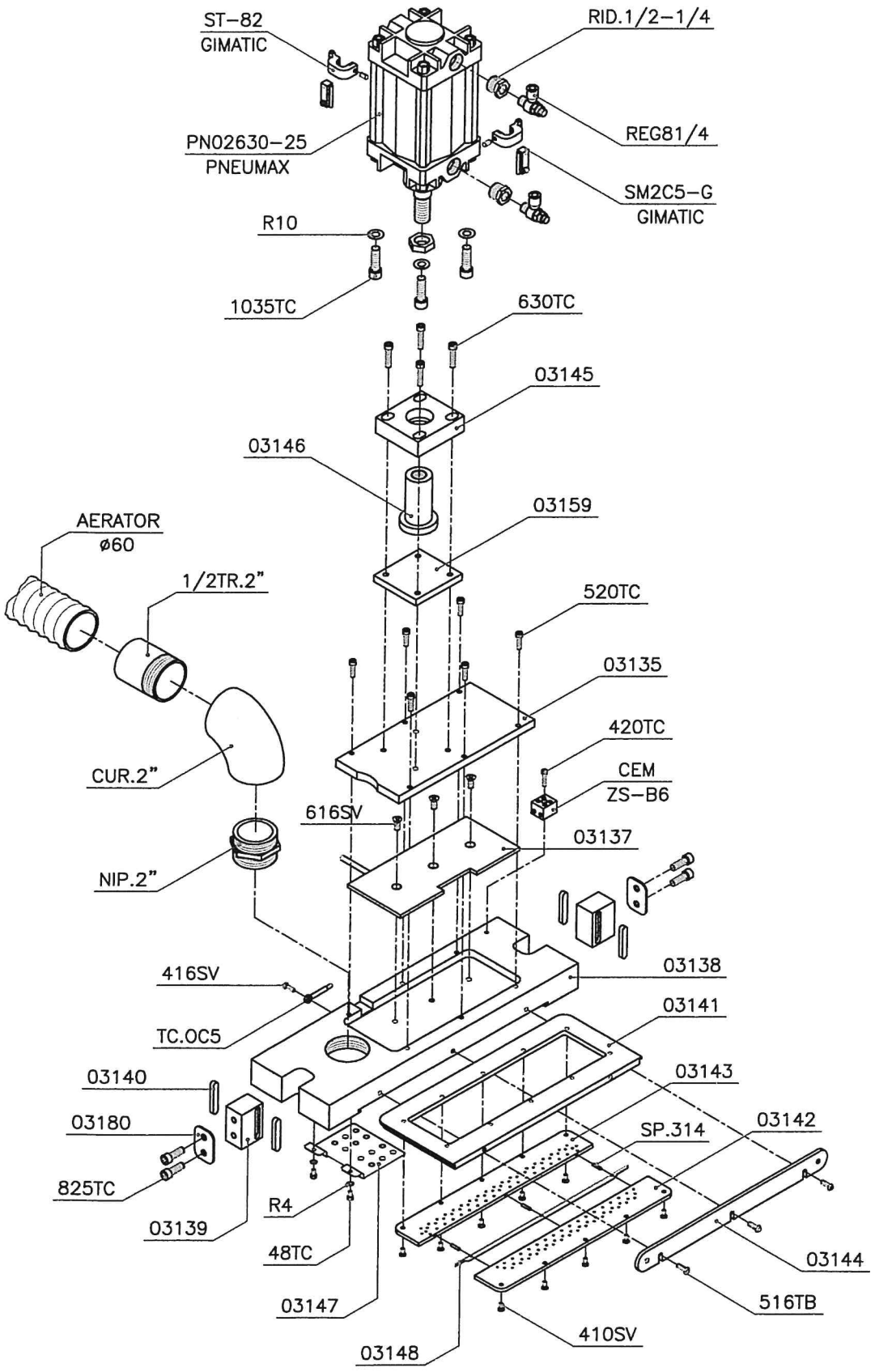
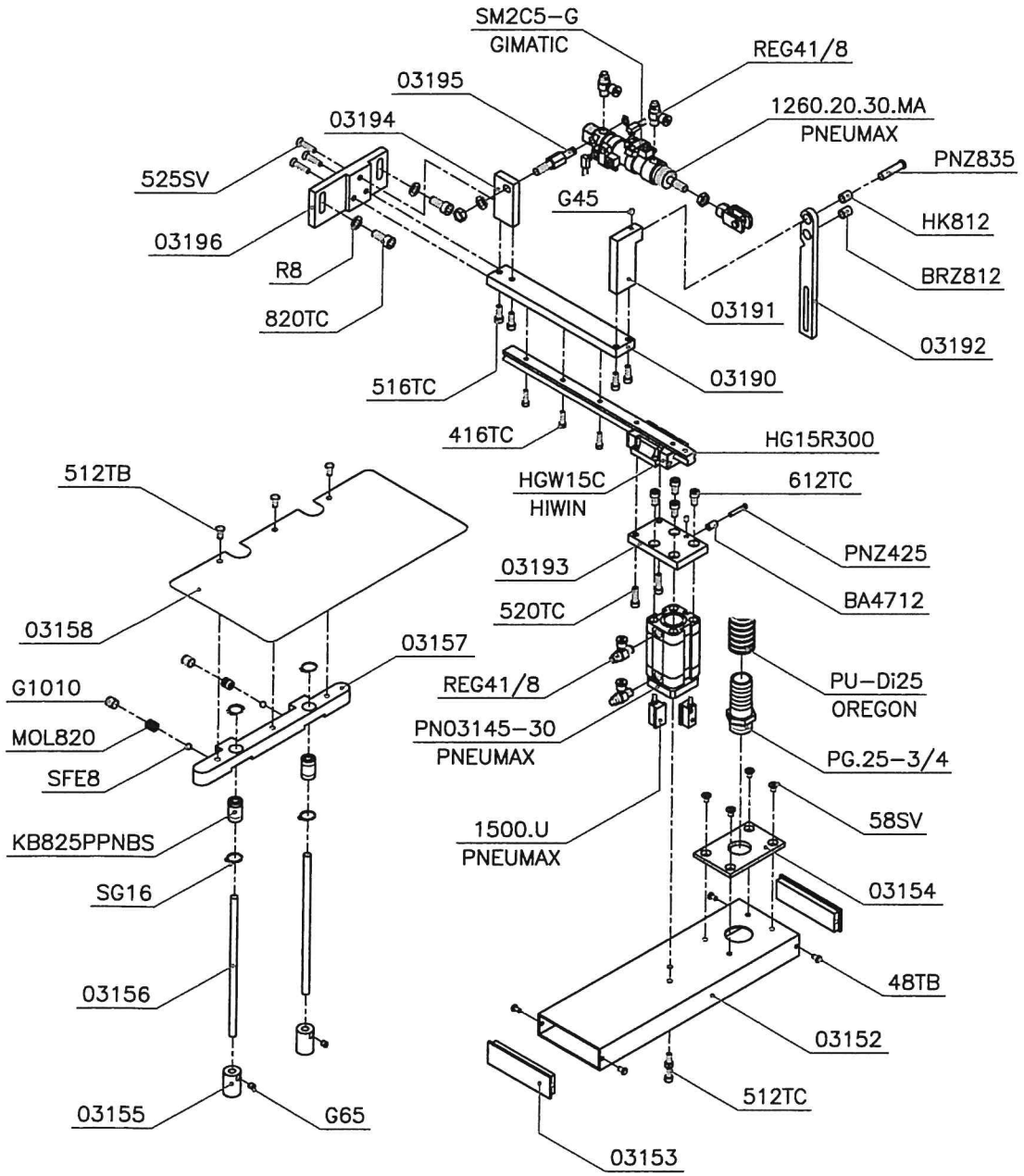
M.A.I.C.A.	



