GB

Pressing for Excellence

Operating instructions

Translation of the original operating instructions

Jacket front underpressing machine

BRI-600

CE

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

BRI-600, Version 1, en_GB
16.10.2024

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1 General information

1.1 Type plate

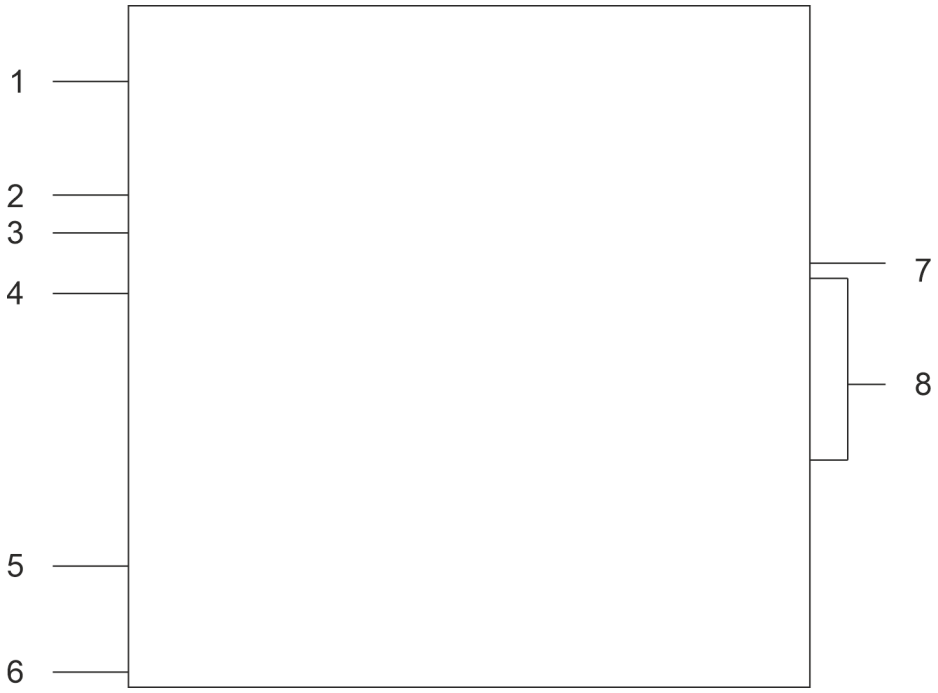

Fig. 1: Type plate

1 Address
2 Designation of machine
3 Type of machine
4 Year of construction
5 Buck number
6 Serial number
7 Order number
8 Weight, connected loads

1.2 Declaration of conformity

EU-Konformitätserklärung / EU declaration of conformity / Déclaration UE de conformité

Manufacturer: **VEIT**

Model: **Vorderteil-Vorbügelmaschine**
Jacket Front Underpressing Machine

Type: BRI-600/_____ serial number: _____

machine number: _____ CE marking affixed: _____

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.

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:

Directive 2006/42/EC (L 157/24 - 09.06.2006 - MD)

Directive 2014/30/EU (L 96/79 - 29.03.2014 - EMCD)

Angewandte harmonisierte Normen, insbesondere:
Applied harmonized standards, in particular:
Normes harmonisées utilisées, notamment:

EN ISO 12100:2010

EN 60204-1:2018

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:

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Landsberg, 04.09.2024

ppa.
Sascha Oehl
(Director Product and Innovation)

2 Intended use

This machine has been developed, designed and built for industrial and commercial use only. Die Maschine ist ausschließlich für den Betrieb in geschlossenen Räumen vorgesehen.

The jacket front underpressing machine BRI-600 is designed for men's and ladies' jackets and serves to press left and right front parts by applying steam and pressure followed by a cooling phase. The underpressing machine BRI-600/101 is also designed to open side seams and chest darts and to insert the chest piece and adhesive tapes.

NOTICE!

The machine is intended for treating textiles only. The manufacturer will no 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").

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

2.1 Unintended use

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.

2.2 Reasonably foreseeable misuse

- Removal of safety frame
- Outdoor operation
- Operation without (adequate) knowledge of the operating instructions
- Removal of protective hoods

2.3 Overview of the machine

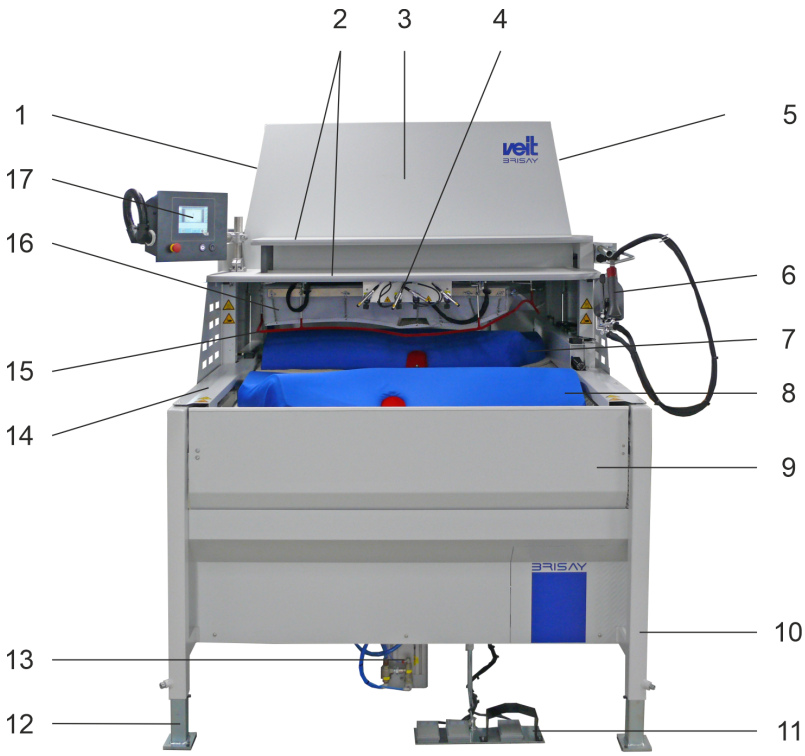

Fig. 2: Overview of the machine

The machine is composed of the following subassemblies:

1 Electric switch cabinet
2 Deposit
3 Guiding unit rear head buck (not visible)
4 Positioning lights
5 Pneumatic switch cabine
6 Steam iron including mounting set (option)
7 Sledge with lower and head buck (head buck not visible)
8 Front lower buck
9 Rocker switch
10 Ground frame
11 Pedal strip
12 Machine mounting pad
13 Guiding unit front lower buck
14 Linear travelling frame sledge (not visible)
15 Safety frame
16 Rear head buck
17 Control panel

2.4 Function

The jacket front underpressing machine BRI-600 is designed for men’s and ladies’ jackets and serves to press left and right front parts by applying steam and pressure followed by a cooling phase.

The underpressing machine BRI-600/101 is also designed to open side seams and chest darts and to insert the chest piece and adhesive tapes.

To reduce production times, the machine may be loaded during one operating cycle.

The process cycle is controlled by the machine control. All the machine’s movements are electropneumatic.

The edge suction extracts the steam outside of the pressing surface. This is to prevent marks at the edges of the pressing surface.

Operating workflow:

- The garment has to be inserted and adjusted by the operator.
- Laser position control lamps (option) may be used to position the garment on the lower buck.
- The garment is fixed on the lower buck by suction. After having activated the suction, the operating cycle may be started.
- If the front lower buck is in loading position, the programme runs as follows:
  - The front lower buck is lowered, the sledge moves forwards and the front lower buck is raised again.

    If the lower buck on the sledge is in loading position:
  - the sledge moves backwards and the rear head buck is lowered.
- The suction switches off.
- The steam supply is switched on. Steam is admitted to the garment via the steam exhaust ports in the head and lower buck.
- The steam supply switches off once the pre-set steaming time has elapsed.
- Due to the following suction of the lower buck, the temperature of the garment is lowered and the pressing result fixed.
- The machine type BRI-600/101 provides for a better cooling by aeration which is activated together with the "suction lower buck".

  As an option, the machine type BRI-600/202 offer the possibility of cooling the garment by using the function "blowing" in connection with "suction head buck". It is possible to activate "Distance head buck" as well, if necessary.
- Depending on whether the front or back pressing cycle is active:
  - the front lower buck is lowered once the pressing time has run off. After a new start, the sledge moves backwards and the front lower buck is raised again.
  - the rear head buck is raised once the pressing time has run off. After a new start, the sledge moves forwards.
- The garment is removed by the operator.

The steam iron with mounting set (option) is provided to open the side seams and the chest darts.

2.5 Technical data

Product-related data

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

Tab. 1: Dimensions and weight

Width	1450 mm
Depth	1700 mm
Height	1830 mm
Weight	approx. 700 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	IP 43

Tab. 3: Compressed air supply

	Machine	Blowing (option)
Connected load	6 bar / 0.6 MPa	6 bar / 0.6 MPa
Consumption	119 l/min	98 l/min
Connection (1x)	12 x 2 mm	12 x 2 mm

Tab. 4: Steam supply

Connected load	4.5-6 bar / 0.45-0.6 MPa
Consumption	32.5 kg/h
Connection (1x)	1/2"

Tab. 5: Suction

Connected load	mind. 120 mbar / 0.012 MPa
Consumption	3000 l/min
Connection (2x)	1 1/2"

Tab. 6: Condensate

Connected load	max. 0.5 bar / 0.05 MPa
Connection (2x)	3/8"

Tab. 7: General data

Umgebungstemperatur	+5°C bis +45°C
Geräuschpegel	<=70 dB(A)

2.6 Scope of delivery

The delivery comprises:

1. Jacket front underpressing machine
   - BRI-600/101 with concave pressing bucks or
   - BRI-600/202 with convex pressing bucks

   Standard:

   - Steam head bucks
   - Steam lower bucks
   - Suction lower bucks
   - Suction head bucks (only with BRI-600/202)
   - Edge suction head bucks
   - Aeration head bucks (only with BRI-600/101)
   - Machine control
   - Positioning lights for chest point

   Options:

   - Blowing lower bucks (only with BRI-600/202)
   - Steam iron including mounting set
   - Positioning lights for breast darts
   - Dart peak holder
2. Operating instructions
3. Technical documentation

These operating instructions cover the maximum scope of delivery.

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.

The warning symbol is attached to the machine

- On the right of the switch cabinet
- On the bottom of the terminal box

WARNING!
Symbol indicating risk of **hand injuries**.

The warning symbol is attached to the machine

- On the left of the frame
- On the left and right of the frame with the cleaning doors open
- On the front left and right of the protective cover of the linear travelling frames

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

The warning symbol is attached to the machine

- On the left of the frame
- On the left and right of the frame with the cleaning doors open
- On the right of the “steam iron connection” protective element
- On the front left and right of the protective cover of the linear travelling frames
- On the rear left bottom below the steam dryer
- On the rear right bottom below the condensate connection

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

The warning symbol is attached to the machine

- On the holder next to the positioning light(s)
- On the positioning light(s)

Reference to **operating instructions**.

The warning symbol is attached to the machine

- On the right of the pneumatic switch cabinet

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

NOTICE!
Request to pay particular attention.

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

Address

Manufacturer

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Asia:	+852 2111 9795
E-Mail:	service@veit.de

Spare parts

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America:	+1 770 8688060
Asia:	+852 28349986

3.3 Built-in safety systems

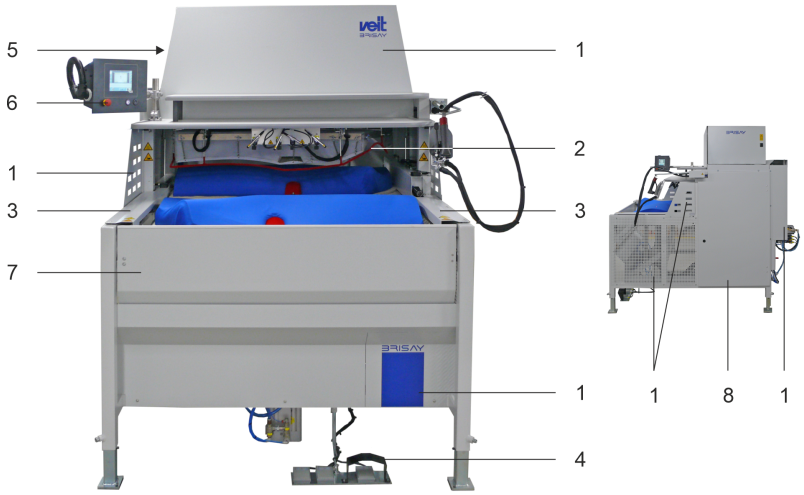


Fig. 3: Safety systems on the machine

1 Protective cover
2 Safety frame
3 Protective cover for linear travelling frame
4 Hoop guard
5 Main switch (not visible)
6 Emergency-stop button
7 Rocker switch
8 Cleaning doors

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
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: ■ The rear upper buck moves up ■ The carriage stops its linear movement ■ The front lower buck moves down ■ Escape of steam is cut off The emergency-stop button can be released by pulling it out. The trigger action of the emergency stop button must be acknowledged by pressing the “control system ON” button. Reset button, LED flashing – Press the reset button until the carriage has moved to its end position.	t	S, F

Safety device	Interval	Inspection
Safety frame A safety frame is mounted around the upper buck at a defined distance. Prior to using the machine, the safety frame must be checked for proper attachment and visible damage. After switching on the machine, a function check must be performed at different locations on a daily basis: ■ Smooth function of mechanics ■ Microswitch is activated Activating the safety frame starts the following sequence: ■ The rear upper buck moves up ■ The carriage stops its linear movement ■ The front lower buck moves down ■ Escape of steam is cut off The trigger action of the safety frame must be acknowledged by pressing the “control system ON” button. Reset button, LED flashing – Press the reset button until the carriage has moved to its end position. Do not start up the machine in the event of an error (repair must be initiated).	t	S, F

Safety device	Interval	Inspection
Rocker switch The rocker switch is installed in the operating area at the front of the machine. Activating the rocker switch starts the following sequence: ■ The rear upper buck moves up ■ The carriage stops its linear movement ■ The front lower buck moves down ■ Escape of steam is cut off The trigger action of the rocker switch must be acknowledged by triggering the safety frame and pressing the “control system ON” button. Reset button, LED flashing – Press the reset button until the carriage has moved to its end position. Do not start up the machine in the event of an error (repair must be initiated).	t	S, F
Cleaning doors There is a cleaning door on both sides of the machine, which is locked with a special lock. The cleaning door may only be opened by skilled personnel using a special key.	t	S

Safety device	Interval	Inspection
Protective cover for linear travelling frames The linear travelling frames of the carriage are secured with a protective cover to prevent people from reaching in. Opening a cover starts the following sequence: ■ The rear upper buck moves up ■ The carriage stops its linear movement ■ The front lower buck moves down ■ Escape of steam is cut off The trigger action of the cover(s) must be acknowledged by triggering the safety frame and pressing the “control system ON” button. Reset button, LED flashing – Press the reset button until the carriage has moved to its end position. Do not start up the machine in the event of an error (repair must be initiated).	t	S, F
Hoop guard (“start” pedal) A hoop guard is mounted above the start pedal to prevent unintentional start-up of the machine.	t	S
Protective cover Guard plates are mounted around the machine to prevent people from reaching in.	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 have to be available to the operating personnel at any time.

The included safety instructions must be observed.

It is strictly forbidden to put the 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 chapters OPERATION / OPERATING MODES
- 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 EN 60204.

4 Notes on 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 button 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

The closing movement of the rear upper buck and the front lower buck as well as the travel movement of the carriage and the front lower buck cause an increased **risk of crushing**.

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

- Do not reach into the opening between carriage the rocker switch.
- Service and maintain the machine only if it has been switched off.
- Open the cleaning doors only if the machine has been switched off.
- Safety shoes must be worn when adjusting and maintaining the machine in order to avoid crushing.

WARNING!

Risk of burns

The closing movement of the rear upper buck and the front lower buck as well as the travel movement of the carriage and the front lower buck cause an increased **risk of burns**.

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

All parts connected to steam and condensate (e.g. buck plates, buck supporting plates, hoses, hose connections, steam valves, steam distributors, steam spraying systems) cause an increased **risk of burns**.

Pay attention to the **risk of burns** when handling the steam iron (option).

– The machine is hot during operation. Do not touch any hoses or connections.
– Safety gloves must be worn when adjusting and maintaining hot machine parts in order to avoid burns.

WARNING!

Lock the cleaning doors during operation

During operation, the cleaning doors must be locked. There is a **risk of crushing and a risk of burns**.

– Lock the service doors using the special key.

WARNING!

Risk of fire

If a buck remains closed over a longer period during operation, there is a **risk of fire.**

– Never leave the machine unattended.

WARNING!

Risk of injuries caused by open, long hair, loose clothes or jewellery

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.

– Wear a hairnet
– Do not wear loose clothes
– Do not wear jewellery

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.

WARNING!

Risk of injuries caused by moving parts

There is a risk of serious injuries caused by moving parts.

– Do not reach into the mechanical parts while they are moving.

WARNING!

Work on the electrical system

Work on the electrical system must only be carried out by electrically skilled persons. **Danger to life!**

– Any work on the electrical system must only be carried out by electrically skilled persons.
– It is not allowed to work on live components.
– Follow the five safety rules of electrical engineering prior to working on the electrical system:
  – Disconnect from power source
  – Secure against being switched on again
  – Determine voltage absence on all poles
  – Earth and short circuit
  – Cover of fence off adjacent live parts

WARNING!

Working on the machine

The machine must be stopped prior to working on the machine or the electrical equipment.

– Perform the shutdown procedure
– Allow the machine components to cool down
– Wear personal protective equipment, if required

CAUTION!

Risk of eye injuries

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

– Do not look into the laser beam

CAUTION!

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. Otherwise, there is a risk of falling down.

– Use ladders that meet the required safety standards.
– Use working platforms that meet the required safety standards.
– Do not mount on any components of the machine.
– Wear a safety harness 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.

CAUTION!

Tripping hazard caused by incorrectly installed cables

Cables must be installed such that tripping hazards can be avoided.

– Cables and connections must be installed such that hazards can be avoided.
– In the event of leaks, repairs must be immediately initiated and spilled liquids (water, condensate or operating supplies) must be removed.

CAUTION!

Risk of crushing and impact hazard caused by opening the shut-off valve of the “machine control system” compressed air supply too quickly

Opening the shut-off valve of the “machine control system” compressed air supply too quickly causes a sudden pressurisation near the machine which results in a risk of crushing and an impact hazard.

– Open the shut-off valve of the “machine control system” compressed air supply slowly
– See also *Procedure instructions on page 47*

CAUTION!

Risk of burns and risk of scalding caused by opening the shut-off valve of the steam supply too quickly

Opening the shut-off valve of the steam supply too quickly causes a sudden pressurisation near the machine which results in a risk of burns and a risk of scalding.

– Open the shut-off valve of the steam supply slowly
– See also *Procedure instructions on page 47*

4.1 Danger zone of the machine

The operator has access to the following areas of the machine:

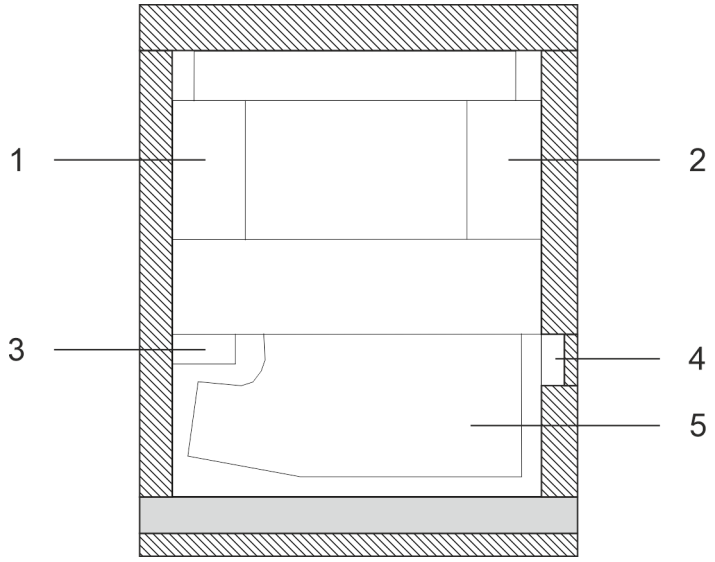


Fig. 4: Danger zones of the machine

1 Electric switch cabinet
2 Pneumatic switch cabinet
3 Control panel
4 Steam iron (option)
5 Front lower bucks

Operating area	
Danger zone	

CAUTION!
Danger zone
The danger zone is at 1 m around the machine.

– Do not enter the danger zone during operation.

CAUTION!
Risk of crushing in the danger zone
There is a risk of crushing in the danger zone caused by moving parts.

– Do not enter the danger zone during operation.
– The operator may only start the pressing process if there are no other persons in the danger zone.

CAUTION!

Risk of burns caused by hot surfaces

There is a risk of burns in the danger zone caused by hot surfaces and components that carry steam.

– Do not enter the danger zone during operation.
– The operator may only start the pressing process if there are no other persons in the danger zone.

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

CAUTION!

Information on harmful vapours

The operating company must ensure that harmful vapours are effectively removed and that safety of personnel is guaranteed.

– The company must assess whether their textiles or adhesive resins cause vapours to occur.

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

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

1. Cutting 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

- Cut off the compressed air valve.
- Exhaust the air from the compressed air lines.
  Attention! The rear 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!
Unloading and transporting the machine
The following must be observed when unloading and transporting the machine. Disregarding these procedures presents a risk of death or injury of the personnel.

– 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 machine's centre of gravity. The machine must be secured before being transported.
– Avoid shocks and pay attention to hoses on the earthing plate.
– It is forbidden to stay under suspended loads.

NOTICE!

Unloading and transporting the machine

The following must be observed when unloading and transporting the machine. Disregarding these procedures may cause damage to the machine.

- 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.
- Pay attention to the machine's centre of gravity. The machine must be secured before being transported.
- Avoid shocks.
- Pay attention to hoses on the earthing plate.

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:

- 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

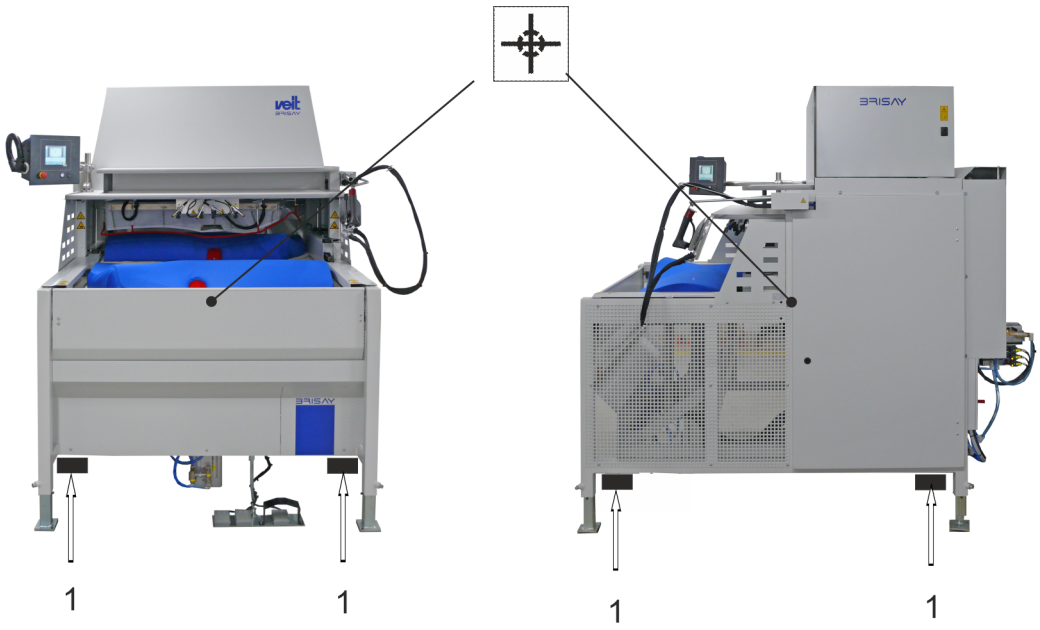


Fig. 5: Transport using a forklift truck, centre of gravity, lifting points (BRI-235VC shown)

⌖ Centre of gravity
1 Fork lifting points

- Adjust the width of the fork based on 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.
- Lift up the machine using a forklift truck.

Transport by crane

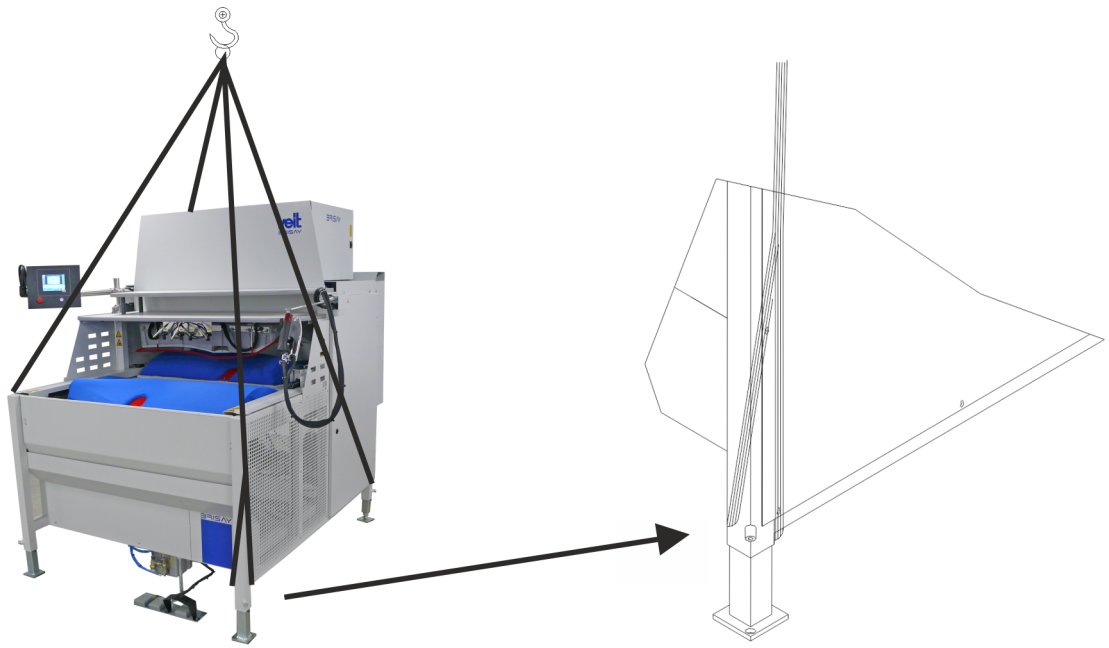


Fig. 6: Transport by crane

- Fasten ropes at the four machine mounting pads (see Fig. 6).
- Lift the machine and transport it to the place of installation.

5.2.1 Lifting points

Assembly	Weight	Centre of gravity	Lifting point	Lifting equipment
Entire machine	700 kg, approx.	see Fig. 5	below the ground frame (see Fig. 5)	Forklift truck
		see Fig. 5	below the ground frame at the machine mounting pads (see Fig. 6)	crane, ropes, hooks

5.3 Transport safeguards

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

CAUTION!

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.

WARNING!

Risk of burns

There is a risk of burns from the pressing bucks as well as from all components connected to steam and condensate.

- Make sure that the pressing bucks as well as all parts connected to steam and condensate have cooled down.
- Wear personal protective equipment.

1. Move the machine to home position, i.e.:
   - The rear upper buck moves up.
   - The carriage moves backwards.
   - The front lower buck moves to the loading position.
2. Select “Pressure level 2 bar” in the “Set single track” for track 1 supervisor function.
3. Activate the selected function.
4. The rear upper buck closes.

Fig. 7: Transport safeguard for upper buck guiding unit

1 Transport safeguard

5. Secure the upper buck guiding unit using the transport safeguard.
6. Cut off the compressed air supply, and exhaust air from the compressed air lines via the maintenance unit.
7. Switch off the machine and unplug the mains connector.

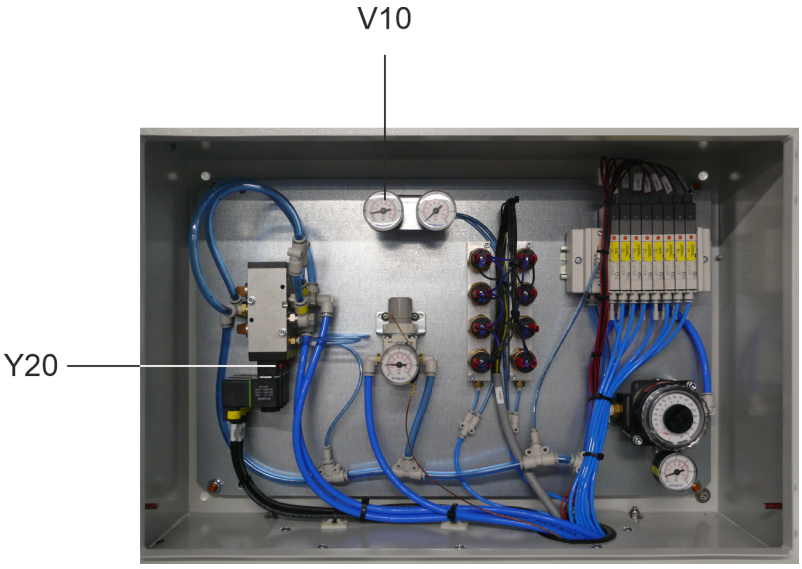


Fig. 8: Valve board

V10 Pressure gauge
Y20 Supplementary manual actuation device

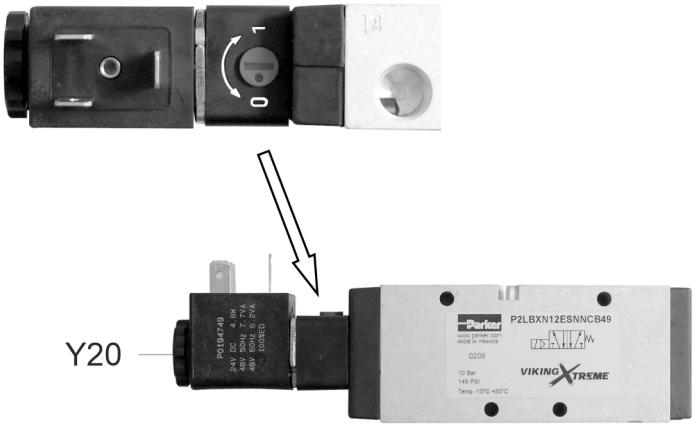


Fig. 9: Supplementary manual actuation device

Y20 Supplementary manual actuation device

8.
   - Set the supplementary manual actuation device at the solenoid valve in the switch cabinet from ”0” to ”1”.
   - The front lower buck moves down (push it to the end position, if necessary).
   - Set the supplementary manual actuation device at the solenoid valve in the switch cabinet from ”1” to ”0”.

9. Pull off the pneumatic hose from pressure gauge V10 to exhaust the air from the compressed air lines of the front lower buck. Restore the hose connection.

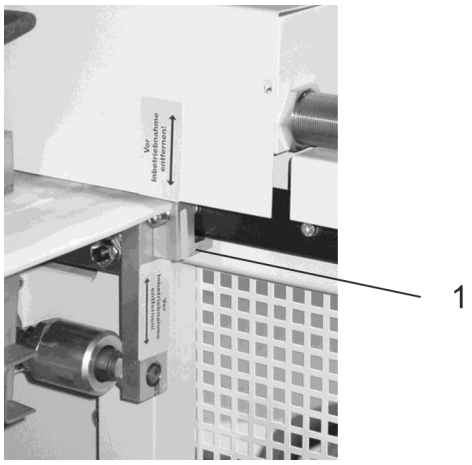


Fig. 10: Transport safeguard for linear travelling frame

1 Transport safeguard for linear travelling frame

10. Secure the carriage using the transport safeguard.

11. Remove the connection lines for compressed air, suction, steam and condensate drain provided by the customer.

12. Make sure that the packaging of the steam iron (option) is shock-proof.

6 Installation

6.1 Setup

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

- Make sure that the statics of the building are designed to carry the weight of the machine.
- The device has to be set up on an even surface.
- The energy supply (electrical 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.
- Position the machine in such a way that any motion of the machine does not impair the workers and operators.

