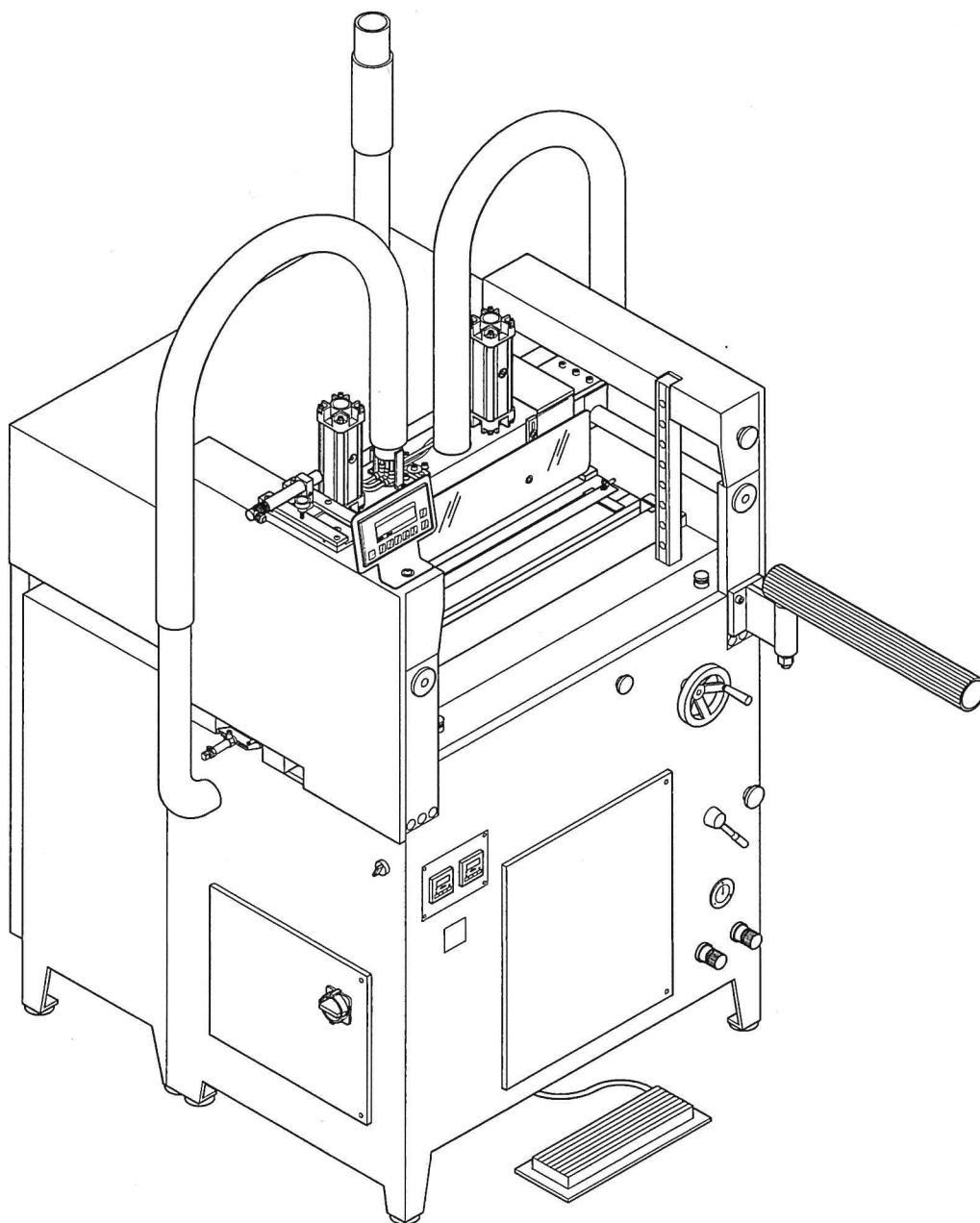


IRONING MACHINE mod. 1005



Instructions for use and maintenance



MAICA Macchine Automatismi Industriali Camicerie Abbigliamento



Macchine Automatismi Industriali Camicerie Abbigliamento

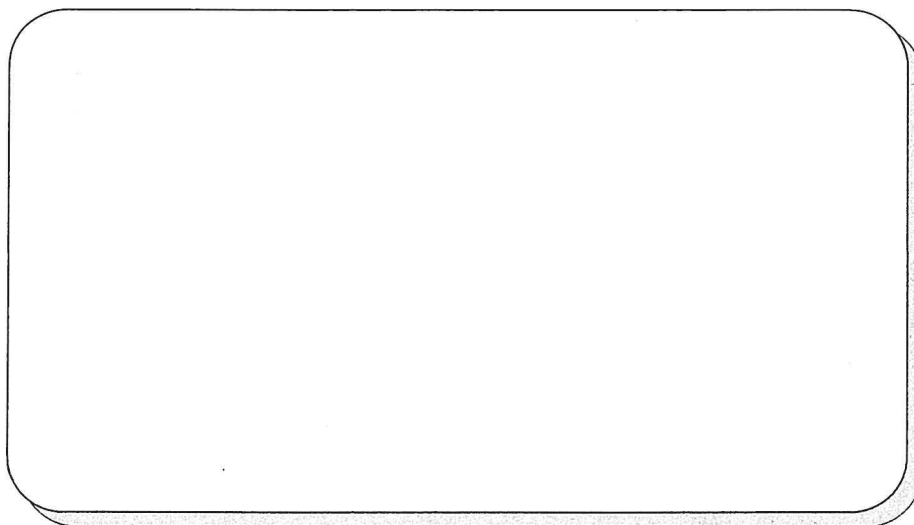
Via Casale, 23 - 24060 Torre de' Roveri (Bergamo) - ITALY

Telefono (+39) 35 580040 - Telefax (+39) 35 580920

web: www.maicaitalia.com

e-mail: info.maicaitalia@maicaitalia.com

AUTHORIZED AREA DEALER FOR ASSISTANCE



EEC CONFORMITY DECLARATION

The **1005 ironing machine**, as described in this manual, complies with the standards set down by the following EEC Directives:

UNI EN 292-1	Machine safety. Essential principles.
UNI EN 292-2	Machine safety. Essential principles.
UNI EN 294	Machine safety. Safety distances for arms.
UNI EN 349	Machine safety. Minimum crushing distances.
UNI EN 418	Machine safety. Emergency stop devices.
pr EN 563	Machine safety. Contact surface temperatures. Ergonomic data.
pr EN 574	Machine safety. Two-hand control devices.
pr EN 953	Machine safety. Guard design and construction.
pr EN 1088	Machine safety. Interlocking devices with or without guard locking.
EN 60204-1	Electrical devices on industrial machines. Part 1: general standards.
EN 60529	Levels of protection guaranteed by guards (IP code)
EN 60825	Radiation safety of laser products; plant classification; requirements and guide for the operator.

Manufacturer:
M.A.I.C.A. S.r.l.

01 - GENERALITIES

CHARACTERISTICS AND FIELD OF APPLICATION

The 1005 ironing machine has been designed specifically for the folding of the front facing and short sleeves, or any application where an edge must be folded back with one or two pleats. This machine folds the edge of the fabric with perfect accuracy along the whole length for ironing.

Measurements can be modified quickly and easily, without the need for special devices.

The machine can produce pleats measuring a minimum of 20 mm to a maximum of 70 mm with continuous increases over a length of 900 mm.

The 1005 can be used to insert the stiffener, whether adhesive-backed or otherwise, normally or automatically.

It has an automatic stacker that picks up the folded part after ironing.

For ironing striped material, there is a laser device that feeds the fabric. If the cut is not perfect, it folds the extra part back to re-absorb the excess length (even if only 1 mm).

New PLC control system.

ADVISED USE

The 1005 ironing machine **must only be used** in applications where a folded back edge is required. The manufacturer cannot be held liable for any damage to persons or property arising from the incorrect use of this machine or any use differing from the instructions indicated in this manual.

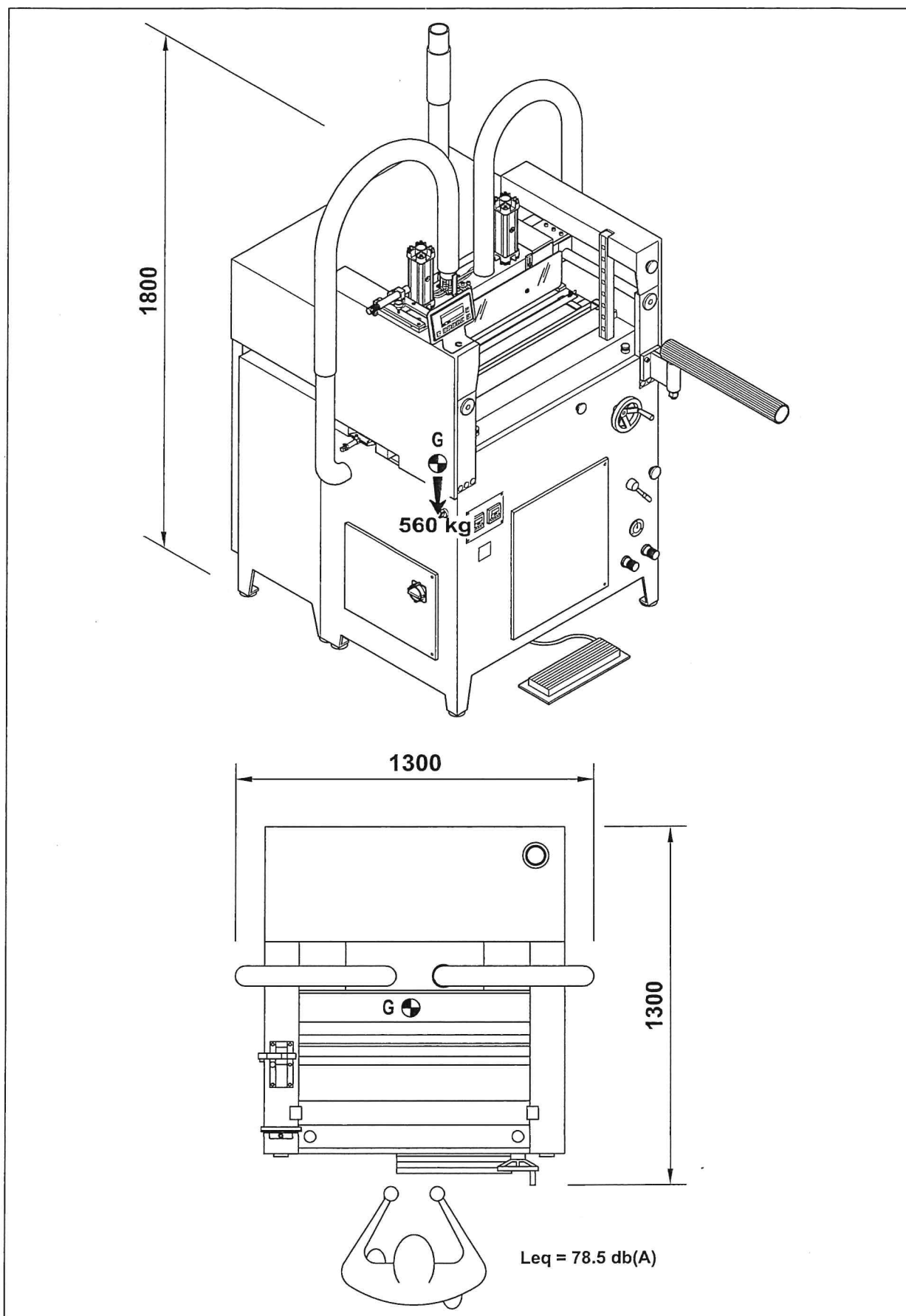
The  symbol indicates there exists a risk or danger for the health of the operator and, therefore, much care must be taken at this point.

The machine has an ironing unit which can reach temperatures above 70°C during use. Be very careful when touching these parts.

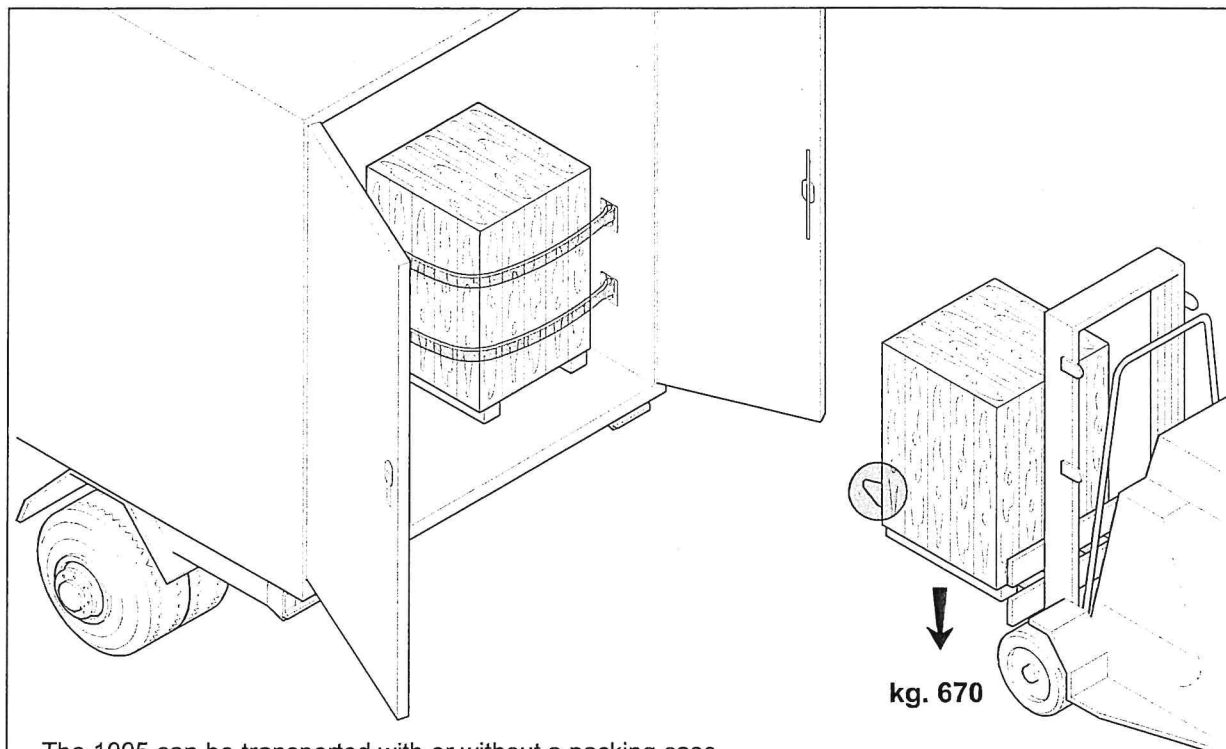
Always disconnect the machine from the mains supply, the compressed air supply and wait for the ironing parts to cool down before undertaking any adjustment, replacement or maintenance work.