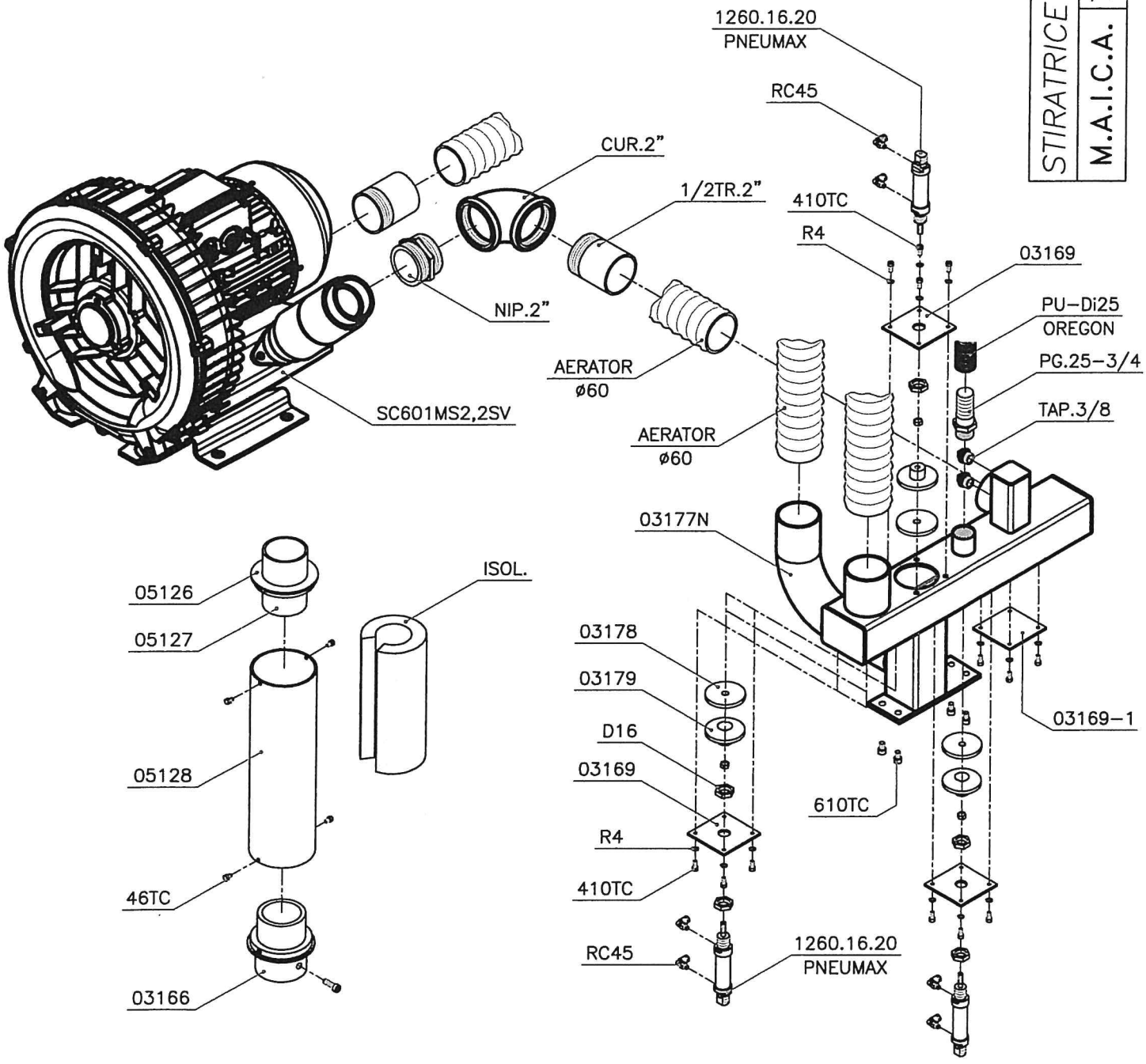
STIRATRICE 1003	TAV. 3
M.A.I.C.A.	



STIRATRICE 1003	TAV. 4
M.A.I.C.A.	



STIRATRICE 1003	TAV. 5
M.A.I.C.A.	



MACCHINA STIRATRICE
MOD. 1003 S7_1200.

M.A.I.C.A. s.r.l.