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").*

Adjusting

Tab. 11: Ergonomic guidelines

Ergonomic guidelines	
Men and women working in upright position	**Women working in upright position**
Working height: floor - upper edge lower buck approx. 113 cm	Working height: - upper edge lower buck approx. 103 cm

- Move the forks of the truck underneath the machine (*'Transport using a forklift truck' on page 37*). Lift the machine to the desired working height, *Tab. 11 'Ergonomic guidelines' on page 42*

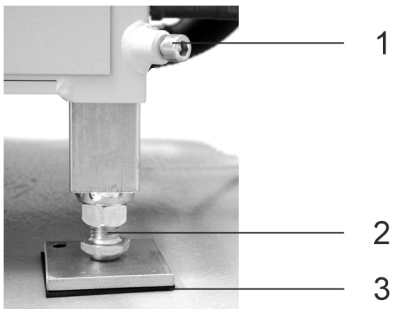


Fig. 11: Adjusting height

1 Check screw
2 Adjustable machine mounting pad
3 Rubber plate

- Place the supplied rubber plates under the four machine mounting pads.
- Open check screws and lower machine mounting pads to the ground and fasten check screws again.
- After having put down the machine, place a water level on the frame of the machine and adjust it by moving the machine mounting pads in X and Y direction.
- Use adjustable machine mounting pad to level out uneven patches
- Mount the pedal strip in accordance with the operating position.
- Remove steam iron (option) from packing and place it on suspension device.
- Remove transport safeguard, ↳ *Chapter 5.3 'Transport safeguards' on page 39*

NOTICE!
Degrease all the guide rods and/or linear guides before commissioning the machine.

6.2 Installation

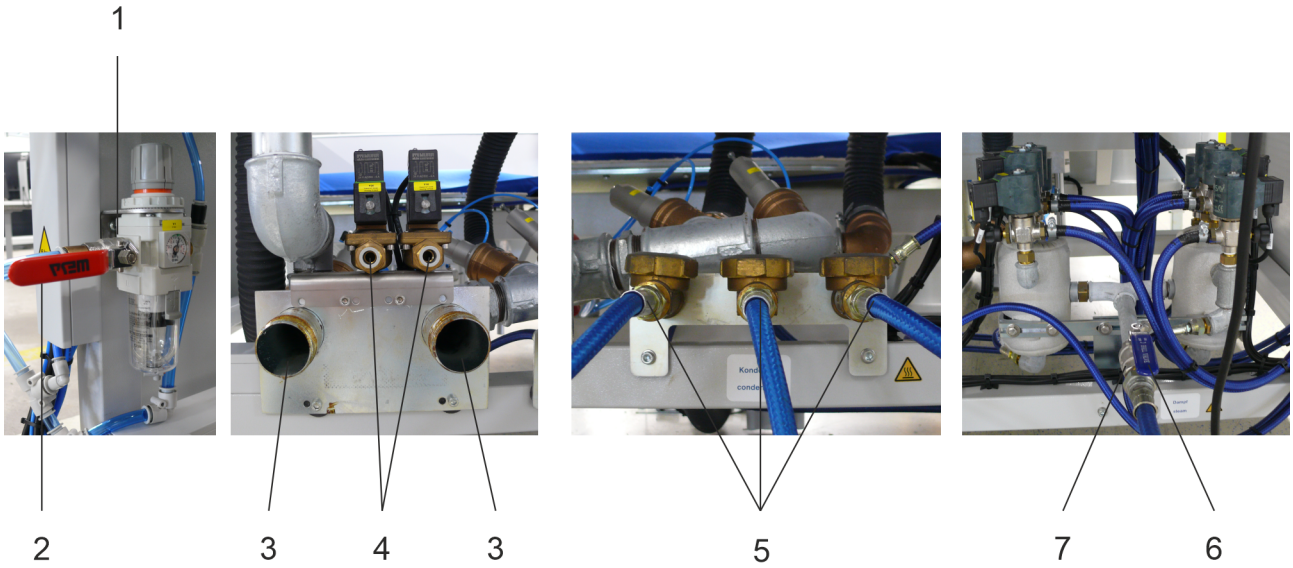


Fig. 12: Supply connections at the back of the machine

1 Compressed-air connection (machine control)
2 Shut-off valve of the compressed-air
3 Connection for suction
4 Compressed-air connection (blowing)
5 Connection for condensate drain
6 Shut-off valve for steam supply
7 Connection of steam supply

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).

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.

Power supply connection

The machine is provided with a plug and must be connected to the power supply system. The plug must be freely accessible and must not be blocked.

Connection to the mains must be protected on site. The regulations of the local power supply companies 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 at the voltage and current indicated on the type plate.

Make sure to observe the mains frequency.

Compressed-air connection

- Compressed-air machine control
  Connect compressed-air connection (pos. 1) to the compressed-air supply provided by the customer.
- Compressed-air blowing (option)
  Connect compressed-air connections "Blowing" (pos. 4) to the compressed-air supply provided by the customer.

WARNING!

Pneumatics operating pressure

An operating pressure higher than 6 bar may result in personal injuries.

– The maximum operating pressure must be 6 bar.

NOTICE!

Pneumatics operating pressure

An operating pressure higher than 6 bar may result in damage to the machine.

– The maximum operating pressure must be 6 bar.

Notes on compressed air quality

Compressed air quality requirements:

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.

- Use clean compressed air which is free from oil and condensate.
- Do not use compressed air that contains chemicals, synthetic oils with organic solvents, salts, caustic gases, etc.
- 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/m³	Pressure dew point in °C	Water content in mg/m³	Residual oil content in mg/m³
3	5	5	-20	880	1

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

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.

Connection of steam supply

- Connect steam connection of the machine (pos. 7 steam supply of the customer.

Connection for condensate drain

- Connect condensate drain (pos. 5) to the appropriate supply pipe of the customer.

Connection for suction

- Connect suction tubes (pos. 6) to the appropriate suction provided by the customer.

6.3 Commissioning

When commissioning the machine, proceed as follows:

1. Switch on the main switch at the switch cabinet, ↳ *Chapter 7.1.1 ‘Switch cabinet’ on page 52*, Fig. 17, Pos. 1
2. Release emergency stop button by pulling it, ↳ *Chapter 3.3 ‘Built-in safety systems’ on page 18*, Fig. 3, Pos. 6.
3. Press the button "Control system ON", ↳ *Further information on page 52*, pos. 2.
4. Open shut-off valve of the compressed-air "machine control" **slowly**, ↳ *Chapter 6.2 ‘Installation’ on page 44*, Fig. 12, Pos. 2.
5. The rear head buck and the front lower buck are raised.
6. Open shut-off valve of the compressed-air supply "Blowing" at the customer’s **slowly** (option), ↳ *Chapter 6.2 ‘Installation’ on page 44*, Fig. 12, pos. 4.
7. Open condensate shut-off valve at the customer’s.
8. Open shut-off valve for steam supply **slowly**, ↳ *Chapter 6.2 ‘Installation’ on page 44*, Fig. 12, pos. 6.
9. If necessary, adjust steam and suction valves ↳ *Chapter 6.3.1 ‘Setting instructions for the steam valve’ on page 48* und ↳ *Chapter 6.3.2 ‘Setting instructions for the suction valve (single-stage)’ on page 49*.
10. Set steam iron (option), ↳ *Chapter 6.3.3 ‘Setting of the steam iron’ on page 50*.

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.

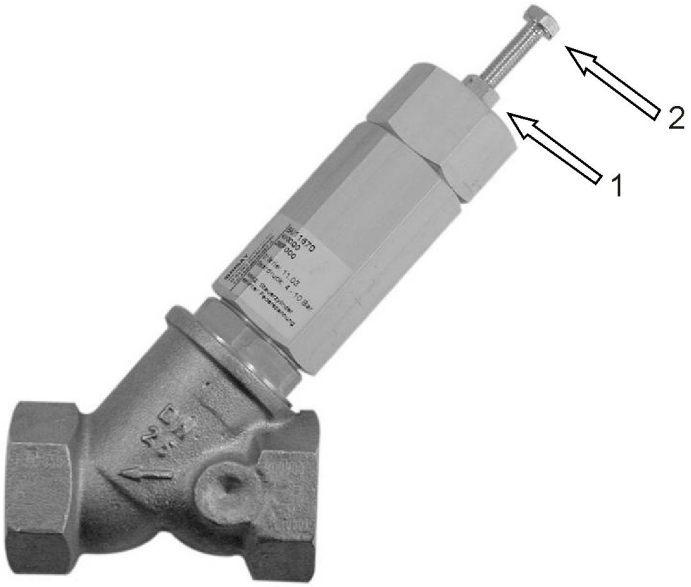


Fig. 14: Suction valve (single-stage)

1 Counter nut
2 Setting screw

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!

Risk of burns

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

– Do not touch any parts connected to steam and condensate.
– Do not touch the Teflon sole.

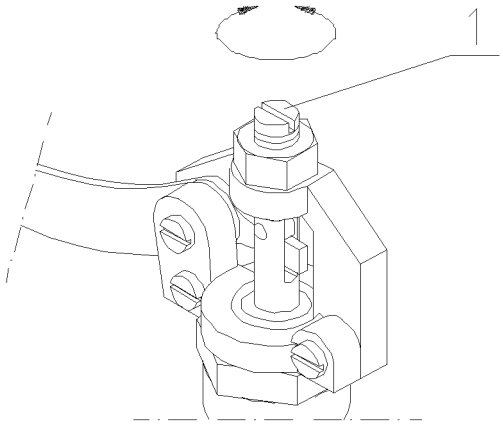


Fig. 15: Setting of the steam iron

1 Setting screw

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

1. To increase the steam volume, loosen the plastic nut on the top of the valve and turn the setting screw (item 1) anticlockwise.
2. Turning the setting screw (item 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 associated with the steam pressure setting function of the steam supply system.

7 Operation

7.1 Controls and indicators

Fig. 16: Controls and indicators

1	**Steam iron (option)** Steam supply is activated by manipulating the lever.
2	**Pedal strip** ↳ *Chapter 7.1.3 'Pedal strip' on page 55*
3	**Control panel with emergency stop button** ↳ *Chapter 7.1.2 'Control panel' on page 52*
4	**Switch cabinet** ↳ *Chapter 7.1.1 'Switch cabinet' on page 52* (not visible)

7.1.1 Switch cabinet

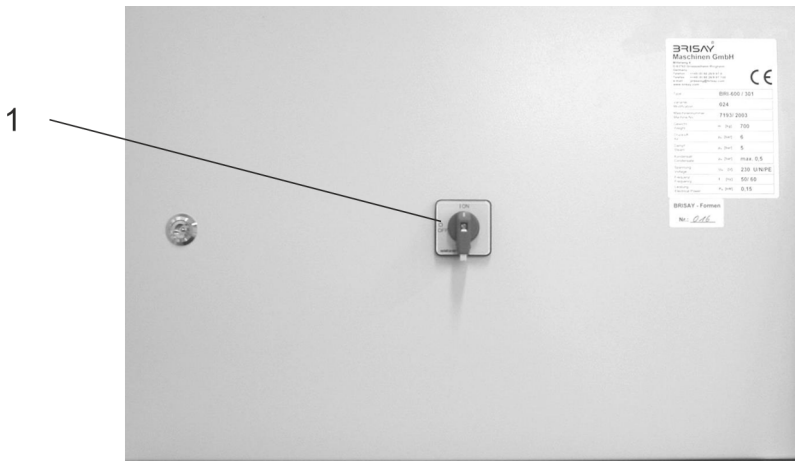


Fig. 17: Switch cabinet

1	**Main switch** *Chapter 3.3 'Built-in safety systems' on page 18.* The main switch disconnects/connects the machine from/to the power supply.

7.1.2 Control panel

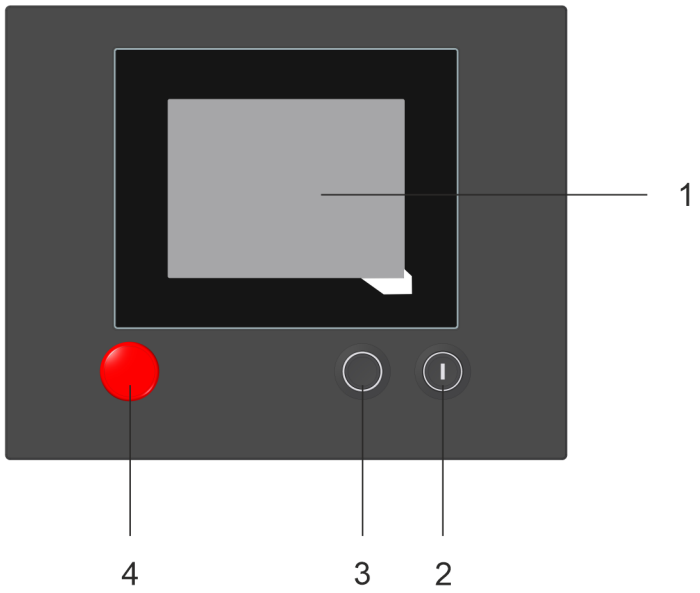


Fig. 18: Control panel

1 Touch panel
2 "Control system ON" button / "Machine ON" indicator
3 "Control system OFF" button / "Control voltage" indicator
4 Emergency stop button

NOTICE!
Do not use sharp objects when operating the touch panel in order not to damage it.

1	**Touch panel** *Chapter 7.1.2.1 'Touch panel' on page 53*
2	**"Control system ON" button / "Machine ON" indicator** Pressing the "control system ON" button switches the machine on. The indicator indicates the "Machine ON" state.
3	**"Control system OFF" button / "Control voltage" indicator** Pressing the "Machine OFF" button switches the machine off. The control voltage indicator is on.
4	**Emergency stop button** (mushroom-headed heavy-duty push-button) By pressing the emergency stop button, the following programme run is triggered: ■ the rear head buck is raised, ■ the sledge stops in its linear movement, ■ the front lower buck is lowered, ■ steam exhaust is switched off. The emergency stop button may be released by pulling it.

7.1.2.1 Touch panel

NOTICE!
The machine control system is described in separate operating instructions.

7.1.2.1.1 Function buttons

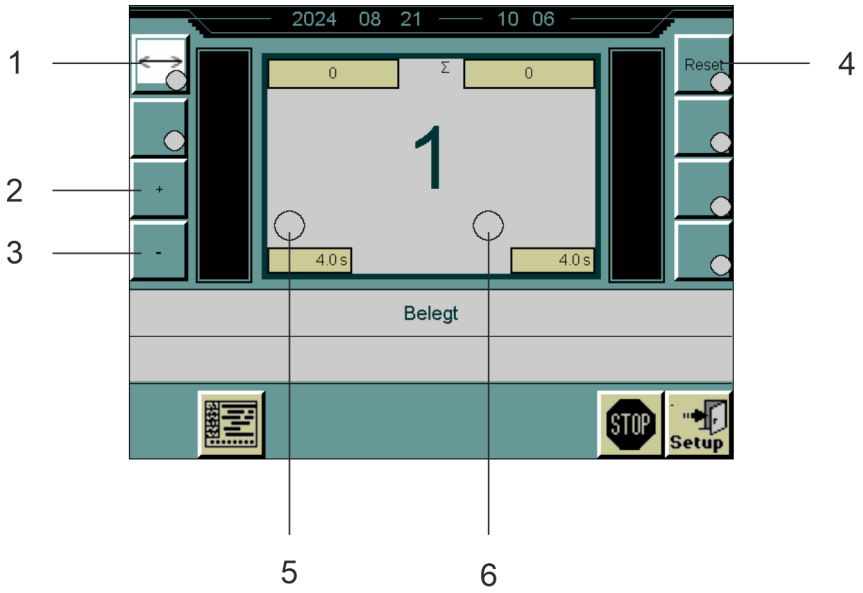


Fig. 19: Function buttons

	**1**	**Carriage forwards/backwards** Pressing the button moves the carriage forwards or backwards.
	**2**	**Program selection** Pressing the button browses the programs forwards numerically.
	**3**	**Program selection** Pressing the button browses the programs backwards numerically.
	**4**	**Reset** LED flashing: the carriage is not in its end position. Press the reset button until the carriage has moved to its end position.
	5	**Front suction** Indicator for front suction on/off
	6	**Rear suction** Indicator for rear suction on/off

7.1.3 Pedal strip

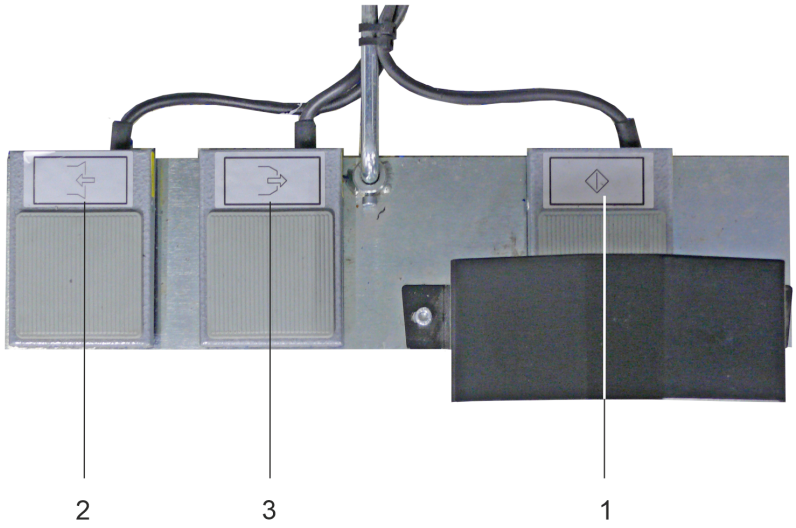


Fig. 20: Pedal strip

1 Start
2 Suction
3 Blowing

Tab. 12: Start

	By pressing the pedal, the operating cycle is started.

Tab. 13: 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. 14: Blowing lower buck (option, only with BRI-600/202)

	When pressing the pedal, the function "Blowing lower buck" is switched on manually and remains active as long as the pedal is pressed.

7.2 Setting up the machine

WARNING!
Setting up the machine must only be carried out by a **qualified person** (definition see chapter "Safety measures").

Do not forget that the risk of injury is increased during setting up the machine.

NOTICE!
The machine control system is described in separate operating instructions.

7.3 Starting the machine

	■ Switch on the main switch on the switch cabinet, ↳ *Chapter 7.1.1 'Switch cabinet' on page 52*.
	■ Release the emergency stop button by pulling it out, ↳ *Further information on page 52*, Pos. 4.
	■ Press the button "Control system ON", ↳ *Further information on page 52*, Pos. 2.
	■ Check safety devices, ↳ *Chapter 3.3 'Built-in safety systems' on page 18* .
	■ Use the touch button on the touchpanel to change to RUN mode.
	■ Die LED flashes - the sledge is not in the end position. Press the reset button until the machine has moved to end position.
 	■ Select the desired program or sequence program using the program selection button.

7.3.1 Emergency stop button was activated

The emergency stop button was activated. Start the machine as follows:

	■ Release the emergency stop button by pulling it out. ↳ *Further information on page 52*, Pos. 4
	■ Press the button "Control system ON". ↳ *Further information on page 52*, pos. 2
	■ Press the exit button on the control panel.
	■ Die LED flashes - the sledge is not in the end position. Press the reset button until the machine has moved to end position.

7.3.2 Safety frame was activated

The safety frame was activated, start the machine as follows:

	■ Press the button "Control system ON". ↳ *Further information on page 52*, pos. 2
	■ Press the exit button on the touchpanel.
	■ Die LED flashes - the sledge is not in the end position. Press the reset button until the machine has moved to end position.

7.4 Pressing in automatic mode

CAUTION!
Pay attention to the potential dangers indicated in Kapitel 4 when operating the machine.

- Place garment on lower buck and align it, if necessary by means of the positioning lights.
- Use steam iron to open side seams or chest darts if necessary.
- Press pedal (< 0.4 s) "Suction on". The garment is fixed on the lower buck by suction.
- Insert adhesive tapes and/or chest piece if necessary (only with BRI-600/101).

- Start operating cycle by pressing the pedal "Start".
- Remove garment from lower buck upon completion of the operating cycle.
- During the programme run, a garment may be placed on the second lower buck and the operating cycle may be started again.

7.5 Switching off the machine

- Switch off the main switch on the switch cabinet.
- Cut off the valve for the steam supply.
- Shut off the compressed air valves (machine control system and blowing).
- Remove any garment in between the upper buck and lower buck.

8 Maintenance

CAUTION!

Increased risk of injuries during maintenance

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

– 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.

8.1 Removing/installing the safety frame

For working on the upper buck(s), the safety frame can be removed/installed as shown in the following, if required:

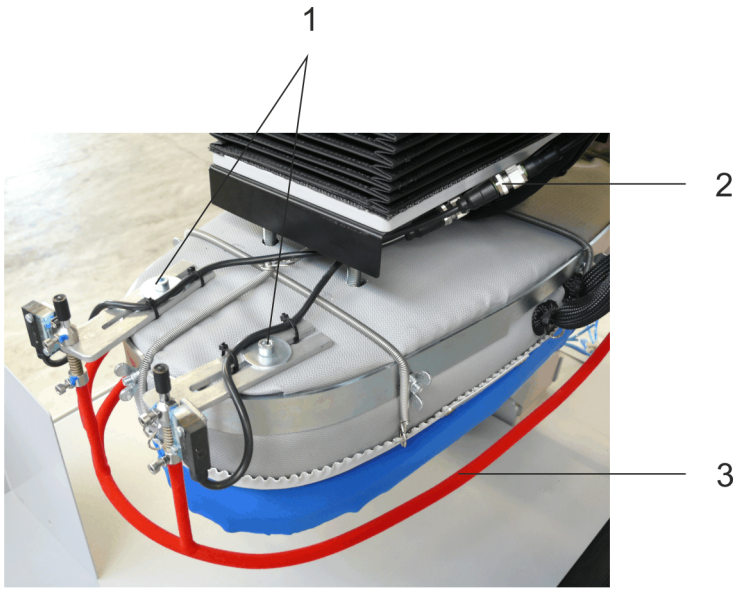


Fig. 21: Safety frame (example: BRI-235VC)

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!

Risk of loss of safety when changing the positions of the safety frame components

The positions of the switching cams, springs, and safety frame holders are preset and provided with a sealing wax. There is a risk of the loss of safety when changing the positions. As a result, there is a risk of crushing and a risk of burns.

– The positions of the switching cams, springs, and safety frame holders must not be changed.

Installation of safety frame

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

WARNING!

Function check of safety frame

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.

NOTICE!

Original cover material of VEIT GmbH

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.
- 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 buck number.

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!

Risk of burns on hot surfaces

Cut off the steam supply before changing the pressing covers. There is a risk of burns from the upper buck(s) and lower buck(s) as well as from all components connected to steam and condensate.

- 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.
- Make sure that the upper buck(s), lower buck(s) as well as all components connected to steam and condensate have cooled down.
- Wear protective gloves.

- Power supply and compressed-air supply remain switched on.
- Remove lateral guard plates and guard plate at back of machine.
- Remove safety frame and casing panels inside the machine.
- Remove rocker switch. Lock both safety switches into po-sition beforehand.
- Remove fastening strips and any worn cover material.

8.2.1 Changing cover of lower bucks

Fig. 22: Changing of pressing covers (lower buck)

1 Fastening strip
2 Hexagon socket screw

Bezugsaufbau

↳ Chapter 13.2 'Covermaterial' on page 105

Changing cover of sledge lower buck

1. If necessary, press function button to move sledge forwards.
2. Place 1st layer of new cover material in line with covering on lower buck.

3. Press function button. Sledge moves backwards.
4. Use supervisor function "Set single track" track 1 to select maximum pressure level (see separate manual C70).

5. Activate selected function. Head buck is lowered and closes.

If the travel of the closing movement is too small, place a silicone foam pad (possibly from head buck) on lower buck.

6. Use supervisor function "Set single track" track 1 to reset function. Head buck is raised.

7. Press function button. Sledge moves forwards.
8. Place 2nd layer of new cover material in line with covering on lower buck.
9. Repeat item *↳ Procedure step 3 on page 63* to *↳ Procedure step 7 on page 63*.
10. Place remaining layers of new cover material in line with covering on lower buck.
11. Stretch pressing cover with fastening strip (pos. 1) and tighten hexagon socket screws (Pos. 2), (siehe Fig. 22).

Changing cover of front lower buck

12. If necessary, press function button to move sledge backwards.
13. Place 1st layer of new cover material in line with covering on lower buck.

14. Press function button. Sledge moves forwards.
15. Use supervisor function "Set single track" track 1 to select maximum pressure level (see separate manual C70).

16. Activate selected function. Lower buck is raised and closes.

17. Use supervisor function "Set single track" track 1 to reset function. Lower buck is lowered.

18. Activate selected function. Sledge moves backwards.
19. Place 2nd layer of new cover material in line with covering on lower buck.
20. Repeat item *Procedure step 14 on page 63* to *Procedure step 18 on page 64*.
21. Place remaining layers of new cover material in line with covering on lower buck.
22. Stretch pressing cover with fastening strip (pos. 1) and tighten hexagon socket screws (pos. 2), (see Fig. 22).

NOTICE!

Pay attention to the position of the cover seams

Make sure that the cover seams are not on the pressing surface. Otherwise, marks will appear on the garment.

8.2.2 Changing cover of head bucks (BRI-600/101)

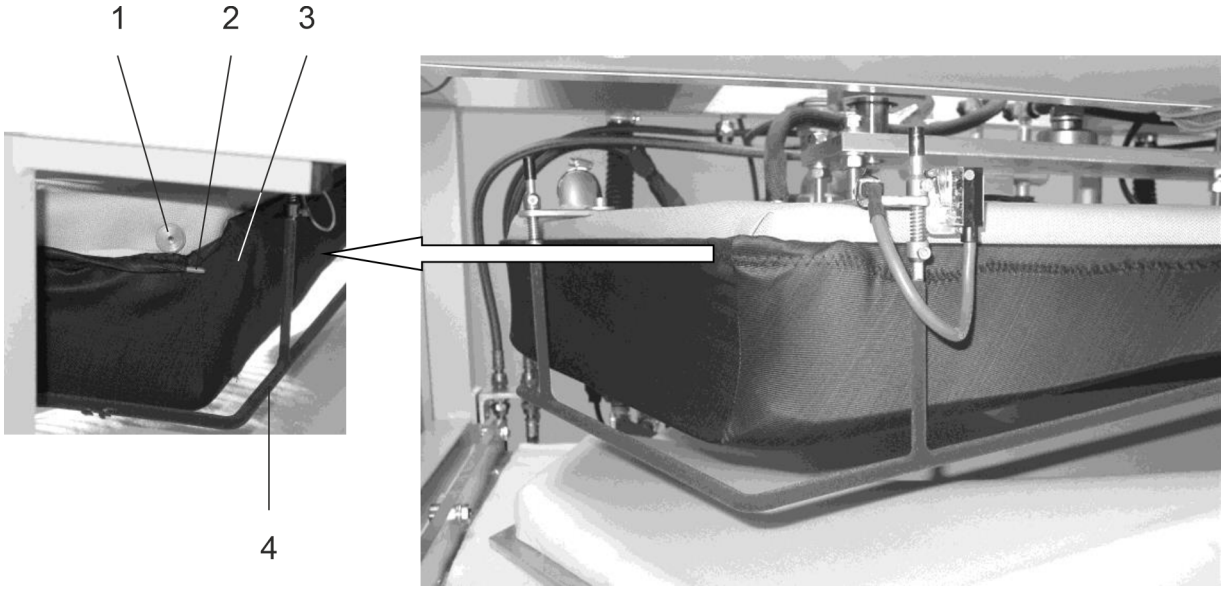


Fig. 23: Changing of pressing covers (head buck BRI-600/101)

1 Knurled nuts
2 Round steel
3 Teflon fabric
4 Safety frame

Bezugsaufbau

Chapter 13.2 'Covermaterial' on page 105

Changing cover of rear head buck

1. If necessary, press function button to move sledge forwards.
2. Place new cover material in line with covering on sledge lower buck.

3. Press function button. Sledge moves backwards.
4. Use supervisor function "Set single track" track 1 to select maximum pressure level (see separate manual C70).

5. Activate selected function. Rear head buck is lowered and closes.
6. Remove cleaning doors to change covers of head buck.
7. **see, Fig. 23**

   Slide round steel (pos. 2) into Teflon fabric (pos. 3). Use round steel to fasten Teflon fabric to knurled nuts (pos. 1).

NOTICE!
Make sure that the cover is not folded. Otherwise, marks will appear on the garment.

8. Mount safety frame, Fig. 23, Pos. 4, and all casing panels inside the machine.
9. Mount both cleaning doors.

10. Use supervisor function "Set single track" track 1 to reset function. Head buck is raised.

Changing cover of seldge head buck

11. Place new pressing cover in line with covering on front lower buck.
12. Press function button. Sledge moves forwards.
13. Use supervisor function "Set single track" track 1 to select maximum pressure level ((see separate manual C70).

14. Activate selected function. Front head buck is raised and closes

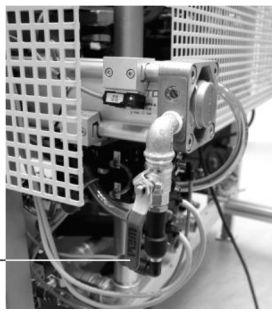


Fig. 24: Shut-off valve

5 Shut-off valve

15. **WARNING!**
Sperren Sie unbedingt die Zuluft zum Schlittenzylinder über das Absperrventil (Pos. 5) ab.

16. **see Fig. 23**

Slide round steel (pos. 2) into Teflon fabric (pos. 3). Use round steel to fasten Teflon fabric to knurled nuts (pos. 1).

NOTICE!
Make sure that the cover is not folded. Otherwise, marks will appear on the garment.

17. Use supervisor function "Set single track" track 1 to reset function. Front head buck is lowered.

18. Mount rocker switches and remove fixations from both safety switches.

19. Open shut-off valve (Pos. 5).

20. Mount lateral guard plates and guard plate at back of machine.

WARNING!
Function check of safety frame
Before commissioning the machine, check the safety frame for proper function.

–

8.2.3 Changing cover of head bucks (BRI-600/202)

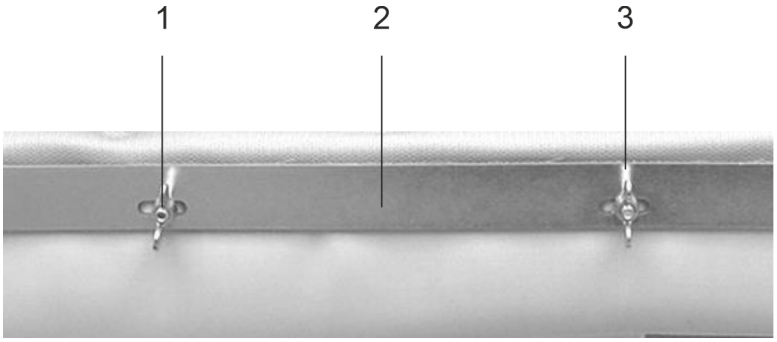


Fig. 25: Changing of pressing covers (head buck BRI-600/202)

1 Threaded bolts
2 Fastening strips
3 Butterfly nuts

Bezugsaufbau

Chapter 13.2 'Covermaterial' on page 105

Changing cover of rear head buck

1. If necessary, press function button to move sledge forwards.
2. Place new cover material in line with covering on sledge lower buck.

3. Press function button. Sledge moves backwards.
4. Use supervisor function "Set single track" track 1 to select maximum pressure level (see separate manual C70).

5. Activate selected function. Front head buck is raised and closes.
6. Remove cleaning doors to change covers of head buck.
7. **see Fig. 25**

   Fasten pressing cover to threaded bolts, (pos. 1). Cut off overlapping cover material and make cuts into its ends. Fasten pressing cover with fastening strips (pos. 2). Tighten butterfly nuts (pos. 3).

NOTICE!

Make sure that the cover is not folded. Otherwise, marks will appear on the garment.

8. Mount safety frame, Fig. 23, Pos. 4, all casing panels inside the machine.
9. Mount both cleaning doors.

10. Use supervisor function "Set single track" track 1 to reset function. Head buck is raised.

Changing cover of sledge head buck

11. Place new pressing cover in line with covering on front lower buck.
12. Press function button. Sledge moves forwards.
13. Use supervisor function "Set single track" track 1 to select maximum pressure level (see separate manual C70).

14. Activate selected function. Front head buck is raised and closes.

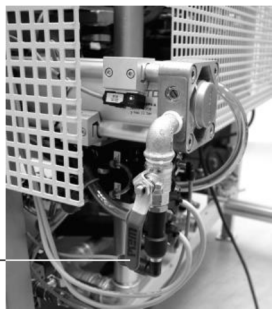


Fig. 26: Shut-off valve

5 Shut-off valve

15. **WARNING!**
Make sure to cut off incoming air to sledge cylinder with shut-off valve (pos. 5).

16. **see Fig. 25**

Fasten pressing cover to threaded bolts (pos. 1). Cut off overlapping cover material and make cuts into its ends. Fasten pressing cover with fastening strips (pos. 2). Tight-en butterfly nuts (pos. 3).

NOTICE!
Make sure that the cover is not folded. Otherwise, marks will appear on the garment.