The machine **must not be** exposed to the weather (rain, sun, etc).

02 - IRONING MACHINE 1005 TECHNICAL DATA

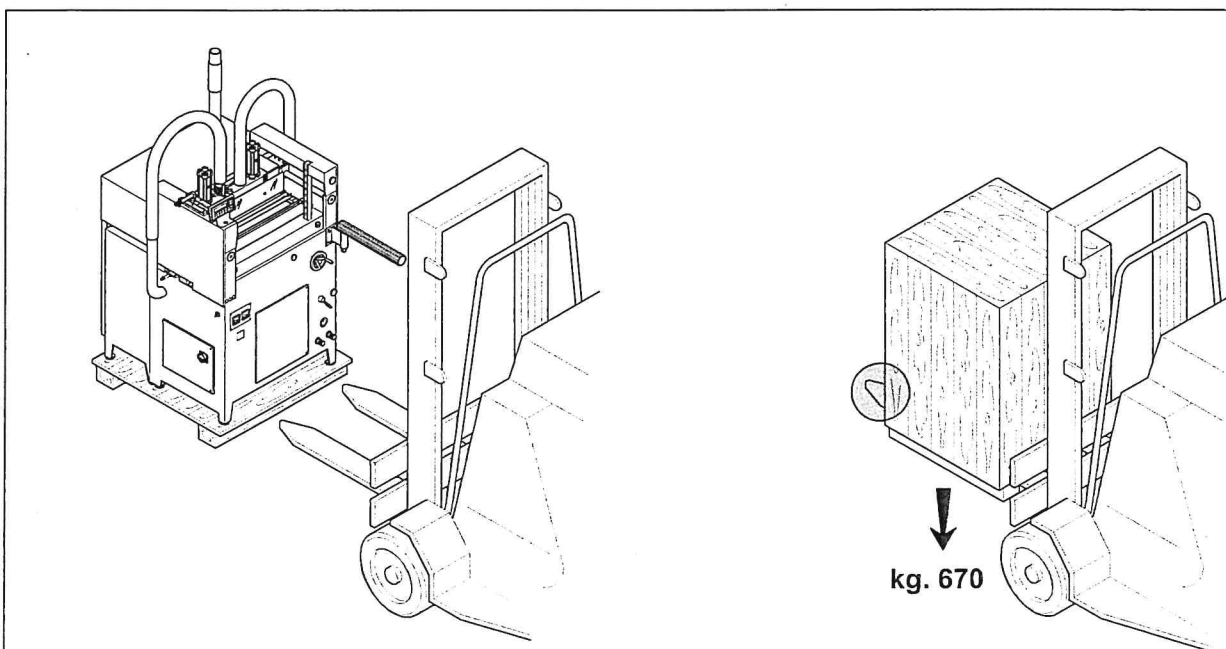


03 - LIFTING AND TRANSPORTATION



The 1005 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 using a fork-lift truck, place the forks under the machine with the front of the 1005 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 front facing the fork-lift truck, as in the figure above.
Place on a solid and even surface, not exposed to the weather.

05 - INSTALLATION

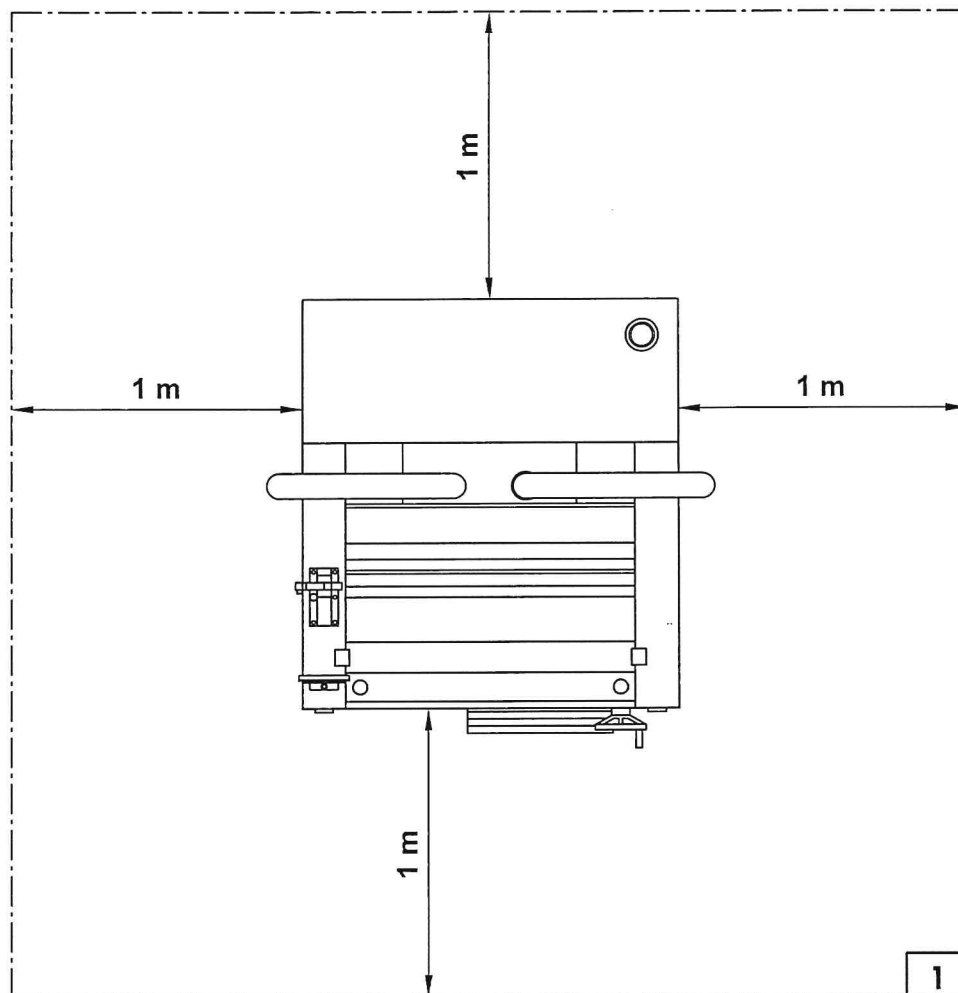
ATTENTION: This machine must only be installed by specialized personnel.

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.

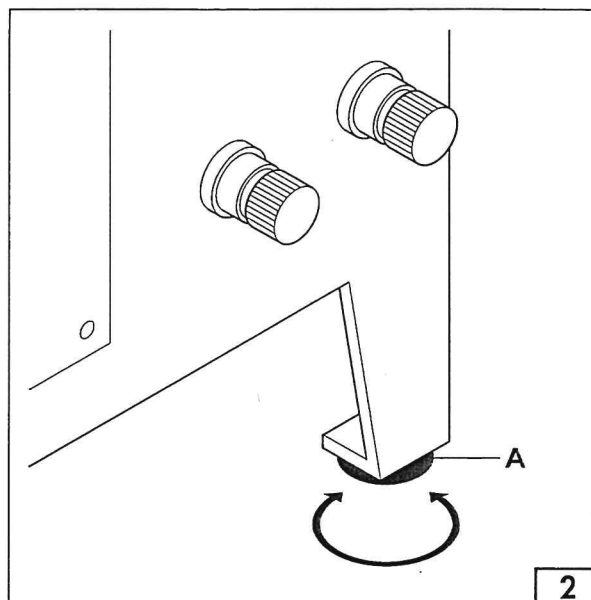


If the machine is installed on a suspended surface, check that the surface can withstand the weight of the machine. This machine must not be installed in areas where there are explosive or inflammable materials and substances.

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



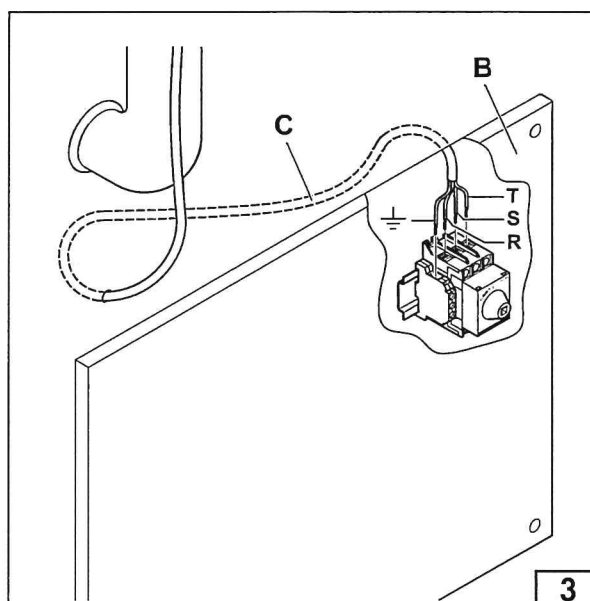
The machine must be placed on a solid and even surface. Use levelling feet "A" to adjust the height (fig. 2).



ELECTRICAL CONNECTION

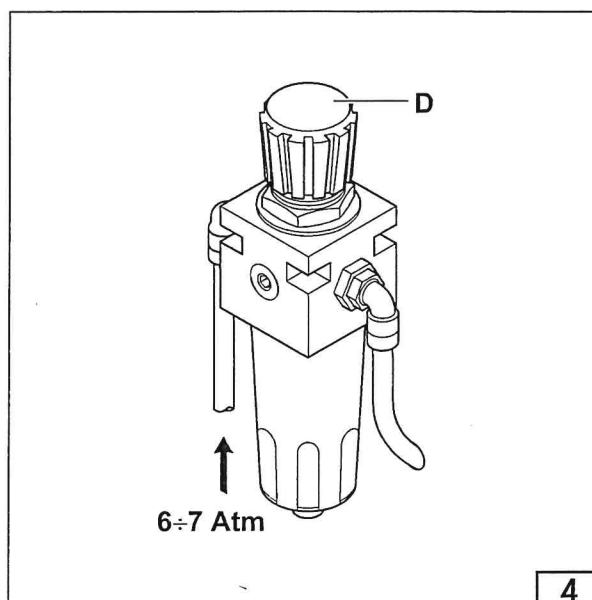
To connect the power cable (see fig. 3):

- open side panel "B";
- pass cable "C" through the cable holes on the machine;
- connect phases **R - S - T** and the earth $\perp$ to the relevant terminals;
- supply the machine with 380V-50Hz.