REV.	DATA	NOME	
0			DATA : 2013
			NOME :
			CONTR. :
			APPR. :

M.A.I.C.A. s.r.l.
MACCHINE AUTOMATISMI INDUSTRIALI
CAMICERIE ABBIGLIAMENTO
Via Casale, 23 - 24060 Torre de Roveri (BG)

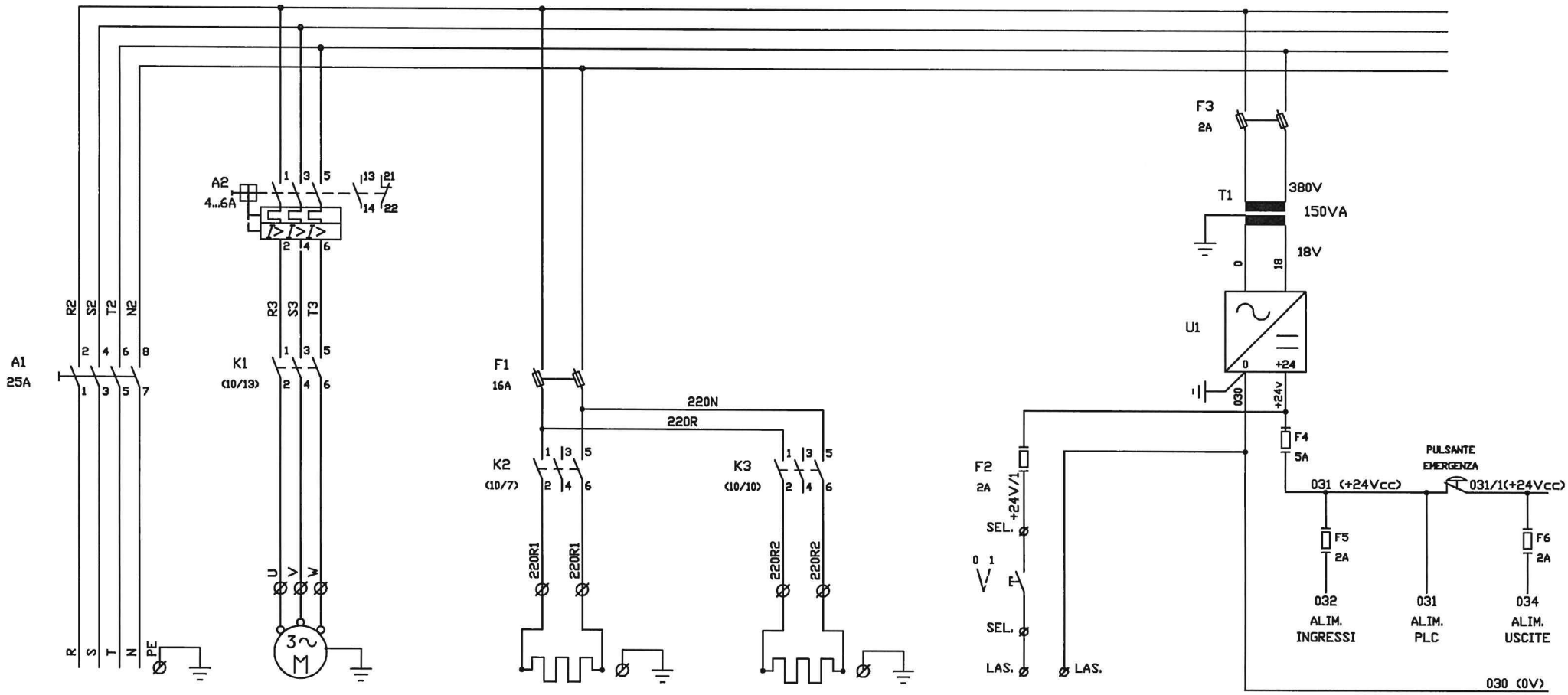
CLIENTE

DESCRIZIONE: STIRATRICE 1003.

FOGLIO N.: 1

N. FOGLI:

DISEGNO N.:



ALIMENTAZIONE
380 50HZ

HP3 (5A)
MOTORE
ASPIRAZIONE

1200W 220V
RESISTENZA
INFERIORE

1200W 220V
RESISTENZA
SUPERIORE

24v
LASER

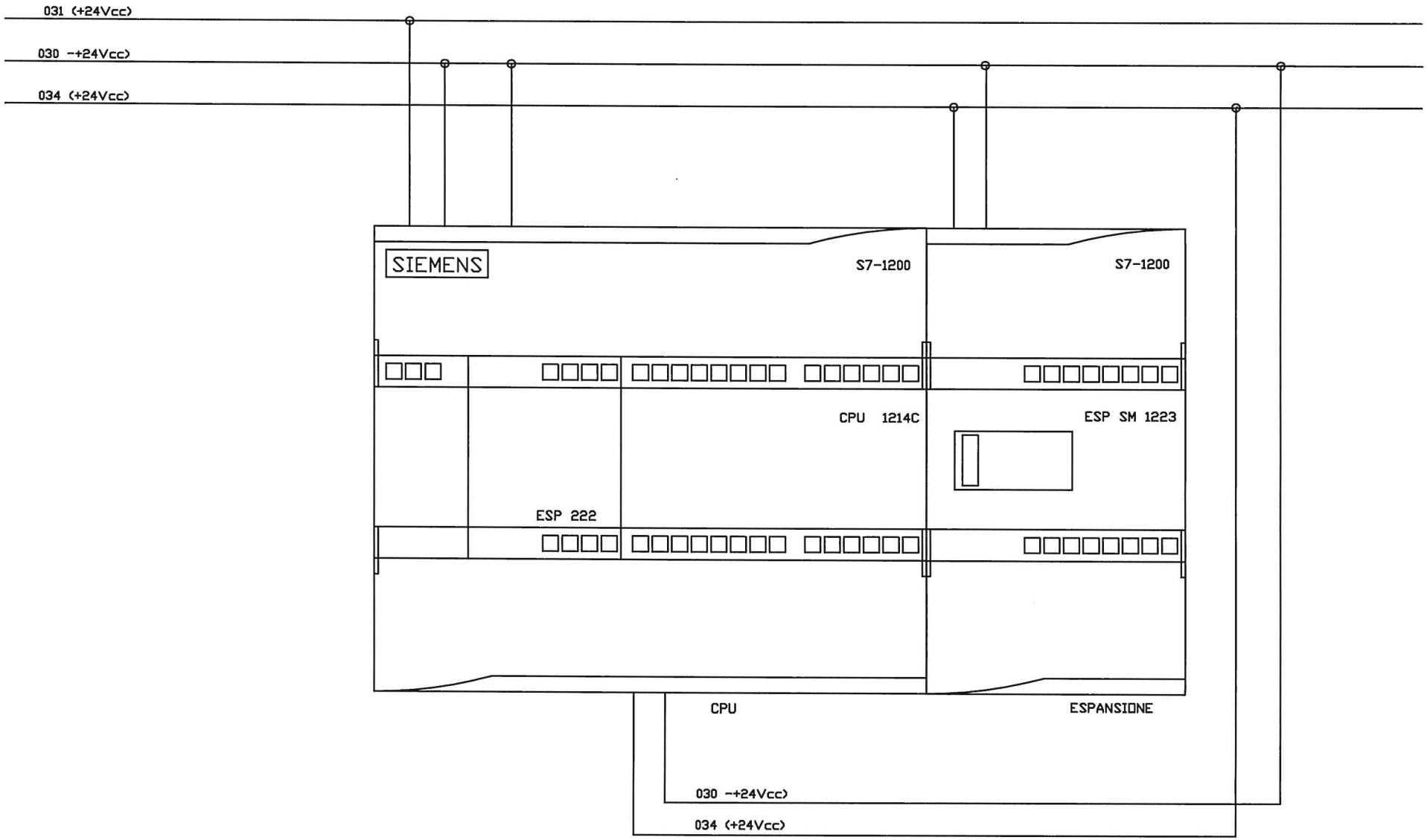
REV.	DATA	NOME	DATA : 2013
0			NOME :
			CONTR. :
			APPR. :