17. Use supervisor function "Set single track" track 1 to reset function. Front head buck is lowered.

18. Mount rocker switches and remove fixations from both safety switches.

19. Open shut-off valve (pos. 5).

20. Mount lateral guard plates and guard plate at back of machine.

WARNING!
Function check of safety frame
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 skilled personnel only. Maintenance, cleaning and repair work must only be carried out by skilled 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, 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 EN 60204.

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).

WARNING!

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

WARNING!

Risk of burns

There is a risk of burns from the pressing bucks as well as from all components connected to steam and condensate.

– Make sure that the pressing bucks as well as all parts connected to steam and condensate have cooled down.
– Wear personal protective equipment.

CAUTION!

Shutdown procedure

Before starting cleaning, maintenance or repair work (by skilled personnel only), the shutdown procedure must be observed. Disregarding these procedures presents a risk of death or injury of the personnel.

– For the shutdown procedure, please refer to *Chapter 4.4 'Shutdown procedures' on page 33*.

CAUTION!

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. Otherwise, there is a risk of falling down.

– Use ladders that meet the required safety standards.

» Continued on the next page

- Use working platforms that meet the required safety standards.
- Do not mount on any components of the machine.
- Wear a safety harness 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.

9.1 Cleaning

Use a lint-free cloth to remove oil and grease from the machine at regular intervals, in particular before carrying out maintenance and repair work.

CAUTION!

For cleaning, **do not use the following**:

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

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

9.2 Maintenance and inspection table

Tab. 15: 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 Replace dirty air filter **once a year**.
	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.
	Cylinder		
	Steam valves		
	Suction valves		
	Hoses and screw connections		
	Bucks		
	All safety switches of the safety frame	Function check for ■ Mechanical damage ■ Mechanical function ■ Smooth serviceability	Check and replace, if necessary. When pressing the safety switch, the machine is switched off and moves to a safe position (upper buck moves up).
	Guiding unit of rear upper buck and front lower buck	Visual inspection for abrasion	If irregularities occur in the guiding system, the VEIT service department must be informed.
	Linear travelling frame of carriage		

9.3 Lubrication

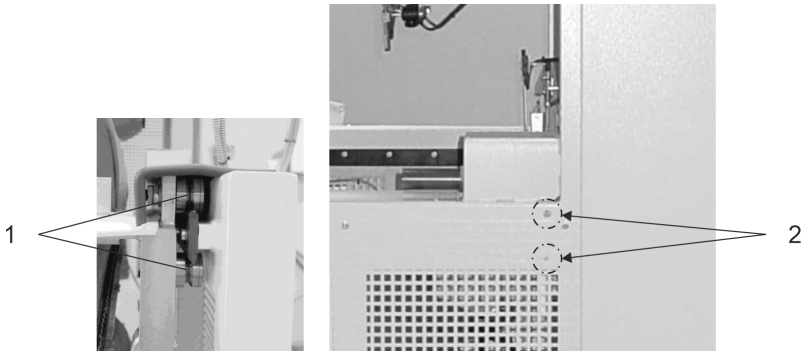


Fig. 27: Lubrication points

1 Roller bearings
2 Drill holes of lubrication points

Tab. 16: Maintenance schedule for bearing unit

Interval	Part to be inspected	Work to be carried out	Remarks
500 hrs	Roller bearings (item 1)	Lubrication via lubrication nipples (1 stroke)	Only use grease types recommended by VEIT. Grease type KC00147 Grease gun with extension BO00434

Tab. 17: 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

CAUTION!
Regrease lubrication points
Regrease the lubrication points at regular intervals.

- Observe the interval in the maintenance schedule for the bearing unit, *Tab. 16 'Maintenance schedule for bearing unit' on page 73*
- Observe the safety data sheets for the lubricants used.
- Wear personal protective equipment, if necessary.

NOTICE!

Regrease lubrication points

Regrease the lubrication points at regular intervals.

- Observe the interval in the maintenance schedule for the bearing unit, *Tab. 16 'Maintenance schedule for bearing unit' on page 73*
- Remove any remaining lubricant.
- Lubricate the machine only if it has been switched off.
- Use lubricants recommended by VEIT.

To lubricate roller bearings, proceed as follows:

1. Make sure to perform a shutdown procedure.

CAUTION!

Shutdown procedure

Before starting cleaning, maintenance or repair work (by skilled personnel only), the shutdown procedure must be observed. Disregarding these procedures presents a risk of death or injury of the personnel.

- For the shutdown procedure, please refer to *Chapter 4.4 'Shutdown procedures' on page 33*.

2. Move the carriage so that lubrication nipples of roller bearings are located behind the drill holes (item 2).
3. Lubricate all roller bearings one after the other (item 1).

9.4 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
- Reattach the casing following maintenance/setting.
- 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.

10.1 Alarm messages on the display

NOTICE!
If faults occur, the following alarm messages are displayed.

NOTICE!
The machine control system is described in separate operating instructions.

Alarm message	Cause	Remedy
Module X defective / missing!	Module X defective	Replace module X
	Module X incorrectly plugged in	Plug in module X correctly
Module X defective / missing! + Node / bus defective / missing	Bus controller or cable defective or connection to panel interrupted	Replace bus controller, check cable, replace if necessary
Module X defective / missing! + Control voltage side X	Bus controller or cable defective or connection to panel interrupted	Replace bus controller, check cable, replace if necessary
Node / bus defective / missing	Bus controller or cable defective or connection to panel interrupted	Replace bus controller, check cable, replace if necessary
Error programme parameter side X	Programme without programmed steps	Edit programme or load existing programme
No VEIT power panel!	No original machine control system in use	Use original machine control system
Error programme administration!	General error of programme administration	Confirm message. If error message is displayed again, contact VEIT.

10.2 Fault, cause, remedy

CAUTION!
The facts and information listed as **faults** in this chapter are described in such a way that they can be eliminated by an **instructed person**. If a fault cannot be remedied, a **skilled person** must be informed.

Fault	Cause	Remedy
No function on the machine	Main switch switched off	Switch on the main switch
	Emergency-stop button pressed	Release the emergency-stop button.
	Machine control system set to switch-on mode	Use the START touch button to change to RUN mode.
	Carriage is not in its end position	Press the reset button until the carriage has moved to its end position.

10.3 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.

Defect	Cause	Remedy
No function on the machine	No mains voltage available	Establish the mains connection and check.
	Electrical supply line not connected properly	Check the assignment and the connection.
	Emergency-stop button S0 defective	Check and replace, if necessary.
	Safety relay K1 defective	Check and replace, if necessary.
	Fuse F1 or F3 was triggered	Replace the fuse.

Defect	Cause	Remedy
	No compressed air available	Connect the compressed air supply.
	“Control system ON” button S1 defective	Check and replace, if necessary.
	Transformer 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.
	Carriage is not in its end position	Press the reset button until the carriage has moved to its end position.
No suction function on lower bucks	No negative pressure available	Check suction function provided by the customer.
	Suction valve Z4 (lower buck on carriage), Z5 (front lower buck) defective	Check and replace sealing or entire valve, if necessary.
	5/2-way valve Y25 (lower buck on carriage), Y13 (front lower buck) defective	Check and replace, if necessary.
	Pedal S10 defective	Check and replace, if necessary.
No program start	Proximity switch S12 or S14 defective	Check, reposition if necessary, or replace
	Empty program position selected	Correct the program selection.
	Machine control system defective	Check and replace, if necessary.
	Carriage is not in its end position	Press the reset button until the carriage has moved to its end position.
Carriage does not move forwards/backwards	Cylinder Z1 leaking or defective	Check for leaks and replace, if necessary.
	Proximity switch S16 or S18 defective	Check and replace, if necessary.
	5/2-way valves Y5, Y6, Y30 defective	Check and replace, if necessary.
	Carriage is not in its end position	Press the reset button until the carriage has moved to its end position.
Carriage buck does not move forwards and backwards correctly	Insufficient compressed air supply	Check the compressed air supply provided by the customer.
	Cylinder Z1 leaking	Check for leaks and replace, if necessary.
	Pressure regulator V2 set incorrectly	Check and set again or replace, if necessary.

Defect	Cause	Remedy
	End position damping set incorrectly	Readjust end position on cylinder Z1
	Shock absorber defective	Check and replace, if necessary.
	5/2-way valves Y5, Y6, Y30 defective	Check and replace, if necessary.
	Proximity switches S13, S15 set incorrectly or defective	Check and set again or replace, if necessary.
Rear upper buck does not move down/up	Cylinder Z2 leaking	Check for leaks and replace, if necessary.
	Stop valves Y19.1, Y19.2 defective	Check and replace, if necessary.
	5/2-way valves Y19, Y20, Y21, Y22 defective	Check and replace, if necessary.
	Proximity switch S14 defective	Check and replace, if necessary.
	Pressure regulator V5 set incorrectly	Check and set again or replace, if necessary.
Rear upper buck does not move up/down correctly	Insufficient compressed air supply	Check the compressed air supply provided by the customer.
	Cylinder Z2 leaking	Check for leaks and replace, if necessary.
	Throttle valve V13 set incorrectly	Check and set again or replace, if necessary.
	Pressure regulator V5 set incorrectly	Check and set again or replace, if necessary.
Rear upper buck does not open with a distance	Proximity switch S19 defective	Check and replace, if necessary.
	Throttle valve V4 set incorrectly	Check and set again or replace, if necessary.
Front lower buck does not move up/down	Cylinder Z3 leaking	Check for leaks and replace, if necessary.
	Stop valves Y7.1, Y7.2 defective	Check and replace, if necessary.
	5/2-way valves Y7, Y8, Y9, Y10, Y11 defective	Check and replace, if necessary.
	Proximity switch S12 defective	Check and replace, if necessary.
	Pressure regulator V6 is set incorrectly	Check and set again or replace, if necessary.
Front lower buck does not move up/down correctly	Insufficient compressed air supply	Check the compressed air supply provided by the customer.
	Cylinder Z3 leaking	Check for leaks and replace, if necessary.

Defect	Cause	Remedy
	Throttle valve V14 set incorrectly	Check and set again or replace, if necessary.
	Pressure regulator V6 is set incorrectly	Check and set again or replace, if necessary.
Front lower buck does not move open with a distance	Proximity switch S17 defective	Check and replace, if necessary.
	Throttle valve D3 set incorrectly	Check and set again or replace, if necessary.
No steam for rear upper buck	No steam or not enough steam available	Check the steam supply provided by the customer.
	Steam valves Y1, Y1.1 set incorrectly or defective	Check and set again or replace, if necessary.
	Relay K2 defective	Check and replace, if necessary.
No steam for upper buck on carriage	No steam or not enough steam available	Check the steam supply provided by the customer.
	Steam valves Y2, Y2.1 set incorrectly or defective	Check and set again or replace, if necessary.
	Relay K3 defective	Check and replace, if necessary.
No steam for lower buck on carriage	No steam or not enough steam available	Check the steam supply provided by the customer.
	Steam valves Y3, Y3.1 set incorrectly or defective	Check and set again or replace, if necessary.
	Relay K4 defective	Check and replace, if necessary.
No steam for front lower buck	No steam or not enough steam available	Check the steam supply provided by the customer.
	Steam valves Y4, Y4.1 set incorrectly or defective	Check and set again or replace, if necessary.
	Relay K5 defective	Check and replace, if necessary.
No suction function for rear upper buck (BRI-600/202 only)	No negative pressure available	Check suction function provided by the customer.
	Suction valve Z8 defective	Check and replace sealing or entire valve, if necessary.
	5/2-way valve Y26 defective	Check and replace, if necessary.
No suction function for upper buck on carriage (BRI-600/202 only)	No negative pressure available	Check suction function provided by the customer.
	Suction valve Z9 defective	Check and replace sealing or entire valve, if necessary.
	5/2-way valve Y14 defective	Check and replace, if necessary.
No aeration function for rear upper buck (option)	Aeration valve Z10 or wire fabrics dirty	Check and replace sealing or entire valve, if necessary, or clean fabrics.

Defect	Cause	Remedy
	5/2-way valve Y29 defective	Check and replace, if necessary.
No aeration function for upper buck on carriage (option)	Aeration valve Z11 defective or fabrics dirty	Check and replace sealing or entire valve, if necessary, or clean fabrics.
	5/2-way valve Y17 defective	Check and replace, if necessary.
No edge suction function for rear upper buck	No negative pressure available	Check suction function provided by the customer.
	Suction valve Z6 defective	Check and replace sealing or entire valve, if necessary.
	5/2-way valve Y27 defective	Check and replace, if necessary.
No edge suction function for upper buck on carriage	No negative pressure available	Check suction function provided by the customer.
	Suction valve Z7 defective	Check and replace sealing or entire valve, if necessary.
	5/2-way valve Y15 defective	Check and replace, if necessary.
No blowing function for lower buck on carriage	2/2-way valve Y28 defective	Check and replace, if necessary.
No blowing function for front lower buck	2/2-way valve Y16 defective	Check and replace, if necessary.

10.4 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

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 on the control panel
- Actuate the rocker switch at the front of the machine
- Activate the safety frame
- Switch off the main switch on the switch cabinet
- Unplug the mains connector

The following procedure is triggered:

- The rear upper buck moves up
- The carriage stops its linear movement
- The front lower buck moves down
- Escape of steam 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

CAUTION!

Risk of injury during disassembly and disposal

Tasks associated with disassembly and disposal may only be carried out by skilled personnel to avoid injuries. It is required to wear personal protective equipment.

- Tasks may only be carried out by skilled personnel.
- Wear personal protective equipment
  - Protective gloves
  - Safety shoes
  - Safety goggles

The machine is mainly built of steel (apart from the electrical equipment) and must be disposed of in accordance with applicable local environmental regulations.

Oil and cleaning agents must also be disposed of in accordance with the local regulations.

Residues must be disposed of in accordance with the instructions provided by the 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
- Serial 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