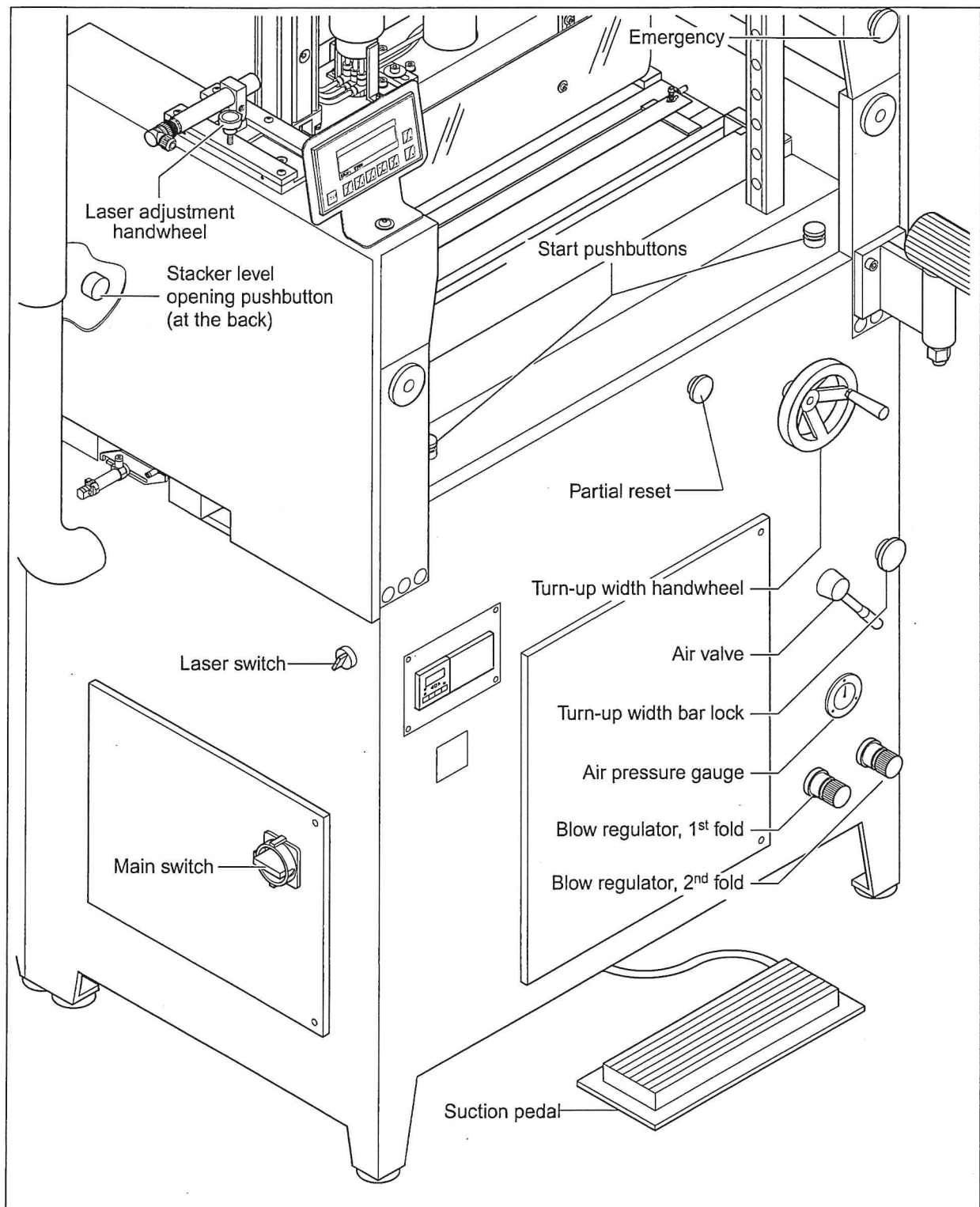


PNEUMATIC CONNECTION

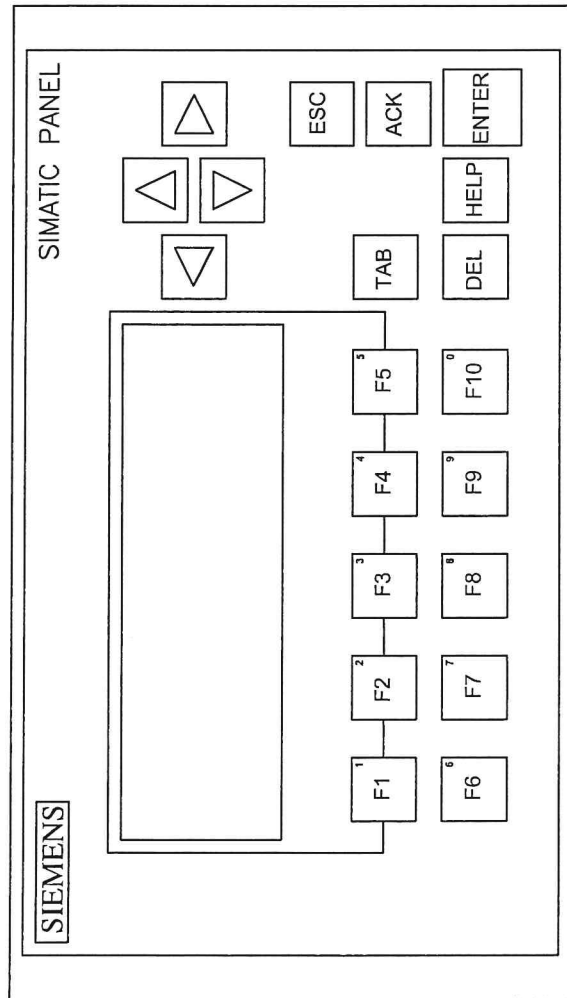
- Connect the machine to the compressed air outlet and make sure that the air flow is sufficient to allow for operation with a constant rate of pressure of 6÷7 Atm.
- Calibrate pressure regulator "D" at between 6÷7 Atm (fig. 4).



06 - MACHINE CONTROLS



TASTIERA SIEMENS KP300 X(1005)



REGOLAZIONI DA TASTIERA

- 01 TEMPO PRELIEVO STOFFA
- 02 TEMPO STIRATURA STOFFA
- 03 TEMPO SOFFIO I PIEGA
- 04 TEMPO SOFFIO II PIEGA
- 05 TEMPO ATTESA VUOTO II
- 06 TEMPO II PIEGA X INTERVENTO BARRIERA
- 07 TEMPO RAFFREDDAMENTO X STRETCH
- 08 TEMPO RITORNO CARRO PRELIEVO
- 09 TEMPO SPRUZZO AQUA
- 10 RESET CONTA PEZZI

ALLARMI A BORDO

- 01 EMERGENZA INSERITA
- 02 IMPILATORE BLOCCATO
- 03 SCARICO NON PARTITO
- 04 ANOMALIA CARRO STIRO BASSO
- 05 INTERVENTO BARRIERA
- 06 ANOMALIA CARRO STIRO AVANTI
- 07 ANOMALIA CARRO STIRO RIPOSO
- 08 SCATTO TERMICO
- 09 PORTA SCARICO APERTA

INSERIMENTO FASI DA TASTIERA

IL CONTROLLO FASI TRAMITE PULSANTI
FUNZIONA SOLO NELLE PAGINE SPECIFICHE

FUNZIONE TASTI

CAMBIO LINGUA:
IL CAMBIO LINGUA E' POSSIBILE PREMENDO IL TASTO F5
SOLO NELLA PAGINA INIZIALE
IL DISPLAY VISUALIZZERA LA LINGUA SELEZIONATA

CAMBIO PAGINA:
PER IL CAMBIO PAGINA AVANTI PREMERE IL TASTO
PER IL CAMBIO PAGINE INDIETRO PREMERE IL TASTO

CAMBIO VALORI:
PER IL CAMBIO VALORI PORTARSI CON I TASTI
SULLA PAGINA DEL VALORE DA MODIFICARE

PREMERE IL TASTO ENTER
IL VALORE VERRA VISUALIZZATO

INSERIRE IL NUOVO VALORE CON I TASTI NUMERICI DA F1 A F10

PER CONFERMARE PREMERE IL TASTO ENTER

PULSANTI FUNZIONANTI IN TUTTE LE PAGINE:
PULSANTE RESET ASPIRAZIONE F1

PULSANTE ACCENDI O SPEGNI LASER F2

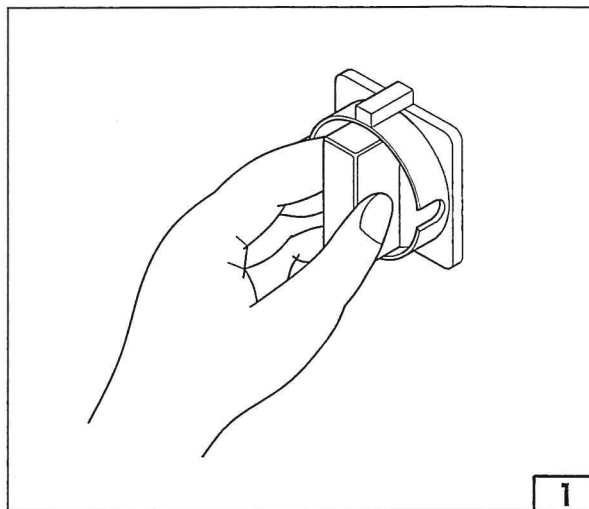
PULSANTE APERTURA PIANI IMPILATORE F3

RESET CONTEGGIO F4	SPRUZZO AQUA F5	DOPPIA PRESSATA F6	BLOCCO I LAMA F7	FASE SETA F8	FASE MANUALE F9	BLOCCO VUOTO II F10
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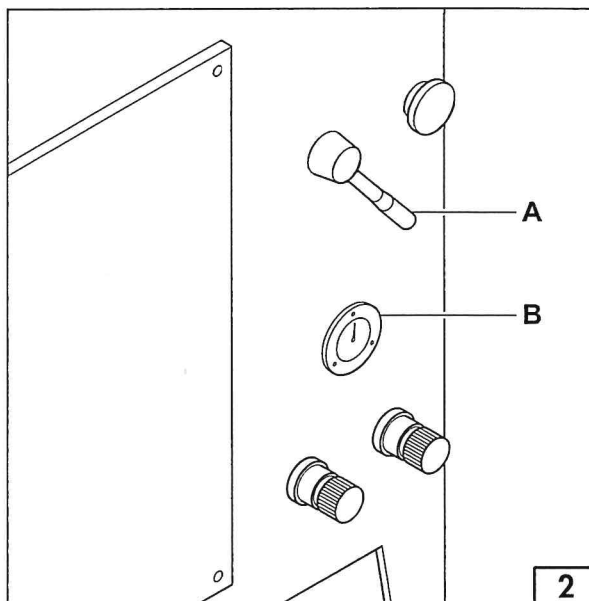
07 - OPERATION

STARTUP

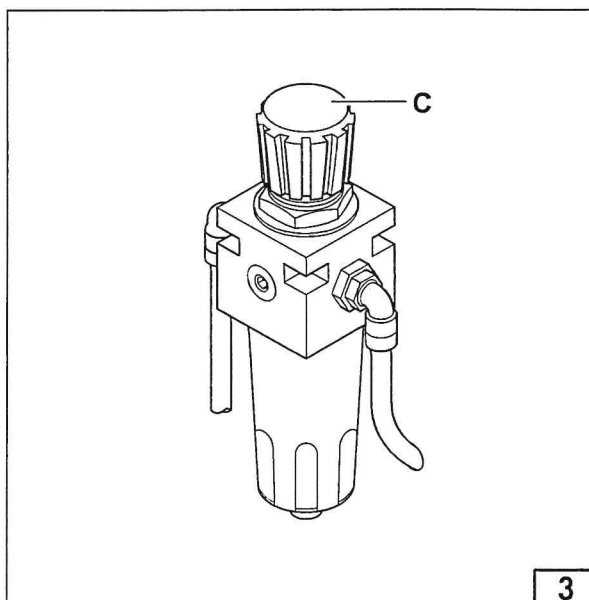
- Turn the main switch to I (fig. 1). The electrical resistances in the ironing plates start to heat up and after about 15 minutes they reach working temperature. The ideal temperature, set in the factory, is approx. 150°C. Depending on the fabrics being used, this can be changed by entering a new value on the keyboard.



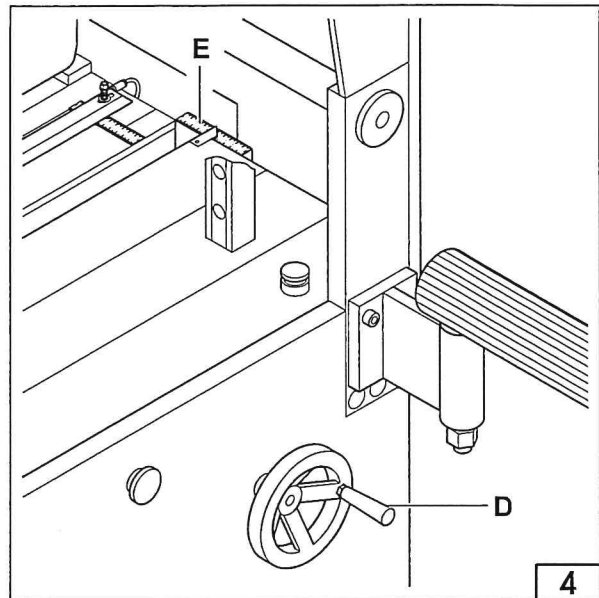
- Open air valve "A" and make sure that pressure gauge "B" reads a pressure of approx. 6-7 Atm (fig. 2).



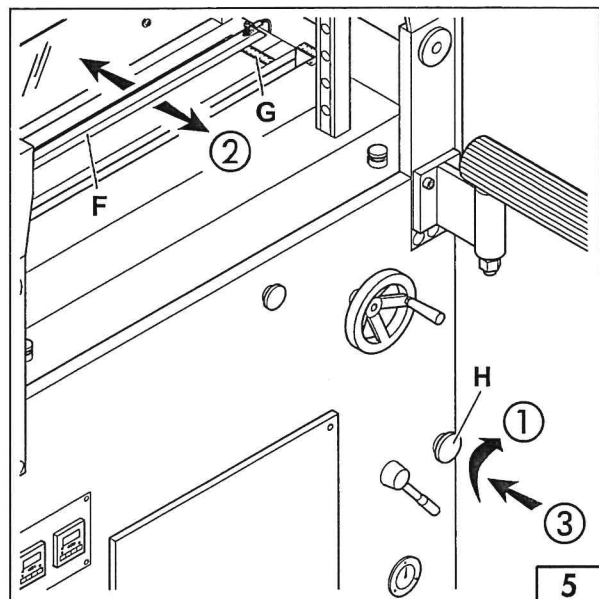
- If necessary, use regulator "C" on the filter unit to adjust the air pressure (fig. 3).



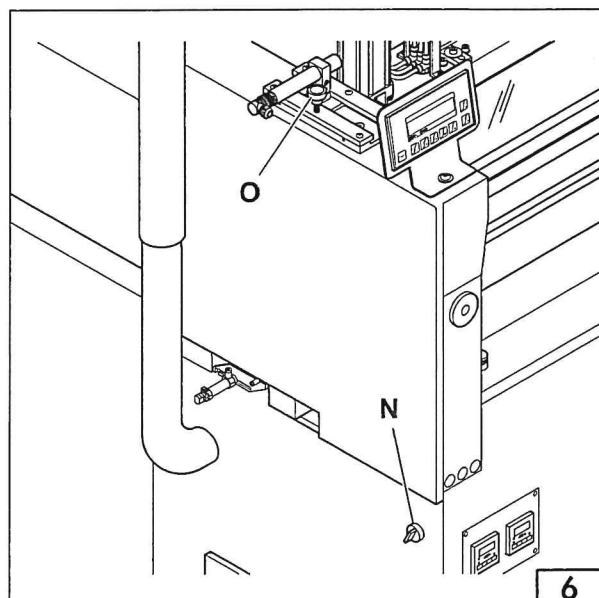
- Before starting ironing, the width of the turn-up must be set. This can be anything between 20 and 70 mm. Use handwheel "D" on the right-hand side of the machine to adjust the setting on graduated scale "E" (fig. 4).