M.A.I.C.A. s.r.l.
MACCHINE AUTOMATISMI INDUSTRIALI
CAMICERIE ABBIGLIAMENTO
Via Casale, 23 - 24060 Torre de Roveri (BG)

CLIENTE

DESCRIZIONE
STIRATRICE 1003

FOGLIO N. 2
N. FOGLI
DISEGNO N.



REV.	DATA	NOME	DATA : 2013
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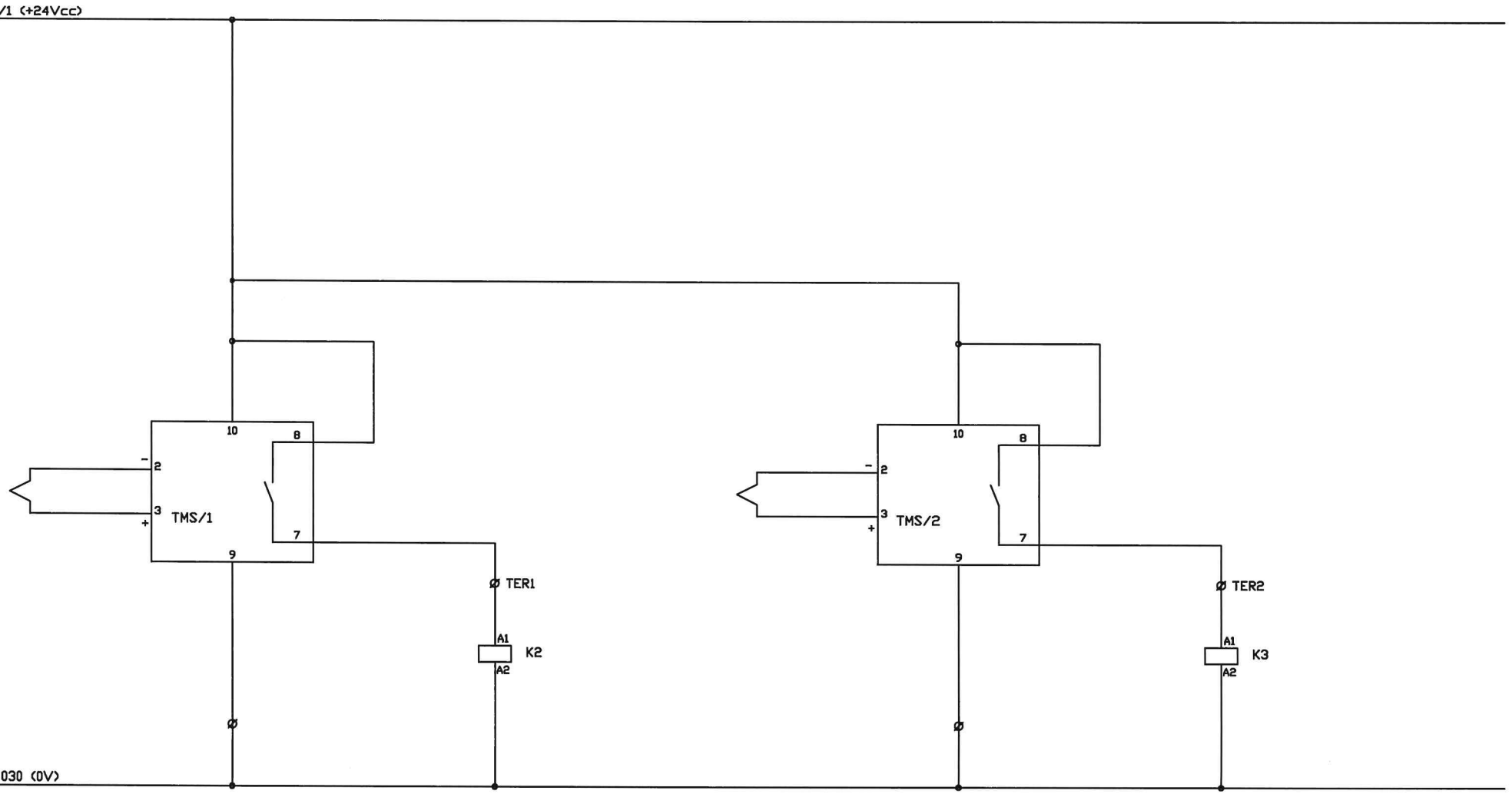
M.A.I.C.A. s.r.l.
MACCHINE AUTOMATISMI INDUSTRIALI
CAMICERIE ABBIGLIAMENTO
Via Casale, 23 - 24060 Torre de Roveri (BG)

CLIENTE

DESCRIZIONE
STIRATRICE 103

FOGLIO N. 3 | N. FOGLI

DISEGNO N.