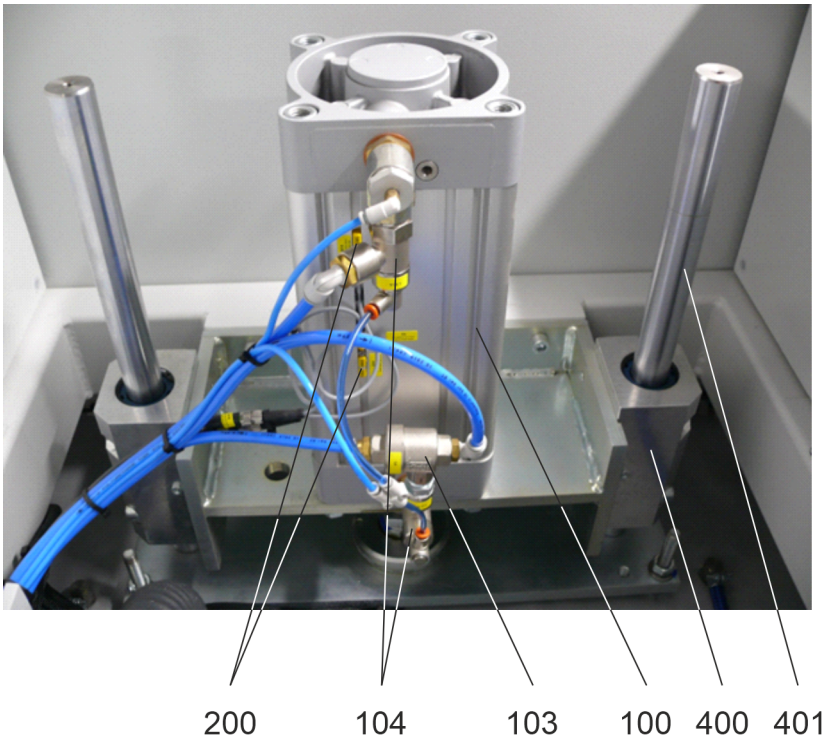


Fig. 28: Guiding unit for rear upper buck

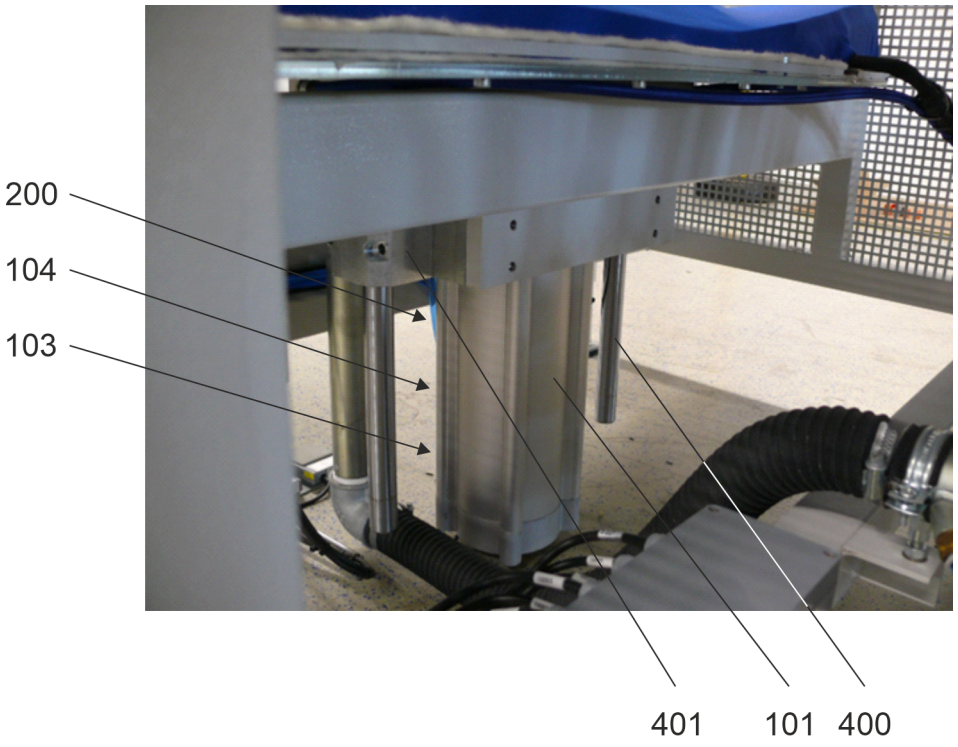


Fig. 29: Guiding unit for front lower buck

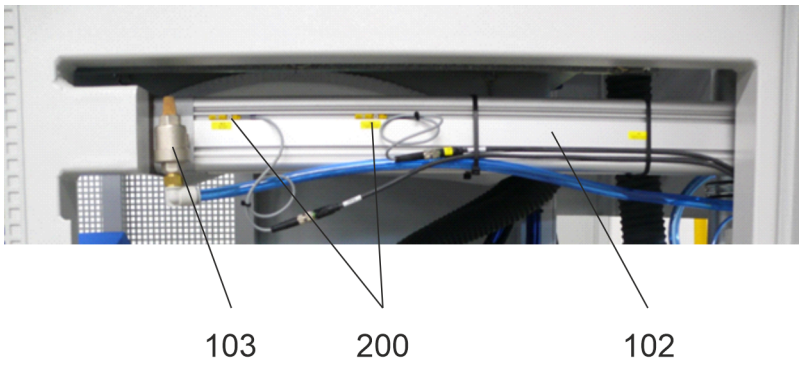


Fig. 30: Cylinder, carriage forwards/backwards

Fig. 31: Self-aligning rod coupler

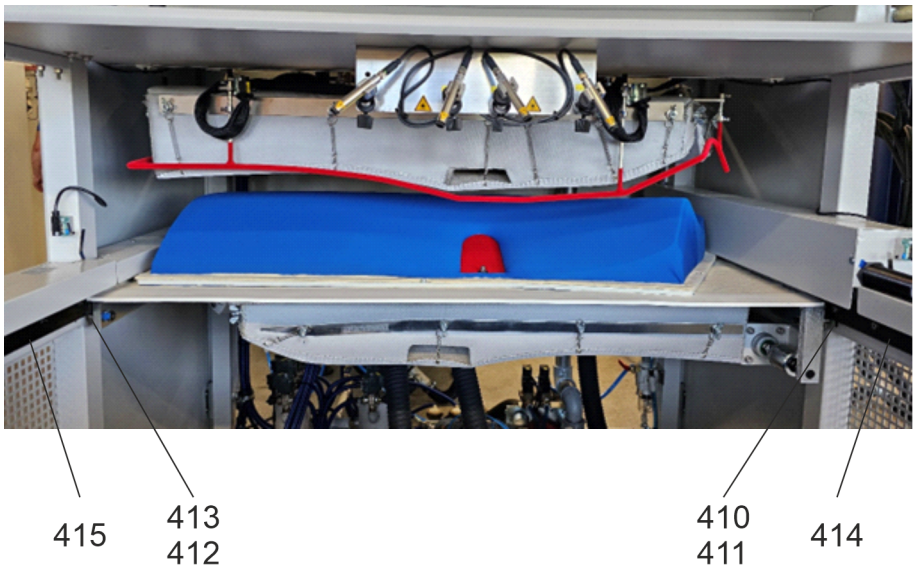


Fig. 32: Linear travelling frame

Fig. 33: Shock absorber

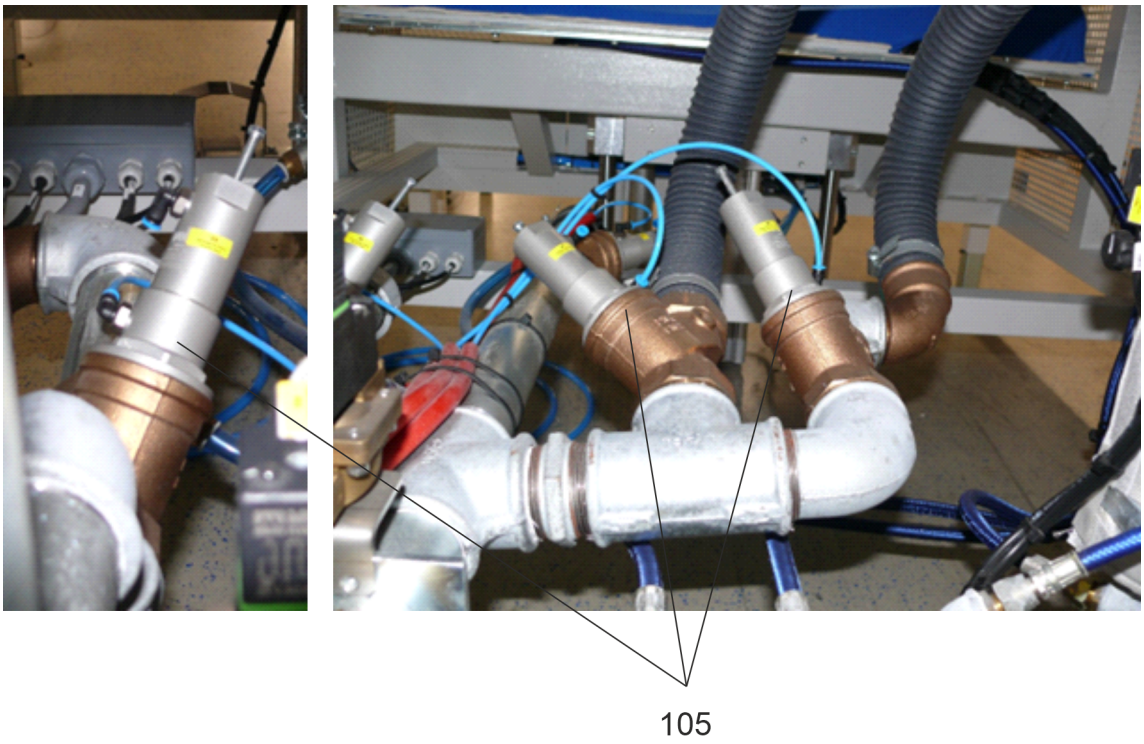


Fig. 34: Suction valve

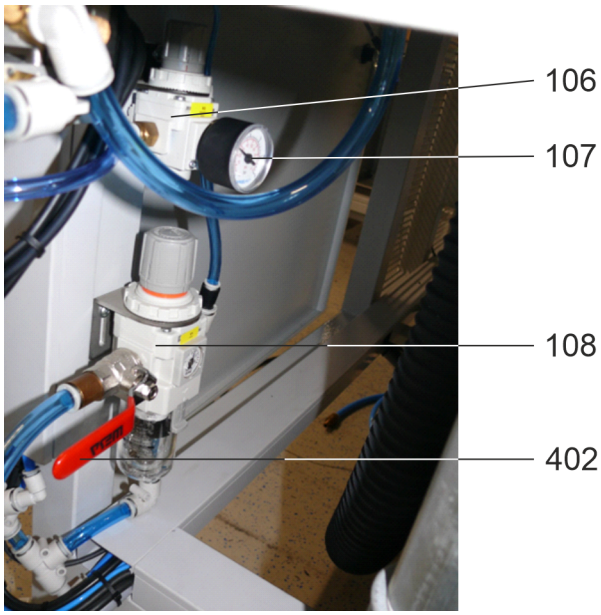


Fig. 35: Maintenance unit

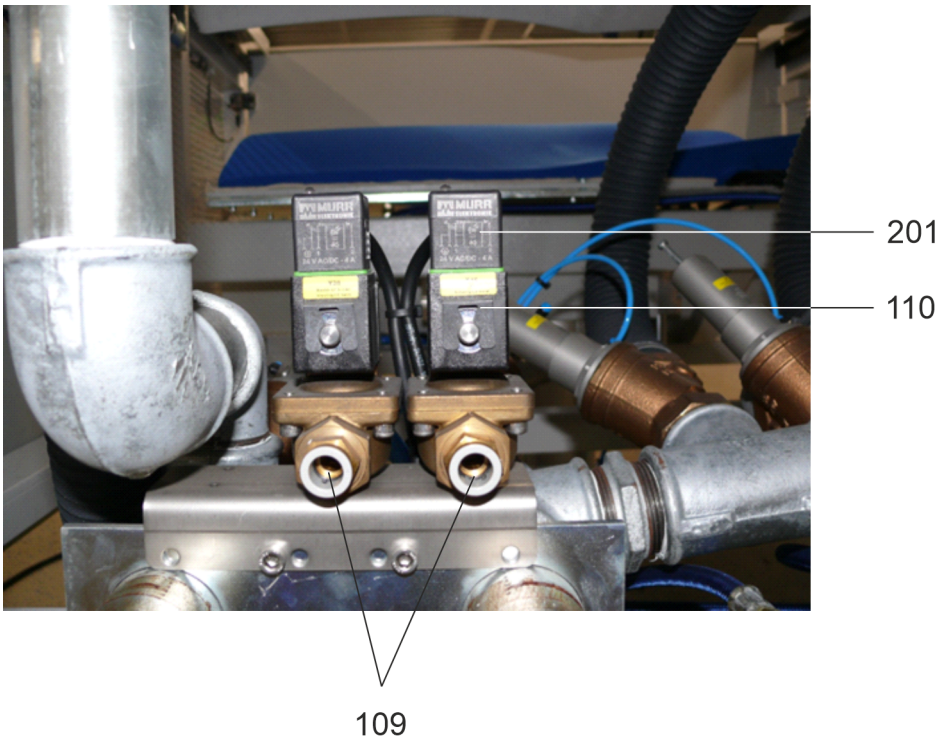


Fig. 36: Blowing valve

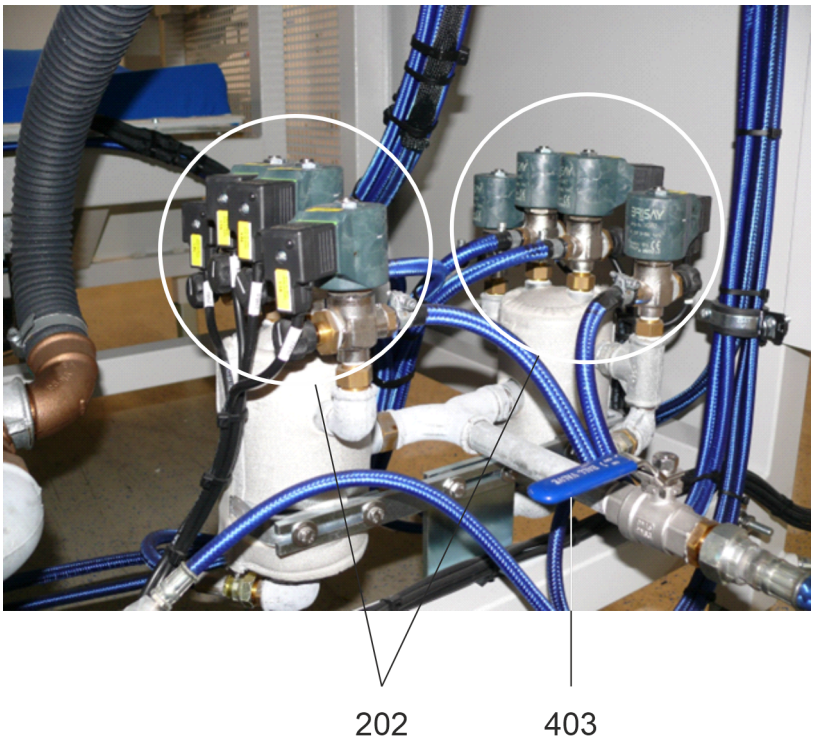


Fig. 37: Steam valve

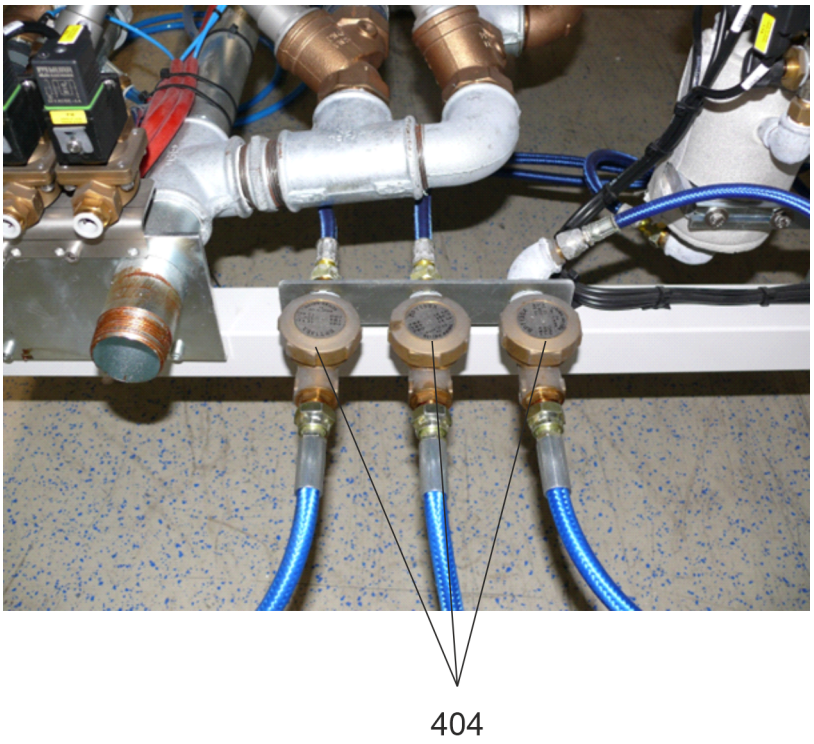


Fig. 38: Condensate drain

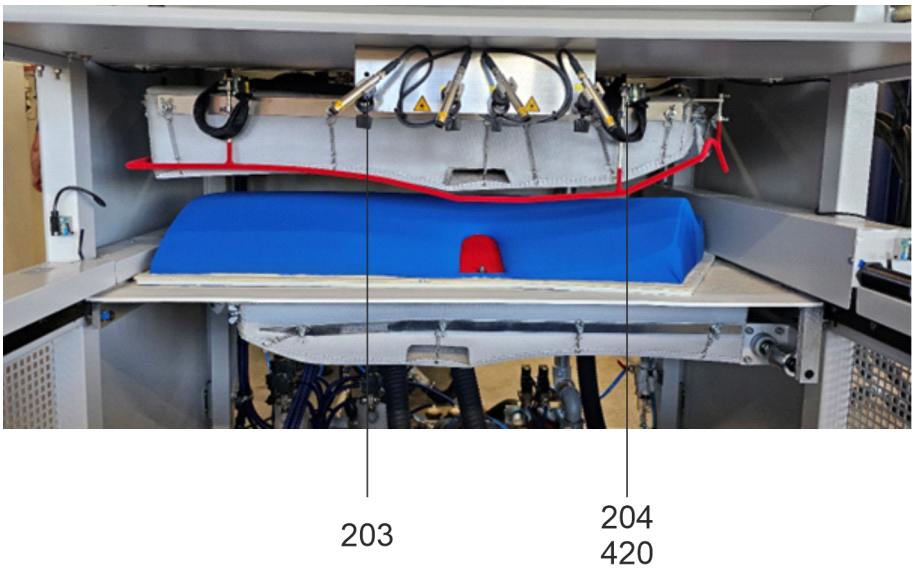


Fig. 39: Laser/safety switch

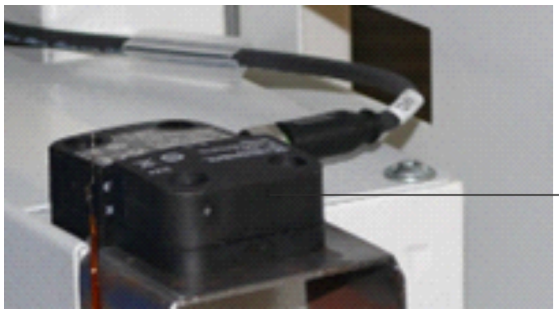


Fig. 40: Safety switch

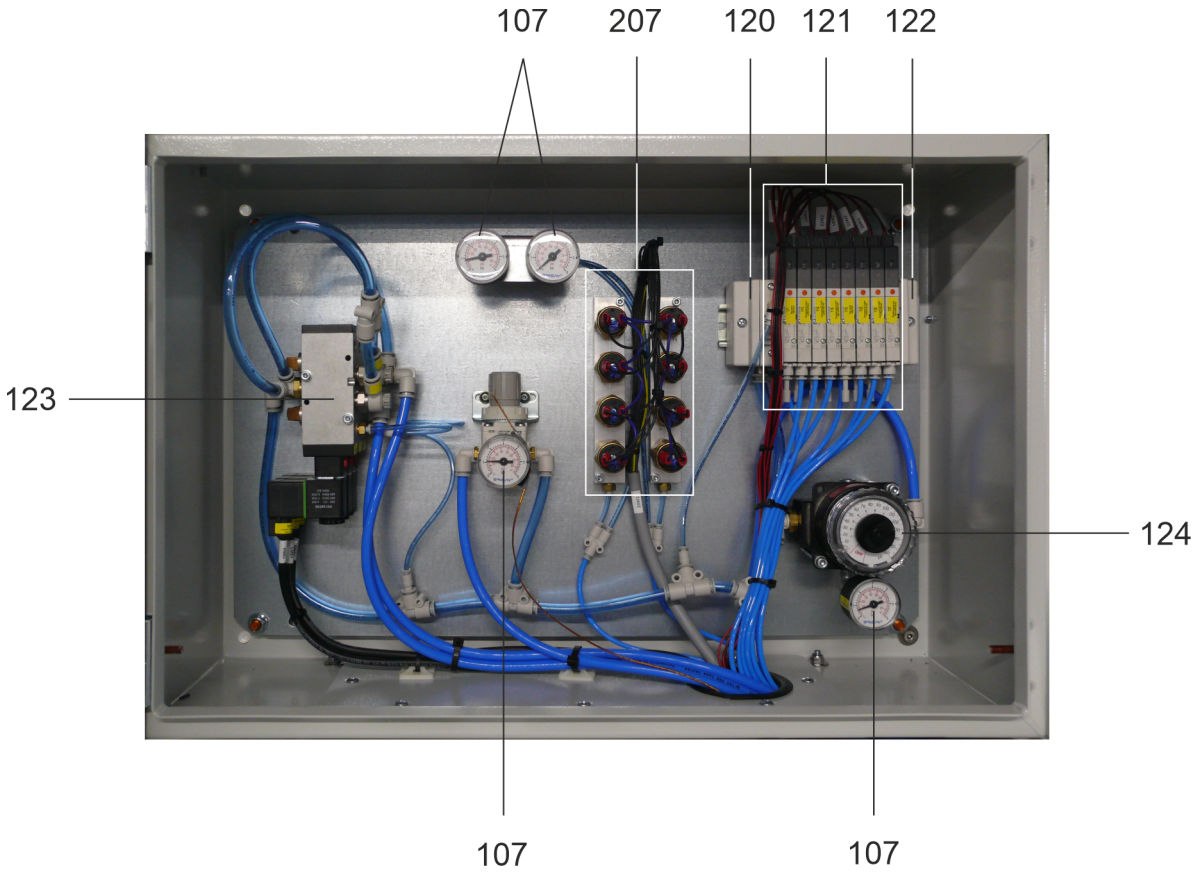


Fig. 41: Pneumatics

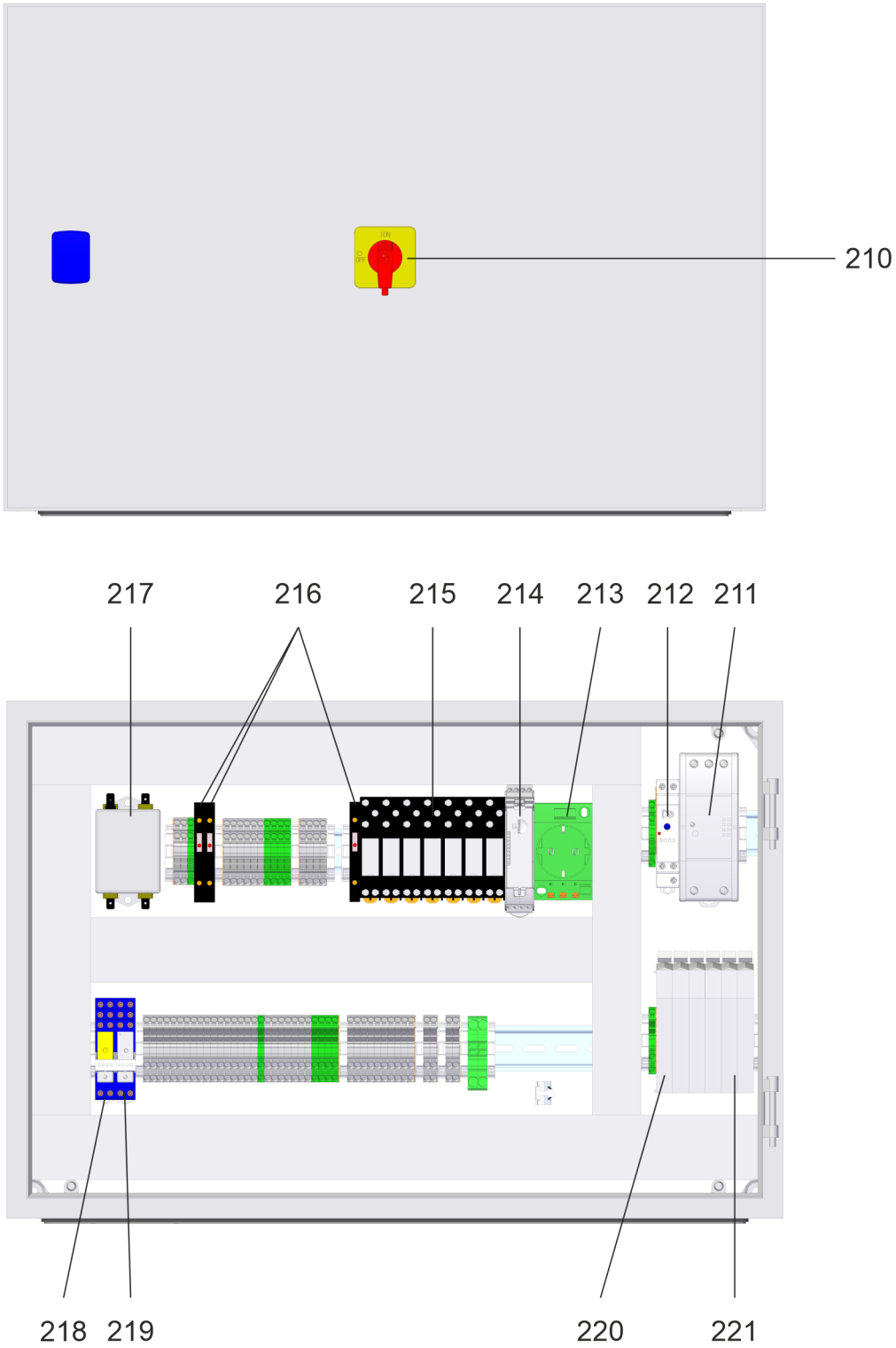


Fig. 42: Switch cabinet

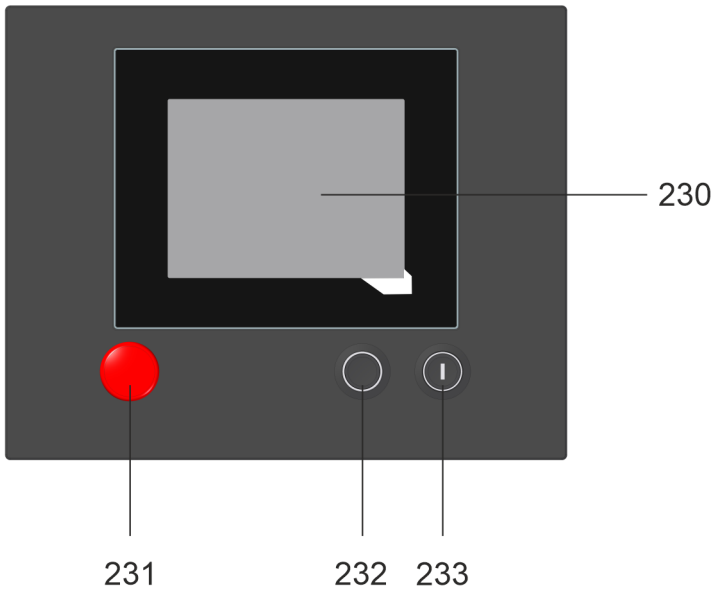


Fig. 43: Control panel

Equipment identification
(*) Equipment identification

Tab. 18: Spare parts, pneumatics

Item	Article number	Designation	EID (*)
100	138368	DSBC 125-160 PPV-A-N3 #1755348	Z2
	138436	WEAR PARTS SET DSBC-125	
101	138358	DSBC 125-300-F-PPVA-N3 1722457	Z3
	138436	WEAR PARTS SET DSBC-125	
102	138396	DSBC 63-750 PPV-A-N3 #1463483	Z1
	138433	WEAR PARTS SET DSBC-63	
103	KV09684	QUICK EXHAUST VALVE VSR -1/4”	
104	KV00501	STOP VALVE 3/8”	
105	172620	Suction valve 1 1/2”, single-stage	Z4, Z5, Z6, Z7, Z8, Z9, Z10, Z11
	172621	Suction valve insert 1 1/2”	
106	KU02003	AR20-F01 H-1 0.5-2(3)BAR	V2, V10, V11
107	KU00004	PRESSURE GAUGE 0-6 BAR G1/8” d = 40 mm	

Item	Article number	Designation	EID (*)
108	154435	Filter regulator AW30-F02EH-B / 01	A3
	KU10003	AF30P060S filter element AW-30	
109	KV09603	Solenoid valve	Y16, Y28
	KD12679	MEMBRANE MX-2-3/8”+ MN1H-2-3/8”	
110	KV12306	MSN1G-24-OD NO. 123060	
111	KZ06142	FK-M 16 x 1.5 NO. 6142	Z1
120	KV00672	SSQ1000-3A-4 END PLATE LEFT	
121	107529	5/2-way valve	Y7, Y13, Y15, Y17, Y19, Y25, Y27, Y29
	KV00632	Cable with connector	
122	KV00673	SSQ1000-2A-4 END PLATE RIGHT	
123	112012	5/2-WAY VALVE - 1/4” with SP. 24 V DC	Y5, Y6, Y8, Y9, Y10, Y11Y20, Y21, Y22, Y30
	KE01260	CABLE CONNECTOR with DIODE + LED + 3 m, KL	
124	KU00007	PRESSURE CONTROL VALVE 6 BAR G 1/4	
	KU02501	MOUNTING BRACKET FOR PRESSURE REDUCER, LARGE / B 220	
	KA00005	KQL 08-01 S / MALE STUD ELBOW COUPLING1/8” (i/o)	
	KA00010	KQH 08-01 S / PLUG-IN SCREW CONNECTION 1/8”-PU 6 MS	
	KA00020	KQT 08-00 / PLUG-IN SCREW CONNECTION T-PU 6	
	KA00025	KQS 04-M5 / STRAIGHT MALE STUD COUPLING M5-PE4/2	
	KA00030	KQH 04-01 S / STRAIGHT MALE STUD COUPLING 1/8”-PE4/2	
	KA00035	KQH 08-02 S / STRAIGHT MALE STUD COUPLING 1/4”-PE8/6	
	KA00045	KQL 04-M5 / ELBOW MALE STUD COUPLING M5-PE 4/2	
	KA00050	KQL 04-01 S / ELBOW MALE STUD COUPLING 1/8”-PE 4/2	
	KA00055	KQL 08-02 S / ELBOW MALE STUD COUPLING 1/4”-PE8/6	
	KA00060	KQL 08-03 S / ELBOW MALE STUD COUPLING 3/8”-PE8/6	

Item	Article number	Designation	EID (*)
	KA00065	KQT 04-M5 / T MALE STUD COUPLING M5 - PE 4/2	
	KA00075	KQT 08-01 S / T MALE STUD COUPLING 1/8” - PE 8/6	
	KA00080	KQT 08-02 S / T MALE STUD COUPLING 1/4” - PE 8/6	
	KA00090	KQT 04-00 / T SCREW CONNECTION PE 4/2	
	KA00100	KQU 04-00 / Y BRANCH FOR PE 4/2 (3x)	
	KA00115	KQU 08-00 / Y BRANCH FOR PE 8/6 (3x)	
	KA00120	KQR 04-08 / REDUCER FITTING FROM PE8/6 TO PE4/2	
	KA00145	KQY 04-M5 / T MALE STUD COUPLING M5-PE4/2	
	KA00160	KQT 12-00 / T CONNECTOR FOR SIZE 12 HOSE	
	KA00195	KQH 12-02 S / STRAIGHT MALE STUD COUPLING 1/4” - PE 12	
	KA00196	KQH 12-03 S / STRAIGHT MALE STUD COUPLING 3/8” - PE 12	
	KA00198	KQL 12-02 S / ELBOW MALE STUD COUPLING 1/4” - PE 12	
	KA00200	KQL 12-03 S / ELBOW MALE STUD COUPLING 3/8” - PE 12	
	KA00320	KQR 08-12 / REDUCER FITTING (I/O)	
	KA00330	KQL 08-12 / ELBOW REDUCER FITTING (I/O)	
	KA00350	KQL 12-00 / L CONNECTOR FOR PU 12	
	KA00400	KQF 04-01 NO. 3114.04.10 / STRAIGHT FEMALE CONNECTOR PE 4/2-1/8	
	KA00440	KQT 12-02 S / T MALE STUD COUPLING 1/4” - PU-12	
	KA00450	KQY 12-03 S / REDUCER T FITTING 3/8” TO 2 x PE-12	
	KM60002	SILENCER WITH SLOT 1/4” KY 2011, SINTERED BRONZE, HÖRBIGER	
	KM60003	SILENCER WITH SLOT 1/8” KY 2010, SINTERED BRONZE, HÖRBIGER	
	KV00676	SSQ1000-PR-4-C8-RS	
	KV01240	AS 2201 F02-08 S / THROTTLE CHECK VALVE 1/4” x PU8	
	KV10352	GRE-1/4 NO. 10352 / EXHAUST AIR VALVE 1/4”	
	KS00017	SILICONE HOSE, RED, 8 x 2 mm ART...	

Item	Article number	Designation	EID (*)
	KS00021	PROTECTIVE HOSE, DIOLEN, 22 mm, BLACK / WITH DURA TREATMENT	
	KS00042	PUN-4x0.75-BL NO. 159662 / HOSE, BLUE	
	KS00086	PUN-8x1.25-BL NO. 159666 / HOSE, BLUE	
	KS10042	TU0425BU-20 HOSE d = 4 x 0.75 mm / TRANSPARENT, BLUE	
	KS10085	TU0805 BU-20 HOSE d = 8 x 1.5 mm / TRANSPARENT, BLUE	
	KS10128	TU1208 BU-20 HOSE d = 12 x 8 mm / TRANSPARENT, BLUE	

Equipment identification
(*) Equipment identification

Tab. 19: Spare parts, electrics

Item	Article number	Designation	EID (*)
200	119445	CYLINDER SWITCH, MAGNETIC, Turck M8	S12, S13, S14, S15, S16, S17, S18, S19
	KE02535	CIRCULAR FEMALE CONNECTOR, M8, 3-pos., 5 m	
201	KE01270	CABLE CONNECTOR with DIO. + LED + 3 m, GRO	Y16, Y26
202	142462	EMV 1/4”, 230 V, 7.5 bar, heat-proof	Y1, Y1.1, Y2, Y2.1, Y3, Y3.1, Y4, Y4.1
	KV02180	PLUNGER MV99.. = 5+6+7, RULON	
	KV02181	PLUNGER PIPE stainless steel, d = 5.5 MV9922	
	4283210000	Coil 200-254 V/50-60/EMVNW2.8-4	
	KV02185	HANDWHEEL FOR SOLENOID VALVE KV02165	
	149288	Valve connector, 5 m 230 V + interference suppression	
203	161902	Laser diode module, 650 nm/1 mW/24 V DC	
	KE00422	BALL-AND-SOCKET JOINTS, BASE d = 24 mm	
204	174841	SWITCH (SAFETY) with ROLLER	
	174850	M12 female 0° A-cod., with cable	
	KA06215	CV-PK-6-B NO. 6215	
205	174370	Safety sensor BNS 260-02Z-ST-R	S1.0, S1.4

Item	Article number	Designation	EID (*)
	174846	M8 male 0° / M8 female 0° A-cod.	12W3, 12W7
206	174386	Safety sensor BNS 260-02Z-ST-L	S1.3
	174846	M8 male 0° / M8 female 0° A-cod.	12W5
207	KE10040	PRESSURE SWITCH, N/O CONTACT	S26, S27, S28, S29, S30, S31, S32, S33
210	KE50150	Main switch	Q1
211	172476	IDEC POWER SUPPLY UNIT PS5R-VF24	T1
212	174843	Time relay, response delay	K6T
213	KE80061	SCHUKO SOCKET, CONTROL PANEL MOUNTING, 16 A, 2-POS.	X3
214	169798	Schmersal safety component	K1
215	KE00274	PRINT RELAY, 1 CHANGE-OVER CONTACT, 16 A, 24 V DC	K2, K3, K4, K5, K7, K8, K9
	164926	Omron plug-in socket relay P2RFZ-05-E	
216	9230350850	Locking clamp 4 mm^2	F1, F2, F3
	9290751500	Fuse, 2 A, medium acting, 5 x 20	
	9290550030	FUSE, 2 A, slow acting, 5 x 20	
	9290550060	Fuse, 6.3 A, medium acting, 5 x 20	
217	135821	Mains filter FSW 16 A / 5500.2218	A2
218	157511	Finder relay 50.12	K10
	9290750720	Finder relay base, 8-pos.	
	928015188	FREE-WHEELING DIODE / 12–110 V DC	
	132042	Retaining bracket for Finder relay	
219	9290750640	Plug-in/print relay	K11
	9290750720	Finder relay base, 8-pos.	
	928015188	FREE-WHEELING DIODE / 12–110 V DC	
	132042	Retaining bracket for Finder relay	
220	125900	X20BM01 supply bus module	SPS2
	125902	X20BR9300 bus receiver	
	125907	X20TB12 field terminal block, 12-pos.	
221	125901	X20BM15 bus module	SPS3-SPS7

Item	Article number	Designation	EID (*)
	125903	X20DI9371 dig. inputs 12 x	
	125904	X20DO9322 dig. outputs 12 x	
	125907	X20TB12 field terminal block, 12-pos.	
230	175094	Touch panel 4PPC70.0573-20B with software	SPS1
231	161887	Emergency-stop button, LUMOTAST 16 R	S0
232	156887	Switch-off button, ring lighting	S2
	139233	Switching element, changeover switch	
	159249	Light emitting diode, ultra-white, 24 V DC	
233	156886	Switch-on button, ring lighting	S1
	174840	Illuminated tactile clock generator CTL2	
	139234	Light emitting diode, ultra-green, 24 V DC	
	KE10055	FOOT PEDAL with 1 switch with 3.5 m CABLE/STANDARD 6289-55169-SC	S10, S11, S20
	174266	Y distributor	
	171798	Connection line S61-5M, M8x1 4-pin.	
	174847	M8 male 0° / M8 female 0° A-cod. PUR 4x0.25 bk UL/CSA + drag chain 3 m	
	174848	M8 male 0° / M8 female 0° A-cod. PUR 4x0.25 bk UL/CSA + drag chain 4 m	
	174849	M8 male 0° A-cod., with cable PUR 4x0.25 bk UL/CSA + robot + drag chain 7.5 m	

Tab. 20: Spare parts, mechanics

Item	Article number	Designation
400	KL00001	TANDEM LINEAR SET, with LUBRICATION NIPPLE
	KN07247	Seeger ring D = 47 mm
	KL00018	BALL BUSHING SSE M30 THOMSON
401	KL00011	SHAFT FOR GUIDING UNIT d = 30 x 450
402	132977	BALL VALVE 3/8” (inside/inside), stainless steel
403	132976	BALL VALVE 1/2” (inside/inside), stainless steel
404	KV00510	CONDENSATE DRAIN BPT 13 SX 3/8”
410	KL00033	Roller bearing NFR 32

Item	Article number	Designation
411	KL00034	ROLLER BEARING ECCENTRIC NFRE 32
412	KL00095	ROLLER BEARING KEHT 22-10 with PIN
413	KL00100	Roller bearing CENTRIC, KHT 22 P
414	KL00170	RAIL PFS32/1500 MT CV 12
415	KL00175	RAIL PFL46x10/1500 M CV 12
416	KZ00100	Shock absorber, 50 mm STROKE, M33x1.5
	113696	Spring for shock absorber OEM 1.25
420	KF21661	COMPRESSION SPRING VD-166, stainless
	0017224	STEAM INJECTION DISTRIBUTOR, 10-STAGE
	KF22500	Compression spring D 250, D=2.0/DM=16.0/LO=68.0 /if=8.5
	KS30200	Tetraflex 3/8” 200, with fitting
	KS31200	Tetraflex 3/8” 1200, with fitting
	KS31400	Tetraflex 3/8” 1400, with fitting
	KS31600	Tetraflex 3/8” 1600 with fitting
	KS31800	Tetraflex 3/8” 1800 with fitting
	KS32400	Tetraflex 3/8” 2400 with fitting
	126683	Tetraflex 3/8” 1700 without fitting
	126684	Tetraflex 3/8” 1800 without fitting
	126685	Tetraflex 3/8” 1900 without fitting
	125616	Tetraflex 3/8” 2000 without fitting
	127266	Tetraflex 3/8” 2500 without fitting
	KS52035	Suction hose 1”
	KS52050	Suction hose 1 1/2”
	BO00434	LUBRICATION GUN, EXTENDED
	KC00147	GREASE, TEMPERATURE-RESISTANT, STABURAGS NBU 12/300 KP NO. 83038

Tab. 21: Spare parts, steam iron

Item	Article number	Designation
	BO01221	BRI-1 STAINLESS STEEL STEAM IRON WITH TEFLON SOLE, 1 ROW OF HOLES
	BO01223	BRI-3 STAINLESS STEEL STEAM IRON WITH TEFLON SOLE, 3 ROWS OF HOLES
	BO00541	TEFLON SOLE / FOR BRI-1 STEAM IRON
	BO00543	TEFLON SOLE / FOR BRI-3 STEAM IRON
	KG00125	AEROFIT (FLEECE) 100 cm WIDE
	KG20040	STAINLESS STEEL WIRE MESH d=0.16 mm w=1.5 m MESH 0.077/0.48 FABRIC=107/40
	KUE05000	STEAM VALVE FOR BRI-1 AND BRI-3
	KUE05020	WEAR PARTS SET FOR KUE05000 / CPL. (for BRI-1 and 3 STEAM VALVE)
	KUE05050	LEVER FOR BRI-1 AND BRI-3 / PART NO. 2012156
	KUE05060	LEVER FASTENER for BRI-1 + BRI-3 / PART NO. 2012320
	127228	BRI-1/3, retrofitting for handle piece
	KUE05100	GUARD PLATE FOR HSN-300 ALU
	KUE05120	CAP 1/4” MS-VN FOR KNEE BRI-1/3 / PART NO. 2012925
	KUE05130	SEALING RING FOR CAP 1/4” TO KNEE / BRI-1/BRI-3, PART NO. 2019939
	KUE05150	INSERT 1/4”x14x33 for BRI-1/BRI-3 / PART NO. 2012805
	KUE05151	INSERT 1/4”x14x33 for BRI-1/BRI-3 PART NO. 2012814 (SUS) with SEALS
	KUE05170	CAP, SILICONE FOR BRI-1 AND BRI-3 / PART NO. 2019947
	KF10300	WHIP L0=300 mm LONG, PART A1
	KS41501	TETRAFLEX-TERYLENE HOSE LINE / DN 4 X 1500, BOTH SIDES 1/4”
	127261	Tetraflex 1/4” 3300, with fitting
	127262	Tetraflex 1/4” 4400, with fitting

Bezugsmaterial für BRISAY Bügelmaschinen
Cover material for BRISAY pressing machines

Stand 07/2024

BRI-600/101 Vorderteil- Vorbügelmaschine (konkave Bügelform)

BRI-600/101 Jacket Front- Underpressing Machine (concave pressing buck)

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.: _____

VEIT GmbH, Justus-von-Liebigstr. 15, D-86899 Landsberg am Lech,
Tel. +49 (8191) 479-0

Bezugsmaterial für BRISAY Bügelmaschinen
Cover material for BRISAY pressing machines

Stand 07/2024

BRI-600/101 Vorderteil- Vorbügelmaschine (konkave Bügelform)

BRI-600/101 Jacket Front- Underpressing Machine (concave pressing buck)

	Artikelbezeichnung **der Bezugslagen, beginnend auf der Metall-Bügelform**	**description** **of the layers, starting at the metall-iron buck**	Meterware / yard goods	Fertigware einzeln / 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 lfm. / qty. linear meter. **m**
1					C217XX01	C217XX02		
	1. Kupferdrahtgewebe	1. copper wire	2570100230	L11	•		130	2,30
	2. Nomex Nadelfilz 6mm	2. nomex needle felt 6mm	2570100110	L12	•	•	160	2,00
	3. Kupferdrahtgewebe verzinnt	3. solder coated copper wire	2570100240	L13	•	•	130	1,20
	4. Polyestergewebe	4. polyester wire	KG00050	L14	•	•	160	1,10
	5. Nomex Bügelnessel	5. nomex pressing needle	140929	L15	•	•	160	2,00
2						C217XX03		
	1. Kupferdrahtgewebe	1. copper wire	2570100230	L21	•		130	1,20
	2. Nomex Nadelfilz 4mm	2. nomex needle felt 4mm	2240201440	L22	•	•	160	1,40
	3. Silikonschaum 10mm	3. silicon foam 10mm	139446	L23	•	•	90	1,10
	4. Teflongewebe braun	4. teflon woven material brown	KG30040	L24	•	•	135	2,70

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.

VEIT GmbH, Justus-von-Liebigstr. 15, D-86899 Landsberg am Lech,
Tel. +49 (8191) 479-0

Bezugsmaterial für BRISAY Bügelmaschinen
Cover material for BRISAY pressing machines

Stand 07/2024

BRI-600/201, BRI-600/202 Vorderteil- Vorbügelmaschine (konvexe Bügelformen)

BRI-600/201, BRI-600/202 Jacket Front- Underpressing Machine (convex pressing bucks)

	Artikelbezeichnung **der Bezugslagen, beginnend auf der Metall-Bügelform**	**description** **of the layers, starting at the metall-iron buck**	Meterware / yard goods	Fertigware einzeln / 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 lfm. / qty. linear meter. **m**
1	**bis Form 15**	**until buck 15**			C317XX01	C317XX02		
	1. Kupferdrahtgewebe	1. copper wire	2570100230	L11	•		130	1,50
	2. Nomex Nadelfilz 4mm	2. nomex needle felt 4mm	2240201440	L12	•	•	160	1,50
	1. Silikonschaum 10mm	1. silicon foam 10mm	139446	L13	•	•	134	2,00
	2. Stretch blau	2. stretch blue	2570100040	L14	•	•	140	3,00
2						C317XX03		
	1. Kupferdrahtgewebe	1. copper wire	2570100230	L21	•		130	3,00
	2. Nomex Nadelfilz 4mm	2. nomex needle felt 4mm	2240201440	L22	•	•	160	1,50
	3. Kupferdrahtgewebe verzinnt	3. solder coated copper wire	2570100240	L23	•	•	130	3,00
	1. Kupferdrahtgewebe verzinnt (fein)	1. solder coated copper wire (fine)	115315	L24	•	•	150	3,00

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.

VEIT GmbH, Justus-von-Liebigstr. 15, D-86899 Landsberg am Lech,
Tel. +49 (8191) 479-0

Bezugsmaterial für BRISAY Bügelmaschinen
Cover material for BRISAY pressing machines

Stand 07/2024

BRI-600/201, BRI-600/202 Vorderteil- Vorbügelmaschine (konvexe Bügelformen)

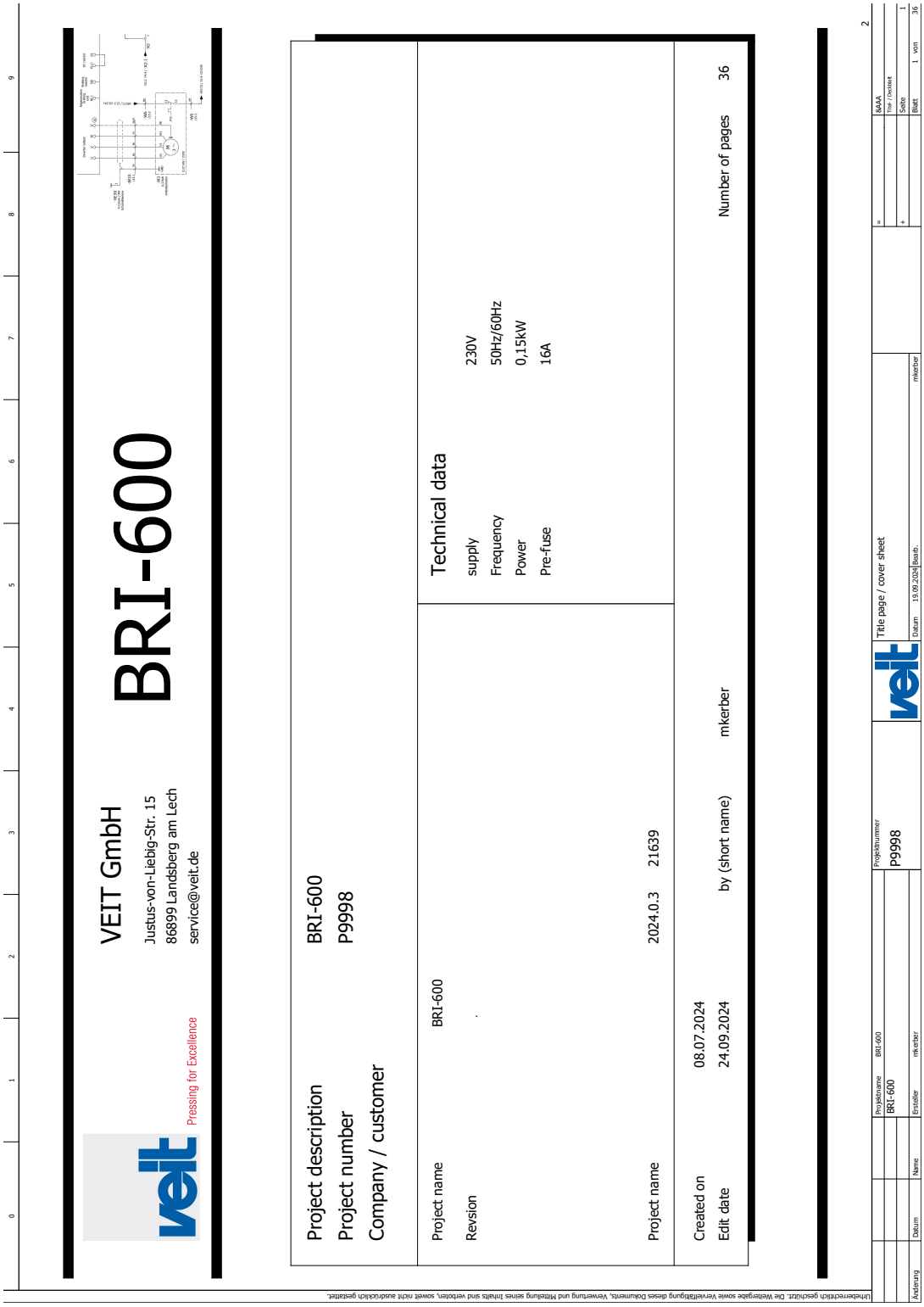
BRI-600/201, BRI-600/202 Jacket Front- Underpressing Machine (convex pressing bucks)

	Artikelbezeichnung **der Bezugslagen, beginnend auf der Metall-Bügelform**	**description** **of the layers, starting at the metall-iron buck**	Meterware / yard goods	Fertigware einzeln / 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 lfm. / qty. linear meter. **m**
1	**ab Form 18**	**from buck 18**			C317XX01	C317XX02		
	1. Kupferdrahtgewebe	1. copper wire	2570100230	L11	•		130	1,50
	2. Nomex Nadelfilz 4mm	2. nomex needle felt 4mm	2240201440	L12	•	•	160	1,50
	1. Silikonschaum 10mm	1. silicon foam 10mm	139446	L13	•	•	134	2,00
	2. Stretch blau	2. stretch blue	2570100040	L14	•	•	140	3,00
2						C317XX03		
	1. Kupferdrahtgewebe	1. copper wire	2570100230	L21	•		130	3,00
	2. Nomex Nadelfilz 6mm	2. nomex needle felt 6mm	2570100110	L22	•	•	160	1,50
	3. Kupferdrahtgewebe verzinnt	3. solder coated copper wire	2570100240	L23	•	•	130	3,00
	1. Kupferdrahtgewebe verzinnt (fein)	1. solder coated copper wire (fine)	115315	L24	•	•	150	3,00

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.