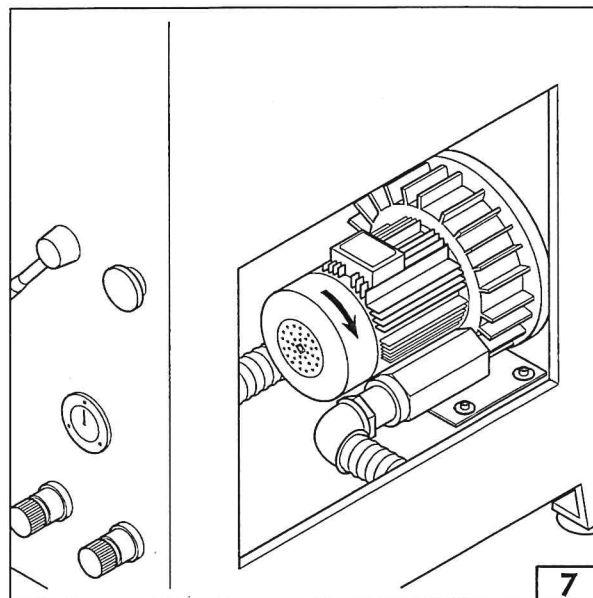
- Now set the width of the inside fold, again between 20 and 70 mm, by moving stop rod "F" by hand to adjust the setting on graduated rod "G" (fig. 5). To move the stop rod, first release it by turning pushbutton "H" as shown in the figure. Once the inside fold measurement has been set, block the rod by pressing pushbutton "H".
- For sizes in excess of 30 mm, use the fabric-support spacers. These must never be set fast, but should have a certain amount of play.



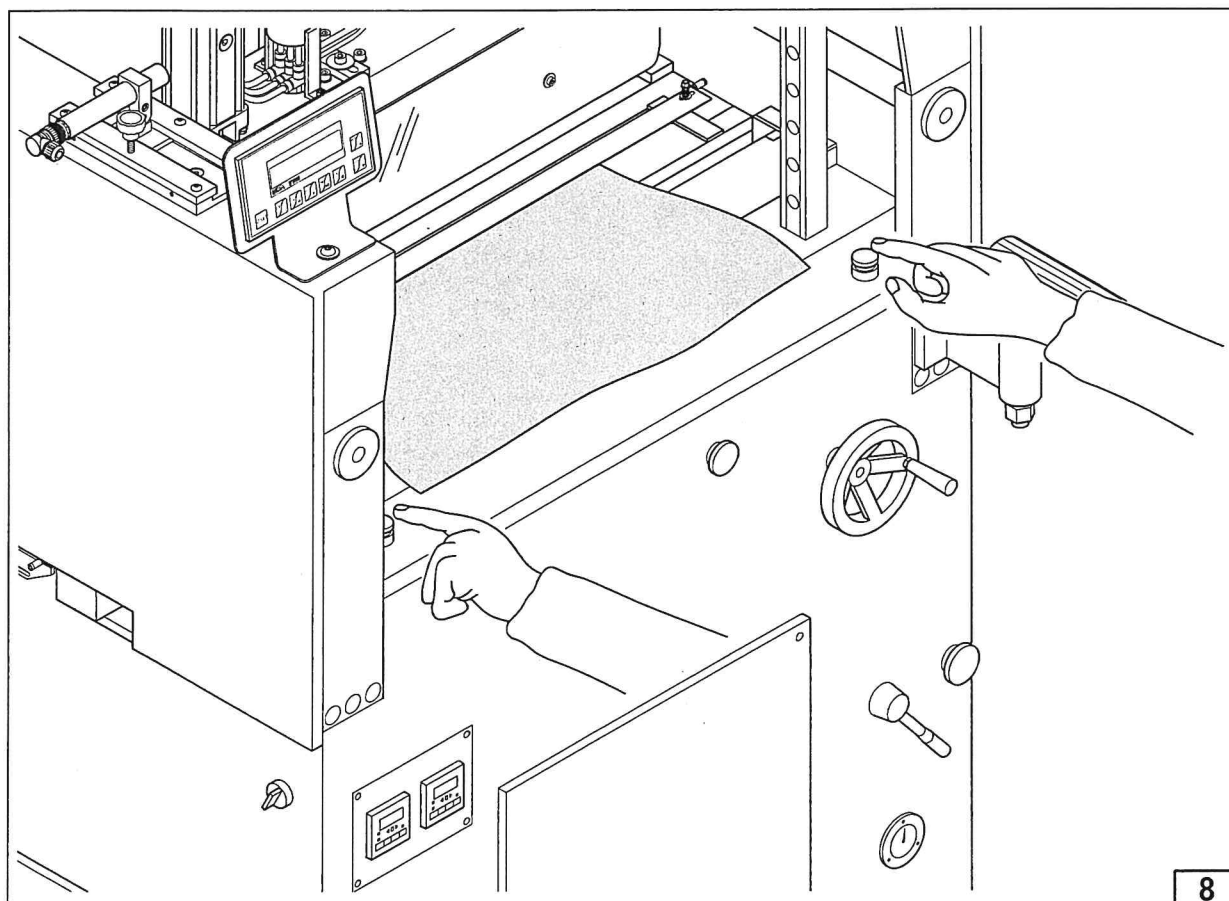
- If using a stiff fabric, the laser beam is necessary for perfect alignment. Use switch "N" (fig. 6). This beam can be adjusted by means of handwheel "O" on the left-hand side of the machine.
- Turn on the aspirator by pressing one of the two START pushbuttons on the machine. The aspiration stops automatically about 2 minutes after it starts, in the case in which the machine it does not come used.



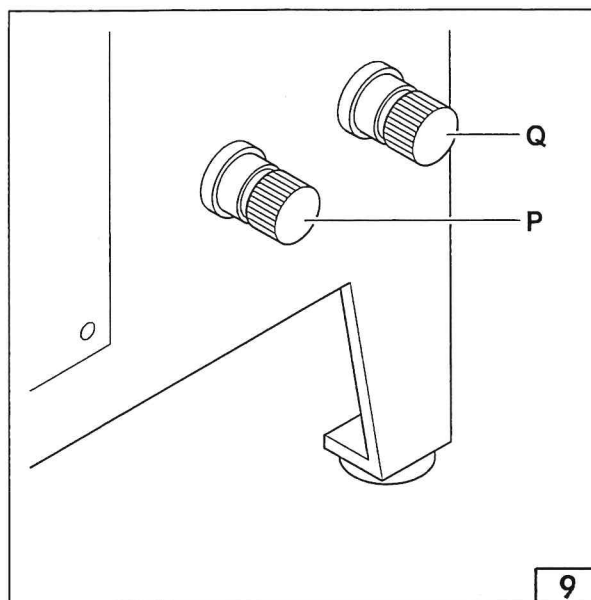
- Check that the machine rotates in the same direction as that shown by the arrow on the motor (fig. 7).



- Place the fabric for folding on the machine, lining it up against the stop rod. If the fabric is striped, check the alignment using the laser beam starting from the armhole or neck notch.
- If using a stiffener, press the pedal to get sufficient fabric suction.
- Start the machine up by pressing the two green pushbuttons, as in figure 8. The 1st fold is then made, the fabric is turned and the 2nd fold made, together with the ironing of the whole turn-up.

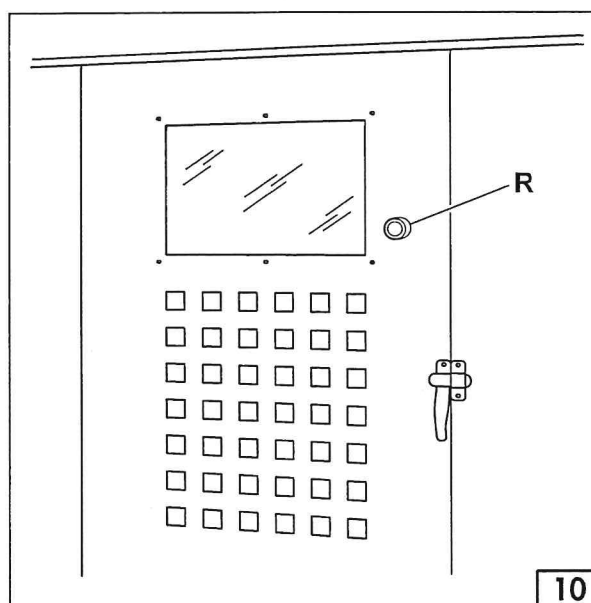


- If there are any imperfections during the 1st fold, use regulator "P" (fig. 9) to decrease or increase the air pressure. We recommend using the minimum pressure needed. The 1st fold is blown under the moving rod that stops the fabric.
- During the 2nd fold, check that the fabric is turned properly. If the blow is not strong enough, the fabric will not turn sufficiently; if it is too strong, the fabric comes away from the suction surface (this may happen with particularly light-weight fabric). Use regulator "Q" to adjust the strength.
- If the guard barrier is excited during ironing, the machine automatically stops. Press the two green pushbuttons again to restart.



- It may happen that, after second ironing, especially in the case of synthetic fabrics, the turn-up tends to open when it is removed.
- To avoid this problem, delay the stacker brush movement by adjusting the brush start time.
- We recommend removing the ironed items from the stacker when there are 50-60. To make this easier to do, press pushbutton "R" on the back of the machine (fig. 10).
- Open the back door, remove the ironed items and close the door again to start the machine back up.

Attention: if the back door is left open during operation, the machine will stop. Press the two green startup pushbuttons to restart the cycle.

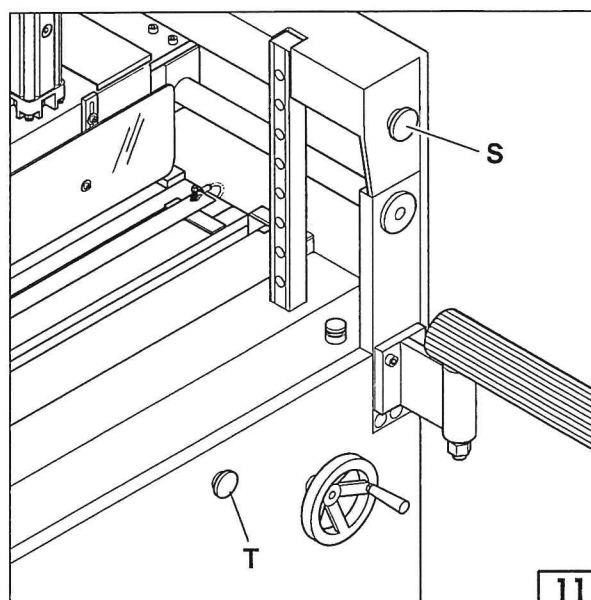


Emergency pushbutton "S" for stopping the machine completely in the event of a malfunction (fig. 11).

To restart the machine:

- release the emergency pushbutton by turning it a quarter turn anti-clockwise;
- press one of the two black pushbuttons;
- press the two black start pushbuttons until the ironing carriage returns to the start position.

Partial emergency (or reset) pushbutton "T" is for stopping the machine without resetting the next work cycle.



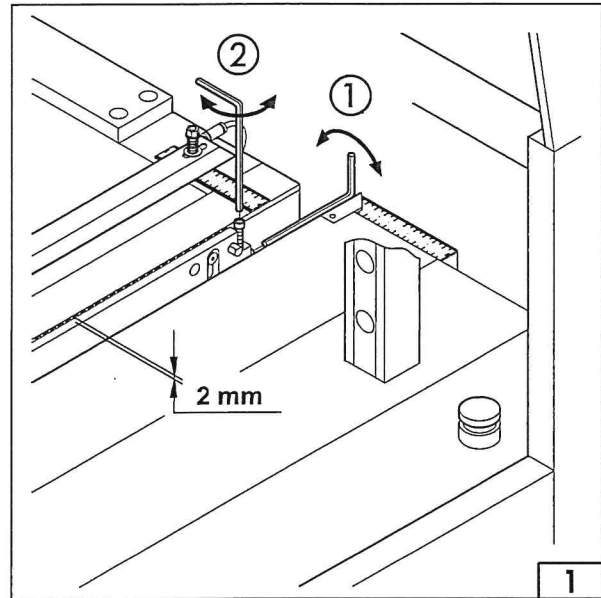
08 - ADJUSTMENTS



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.

VARYING THE FABRIC THICKNESS

If the thickness of the fabric differs, the bar can be adjusted using the side screws as shown in figure 1. The recommended distance is 2 mm.



09 - MAINTENANCE

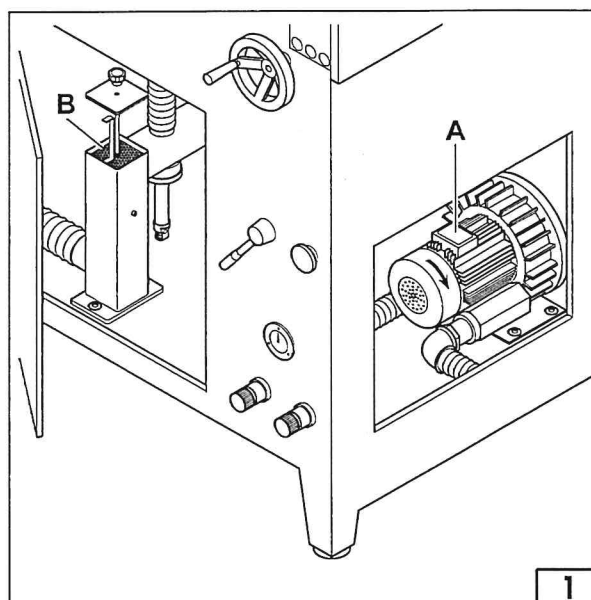


Always disconnect the machine from the mains supply, the compressed air supply and wait for the ironing parts to cool down before undertaking any adjustment, replacement or maintenance work. The operations described below must only be carried out by specialized personnel.

The 1005 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.