TERMOSTATO RESISTENZA INFERIORE

TERMOSTATO RESISTENZA SUPERIORE

REV.	DATA	NOME	DATA : 2013
0			NOME :
			CONTR. :
			APPR. :

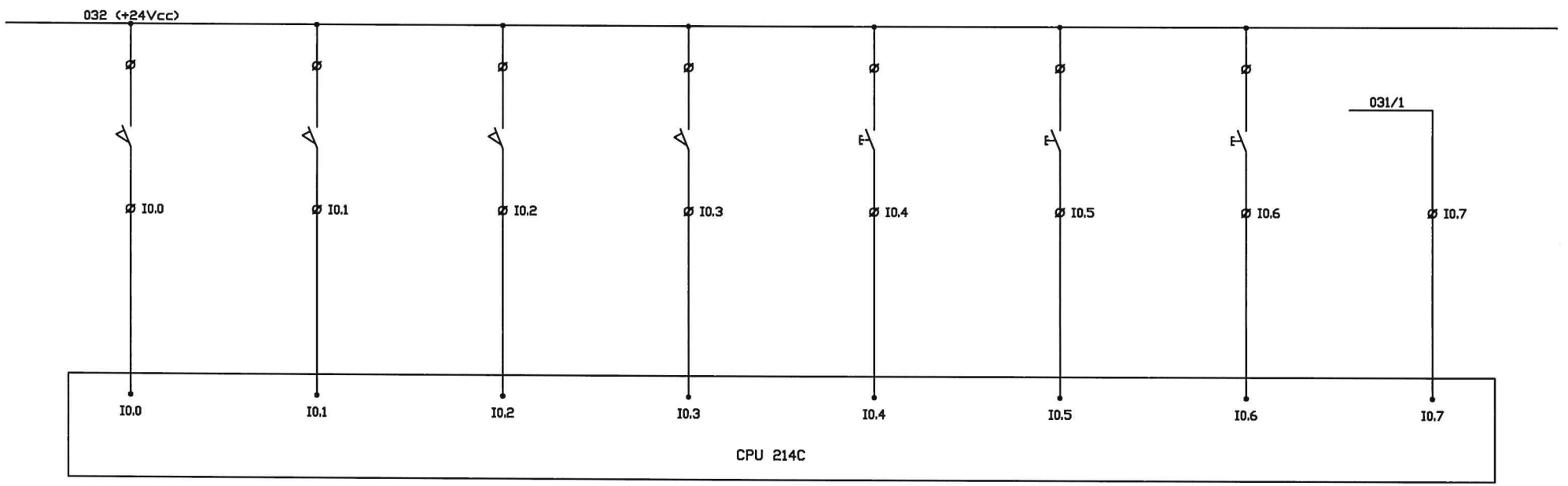
M.A.I.C.A. s.r.l.
MACCHINE AUTOMATISMI INDUSTRIALI
CAMICERIE ABBIGLIAMENTO
Via Casale, 23 - 24060 Torre de Roveri (BG)

CLIENTE

DESCRIZIONE
STIRATRICE 1003

FOGLIO N. 4 | N. FOGLI

DISEGNO N.



REV.	DATA	NOME	DATA : 2013	M.A.I.C.A. s.r.l.	CLIENTE	DESCRIZIONE	FOGLIO N.	N. FOGLI
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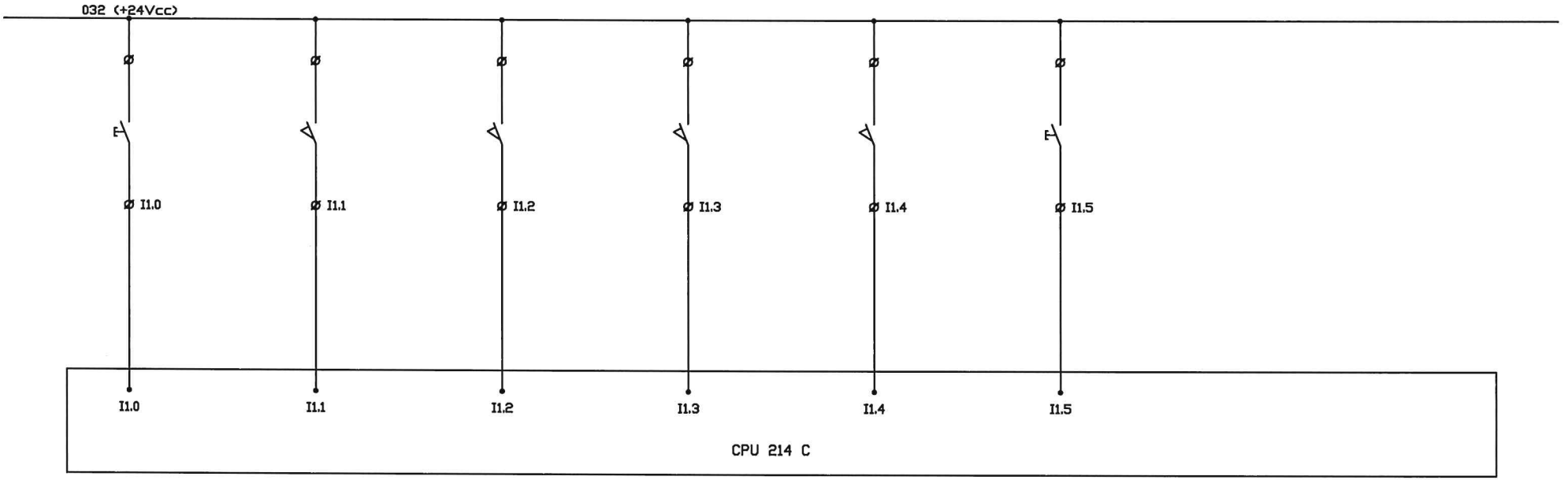
			CONTR. :	Via Casale, 23 - 24060 Torre de Roveri (BG)			DISEGNO N.	
			APPR. :					