VEIT GmbH, Justus-von-Liebigstr. 15, D-86899 Landsberg am Lech,
Tel. +49 (8191) 479-0

13.3 Circuit diagrams



SAFETY REGULATIONS

GENERAL SAFETY REGULATIONS

DANGER !

During plant operation certain items are under dangerous voltage!
Non-observance of safety instructions can result in death, serious injuries or material damage.

Only specialist personnel may carry out transport, installation and commissioning work.

The applicable valid standards as well as the national and / or company-specific accident prevention regulations are to observed.

The following safety instructions are to be observed:

The erection, commissioning, troubleshooting as well as repair of the plant may only be carried out by qualified personnel that is familiar with the corresponding operating instructions.

Mounting of the devices has to be effected in accordance with the valid standards, state and local regulations.
Proper grounding and conductor dimensioning as well as proper short-circuit proofing have to be ensured.
These measures serve to ensure the safety of the plant and of the operating personnel.

Before carrying out safety checks, maintenance work and repair measures ensure that all the power supplies are switched off, are secured against being switched on unintentionally and are marked correspondingly.

Only test devices that are in a technically perfect condition and are suitable for the respective measurement may be used to carry out measurements!

The instructions specified in the respective operating instructions are to be followed strictly!
It is mandatory that hazard, warning and safety instructions be observed!

All doors and covers are to be kept closed during the plant operation.
If cooling devices are installed in the plant, ensure that these systems operate trouble-free.
These include the regular cleaning of the filters, in as far as they exist.

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Assignment	Assignment	Page		Page description	Date	Edited by
		&AAA	1	Title page / cover sheet	19.09.2024	mkerber
		&AAA	2	Safety regulations	19.09.2024	mkerber
		&AAB	1	Inhaltsverzeichnis	24.09.2024	mkerber
		&AAB	2	Inhaltsverzeichnis	24.09.2024	mkerber
		&ADB	5	Structure identifier overview	03.09.2024	mkerber
	=GRF			Schaltschrank 1		
		&EFA	7	Title page / cover sheet	19.09.2024	mkerber
		&EFA	8	Control structure	18.09.2024	mkerber
		&EFA	9	modules with cross-reference / function text	18.09.2024	mkerber
		&EFS	10	Power supply	18.09.2024	mkerber
		&EFS	11	safety relay	18.09.2024	mkerber
		&EFS	12	safety circuit 1	18.09.2024	mkerber
		&EFS	13	safety circuit 2	18.09.2024	mkerber
		&EFS	14	Control on/off	19.09.2024	mkerber
		&EFS	15	control panel	19.09.2024	mkerber
		&EFS	16	move slide	19.09.2024	mkerber
		&EFS	17	move slide	19.09.2024	mkerber
		&EFS	18	table up/down	19.09.2024	mkerber
		&EFS	19	table up/down	19.09.2024	mkerber
		&EFS	20	upper buck press back	19.09.2024	mkerber
		&EFS	21	upper buck press front	19.09.2024	mkerber
		&EFS	22	suction front/back	19.09.2024	mkerber
		&EFS	23	blowing	19.09.2024	mkerber
		&EFS	24	steam control	19.09.2024	mkerber
		&EFS	25	steam control	19.09.2024	mkerber
	=BF			Schaltschrank 1		
		&EFS	26	suction upper buck (BRI-600/202)	19.09.2024	mkerber
		&EFS	27	lower buck blowing (BRI-600/202)	19.09.2024	mkerber

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Assignment	Assignment	Page		Page description	Date	Edited by
=BF	+A01			Schaltschrank 1		
		&EFS	28	laser pointer (option)	19.09.2024	mkerber
=FLU						
		&MFS	29	Title page / cover sheet	18.09.2024	mkerber
		&MFS	30	slide forwards/backwards	19.09.2024	mkerber
		&MFS	31	upper buck press back	19.09.2024	mkerber
		&MFS	32	upper buck press front	19.09.2024	mkerber
		&MFS	33	suction front/back 1	19.09.2024	mkerber
		&MFS	34	suction front/back 2	19.09.2024	mkerber
		&MFS	35	blowing lower buck	19.09.2024	mkerber
		&MFS	36	suction UB BRI-600/202	19.09.2024	mkerber
		&MFS	37	steam_condensate	19.09.2024	mkerber

3

Projektname BRI-600 | Projektnummer P9998 | Inhaltsverzeichnis | &ADB/5

Änderung | Datum | Name | Ersteller mkerber | Datum 24.09.2024 | Bearb. mkerber | = &AAB Inhaltsverzeichnis | + Seite 4 | Blatt 4 von 36

Structure identifier overview

[VEIT]_F24_002_2020-09-15

Full designation	Labeling	Structure description
=GRF	Functional identifier	Grundfunktion
=BF	Functional identifier	Maschinenfunktionen
=FLU	Functional identifier	Fluid power
+A01	Location identifier	Schaltschrank 1
+A02	Location identifier	Schaltschrank 2
+B01	Location identifier	Bedienteil 1
+C01	Location identifier	Klemmkasten 1
+M01	Location identifier	Maschine
&AAA	Document type	Titel- / Deckblatt
&AAB	Document type	Inhaltsverzeichnis
&ADB	Document type	Strukturkennzeichenübersicht
&EFA	Document type	SPS-Übersicht
&EFS	Document type	Circuitry documents
&MFS	Document type	Schaltkreisklokument Pneumatik

&AAB/4

		Projektname	BRI-600	Projektnummer	P9998
		BRI-600			
Änderung	Datum	Name	Ersteller	mkerber	

Structure identifier overview

Datum 24.09.2024 bearb. mkerber

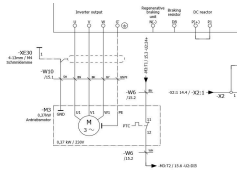
=GRF+A01&EFA/7

=	&ADB	
	Strukturkennzeichenübersicht	
+	Seite	5
	Blatt	5 von 36

VEIT GmbH
Justus-von-Liebig-Str. 15
86899 Landsberg am Lech
service@veit.de

Pressing for Excellence

electric



Project description	BRI-600
Project number	P9998
Company / customer	

Project name	BRI-600		
Revsion	.		
Project name		2024.0.3	21639

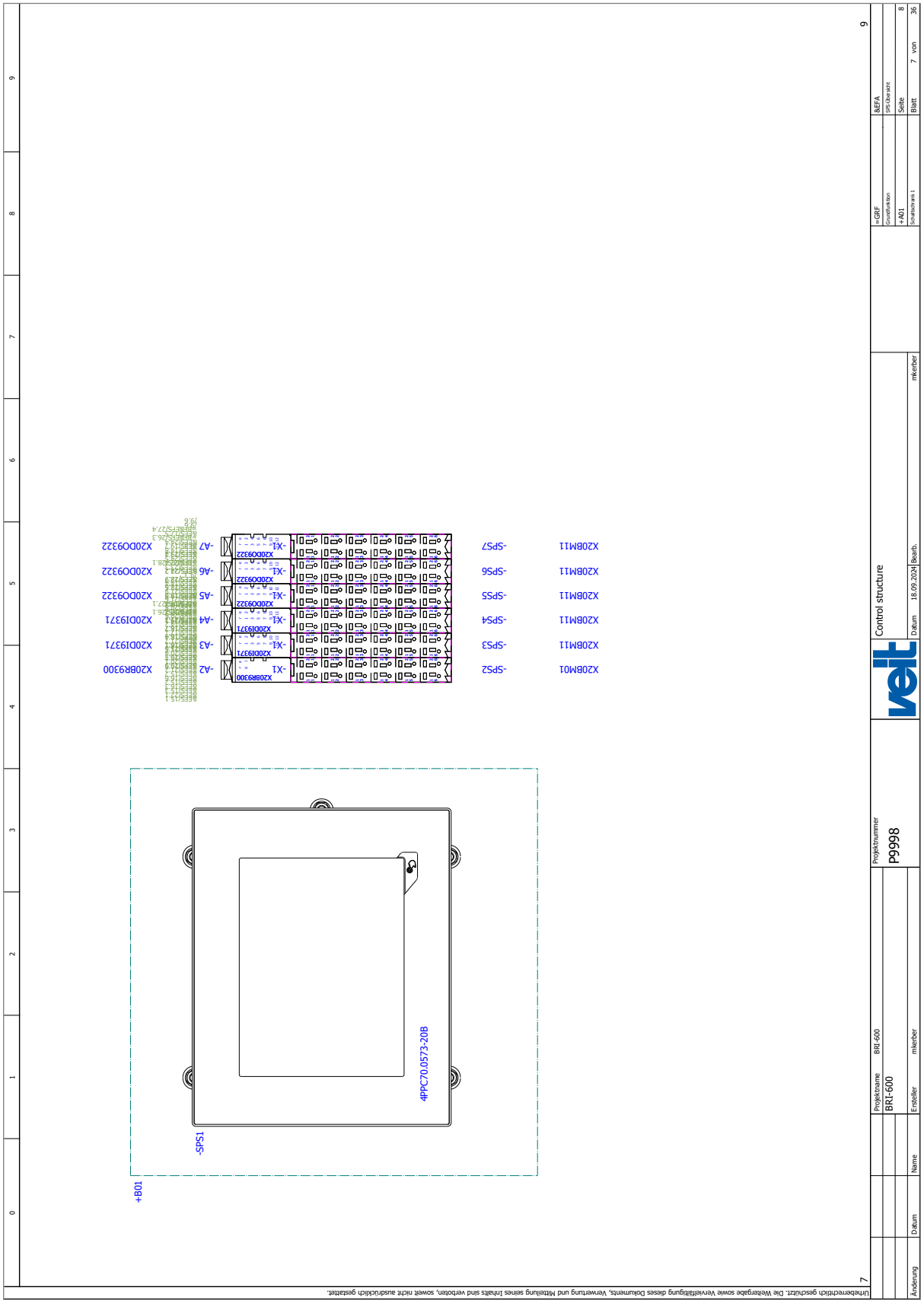
Technical data

supply	230V
Frequency	50Hz/60Hz
Power	0,15kW
Pre-fuse	16A

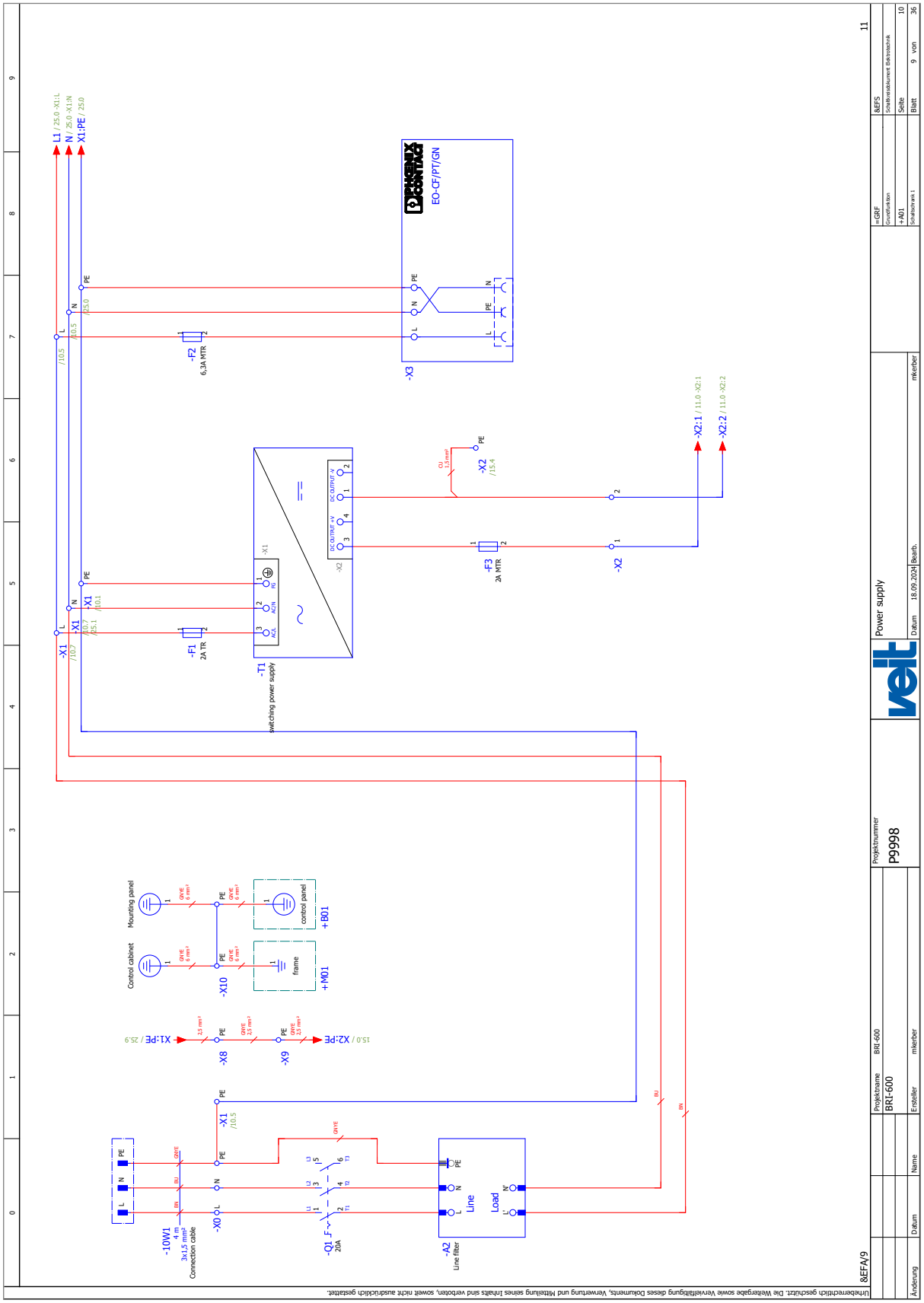
Created on	08.07.2024			
Edit date	24.09.2024	by (short name)	mkerber	Number of pages 36

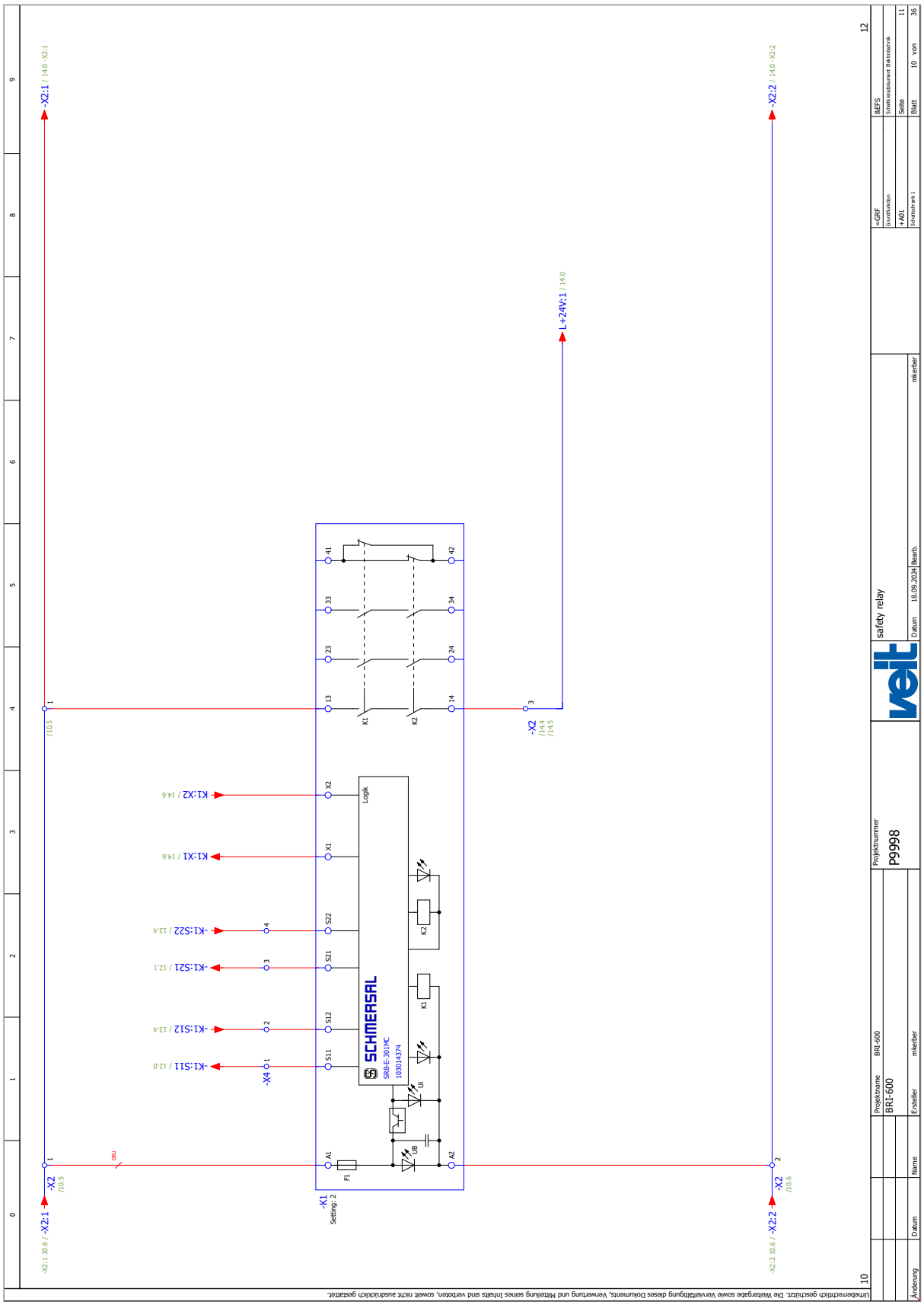
=+&ADB/5 8

			Projektname BRI-600	Projektnummer	Title page / cover sheet		=GRF	&EFA
			BRI-600	P9998			Grundfunktion	SPS-Übersicht
							+A01	Seite 7
Änderung	Datum	Name	Ersteller mkerber		Datum 19.09.2024	Bearb. mkerber	Schaltschrank 1	Blatt 6 von 36


Control structure
Projektnummer
P9998
Projektname
BRI-600
Ersteller
mkerber
Datum
18.09.2024
Bearb.
mkerber
Name
Datum
Änderung
Seite
7 von 36
Blatt
8
-SPS1
4PPC70.0573-20B
+B01
-SPS2
-SPS3
-SPS4
-SPS5
-SPS6
-SPS7
XZ0BM01
XZ0BM11
XZ0BR9300
XZ0DI9371
XZ0DO9322
-A2
-A3
-A4
-A5
-A6
-A7
-X1
Unbefugte Weitergabe sowie Vervielfältigung dieses Dokuments, Verwertung und Mitteilung seines Inhalts sind verboten, soweit nicht ausdrücklich gestattet.


-SPS2-A2
-SPS3-A3
-SPS4-A4
-SPS5-A5
-SPS6-A6
-SPS7-A7
modules with cross-reference / function text
Projektname BRI-600
Projektnummer P9998
&EFS/10
Urheberrechtlich geschützt. Die Weitergabe sowie Vervielfältigung dieses Dokuments, Verwertung und Mitteilung seines Inhalts sind verboten, soweit nicht ausdrücklich gestattet.


Power supply
Projektnummer
P9998
Projektname
BRI-600
-T1
switching power supply
-F1
2A TR
-F2
6,3A MTR
-F3
2A MTR
-X1
-X2
-X3
-X8
-X9
-X10
-A2
Line filter
-Q1
20A
-10W1
Connection cable
+B01
control panel
+M01
frame
Mounting panel
Control cabinet
L1 / 25.0 -X1:L
N / 25.0 -X1:N
X1:PE / 25.0
X2:1 / 11.0 -X2:1
X2:2 / 11.0 -X2:2
X1:PE / 25.9
X2:PE / 15.0
EO-CF/PT/GN
8EFA/9


-X2:1 / 14.0 -X2:1
-X2:2 / 14.0 -X2:2
L+24V:1 / 14.0
-X2
/10.5
-X2
/14.4
/14.5
-X2
/10.6
-K1
Setting: 2
SCHMERSAL
SRB-E-301MC
103014374
Logik
-K1:X2 / 14.6
-K1:X1 / 14.6
-K1:S22 / 13.4
-K1:S21 / 12.1
-K1:S12 / 13.4
-K1:S11 / 12.0
-X4
-X2:1 10.6 / -X2:1
-X2:2 10.6 / -X2:2
Projektname BRI-600
Projektnummer P9998
Ersteller mkerber
Datum 18.09.2024
safety relay
=GRF
+A01
Seite 11
Blatt 10 von 36
Änderung
Datum
Name
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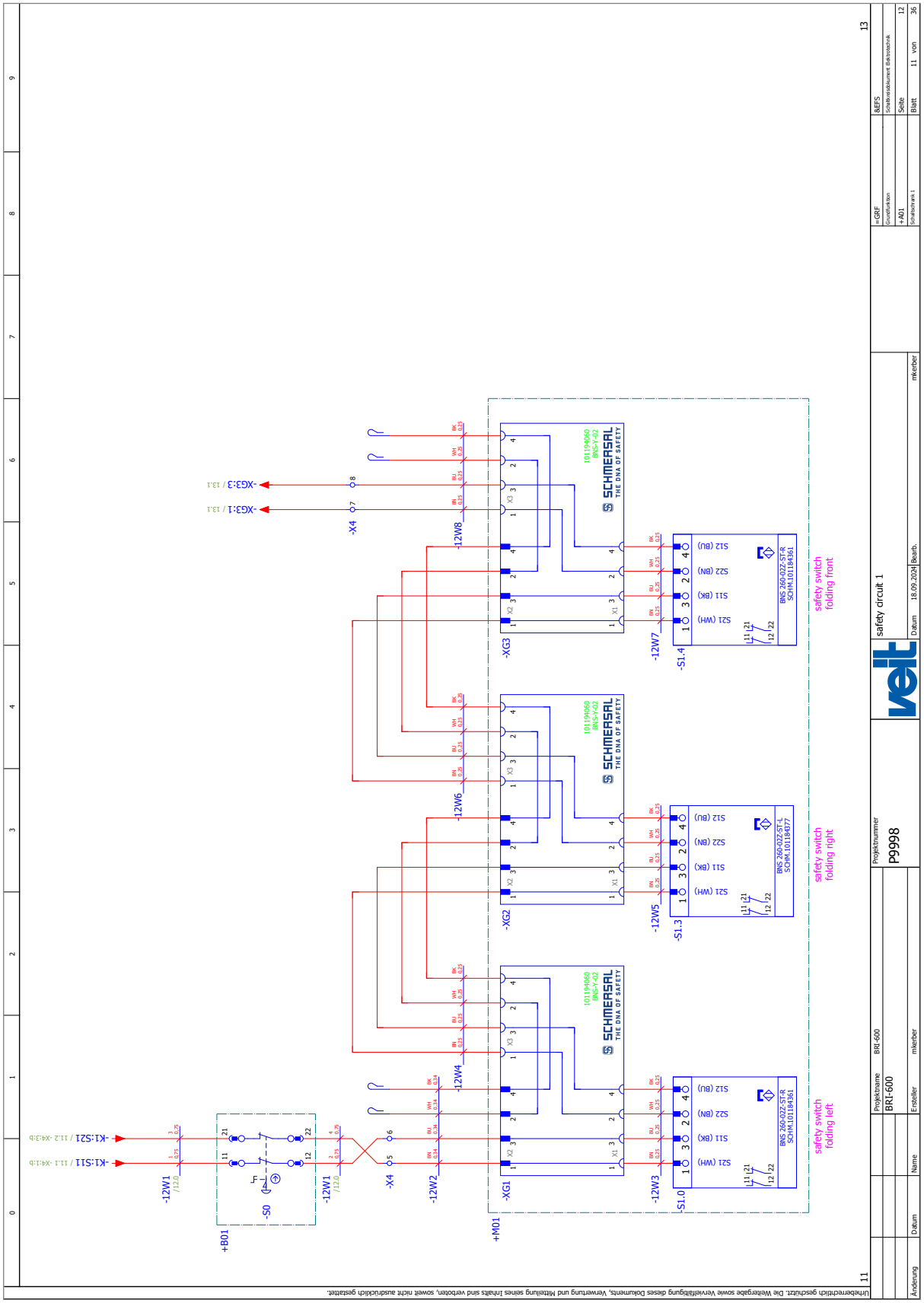
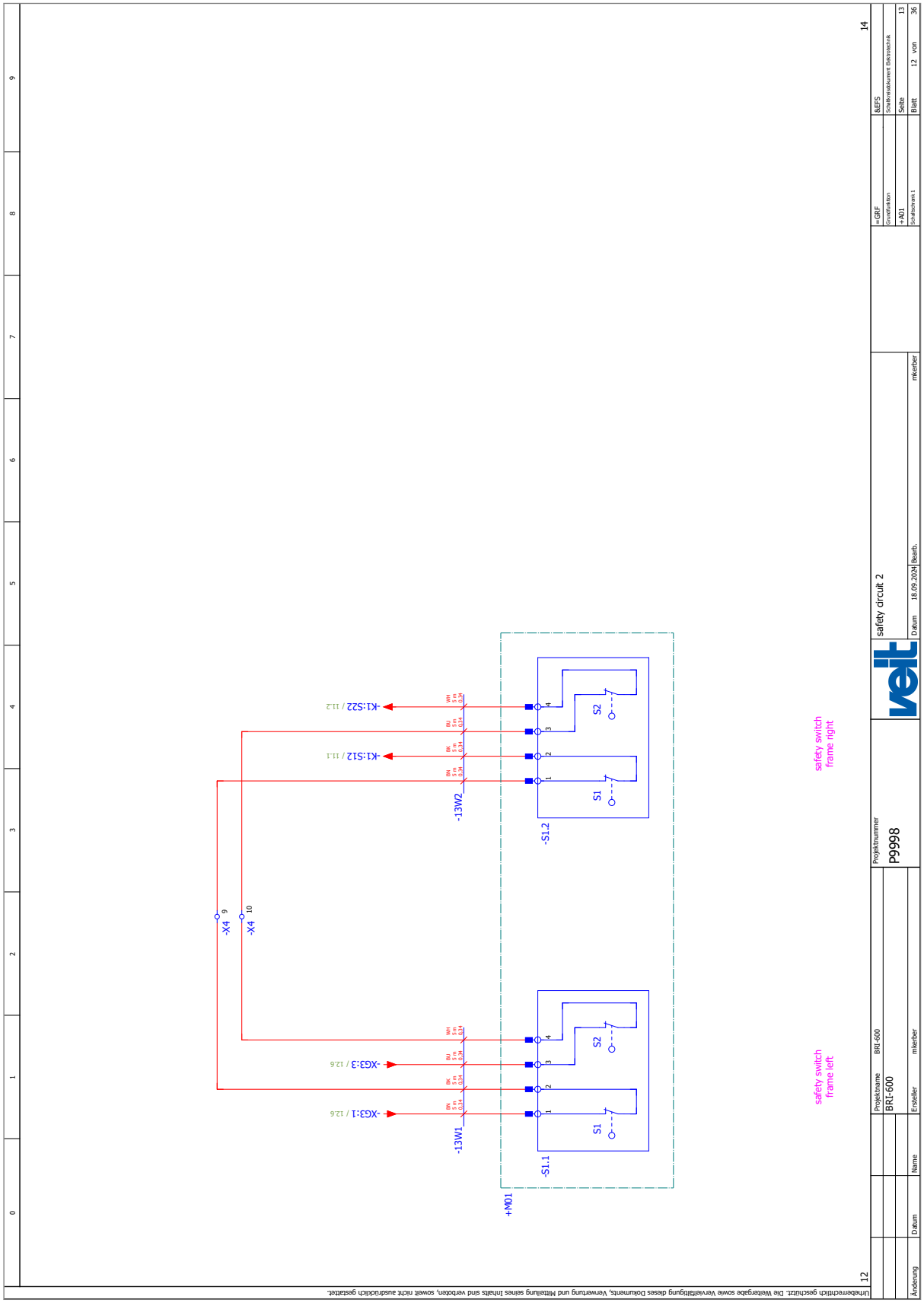
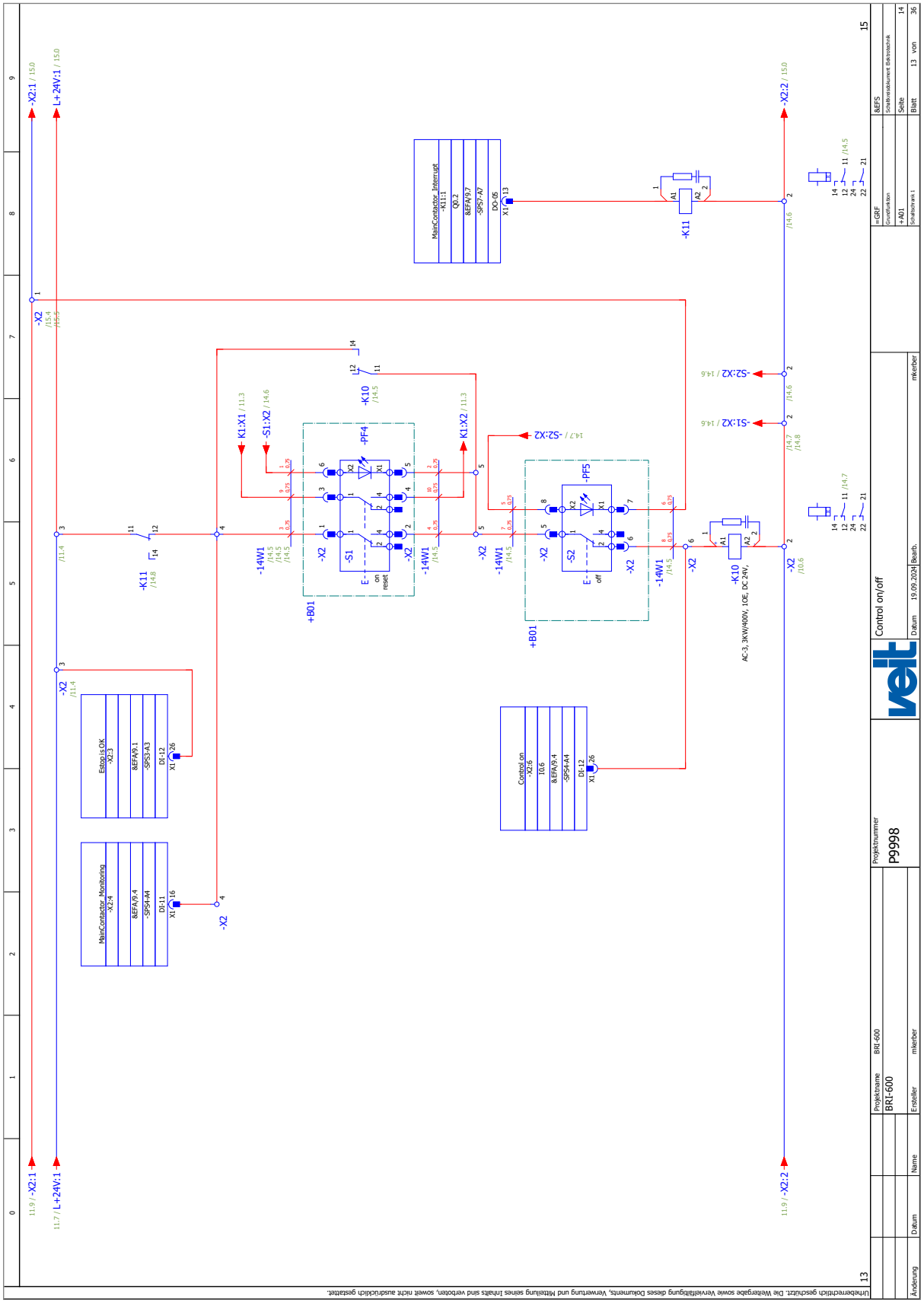
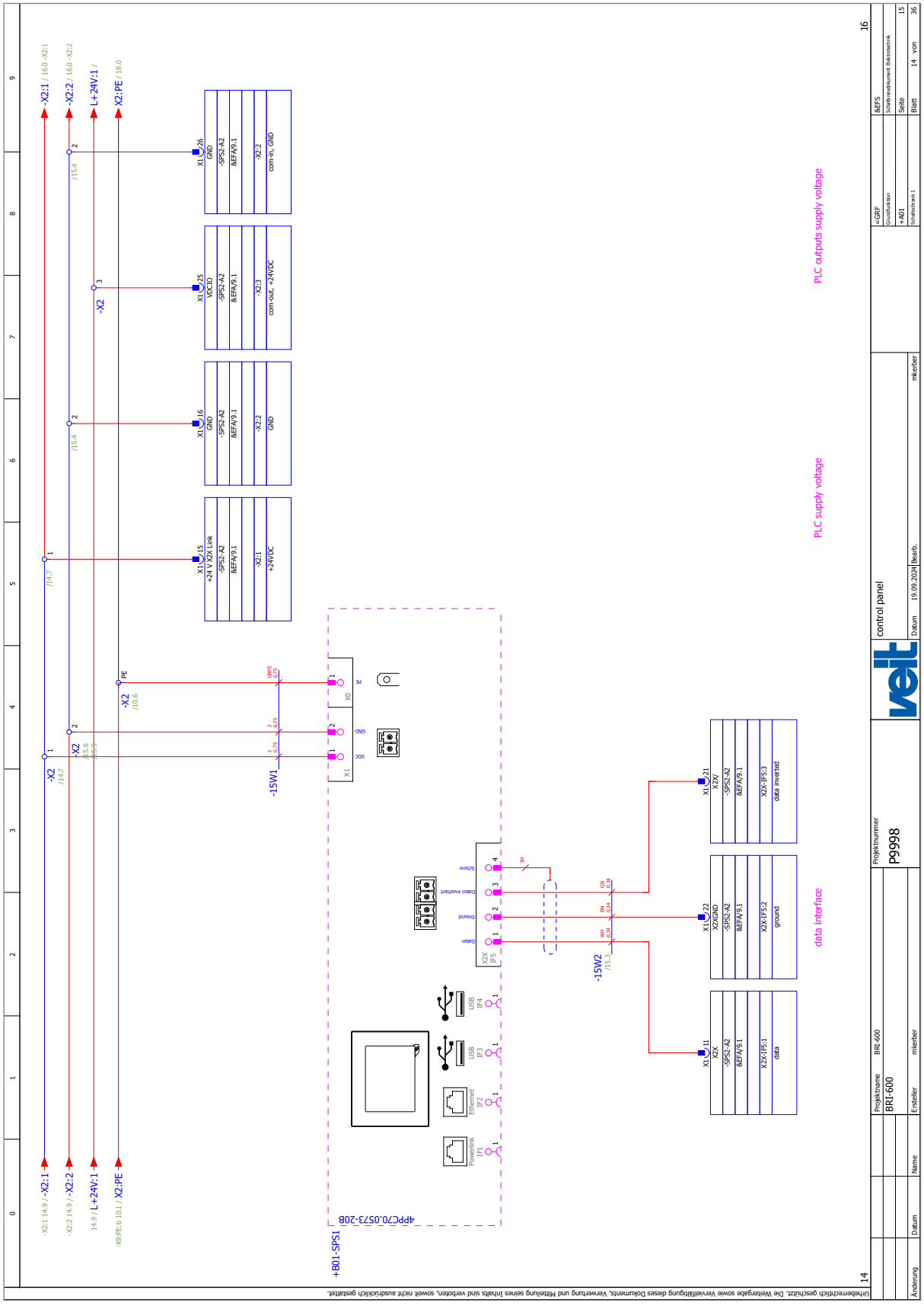

safety switch folding left
safety switch folding right
safety switch folding front
-S1.0
-S1.3
-S1.4
-XG1
-XG2
-XG3
-X4
-S0
+B01
+M01
-12W1
-12W2
-12W3
-12W4
-12W5
-12W6
-12W7
-12W8
-XG3:1 / 13.1
-XG3:3 / 13.1
-K1:S11 / 11.1
-K1:S21 / 11.2
Projektname BRI-600
Projektnummer P9998
Safety circuit 1
=GRF
+A01
Seite 11 von 36
Blatt 11 von 36
Datum 18.09.2024
Bearb. mkerber
Ersteller mkerber
Name
Datum
Änderung
Urheberrechtlich geschützt. Die Weitergabe sowie Vervielfältigung dieses Dokuments, Verwertung und Mitteilung seines Inhalts sind verboten, soweit nicht ausdrücklich gestattet.