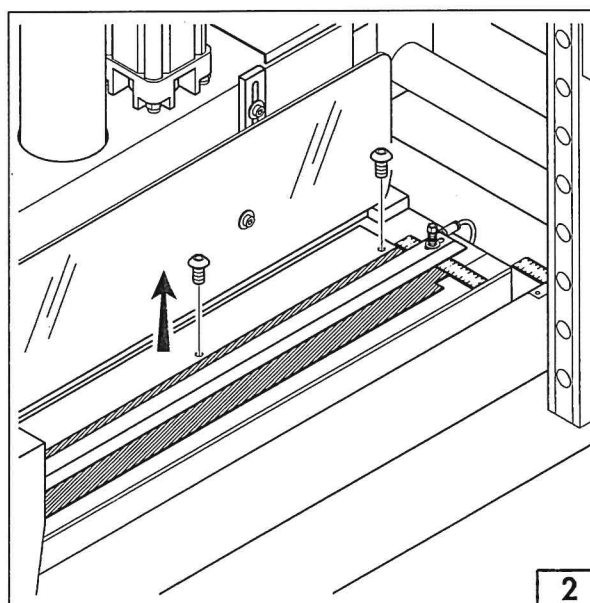
REGULAR CLEANING

Open the doors at the front and on the right-hand side of the machine and clean motor "A" and safety valve "B" with an air jet (fig. 1).



If there is insufficient suction, use a stiff-bristle brush or pin to remove any threads or substances blocking the slits on the folding surface.

After long periods of use, we recommend removing the covers on this surface and removing any deposits underneath (fig. 2).

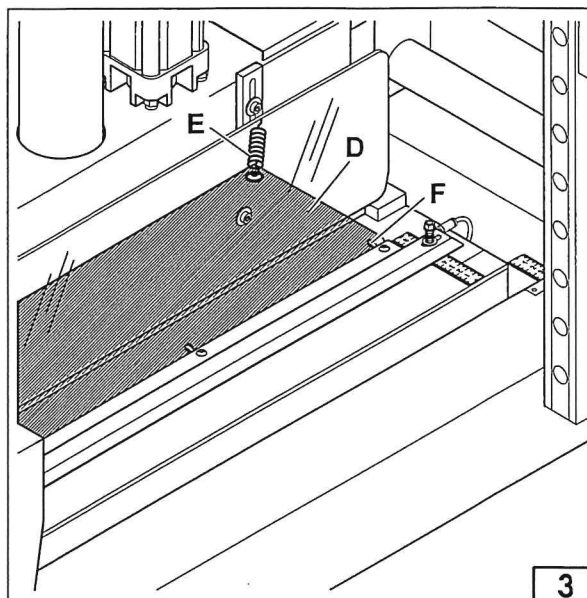


REPLACING THE NO-SHINE SHEET

If, when unloading the ironed turn-up, the turn-up tends to open up, check that teflon sheet "D" is not worn (fig. 3).

If necessary, replace by releasing the two lateral springs "E" at the back of the machine and remove the sheet from the three front hooks "F".

When replacing with a new sheet, make sure that the rough side of the sheet is facing upwards.

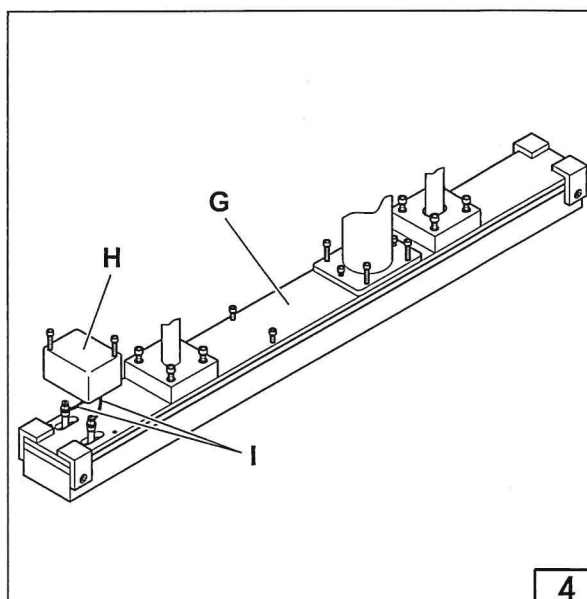


REPLACING THE RESISTANCES

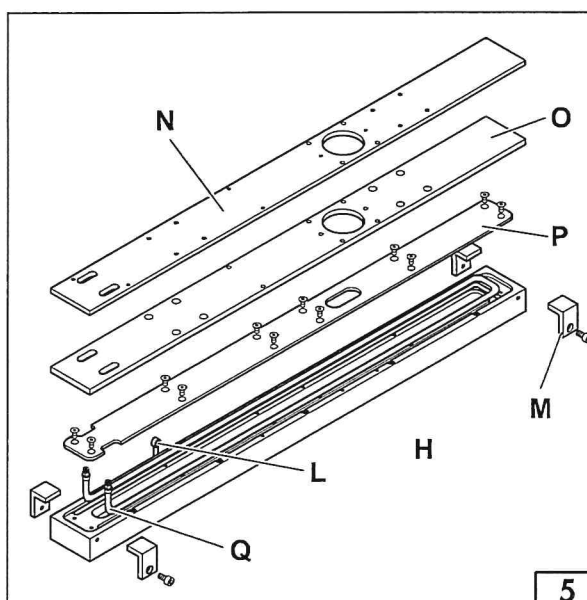
If the ironing is not perfect, check that the top and bottom plates heat up properly. If this is not the case, check the efficiency of the resistances and replace if necessary as described below.

Upper resistance

- (Cut off the air).
- Unscrew all the screws on cover "G" and box "H" (fig. 4).
- Disconnect the resistance wires "I".



- Disconnect thermal sensor "L" (fig. 5).
- Unscrew the screws from the support brackets "M" to remove cover "N" and spacer "O" (fig. 4).
- Unscrew the screws and remove cover "P".
- Extract resistance "Q".



10 - MALFUNCTIONS, CAUSES AND REMEDIES

Ironing plates do not heat up

- Check the efficiency of the resistances (see page 16 to replace).
- Check the efficiency of the thermal sensors.
- Check the efficiency of the electromagnetic switch with a tester.

Irregular temperature

- Check the efficiency of the thermal sensors.
- Check the set temperature (see "Keyboard setting", page 9).

Imperfect ironing

- Check that the set temperature is sufficiently hot (see "Keyboard setting", page 9).
- Check that the ironing time is not too short (see "Keyboard setting", page 9).

Ironed turn-up tends to open up

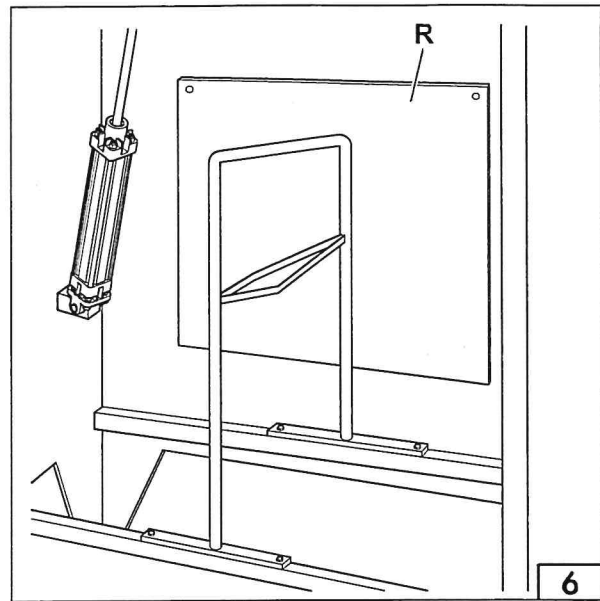
- Check the teflon sheet (see page 16 to replace).
- Delay the stacker brush movement (see "Keyboard setting", page 9).

Not enough suction

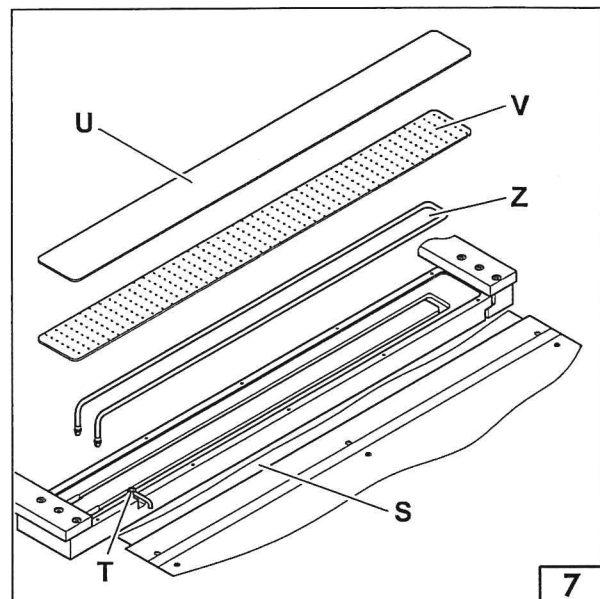
- Check the air pressure.
- Remove any threads or dirt (see page 15).

Lower resistance

- Access the machine from the front or back by removing panel "R" (fig. 6).



- Remove sheet "S" and disconnect the resistance wires (fig. 7).
- Disconnect thermal sensor "T".
- Extract copper strip "U" and rubber strip "V".
- Extract resistance "Z".



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.

The ironing carriage does not move

- Check that there is no dirt or dust on the photoelectric cells in the hand barrier.
- Check that limit stop "A" is pressed.
- Check that limit stop "B" at the end of the unloading cylinder gives the OK for the ironing plates to close.
- Check the efficiency of led "C" (if the unloading surface does not close, check that the led is properly positioned. If not, move in either direction until it lights up and then lock).

The carriage does not lift the fabric when fully forward

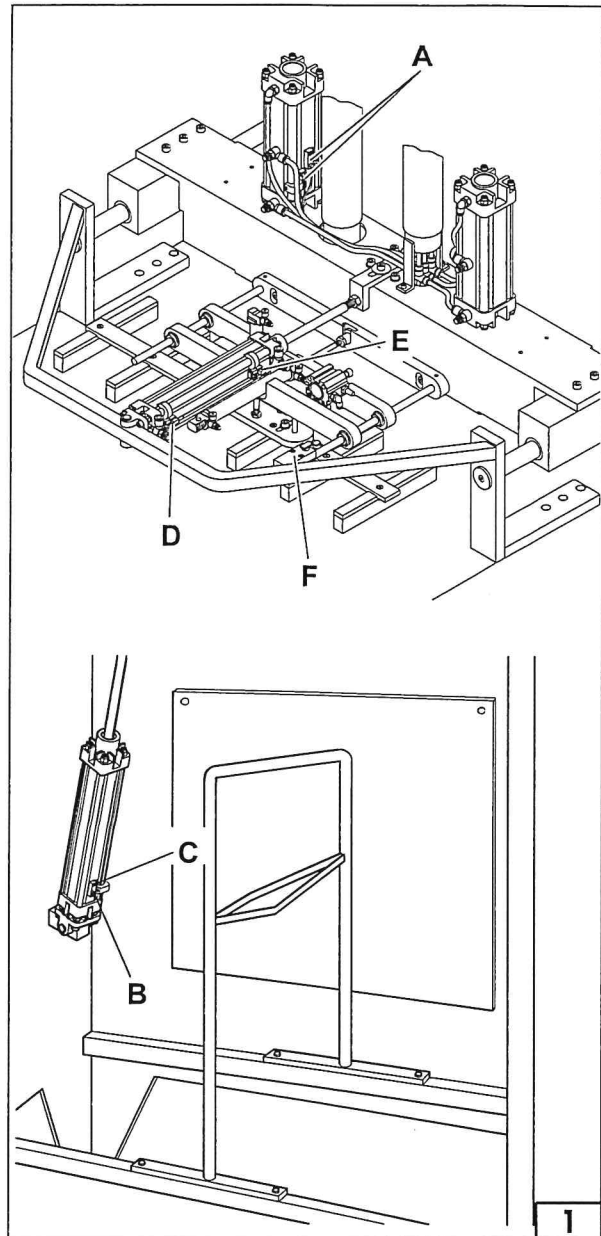
- If occurs during 1st ironing, check the efficiency of magnetic sensor "D".
- If occurs during 2nd ironing, check the efficiency of magnetic sensor "E".

The carriage does not rise

- Check that limit stop "A" is free of obstructions.

Stacker surfaces do not open

- Check the efficiency of limit stop "F".

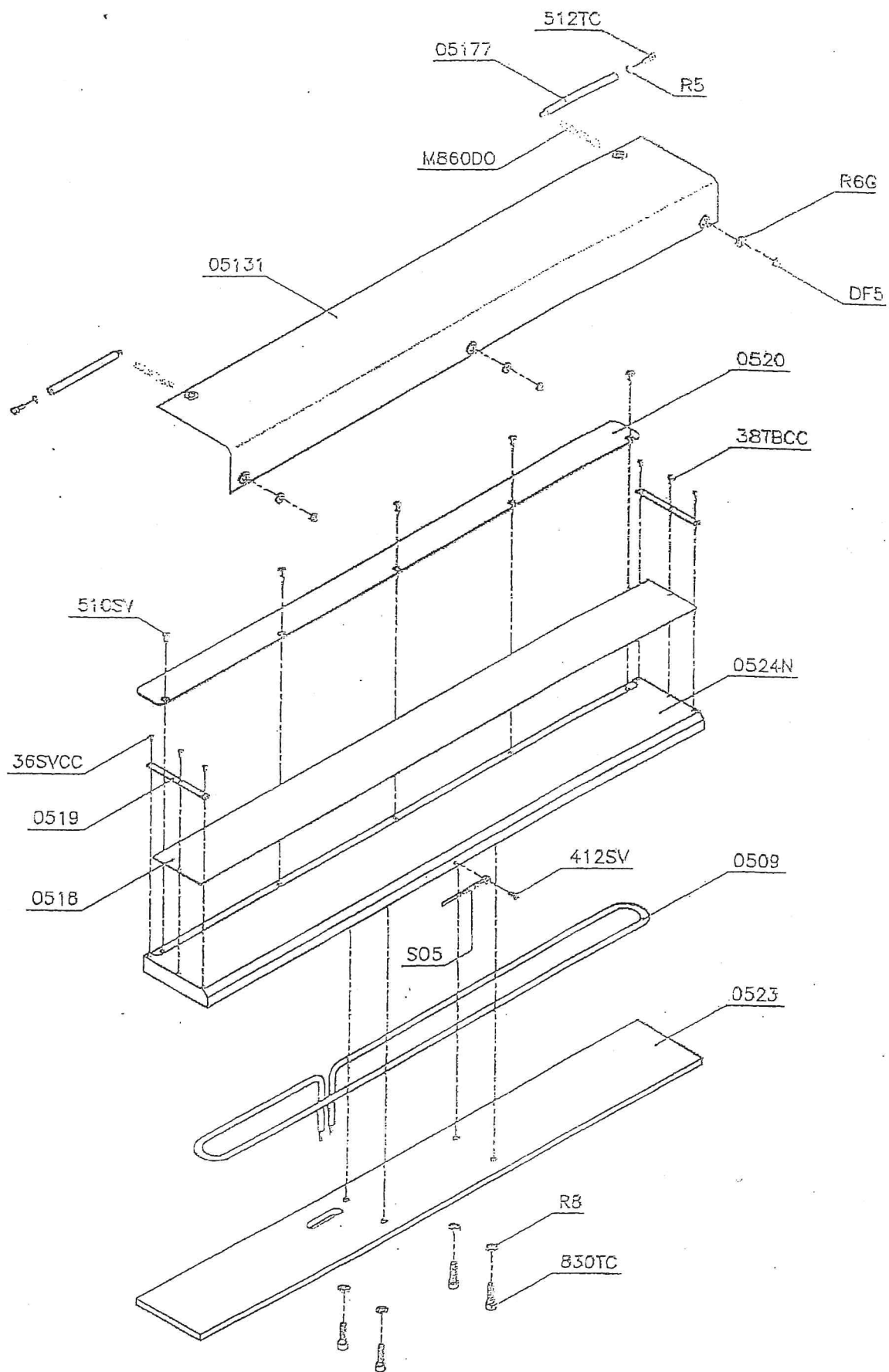


11 - SPARE PARTS TABLES

To help us identify the necessary spare parts quickly, please communicate the following data:

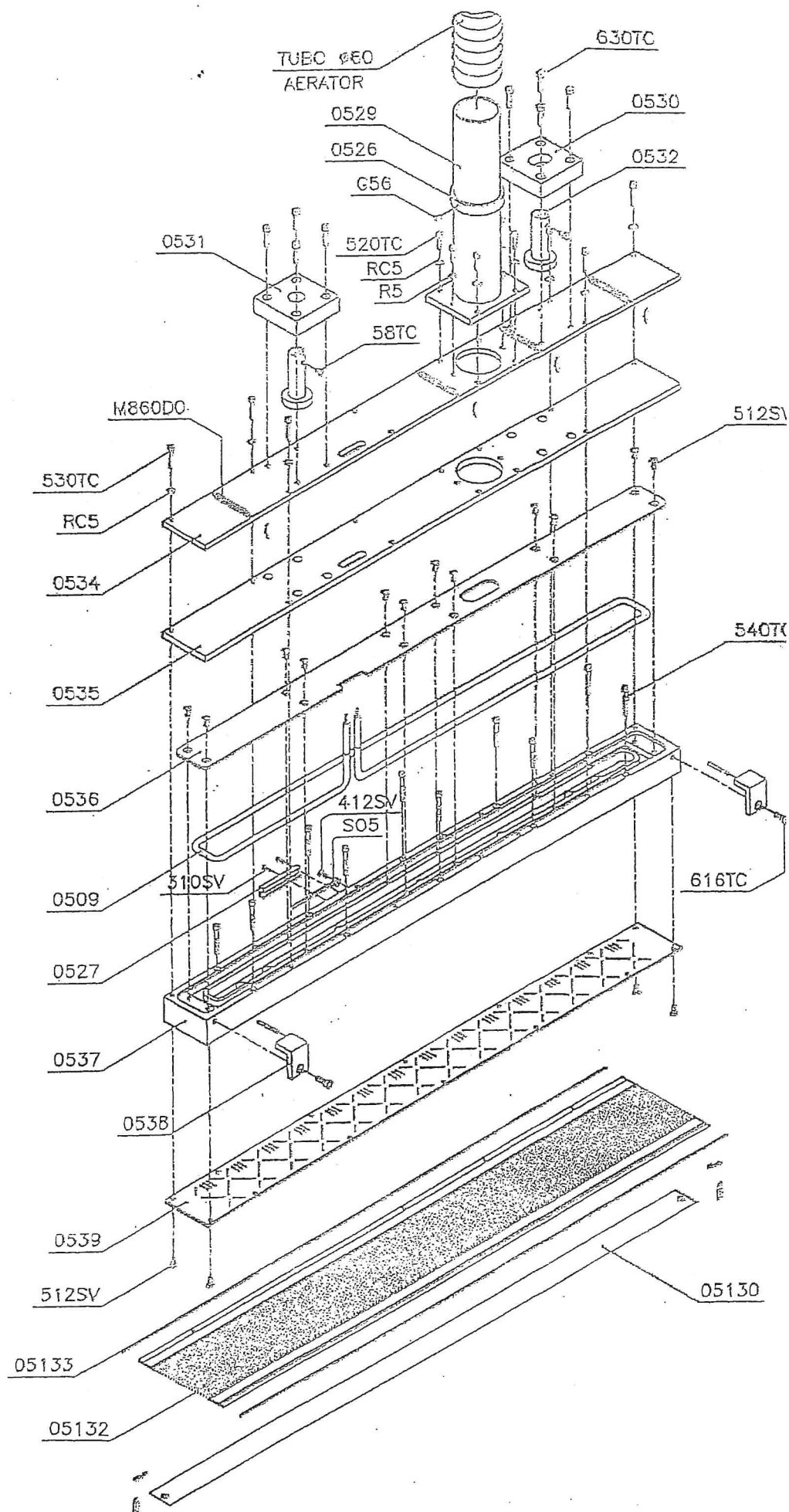
1. Model and serial number of the machine
2. Spare part code
3. Corresponding spare part table