PULSANTE RESET ASPIRAZIONE

FINECORSA SCARICO ALTO

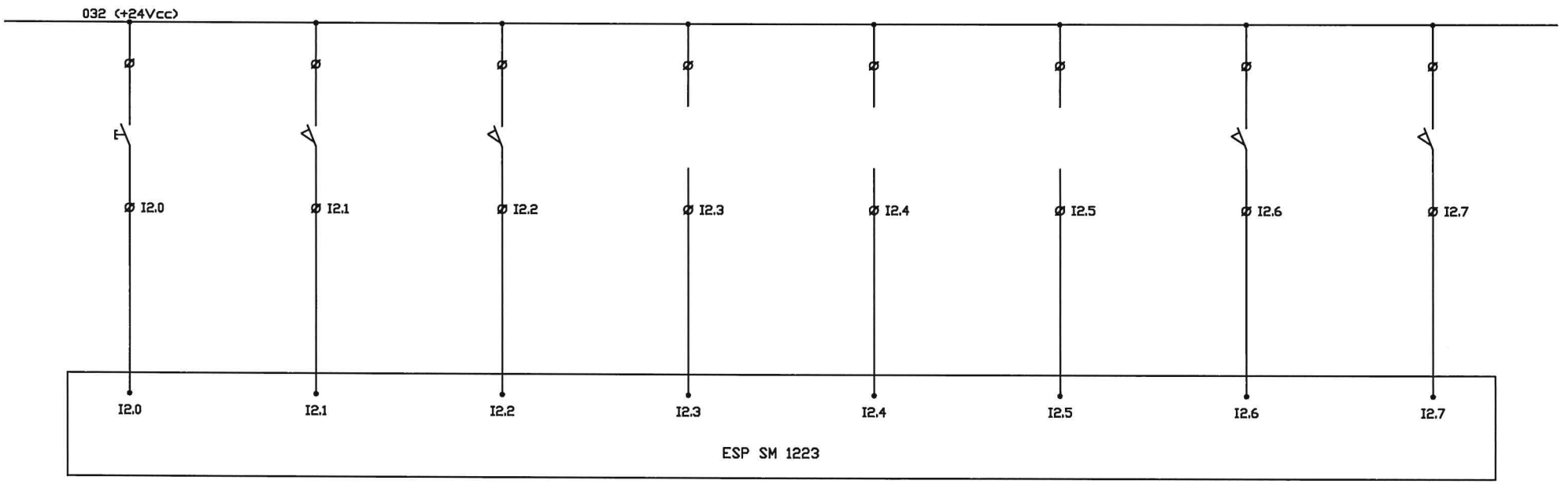
FINECORSA SCARICO BASSO

FINECORSA SCARICO A RIPOSO

FINECORSA SCARICO AVANTI

PULSANTE CONTROLLO TEMPO STIRO

REV.	DATA	NOME	DATA : 2013	M.A.I.C.A. s.r.l.	CLIENTE	DESCRIZIONE	FOGLIO N.	N. FOGLI
0			NOME :	MACCHINE AUTOMATISMI INDUSTRIALI		STIRATRICE 1003	6	
			CONTR. :	CAMICERIE ABBIGLIAMENTO			DISEGNO N.	
			APPR. :	Via Casale, 23 - 24060 Torre de Roveri (BG)				



030 (0V)

PULSANTE PROVA SOFFIO

FINECORSA PORTE

SELETTORE BLOCCO PIEGA CENTRALE

DISPONIBILE

DISPONIBILE

DISPONIBILE

FINECORSA CARRO RASTRELLO RIPOSO

FINECORSA CARRO RASTRELLO AVANTI

MONTATI SOLO SU MODELLI SPECIALI

REV.	DATA	NOME	DATA : 2013
0			NOME :
			CONTR. :
			APPR. :

M.A.I.C.A. s.r.l.
MACCHINE AUTOMATISMI INDUSTRIALI
CAMICERIE ABBIGLIAMENTO
Via Casale, 23 - 24060 Torre de Roveri (BG)