safety circuit 2
P9998
BRI-600
safety switch frame right
safety switch frame left
-S1.1
-S1.2
-13W1
-13W2
-X4
-XG3:1 / 12.6
-XG3:3 / 12.6
-K1:S12 / 11.1
-K1:S22 / 11.2
+M01


Control on/off
P9998
BRI-600
Projektname
Projektnummer
Datum
Name
Änderung
Ersteller
Datum
Bearb.
-X2:1 / 15.0
L+ 24V:1 / 15.0
-X2:2 / 15.0
-K11
-K10
-K1:X1 / 11.3
-S1:X2 / 14.6
-K1:X2 / 11.3
-S2:X2 / 14.6
-S1:X2 / 14.6
+B01
-PF4
-PF5
-S1
-S2
-14W1
MainContactor_Interrupt
MainContactor_Monitoring
Estop is OK
Control on
AC-3, 3KW/400V, 10E, DC 24V,
Unbefugte Weitergabe sowie Vervielfältigung dieses Dokuments, Verwertung und Mitteilung seines Inhalts sind verboten, soweit nicht ausdrücklich gestattet.


PLC outputs supply voltage
PLC supply voltage
data interface
control panel
P9998
BRI-600
+B01-SPS1
-15W1
-15W2
-X2
-X2:1
-X2:2
L+ 24V:1
X2:PE
-SPS2-A2
&EFA/9.1
GND
+24VDC
com-out, +24VDC
com-in, GND
data inverted
ground
data

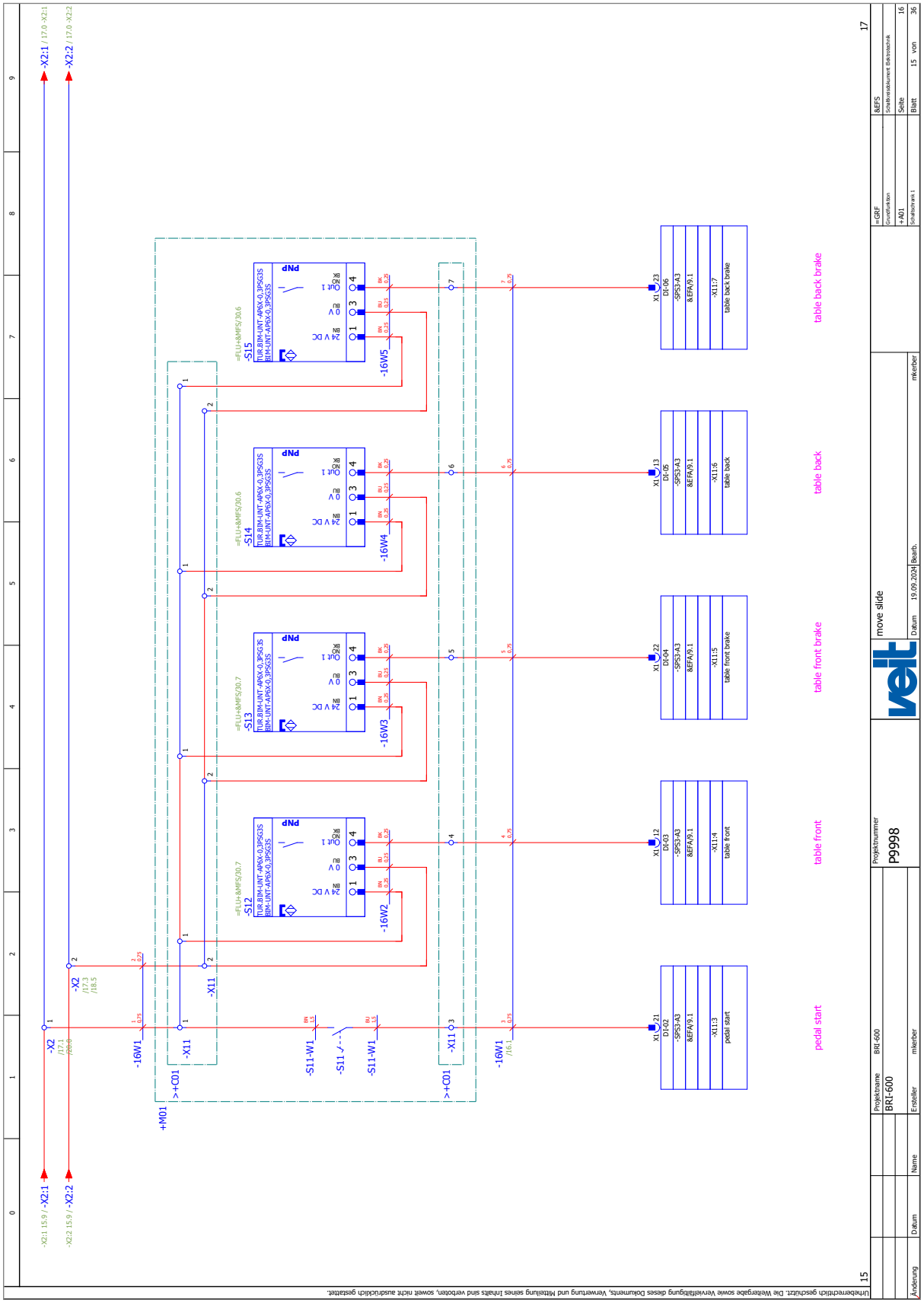
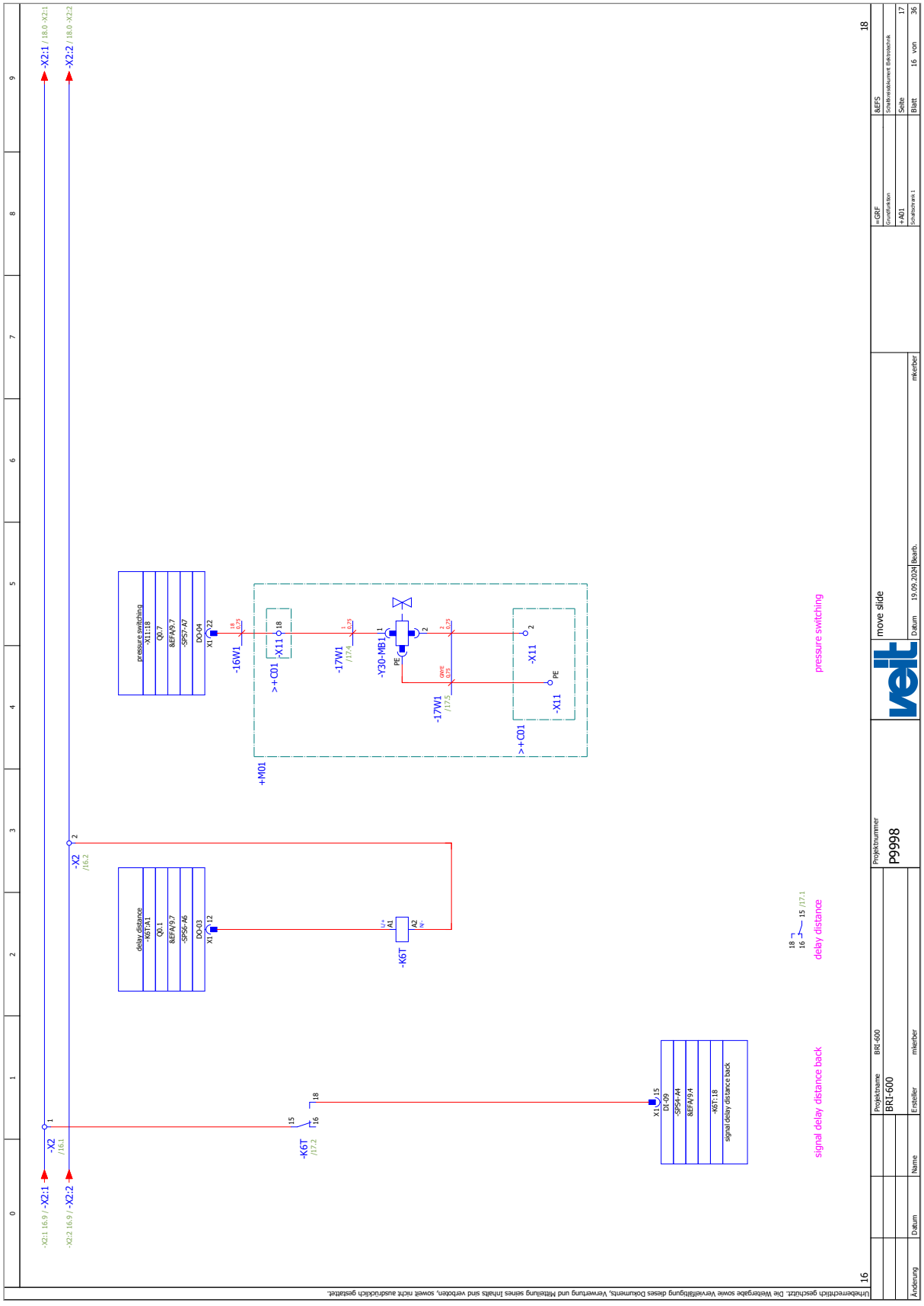


table back brake
table back
table front brake
table front
pedal start
move slide
P9998
BRI-600
Projektname
Projektnummer
Name
Datum
Änderung
Ersteller
mleicher
Datum 19.09.2024
Bearb.
Blatt 15 von 36
Seite 16
Schaltschrank 1
Schaltschrankkonzept Elektrotechnik
Grundfunktion
+A01
=GRF
&EFS
-X2:1 / 17.0 -X2:1
-X2:2 / 17.0 -X2:2
-X2:1 15.9 / -X2:1
-X2:2 15.9 / -X2:2
-X2
-X11
-16W1
-S11-W1
-S11
+M01
>+C01
-S12
-S13
-S14
-S15
-16W2
-16W3
-16W4
-16W5
=FLU+&MFS/30.7
=FLU+&MFS/30.6
TUR.BIM-UNT-AP6X-0.3PSG3S
BIM-UNT-AP6X-0.3PSG3S
24 V DC
0 V
-X11:3
pedal start
-X11:4
table front
-X11:5
table front brake
-X11:6
table back
-X11:7
table back brake
-SPS3-A3
&EFA/9.1
DI-02
DI-03
DI-04
DI-05
DI-06
X1_21
X1_12
X1_22
X1_13
X1_23
Unbefugte Weitergabe sowie Vervielfältigung dieses Dokuments, Verwertung und Mitteilung seines Inhalts sind verboten, soweit nicht ausdrücklich gestattet.


-X2:1 / 18.0 -X2:1
-X2:2 / 18.0 -X2:2
-X2:1 16.9 / -X2:1
-X2:2 16.9 / -X2:2
-X2 /16.1
-X2 /16.2
pressure switching
-X11:18
DO-04
-SPS7-A7
&EFA9.7
-16W1
-17W1
-Y30-MB1
-X11
-K6T
delay distance
-K6T:A1
DO-03
-SPS6-A6
&EFA9.7
signal delay distance back
-K6T:18
-SPS4-A4
&EFA/9.4
DI-09
+M01
pressure switching
delay distance
signal delay distance back
move slide
P9998
BRI-600
Projektname
Projektnummer
Ersteller
Datum
Name
Änderung
mkerber
19.09.2024
=GRF
Grundfunktion
+A01
Schaltschrank 1
&EFS
Schaltkonstrukteur Elektrotechnik
Seite 17
Blatt 16 von 36
16
18

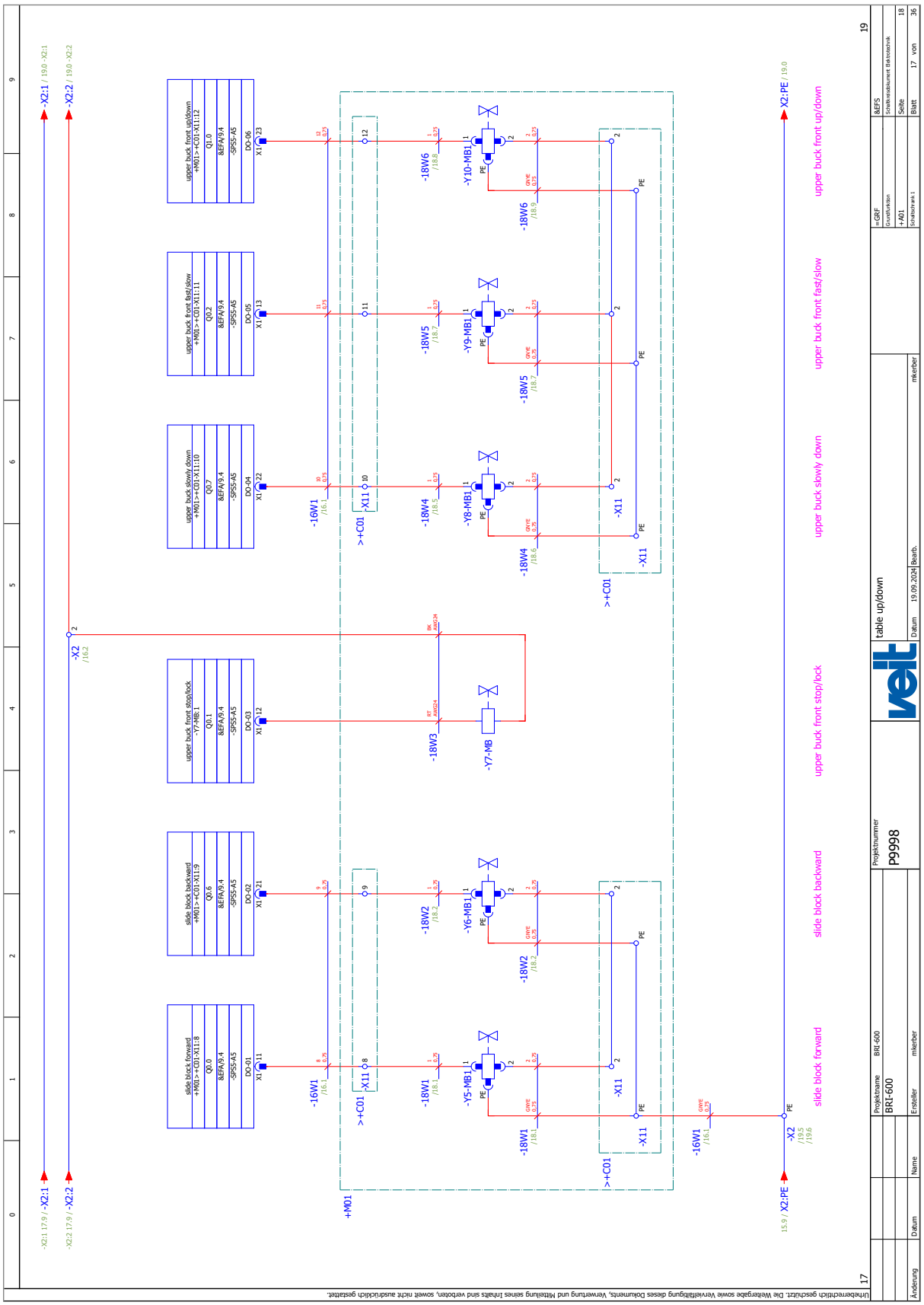


table up/down
P9998
BRI-600
slide block forward
slide block backward
upper buck front stop/lock
upper buck front fast/slow
upper buck front up/down
upper buck slowly down
-X2:1
-X2:2
-X2:PE
+M01
-X2
-16W1
-18W1
-18W2
-18W3
-18W4
-18W5
-18W6
-Y5-MB1
-Y6-MB1
-Y7-MB
-Y8-MB1
-Y9-MB1
-Y10-MB1
>+C01
-X11

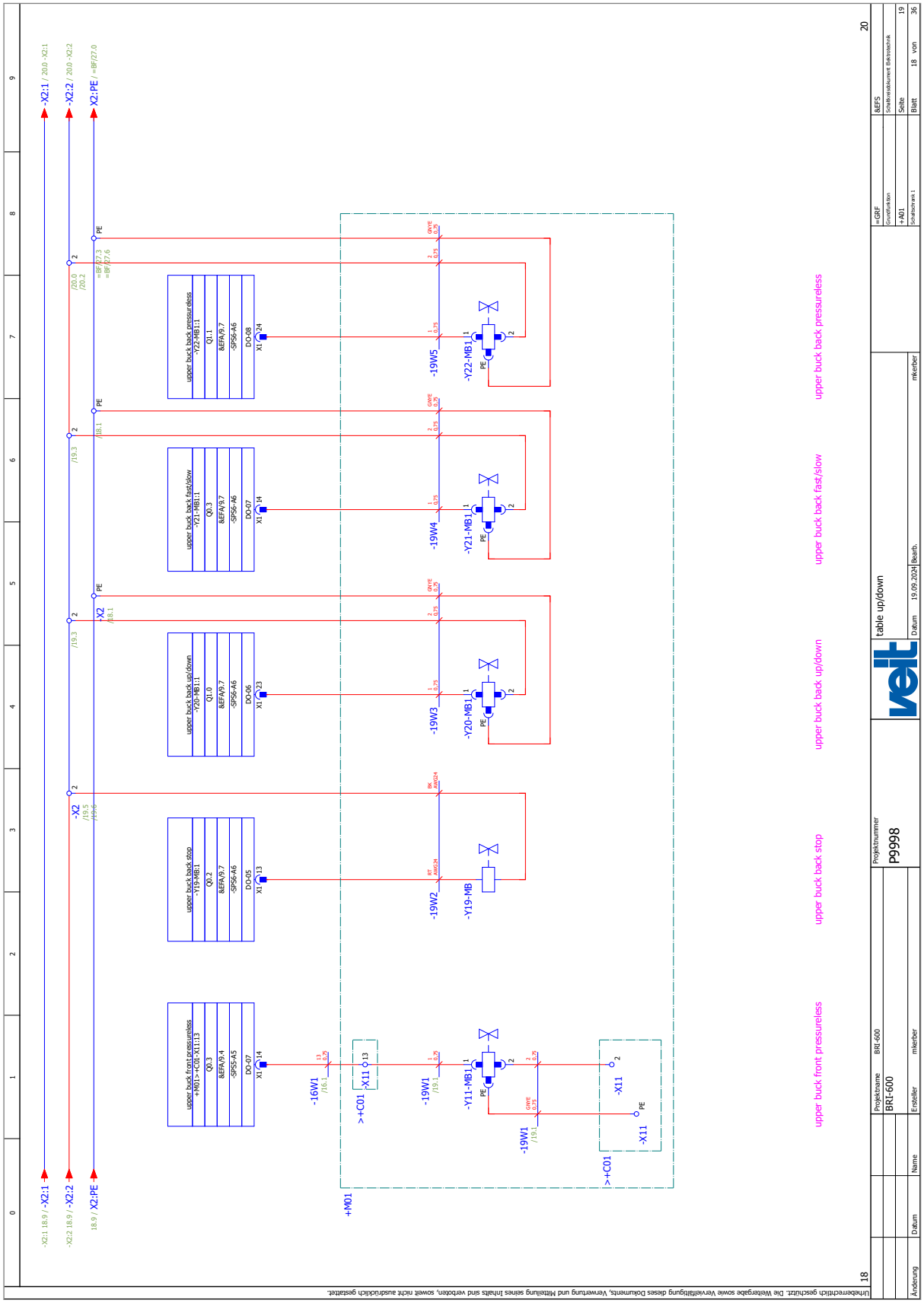
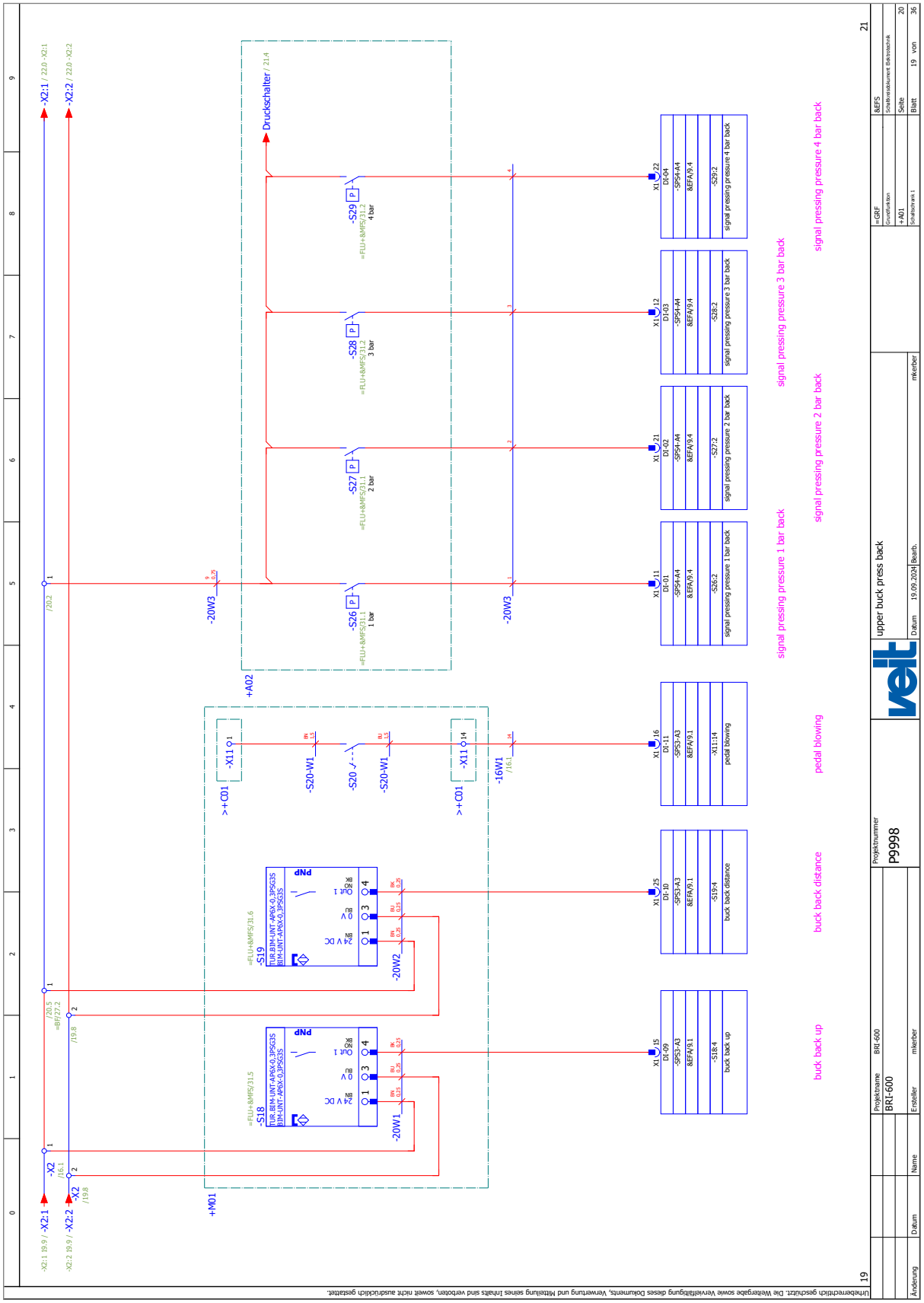
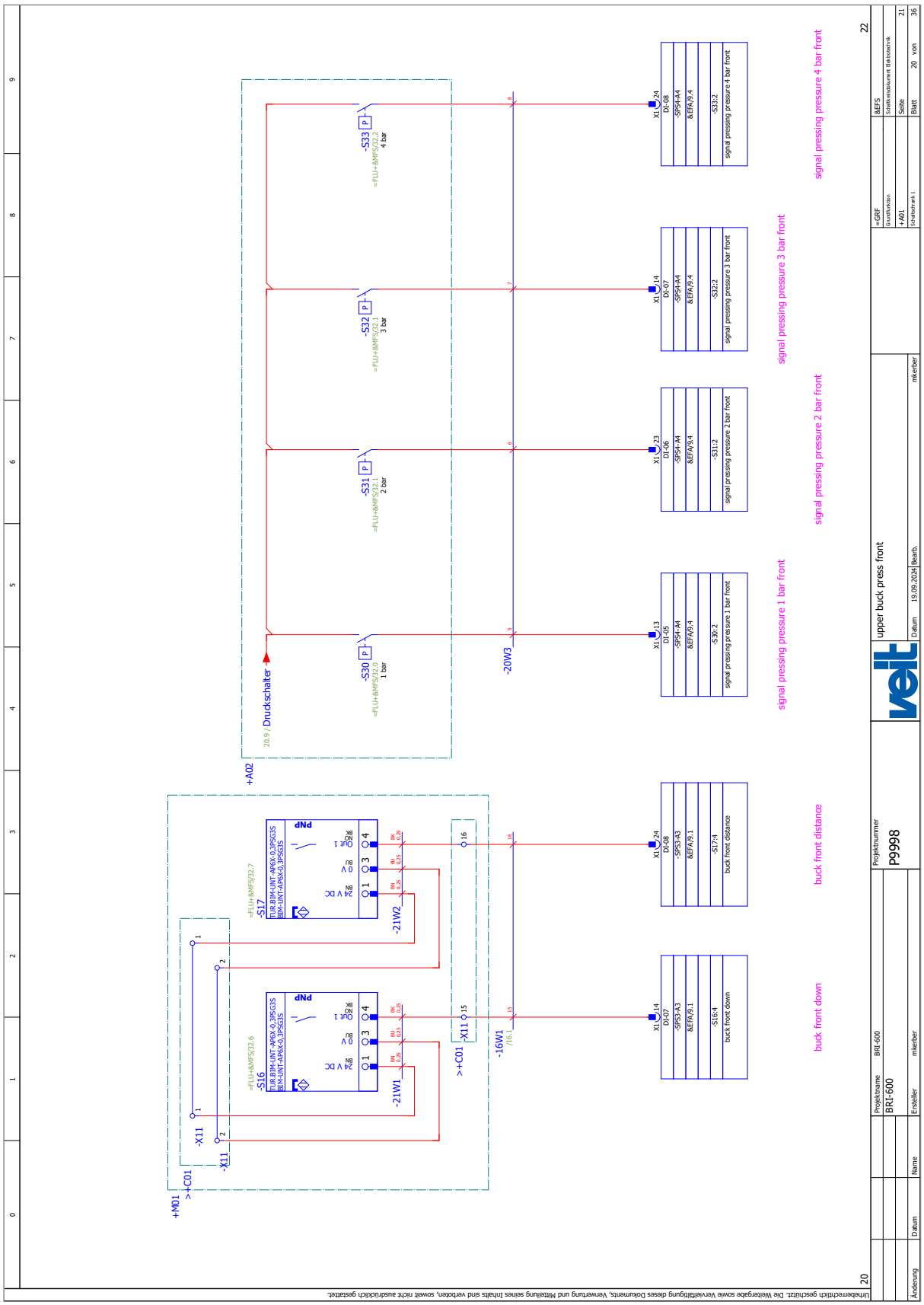
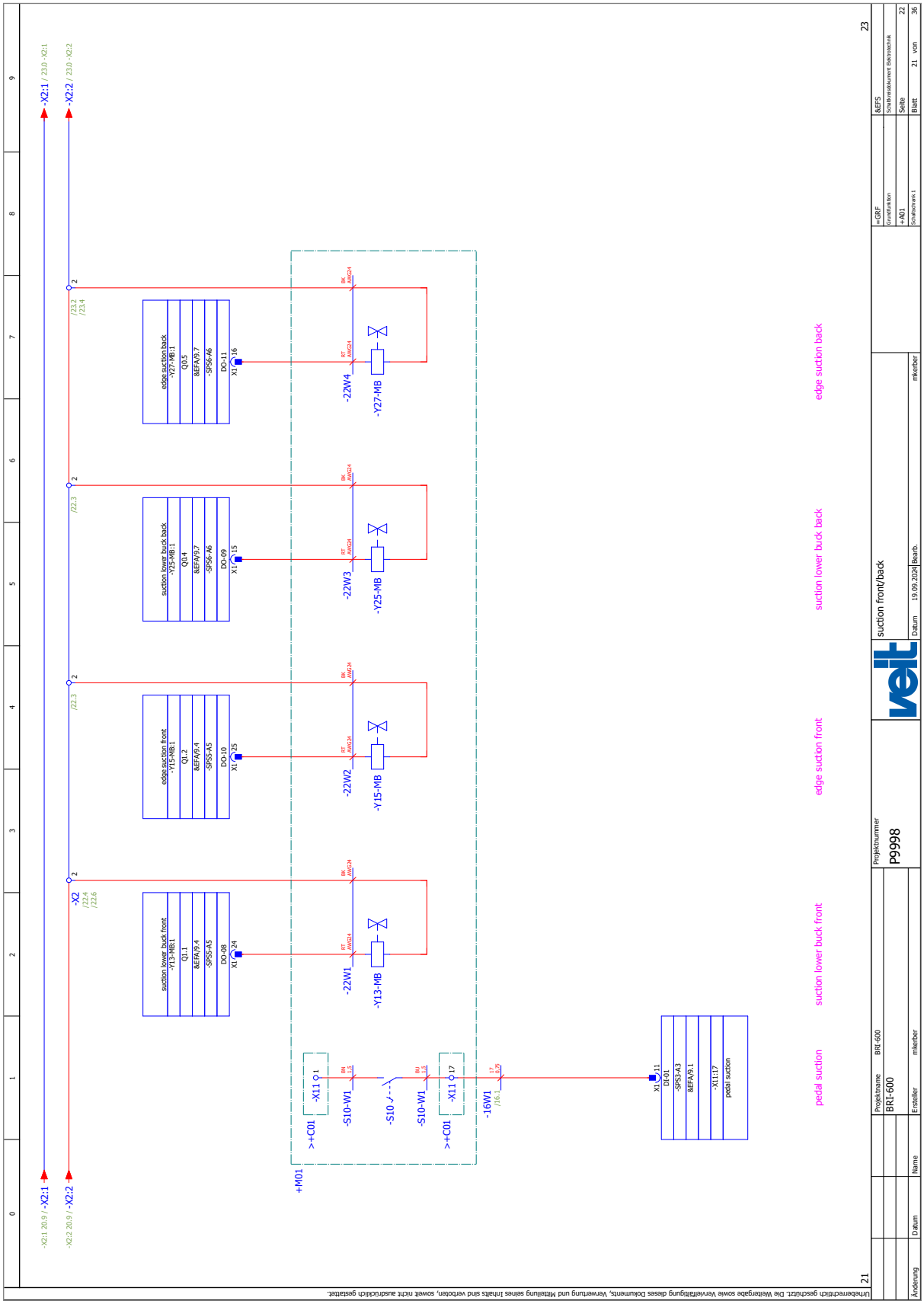
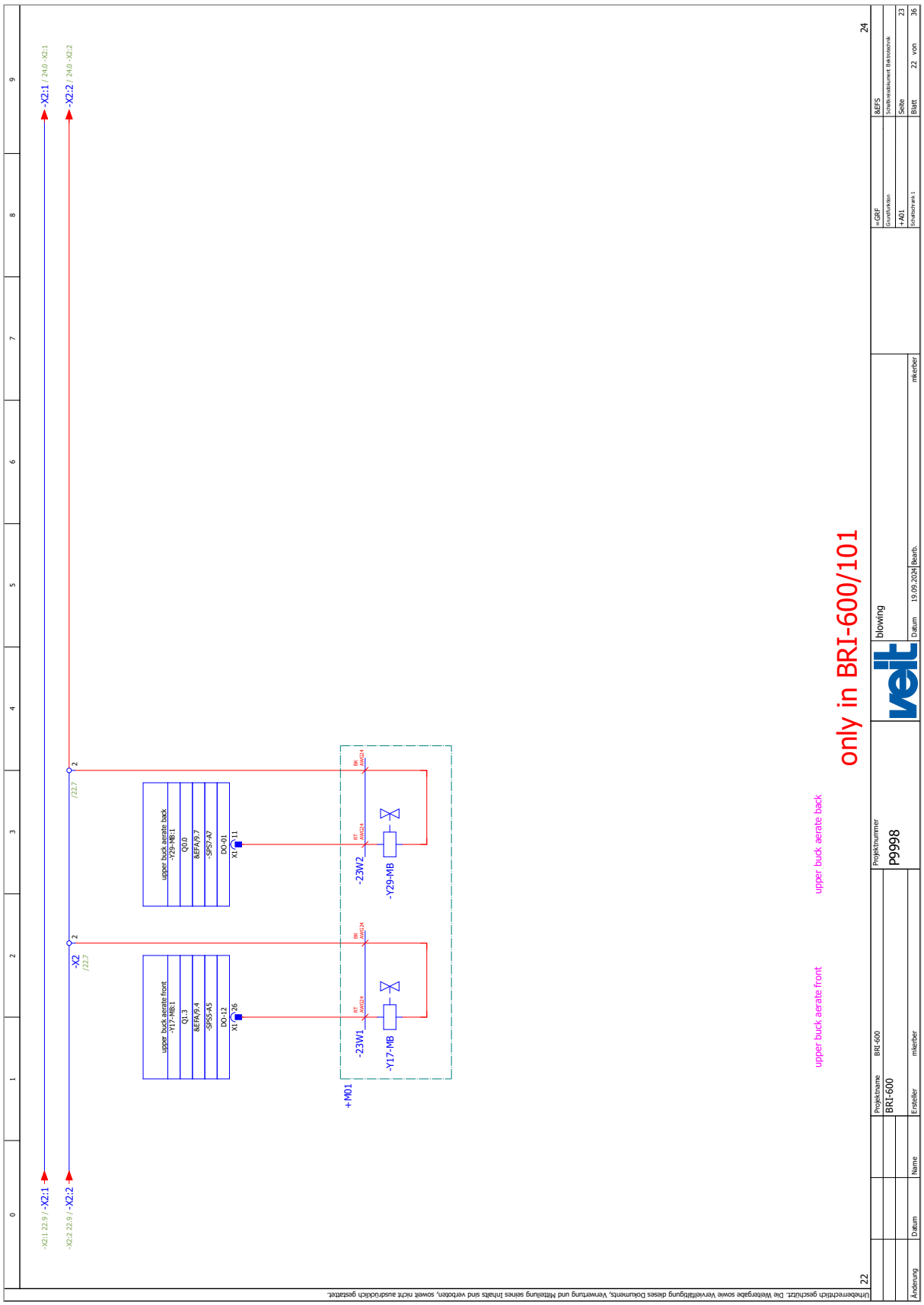