Example: IRONING MACHINE model 1005 Serial no. Code 0524 Table 1



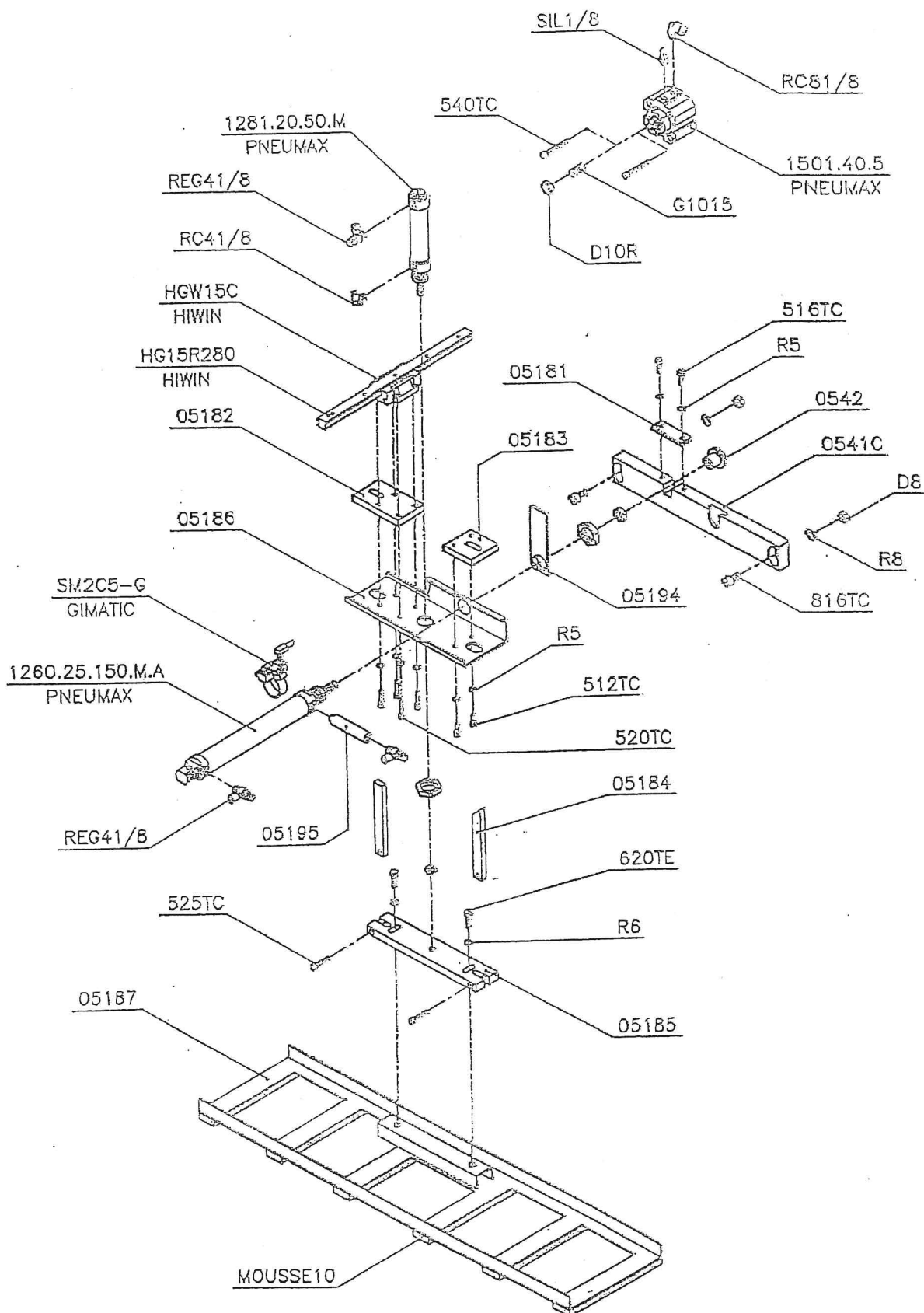
STIRATRICE 1005

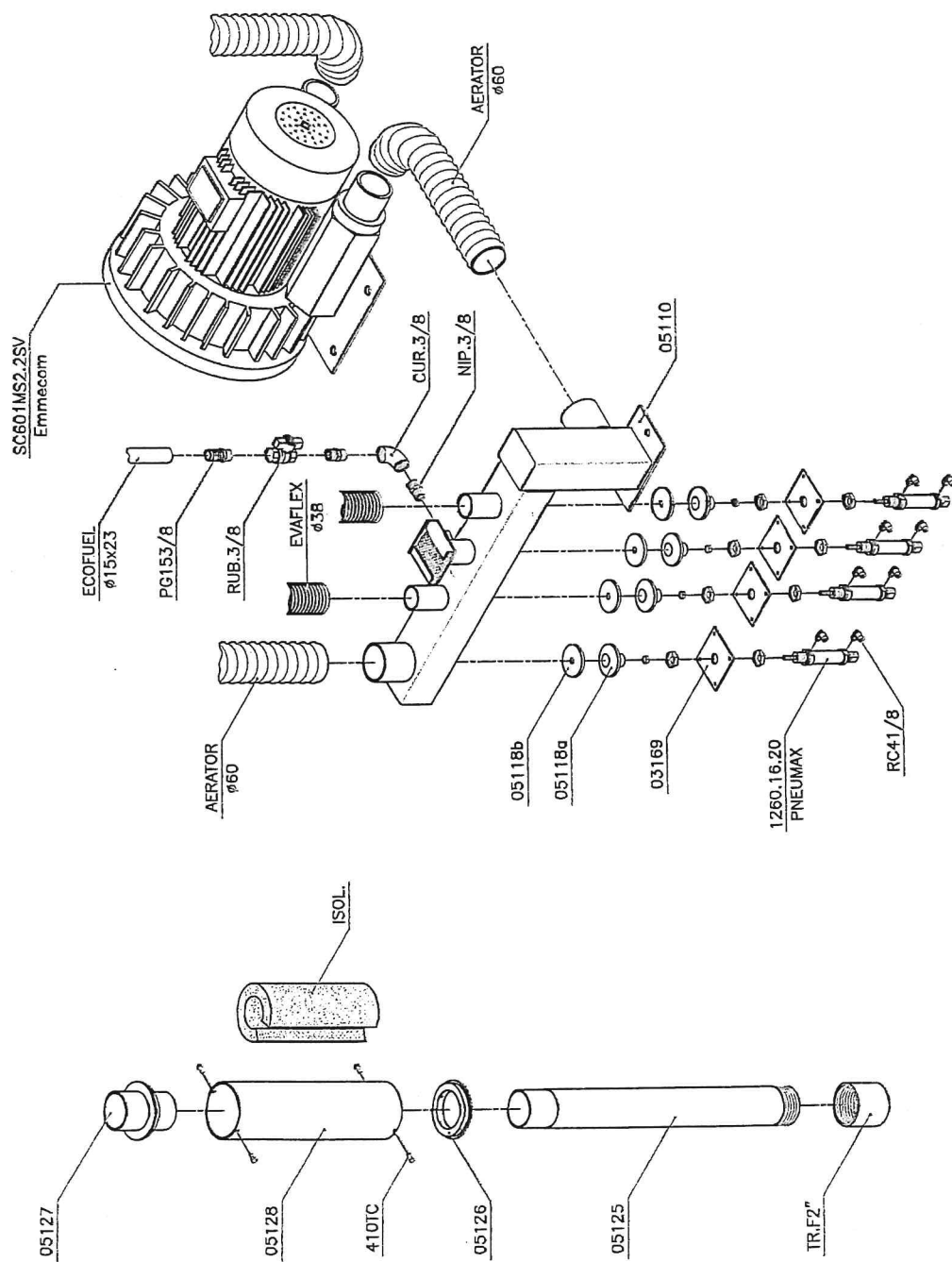
M.A.I.C.A. TAV. 3



STIRATRICE 1005

M.A.I.C.A. TAV. 4



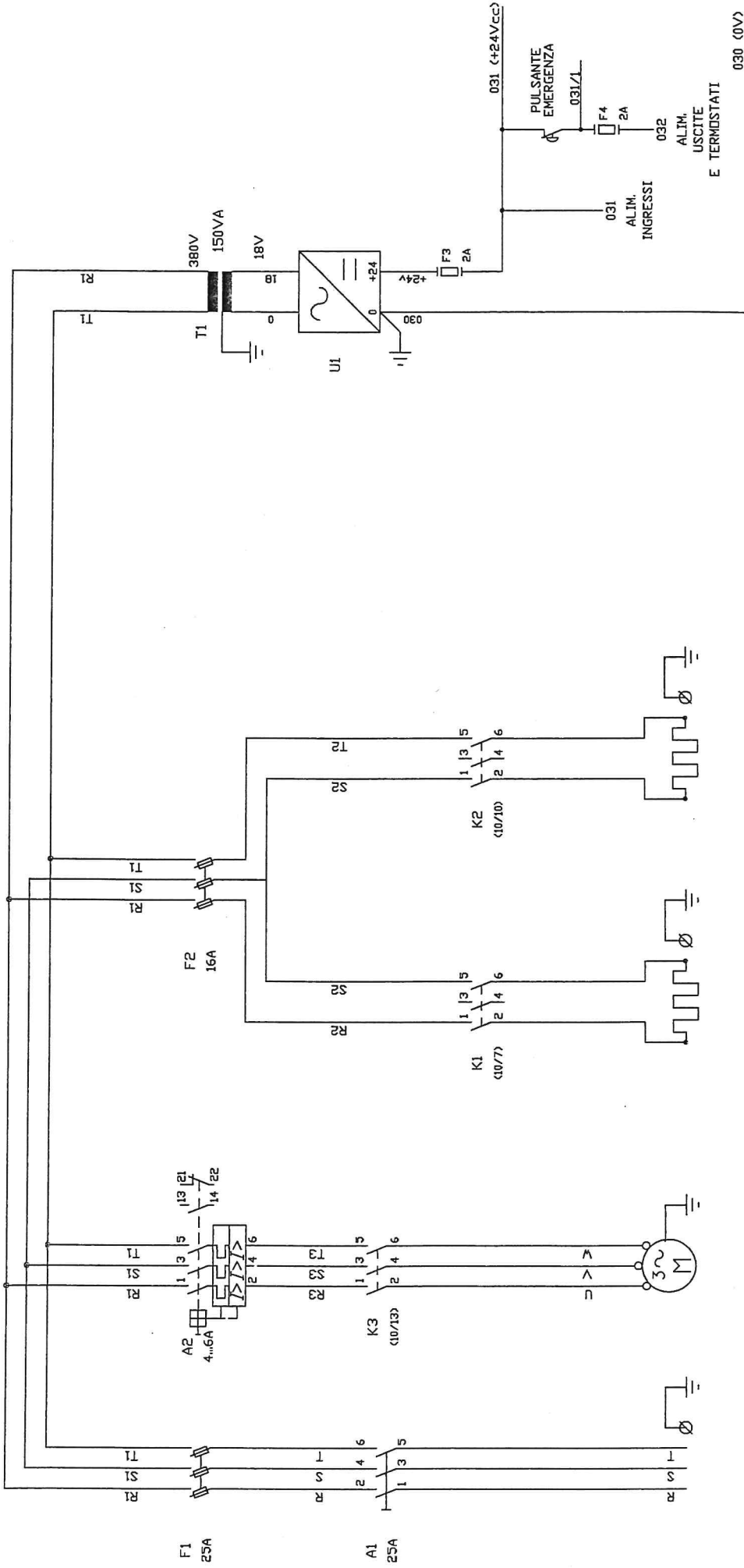


A/1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27
-----	---	---	---	---	---	---	---	---	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----

MACCHINA STIRATRICE
MOD. 1005 S7_1200.

M.A.I.C.A.S.r.l.

REV.	DATA	NOME	DATA	2016	M.A.I.C.A. S.r.l.		CLIENTE	DESCRIZIONE	FOGLIO N.	N. FOGLI
0					MACCHINE AUTOMATISMI INDUSTRIALI			STIRATRICE 1005 S7_1200.	1	
					CAMICERIE ABBIGLIAMENTO					
					Via Casale, 23 - 24060 Torre de Roverl (BG)					



ALIMENTAZIONE
380 50HZ

HP3 (5A)
MOTORE
ASPIRAZIONE

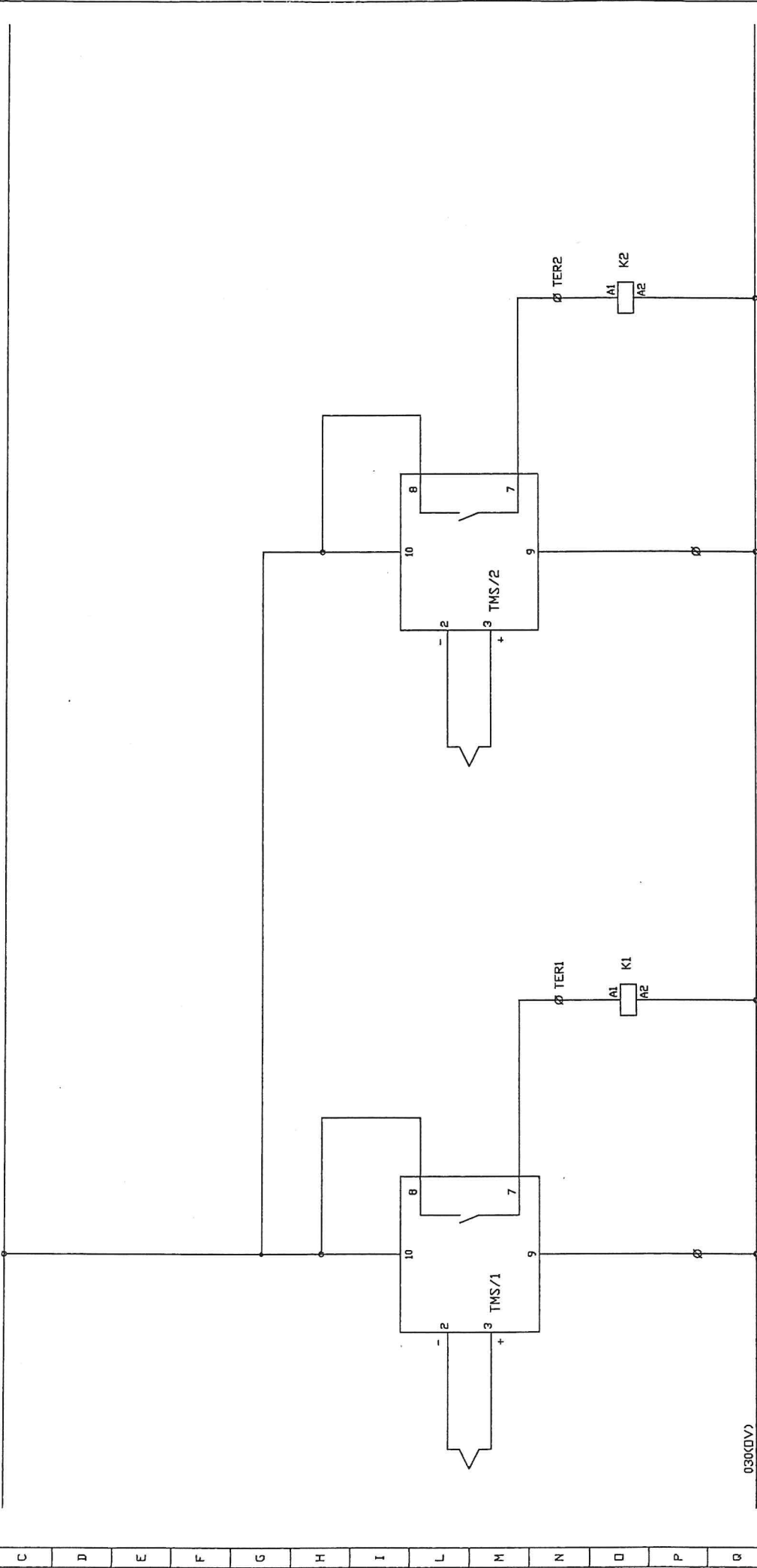
1200W 380V
RESISTENZA
INFERIORE

1200W 380V
RESISTENZA
SUPERIORE

REV.	DATA	NOME	DATA	2016	DESCRIZIONE	FOGLIO N.	N. FOGLI
0					STRATRICE 1005 S7_1200.	2	
						DISEGNO N.	

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

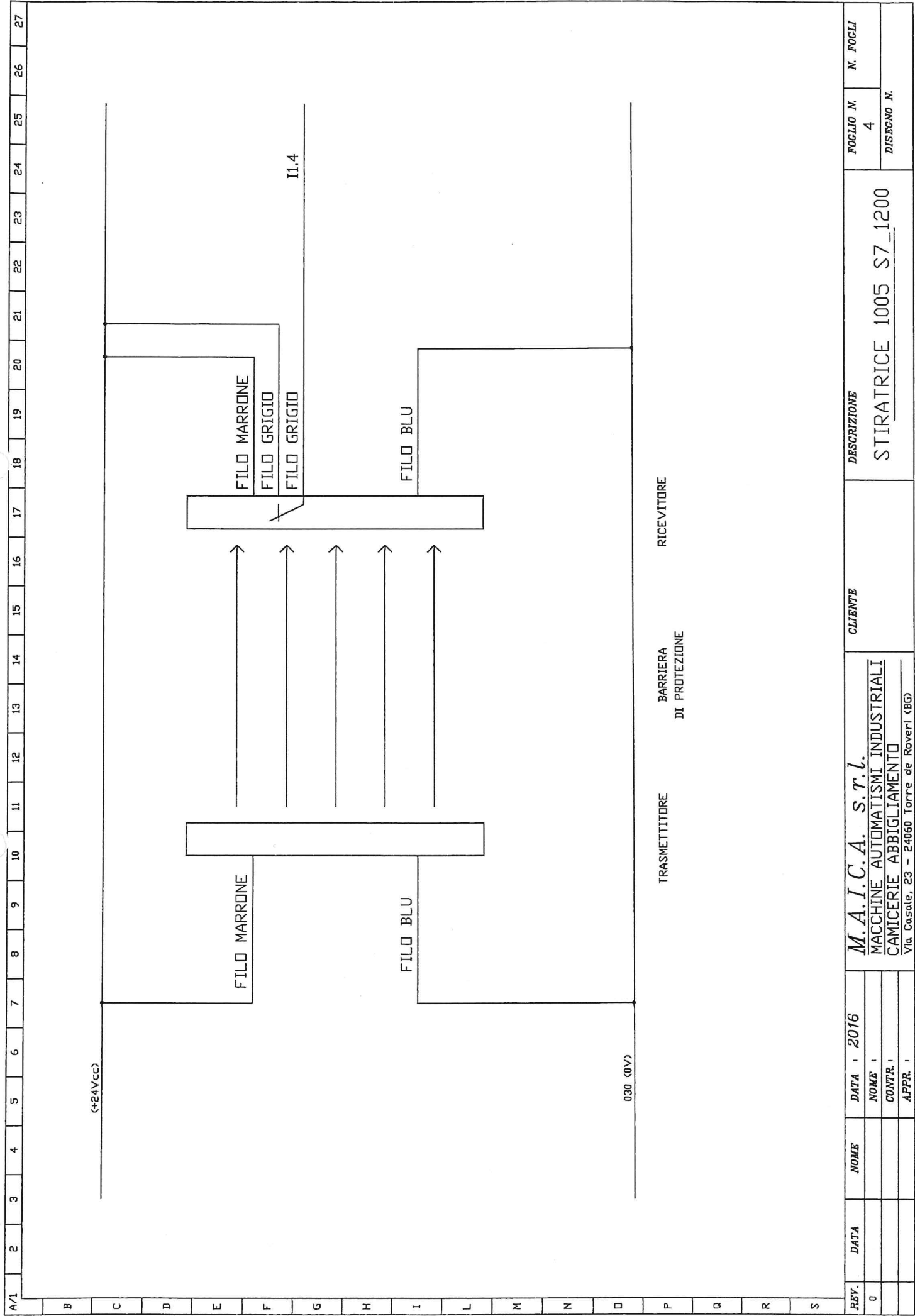
035(24V)