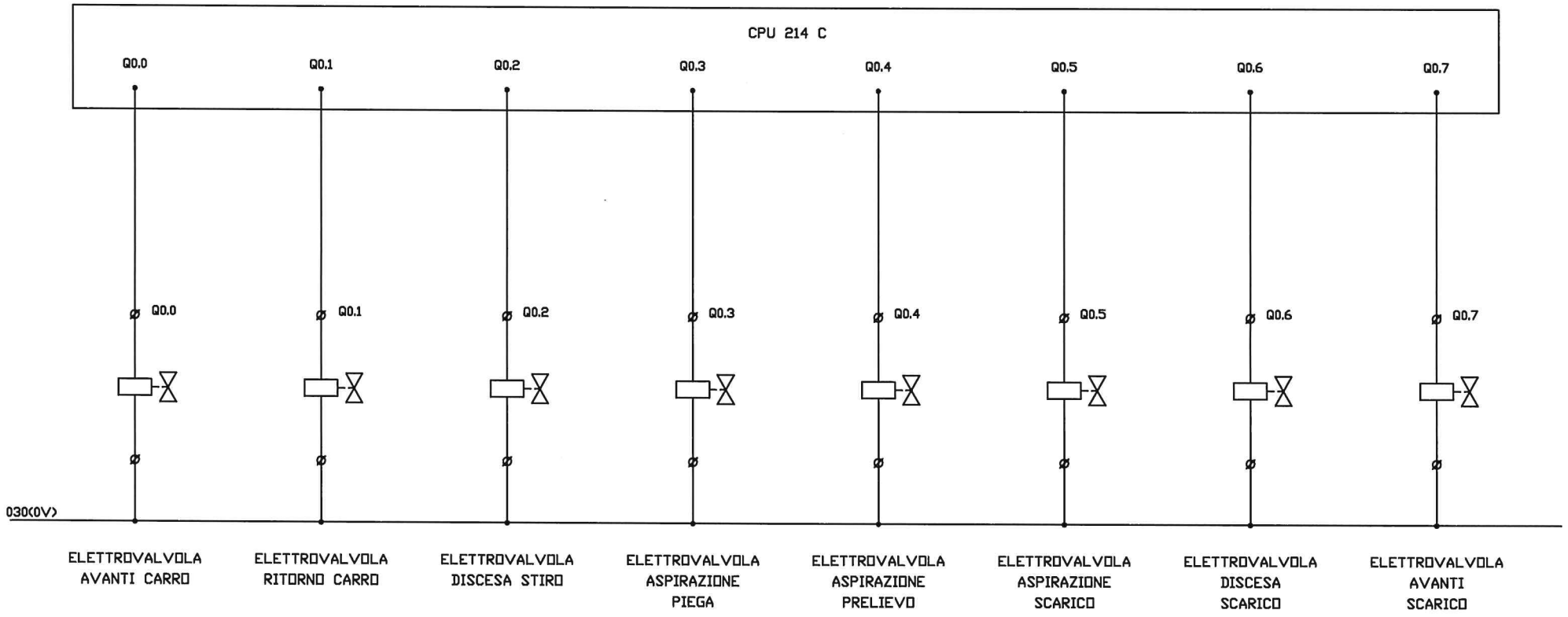
CLIENTE

DESCRIZIONE: STIRATRICE 1003

FOGLIO N. 7

N. FOGLI

DISEGNO N.



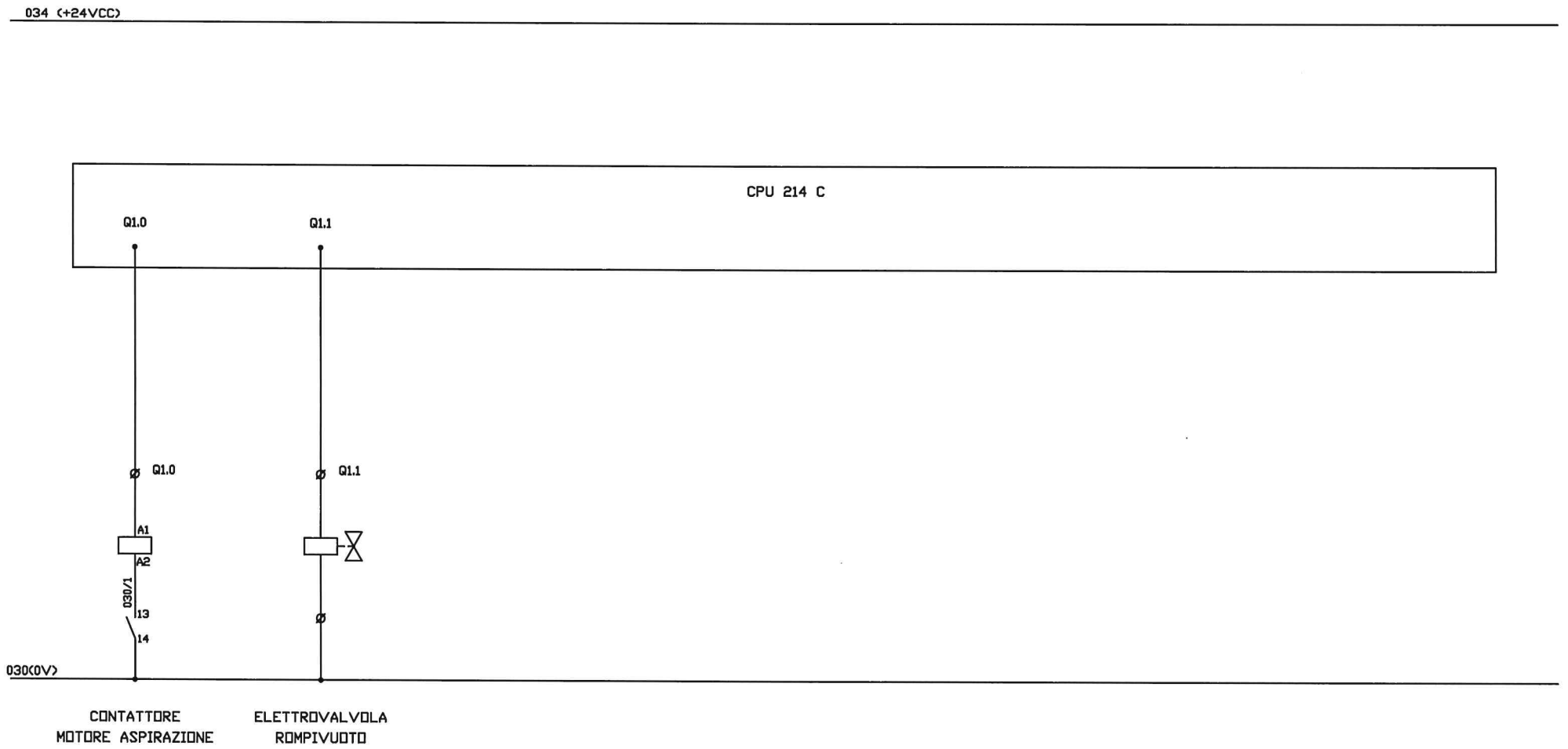
REV.	DATA	NOME	DATA : 2013
0			NOME :
			CONTR. :
			APPR. :

M.A.I.C.A. s.r.l.
MACCHINE AUTOMATISMI INDUSTRIALI
CAMICERIE ABBIGLIAMENTO
Via Casale, 23 - 24060 Torre de Roveri (BG)

CLIENTE

DESCRIZIONE
STIRATRICE 1003

FOGLIO N. 8 | N. FOGLI
DISEGNO N.