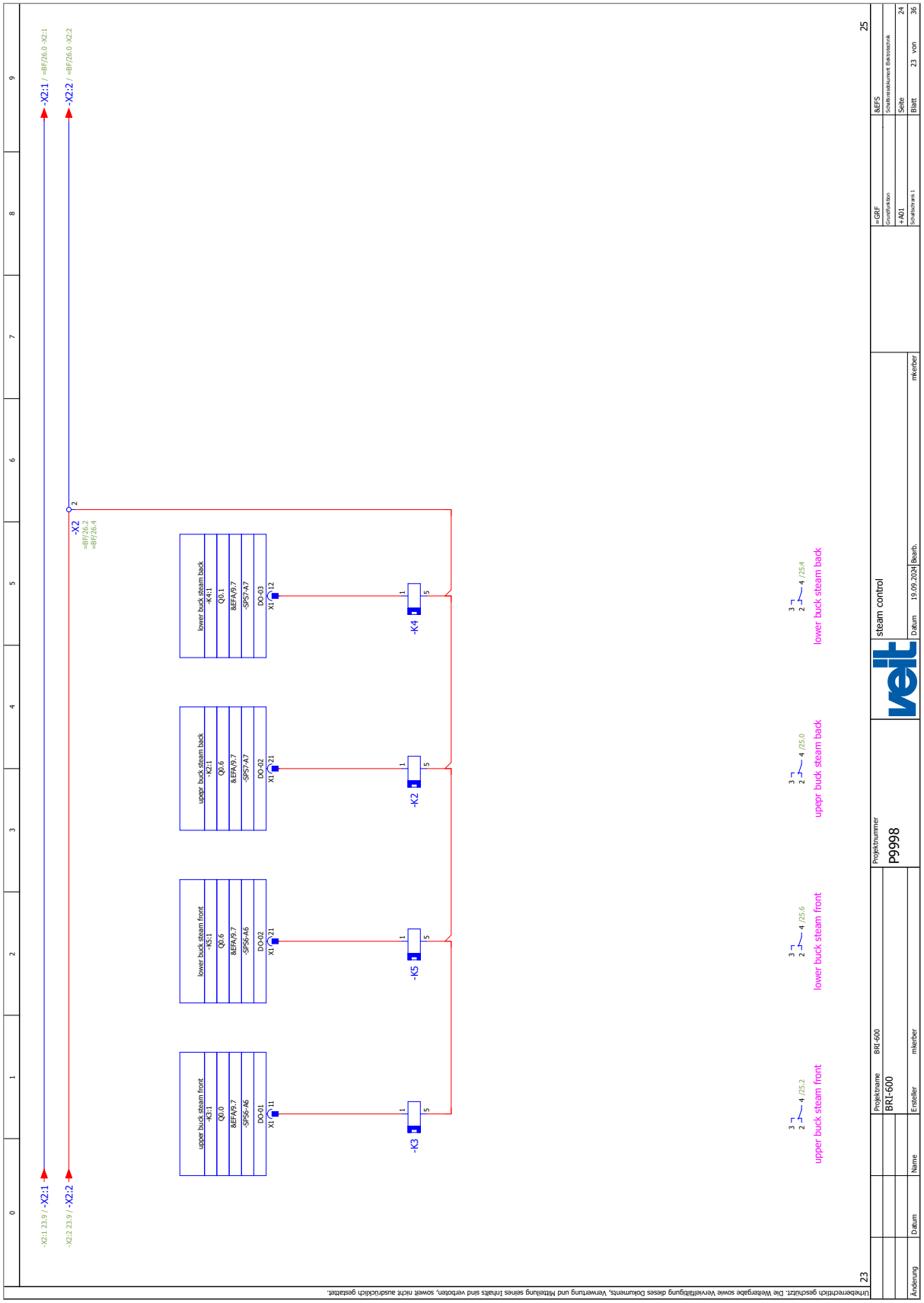
table up/down
P9998
BRI-600
upper buck front pressureless
upper buck back stop
upper buck back up/down
upper buck back fast/slow
upper buck back pressureless
-X2:1
-X2:2
-X2:PE
-16W1
-19W1
-19W2
-19W3
-19W4
-19W5
-Y11-MB1
-Y19-MB
-Y20-MB1
-Y21-MB1
-Y22-MB1
-X11
+M01
>+C01


upper buck press back
P9998
BRI-600
signal pressing pressure 1 bar back
signal pressing pressure 2 bar back
signal pressing pressure 3 bar back
signal pressing pressure 4 bar back
pedal blowing
buck back distance
buck back up
Druckschalter
-S26
-S27
-S28
-S29
-S18
-S19
-S20
-20W1
-20W2
-20W3
-16W1
+A02
+M01
-X2:1
-X2:2
-X2


upper buck press front
P9998
BRI-600
signal pressing pressure 4 bar front
signal pressing pressure 3 bar front
signal pressing pressure 2 bar front
signal pressing pressure 1 bar front
buck front distance
buck front down
+A02
Druckschalter
-S33
-S32
-S31
-S30
-20W3
-16W1
-21W1
-21W2
-S16
-S17
+M01
-X11
-X11
>+C01
>+C01
-X11


-X2:1
-X2:2
-X2
+M01
-22W1
-22W2
-22W3
-22W4
-Y13-MB
-Y15-MB
-Y25-MB
-Y27-MB
-S10-W1
-16W1
suction lower buck front
edge suction front
suction lower buck back
edge suction back
pedal suction
suction front/back
P9998
BRI-600


-X2:1 / 24.0
-X2:2 / 24.0
-X2:1 22.9
-X2:2 22.9
-X2
/22.7
upper buck aerate back
-Y29-MB1
Q0.0
&EFA/9.7
-SPS7-A7
DO-01
X1 11
upper buck aerate front
-Y17-MB1
Q1.3
&EFA/9.4
-SPS5-A5
DO-12
X1 26
-23W2
-Y29-MB
-23W1
-Y17-MB
+M01
upper buck aerate back
upper buck aerate front
only in BRI-600/101
P9998
BRI-600
blowing
19.09.2024
mkerber
=GRF
+A01
&EFS
Seite 23
Blatt 22 von 36
Änderung
Datum
Name
Ersteller
Projektname
Projektnummer
Urheberrechtlich geschützt. Die Weitergabe sowie Vervielfältigung dieses Dokuments, Verwertung und Mitteilung seines Inhalts sind verboten, soweit nicht ausdrücklich gestattet.


-X2:1 / =BF/26.0 -X2:1
-X2:2 / =BF/26.0 -X2:2
-X2
=BF/26.2
=BF/26.4
upper buck steam front
-K3:1
Q0.0
&EFA9.7
-SPS6-A6
DO-01
X1 11
-K3
upper buck steam back
-K2:1
Q0.6
&EFA9.7
-SPS7-A7
DO-02
X1 21
-K2
lower buck steam front
-K5:1
Q0.6
&EFA9.7
-SPS6-A6
DO-02
X1 21
-K5
lower buck steam back
-K4:1
Q0.1
&EFA9.7
-SPS7-A7
DO-03
X1 12
-K4
upper buck steam front
lower buck steam front
upper buck steam back
lower buck steam back
-X2:1 23.9 / -X2:1
-X2:2 23.9 / -X2:2
Projektname
BRI-600
Projektnummer
P9998
steam control
Datum
19.09.2024
Bearb.
mkerber
Ersteller
Name
Änderung
=GRF
&EFS
Schaltschrankbau Bielefeldschmk
+A01
Seite
24
Schaltschrank 1
Blatt
23 von 36
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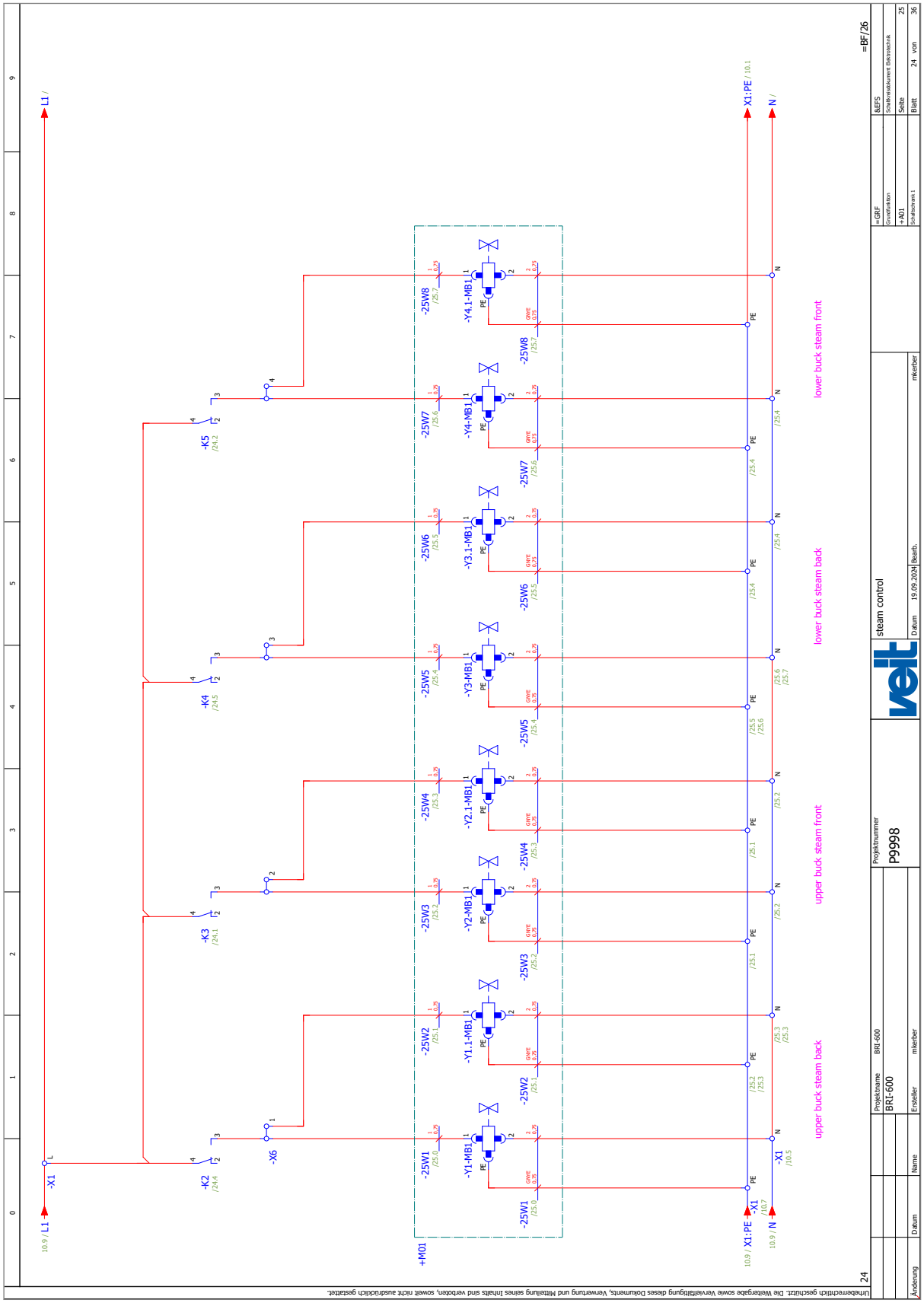
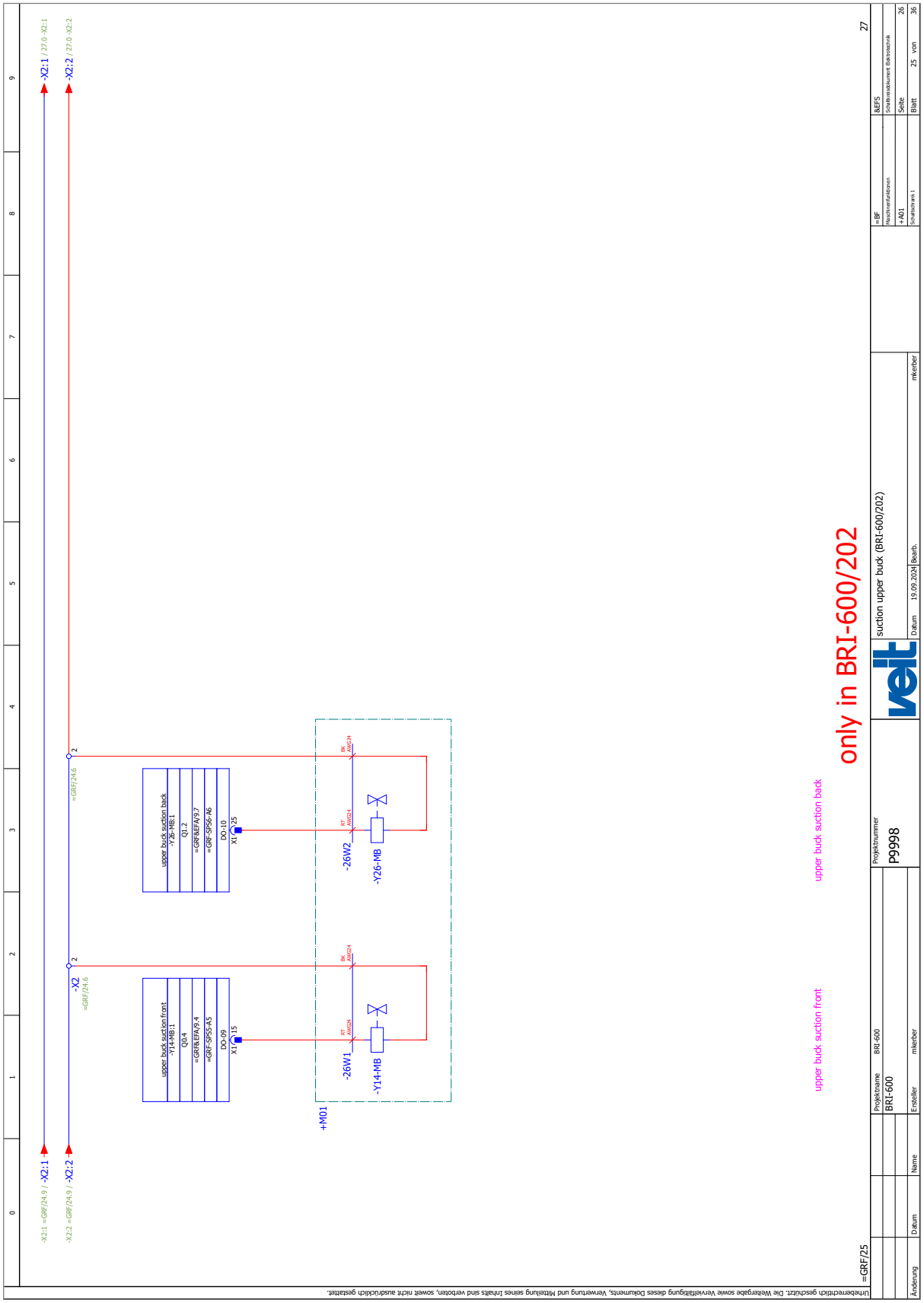

=BF/25
steam control
P9998
BRI-600
lower buck steam front
lower buck steam back
upper buck steam front
upper buck steam back
+M01
-X1
-X6
-K2
-K3
-K4
-K5
-Y1-MB1
-Y2-MB1
-Y3-MB1
-Y4-MB1
-Y1.1-MB1
-Y2.1-MB1
-Y3.1-MB1
-Y4.1-MB1
L1
N
PE
X1:PE


-X2:1 / 27.0 -X2:1
-X2:2 / 27.0 -X2:2
-X2:1 =GRF/24.9 / -X2:1
-X2:2 =GRF/24.9 / -X2:2
-X2
=GRF/24.6
upper buck suction front
-Y14-MB:1
Q0.4
=GRF&EFA/9.4
=GRF-SPS5-A5
DO-09
X1 / 15
upper buck suction back
-Y26-MB:1
Q1.2
=GRF&EFA/9.7
=GRF-SPS6-A6
DO-10
X1 / 25
-26W1
-26W2
-Y14-MB
-Y26-MB
+M01
only in BRI-600/202
upper buck suction back
upper buck suction front
Suction upper buck (BRI-600/202)
Projektname BRI-600
Projektnummer P9998
=GRF/25
Datum 19.09.2024
Bearb. mkerber
Ersteller mkerber
Name
Datum
Änderung
=BF Maschinenelektronen
+A01 Schaltschrank 1
&EFS Schaltschrankdokument Elektrotechnik
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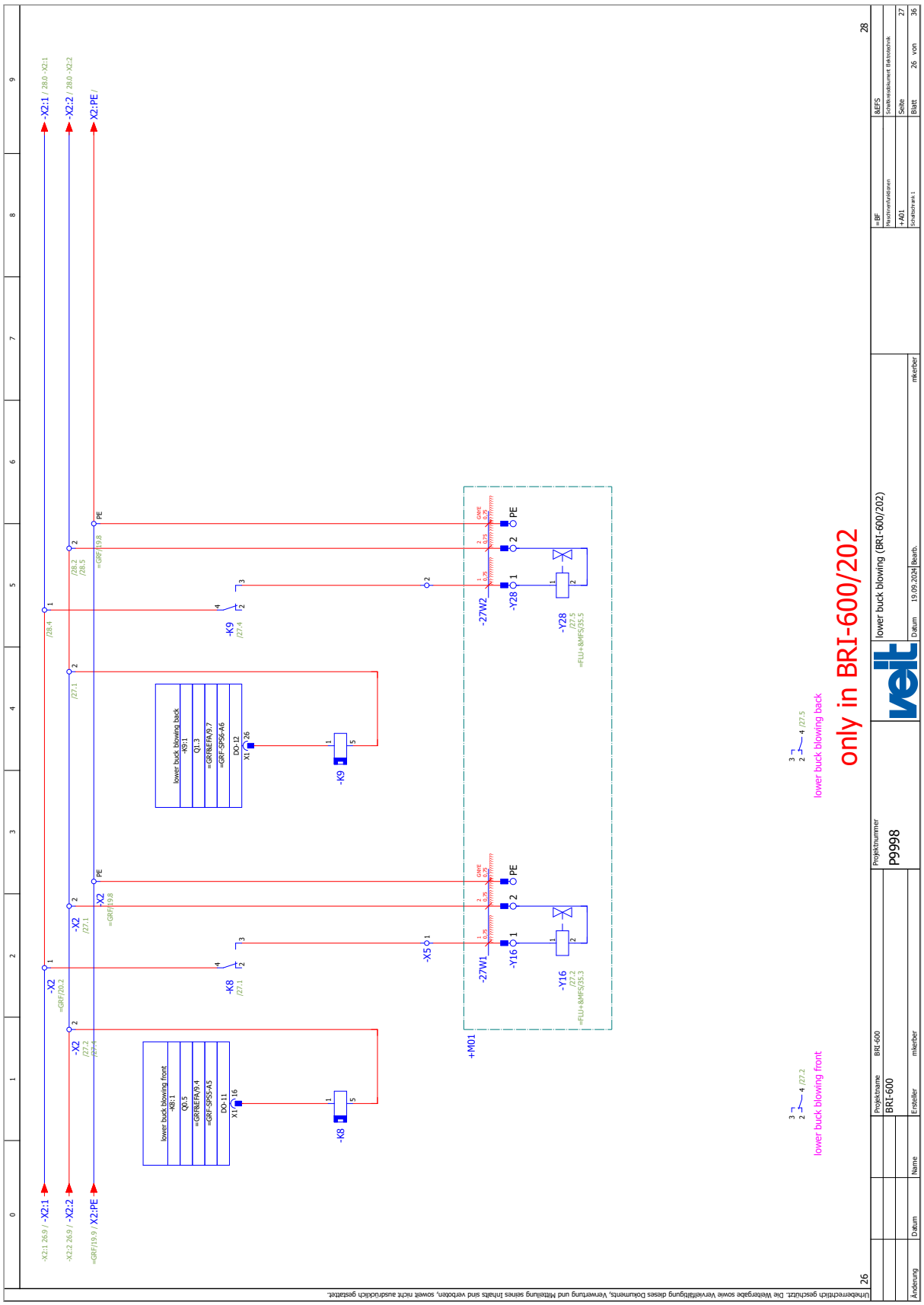
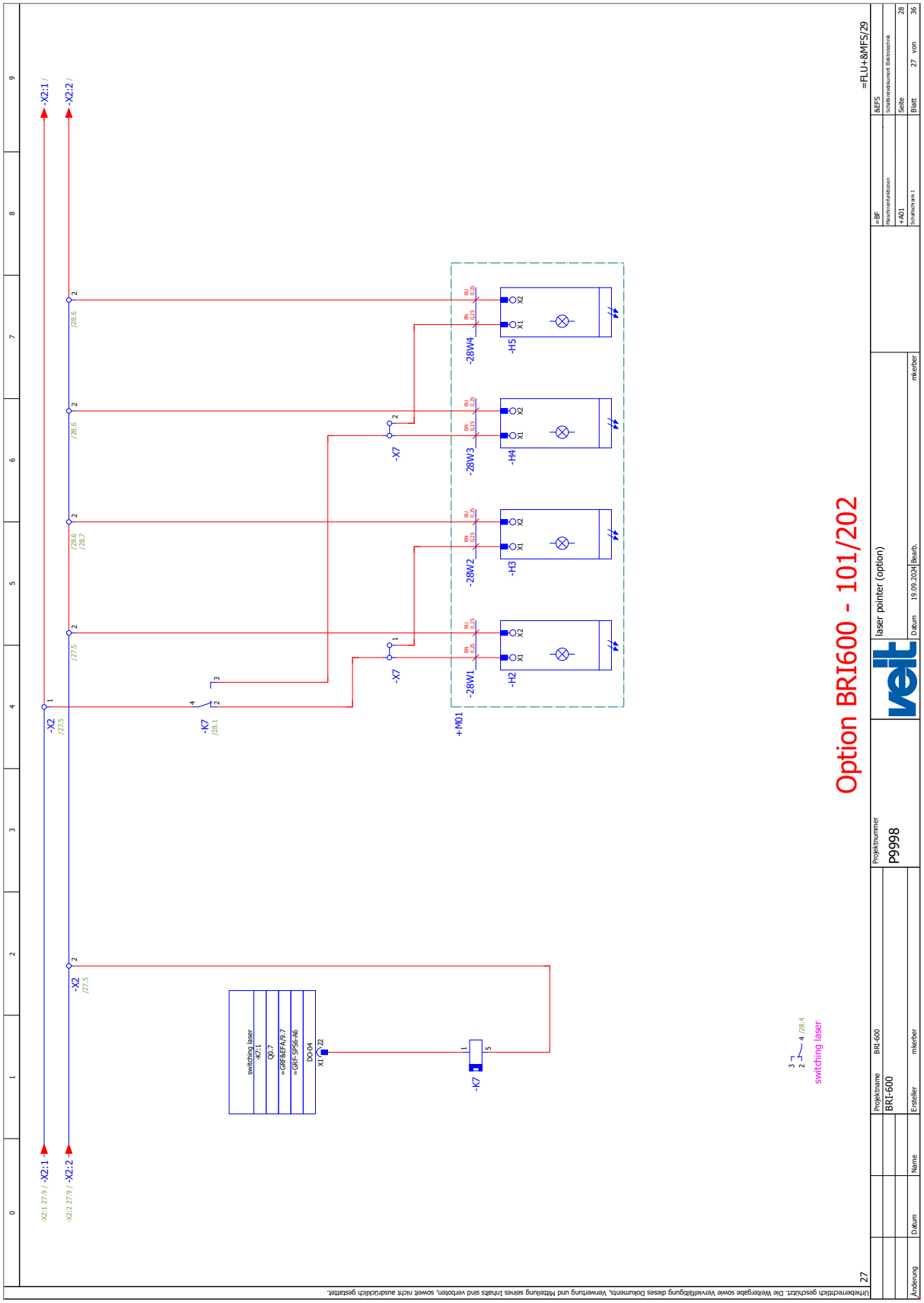
Unbefugte Weitergabe sowie Vervielfältigung dieses Dokuments, Verwertung und Mitteilung seines Inhalts sind verboten, soweit nicht ausdrücklich gestattet.


only in BRI-600/202
lower buck blowing front
lower buck blowing back
+M01
-K8
-K9
-X5
-27W1
-27W2
-Y16
-Y28
-X2
-X2:1
-X2:2
X2:PE
lower buck blowing (BRI-600/202)
BRI-600
P9998


=FLU+&MFS/29
Option BRI600 - 101/202
laser pointer (option)
P9998
BRI-600
switching laser
-X2:1
-X2:2
-X2
-K7
-X7
+M01
-28W1
-28W2
-28W3
-28W4
-H2
-H3
-H4
-H5
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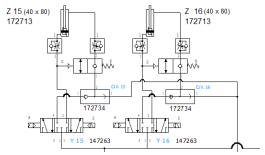
VEIT GmbH

Justus-von-Liebig-Str. 15
86899 Landsberg am Lech
service@veit.de

Pressing for Excellence

Fluid power



Project description	BRI-600
Project number	P9998
Company / customer	

Project name	BRI-600		
Project name		2024.0.3	21639

Technical data

Working pressure	6 bar
Druckluftqualität	Quality class 3 according to DIN ISO 8573-1
Dampfdruck	6 bar

Created on	08.07.2024				
Edit date	24.09.2024	by (short name)	mkerber	Number of pages	36