TERMOSTATO RESISTENZA INFERIORE

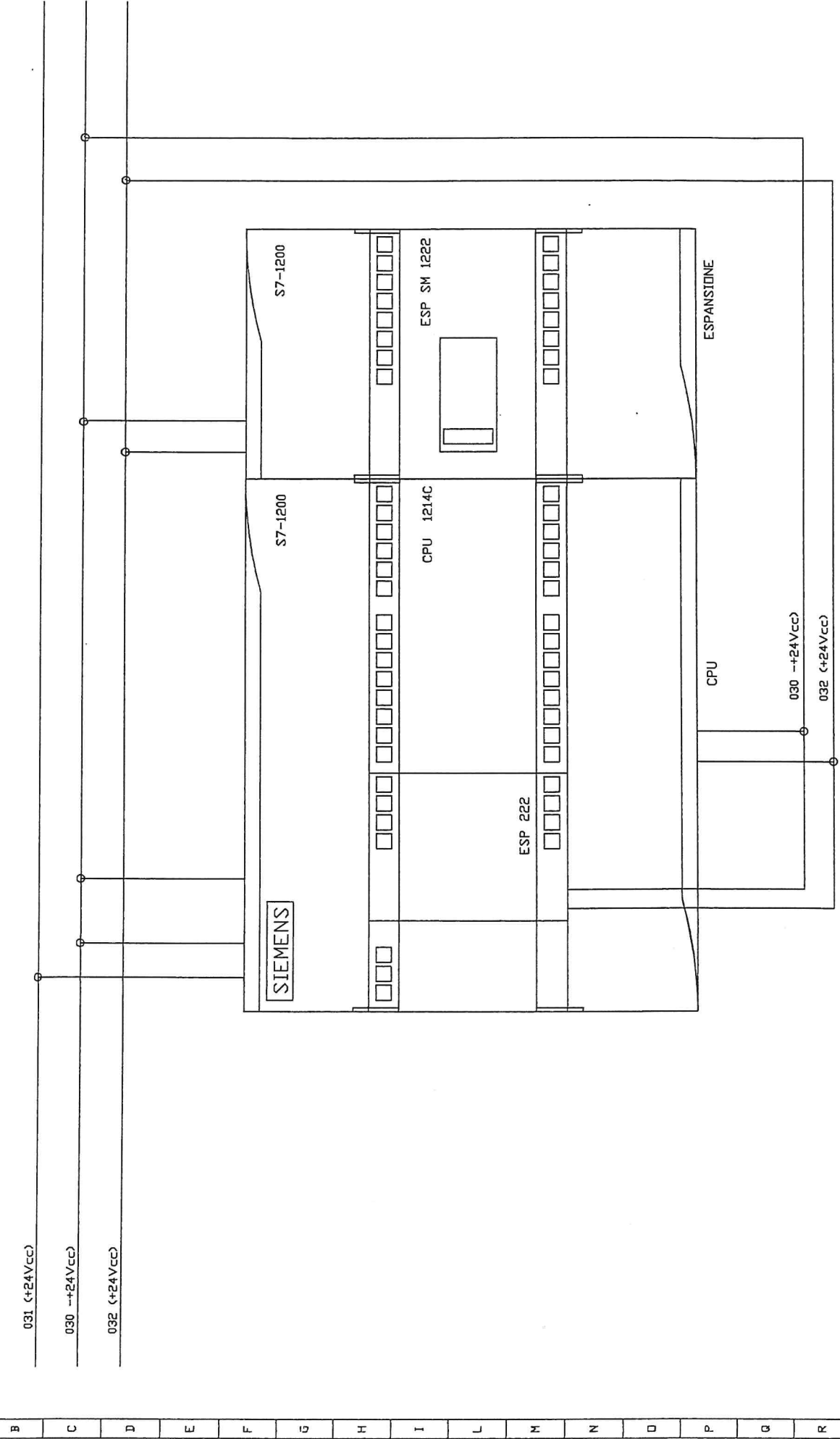
TERMOSTATO RESISTENZA SUPERIORE

REV.	DATA	NOME	DATA	2016	CLIENTE	DESCRIZIONE	FOLIO N.	N. FOGLI
0					M.A.I.C.A. S.r.l.	STIRATRICE 1005 S7_1200	3	
					MACCHINE AUTOMATISMI INDUSTRIALI			
					CAMICERIE ABBIGLIAMENTO			
					Via Casale, 23 - 24060 Torre de Roveri (BG)			



REV.	DATA	NOME	DATA	2016	DESCRIZIONE	CLIENTE	FOGLIO N.	N. FOGLI
0			NOME		STIRATRICE 1005 S7_1200		4	
			CONTR.					
			APPR.					

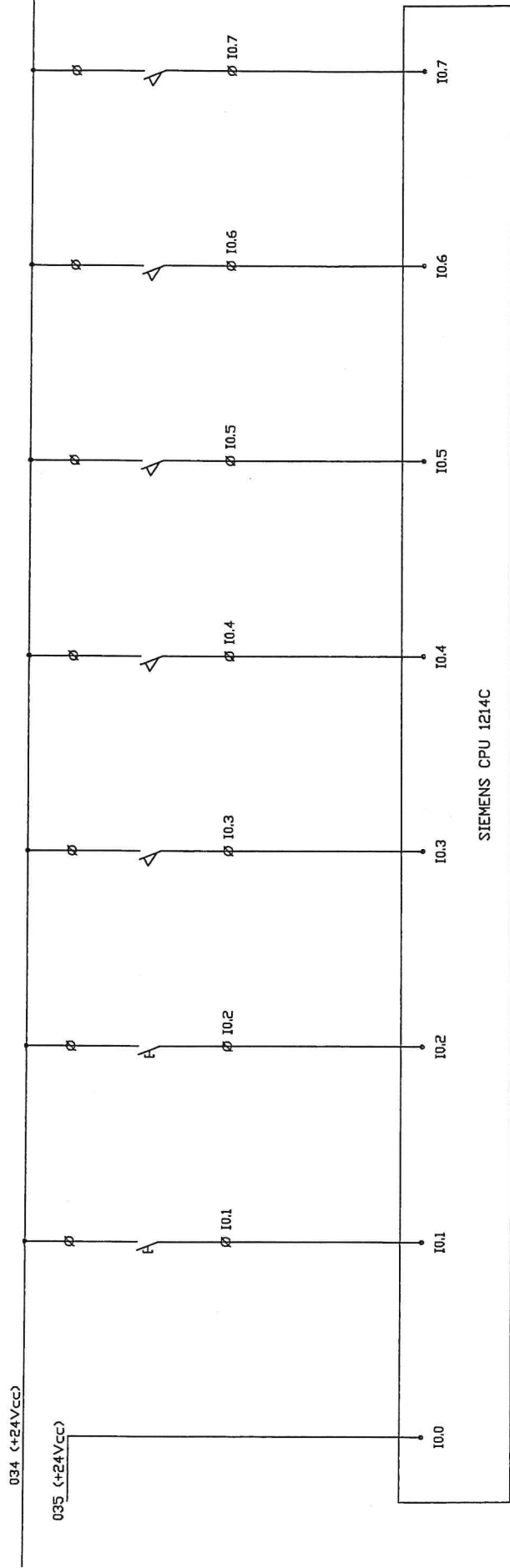
M.A.I.C.A. S.r.l.
MACCHINE AUTOMATISMI INDUSTRIALI
CAMICERIE ABBIGLIAMENTO
Via Casale, 23 - 24060 Torre de Rovere (BG)



REV.	DATA	NOME	DATA	2016	DESCRIZIONE			FOGLIO N.		N. FOGLI	
0					STIRATRICE 1005 S7_1200			5			
								DISEGNO N.			

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DATA	NOME	DATA	2016



030 (0V)

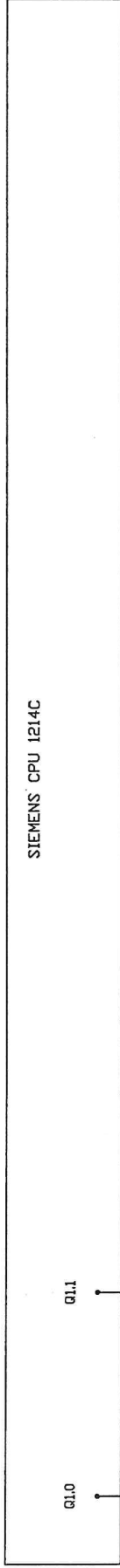
EMERGENZA	PULSANTE START DX	PULSANTE START SX	FINECORSA CARRO STIRO ALTO	FINECORSA CARRO STIRO AVANTI	FINECORSA CARRO STIRO RIPOSO	FINECORSA PARTENZA IMPILATORE	FINECORSA PIANI IMPILATORE APERTI
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REV.	DATA	NOME	DATA	2016	DESCRIZIONE		FOGLIO N.	N. FOGLI
0			NOME		STIRATRICE 1005 S7_1200		6	
			CONTR.					DISEGNO N.
			APPR.					

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[illegible]

032 (+24Vcc)



Q1.1

Q1.0

Q1.1

Q1.0



030(0V)

ELETTRIVALVOLA
ASPIRAZIONE
VUOTO III
+ DISCESA CILINDRO
STIRO A METÀ

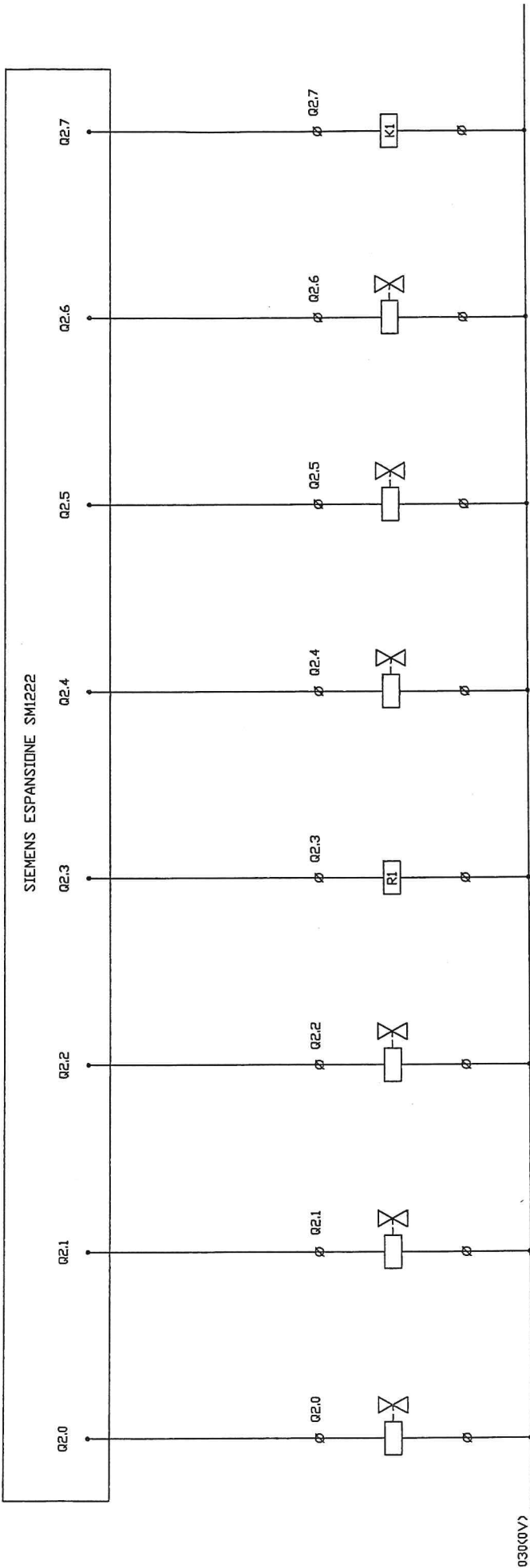
ELETTRIVALVOLA
AVANTI LAMA II

<NERO>

<VIOLA>

REV.	DATA	NOME	DATA	2016	M.A.I.C.A. S.r.l. MACCHINE AUTOMATISMI INDUSTRIALI CAMICERIE ABBIGLIAMENTO Via Casale, 23 - 24060 Torre de Roverè (BG)			CLIENTE	DESCRIZIONE	FOGLIO N.	N. FOGLI
0									STIRATRICE 1005 S7_1200	9	
										DISEGNO N.	

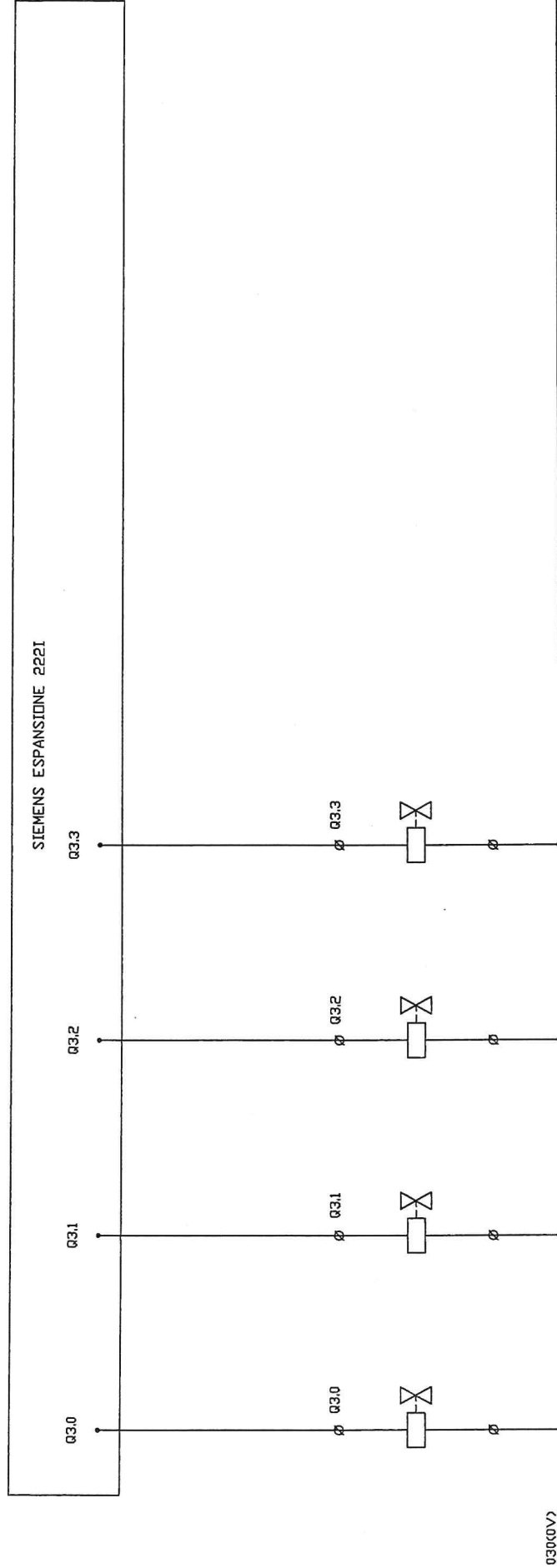
032 (+24Vcc)



REV.	DATA	NOME	DATA	2016	DESCRIZIONE	CLIENTE	N. FOGLIO	N. FOGLI
0					STIRATRICE 1005 S7_1200		10	
								DISEGNO N.

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035 (+24Vcc)



ELETTROVALVOLA CILINDRO TIRA STOFFA
 ELETTROVALVOLA DISCESA RULLO X TAGLIO
 ELETTROVALVOLA TAGLIO ADESIVO
 ELETTROVALVOLA AVANTI ADESIVO

COLLEGATI SOLO
 SU MODELLO CON
 TAGLIO ADESIVO

<GRIGIO-MARRONE>

REV.	DATA	NOME	DATA	2016	DESCRIZIONE	CLIENTE	FOGLIO N.	N. FOGLI
0				NOME	STIRATRICE 1005 S7_1200		11	
				CONTR.				DISEGNO N.
				APPR.				

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