REV.	DATA	NOME	DATA : 2013
0			NOME :
			CONTR. :
			APPR. :

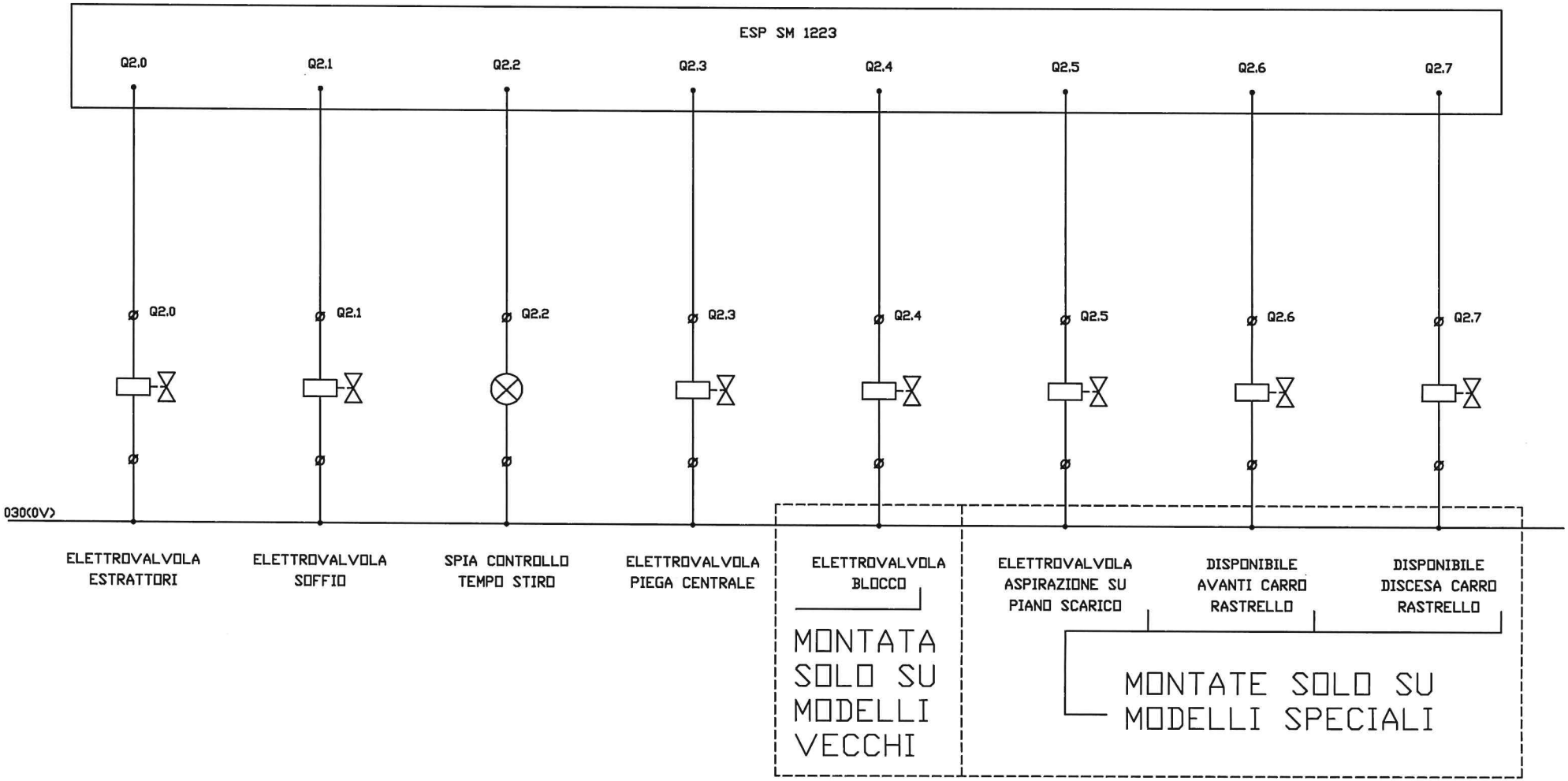
M.A.I.C.A. s.r.l.
MACCHINE AUTOMATISMI INDUSTRIALI
CAMICERIE ABBIGLIAMENTO
Via Casale, 23 - 24060 Torre de Roveri (BG)

CLIENTE

DESCRIZIONE
STIRATRICE 1003

FOGLIO N. 9 | N. FOGLI

DISEGNO N.



REV.	DATA	NOME	DATA : 2013
0			NOME :
			CONTR. :
			APPR. :

M.A.I.C.A. s.r.l.
MACCHINE AUTOMATISMI INDUSTRIALI
CAMICERIE ABBIGLIAMENTO
Via Casale, 23 - 24060 Torre de Roveri (BG)

CLIENTE

DESCRIZIONE
STIRATRICE 1003

FOGLIO N. 10
N. FOGLI
DISEGNO N.

CONTROLLO TEMPO PRELIEVO E STIRO

CONTROLLO TEMPO PRELIEVO

PER AUMENTARE IL TEMPO DI PRELIEVO

A MACCHINA FERMA CON PULSANTE EMERGENZA LIBERO
PREMERE IL PULSANTE START SINISTRO E TENERLO PREMUTO
PREMERE IL PULSANTE CONTROLLO TEMPO STIRO
(AD OGNI IMPULSO CORRISPONDE UN DECIMO)

PER AZZERARE IL TEMPO DI PRELIEVO

PREMERE IL PULSANTE EMERGENZA E LASCIARLO PREMUTO
PREMERE IL PULSANTE START SINISTRO E TENERLO PREMUTO
POI PREMERE IL PULSANTE CONTROLLO TEMPO STIRO X 10 SECONDI

CONTROLLO TEMPO STIRO

PER AUMENTARE IL TEMPO DI STIRO

A MACCHINA FERMA CON PULSANTE EMERGENZA LIBERO
PREMERE IL PULSANTE CONTROLLO TEMPO STIRO
(AD OGNI IMPULSO CORRISPONDE UN SECONDO)

PER AZZERARE IL TEMPO DI STIRO

PREMERE IL PULSANTE EMERGENZA E LASCIARLO PREMUTO
PREMERE IL PULSANTE CONTROLLO TEMPO STIRO X 10 SECONDI