=BF+A01&EFS/28

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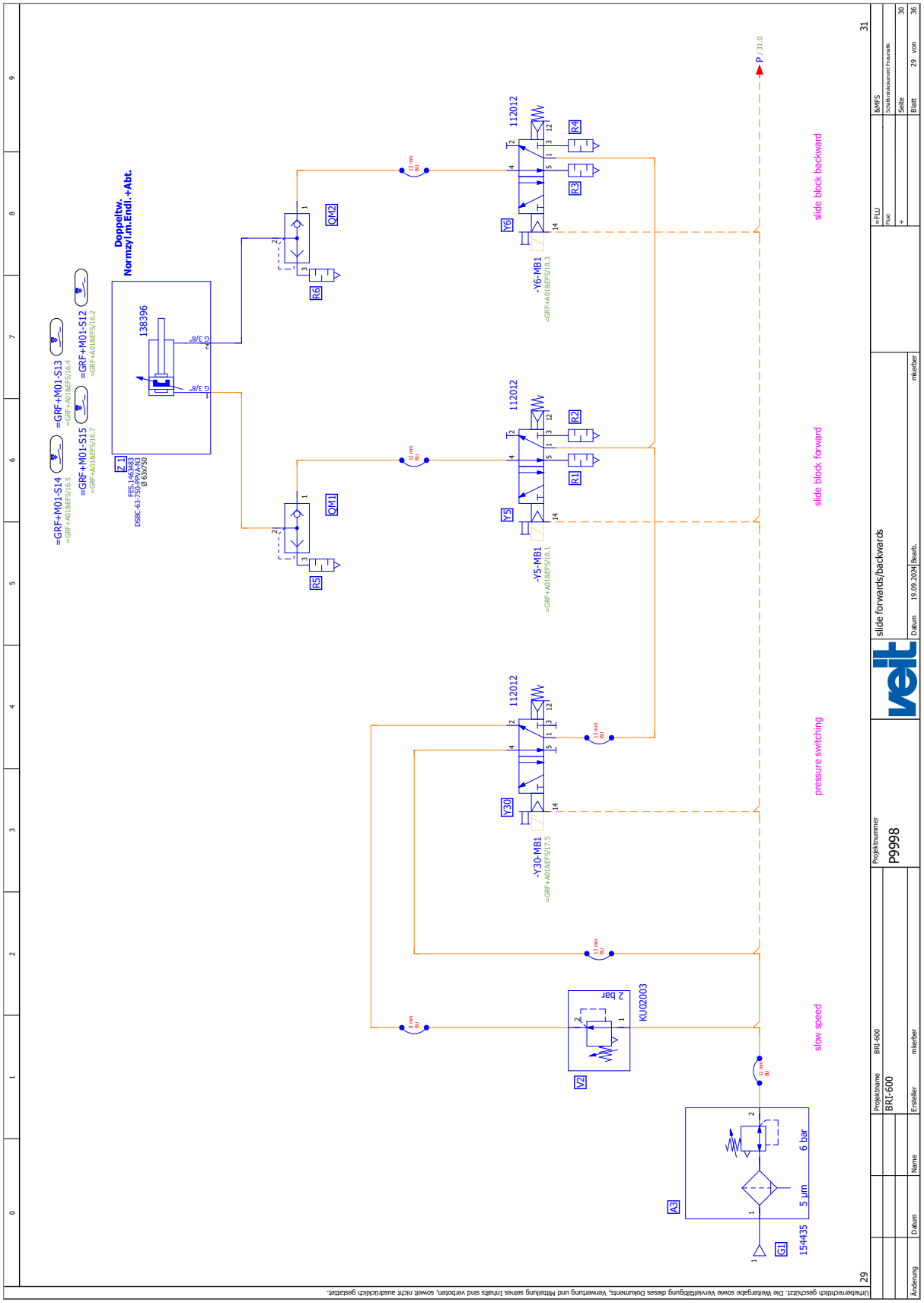
			Projektname BRI-600	Projektnummer	Title page / cover sheet		=FLU	&MFS
			BRI-600	P9998			Fluid	Schaltkreisdokument Pneumatik
							+	Seite 29
Änderung	Datum	Name	Ersteller mkerber		Datum 18.09.2024	Bearb. mkerber		Blatt 28 von 36


slide forwards/backwards
P9998
BRI-600
slide block backward
slide block forward
pressure switching
slow speed
Doppeltw.
Normzyl.m.Endl.+Abt.
138396
112012
KU02003
2 bar
6 bar
5 µm
154435
=GRF+M01-S12
=GRF+M01-S13
=GRF+M01-S14
=GRF+M01-S15
-Y6-MB1
-Y5-MB1
-Y30-MB1
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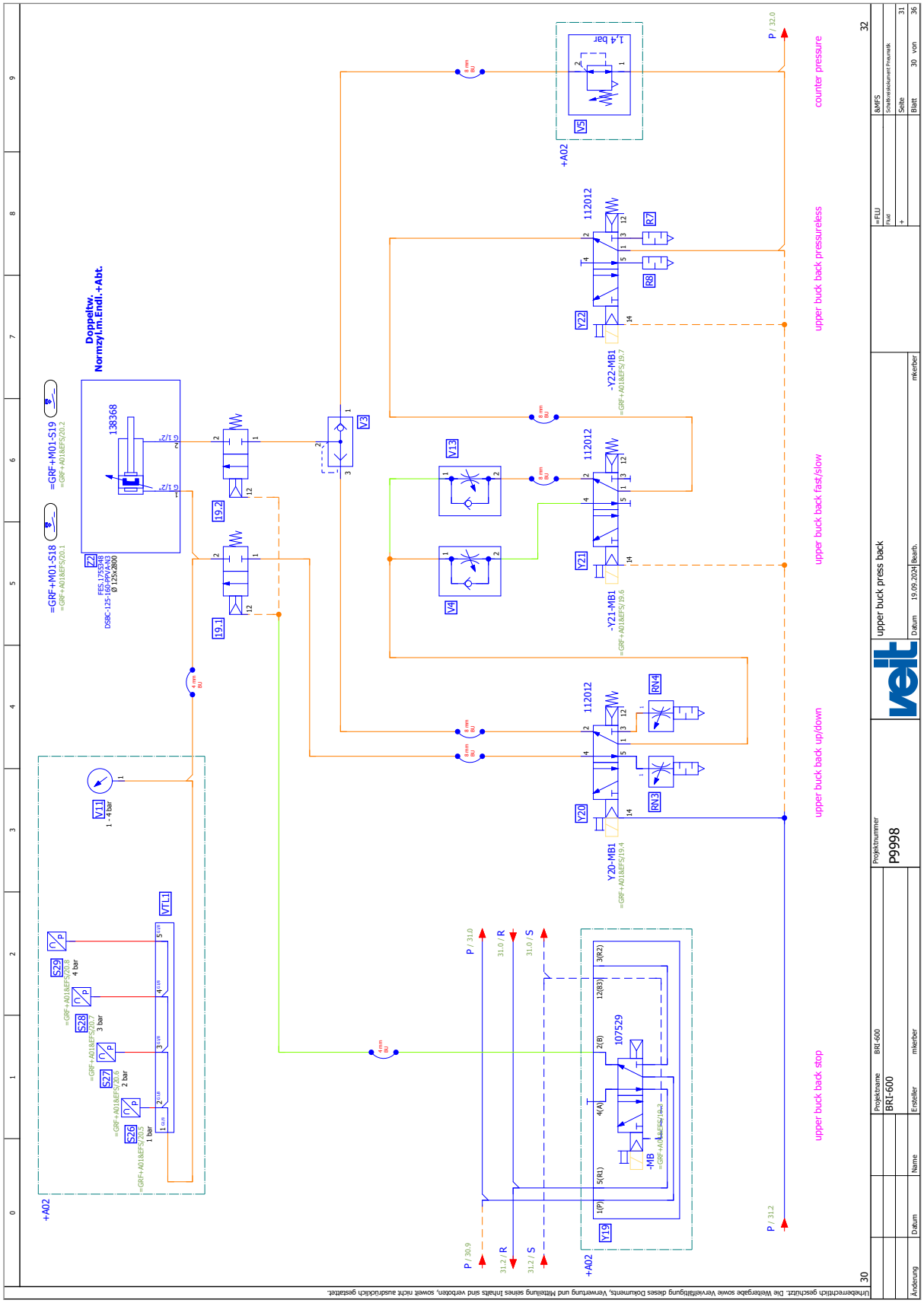
upper buck press back
P9998
BRI-600
upper buck back pressureless
upper buck back fast/slow
upper buck back up/down
upper buck back stop
counter pressure
Doppeltw.
Normzyl.m.Endl.+Abt.
+A02
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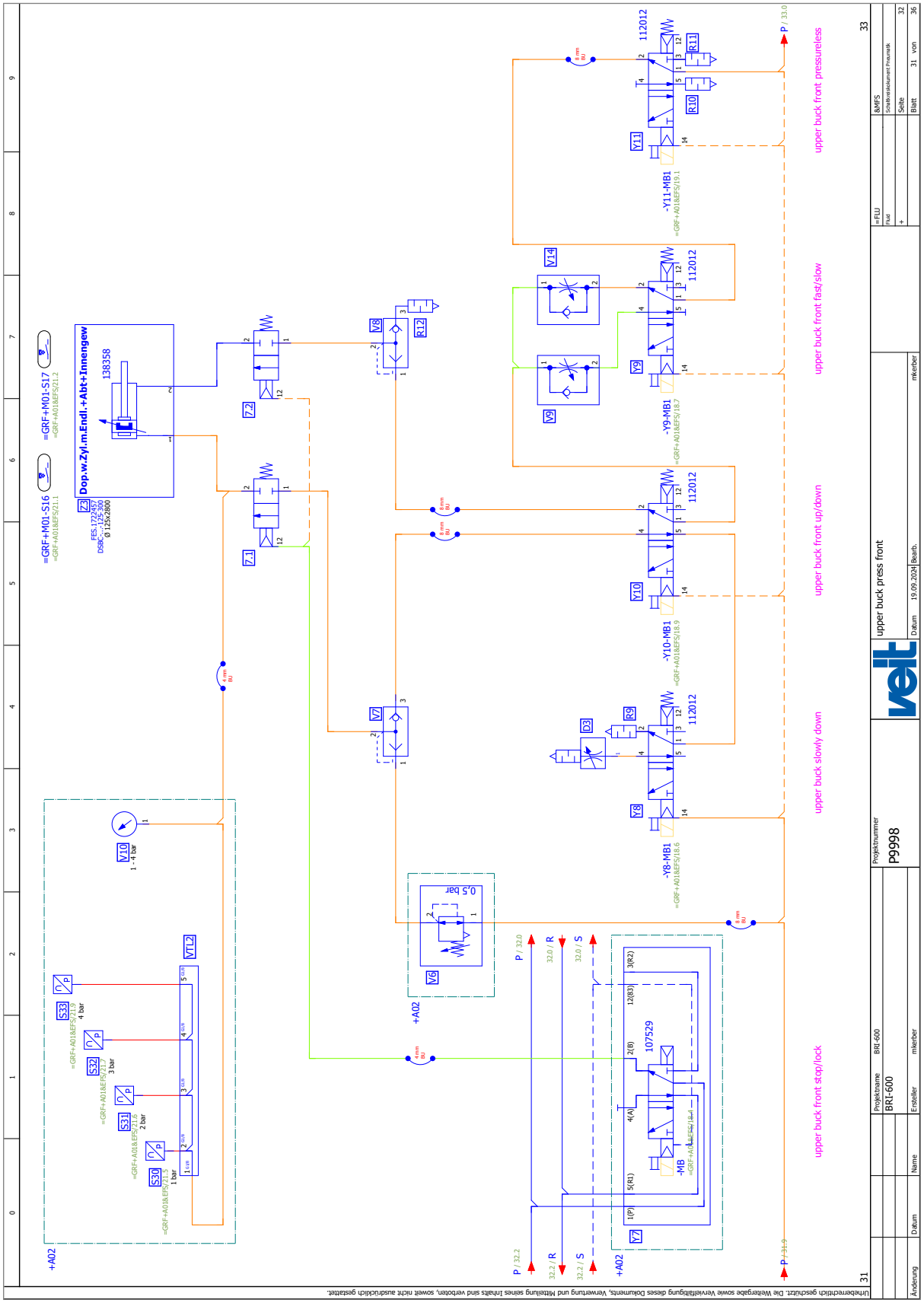
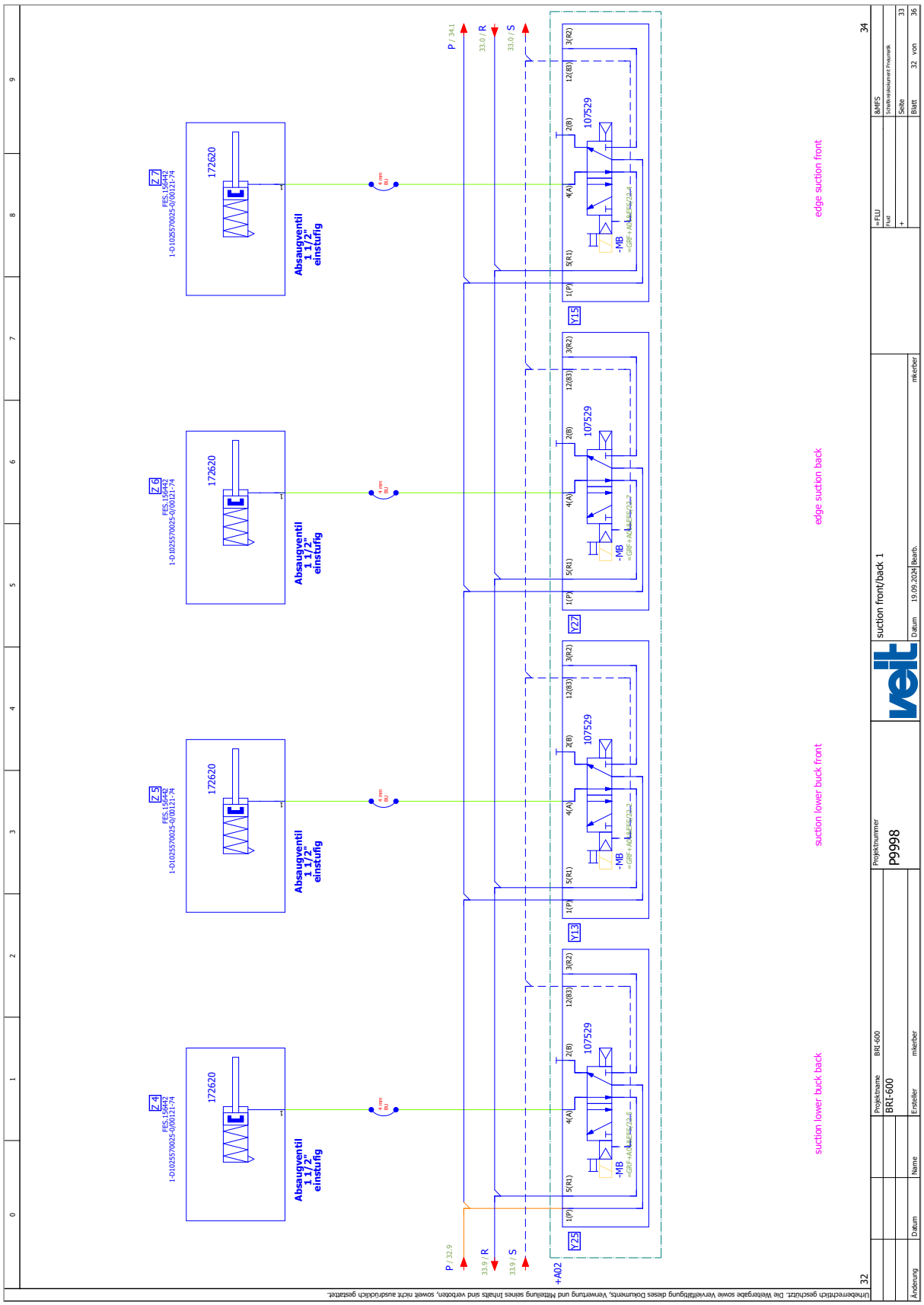
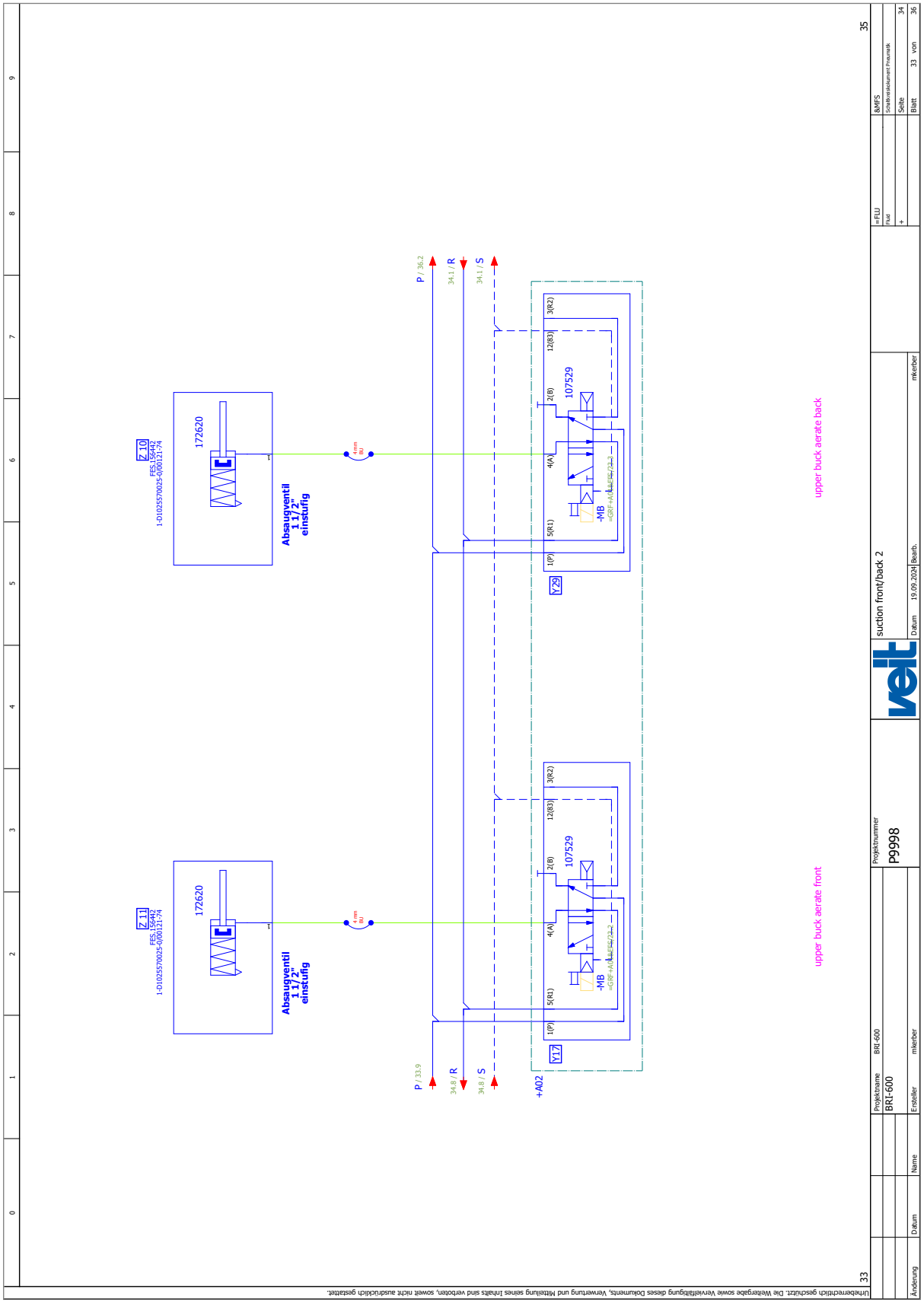

upper buck front pressureless
upper buck front fast/slow
upper buck front up/down
upper buck slowly down
upper buck front stop/lock
upper buck press front
P9998
BRI-600
Dop.w.Zyl.m.Endl.+Abt+Innengew
138358
112012
107529
0,5 bar
+A02
-Y11-MB1
-Y9-MB1
-Y10-MB1
-Y8-MB1
-MB
=GRF+M01-S16
=GRF+M01-S17
Unbefugte Weitergabe sowie Vervielfältigung dieses Dokuments, Verwertung und Mitteilung seines Inhalts sind verboten, soweit nicht ausdrücklich gestattet.


suction front/back 1
P9998
BRI-600
suction lower buck back
suction lower buck front
edge suction back
edge suction front
Absaugventil 1 1/2" einstufig
172620
107529
Y25
Y13
Y27
Y15
Z4
Z5
Z6
Z7
+A02
P / 32.9
33.9 / R
33.9 / S
P / 34.1
33.0 / R
33.0 / S


Z 10
FES.15G442
I-0102557002S-0/001121-74
172620
Absauguentil
1122
einsturig
Z 11
FES.15G442
I-0102557002S-0/001121-74
172620
Absauguentil
1122
einsturig
P /36.2
34.1 /R
34.1 /S
P /33.9
34.8 /R
34.8 /S
+A02
Y29
Y17
107529
-MB
upper buck aerate back
upper buck aerate front
Projektname
BRI-600
Projektnummer
P9998
Suction front/back 2
Datum
19.09.2024
Bearb.
mKember
Ersteller
mKember
Name
Datum
Änderung
=FLU
Fluid
+
&MFS
Schaltnetzelement Pneumatik
Seite
34
Blatt
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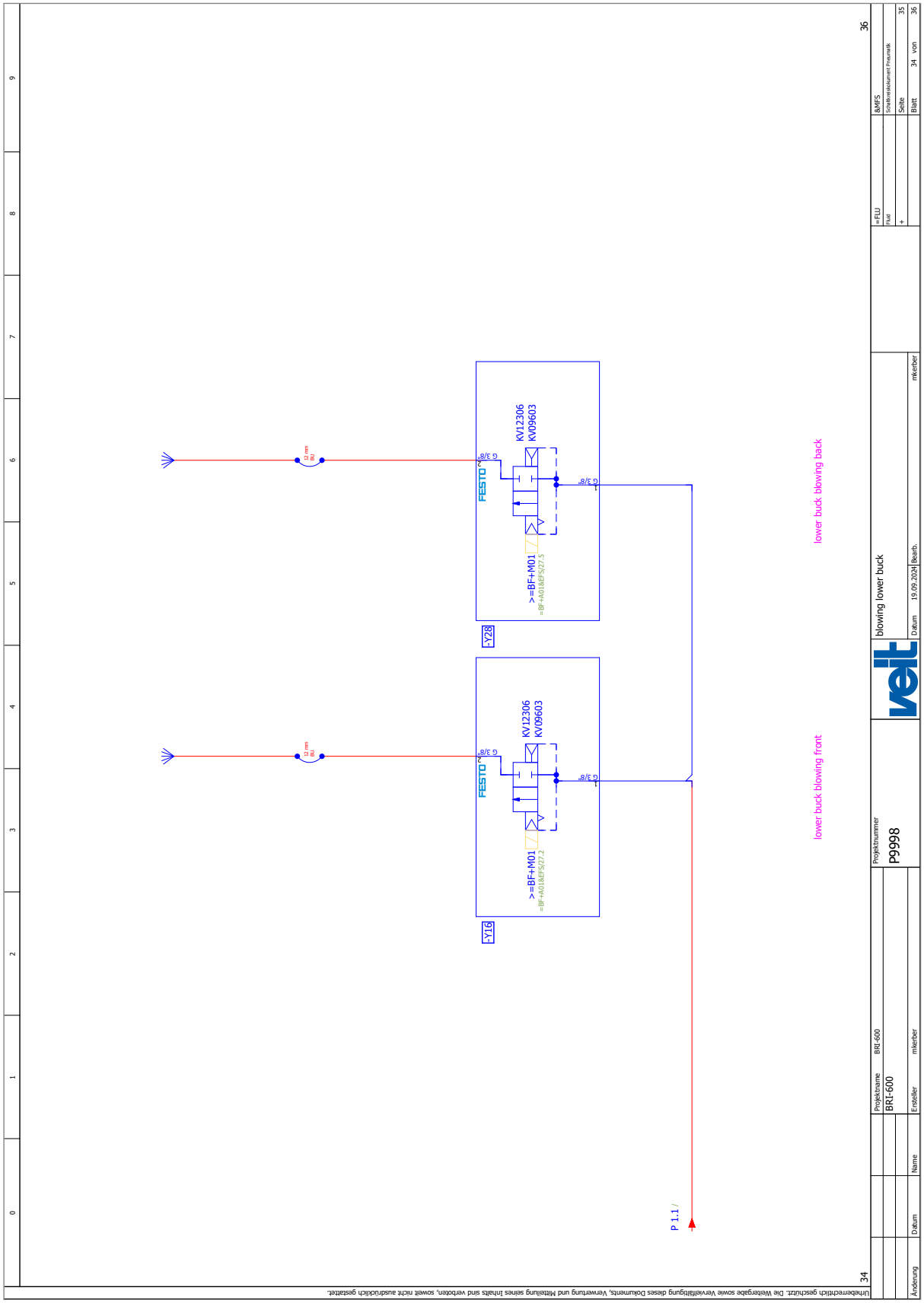
Unbefugte Weitergabe sowie Vervielfältigung dieses Dokuments, Verwertung und Mitteilung seines Inhalts sind verboten, soweit nicht ausdrücklich gestattet.


36
34
FESTO
KV12306
KV09603
>=BF+M01
=BF+A01&EFS/27.5
-Y28
FESTO
KV12306
KV09603
>=BF+M01
=BF+A01&EFS/27.2
-Y16
lower buck blowing back
lower buck blowing front
P 1.1
blowing lower buck
P9998
BRI-600
Projektname
Projektnummer
Ersteller
mkerber
Datum
19.09.2024
Name
Änderung
Seite
Blatt
34 von 36
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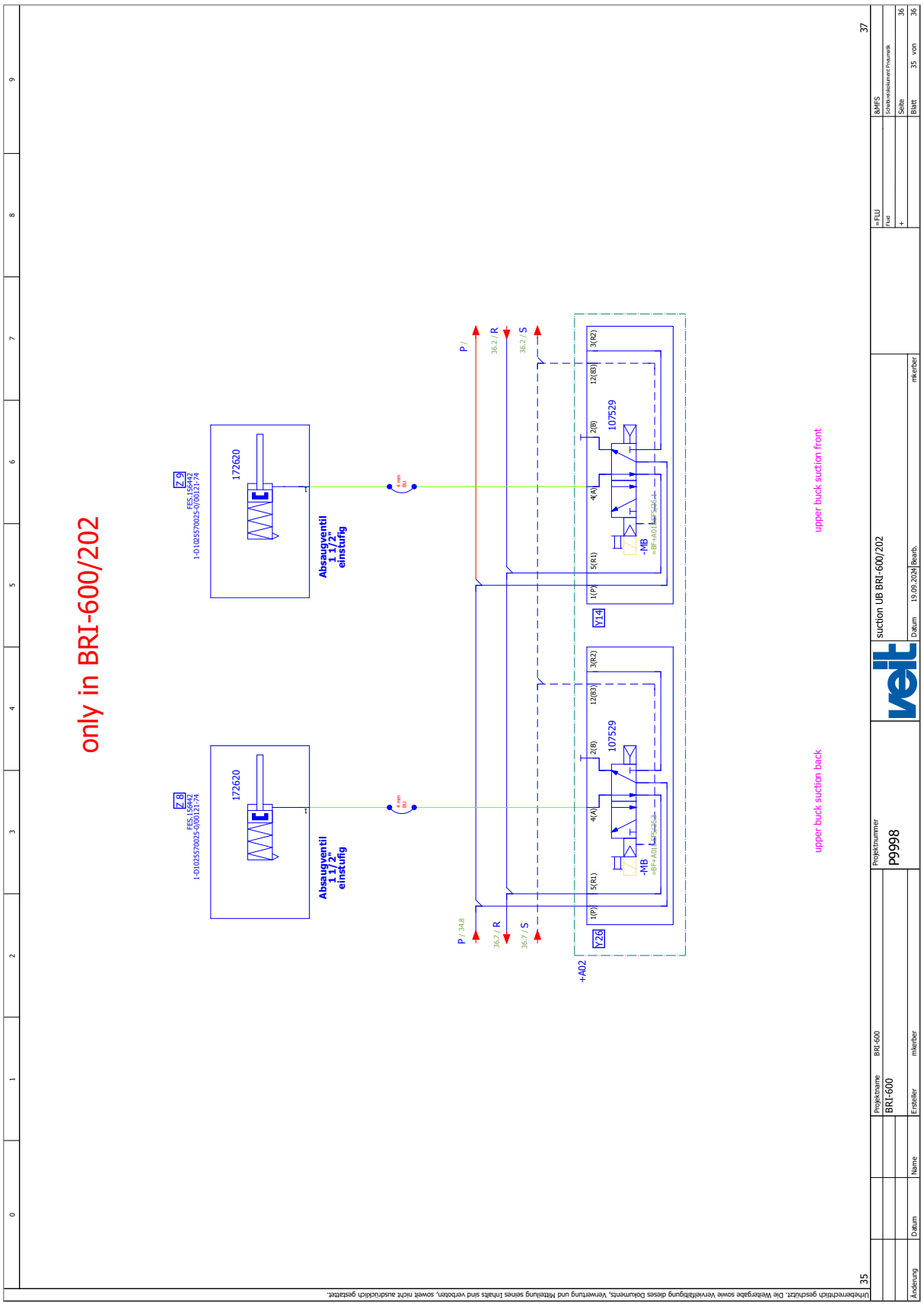
only in BRI-600/202
upper buck suction front
upper buck suction back
Absaugventil 1 1/2" einstufig
Absaugventil 1 1/2" einstufig
172620
172620
107529
107529
Y14
Y26
+A02
-MB
-MB
P / 34.8
36.7 / R
36.7 / S
P /
36.2 / R
36.2 / S
Suction UB BRI-600/202
P9998
BRI-600
BRI-600
Projektname
Projektnummer
Datum
Name
Ersteller
Änderung
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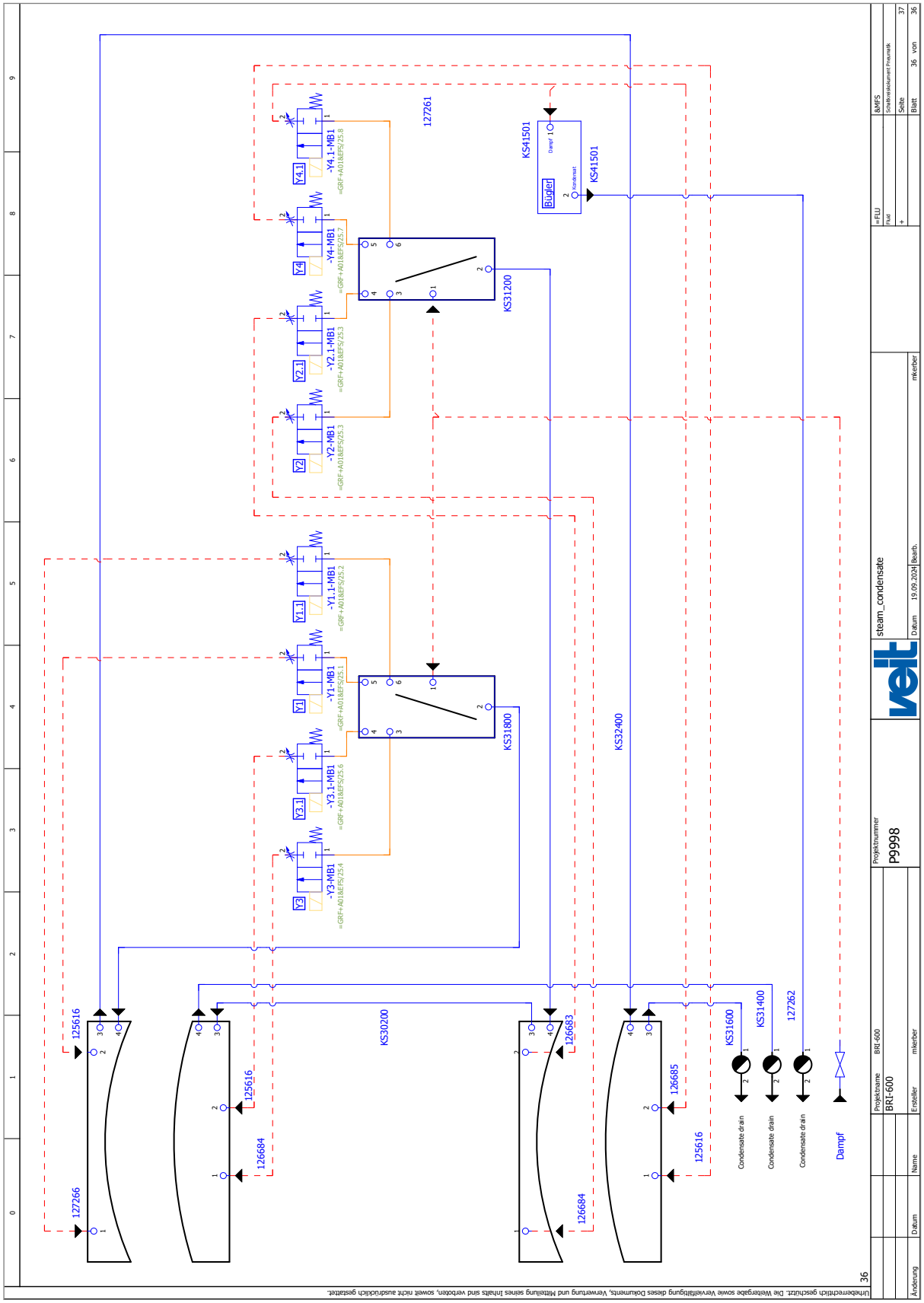
19.09.2024
mkerber
Unbefugte Weitergabe sowie Vervielfältigung dieses Dokuments, Verwertung und Mitteilung seines Inhalts sind verboten, soweit nicht ausdrücklich gestattet.


steam_condensate
P9998
BRI-600
Dampf
Condensate drain
Condensate drain
Condensate drain
KS41501
KS31200
KS31800
KS32400
KS30200
KS31400
KS31600
127261
127266
125616
126684
126683
126685
127262

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T

U

W