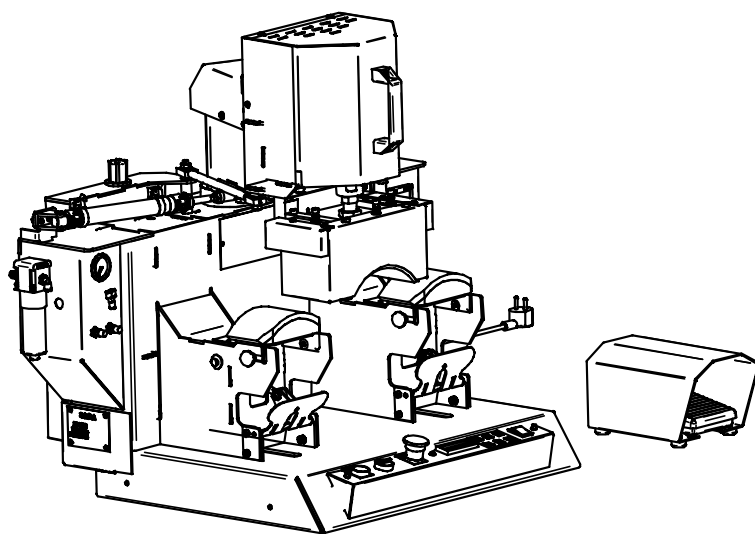


INSTRUCTION MANUAL

BR 180 PCAS



S.E.F.A[®]

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I. CONDITIONS OF GUARANTEE

- The guarantee period starts the day of putting the equipment into service at the user's place, for a duration of one year and for a common use of 8 hours per day.
- The guarantee is strictly limited to our equipments, against the defects of matter and execution, with the buyer's responsibility to prove the known defects.
- Our responsibility is limited to the obligation to rectify or replace free of charge the parts acknowledged as faulty by ourselves, and there will no claim for any indemnity whatever the reason given.

Parts replaced under the guarantee:

- Remain our property
- Are the subject of an invoicing of deposit

A credit of cancellation is activated as soon as the faulty parts are returned. The return will have to occur ONE MONTH MAXIMUM after the intervention.

THE GUARANTEE DOES NOT COVER:

- The retail consumables such as:
fuses, bulbs, transformers, joint, flexible devices...
- The supplies, which are not our own manufacturing, undergo the guarantee of their manufacturer.

THE GUARANTEE DOES NOT APPLY :

- To replacements, nor repairs which would result from normal wear and tear of apparatus and machines, of deteriorations and accidents coming from negligence, defect of monitoring and maintenance, defective use or modifications without our written agreement.
- In case of vice coming from the material supplied by the buyer, or a design imposed by the latter.
- To repairs which would result from deteriorations or accidents occurred during transport.
- To operations of maintenance and adjustments inherent in the use of the machine, and indicated in the maintenance manual, such as:
adjustments of intermediaries, screwing of piping, etc... do not enter the clauses of guarantee.



For the pneumatic machines, any trace of detergent oil in the pneumatic circuit inhibits the conditions of guarantee previously mentioned.

**For any technical information or spare parts orders,
please give the reference number of the machine as well as its serial number.**

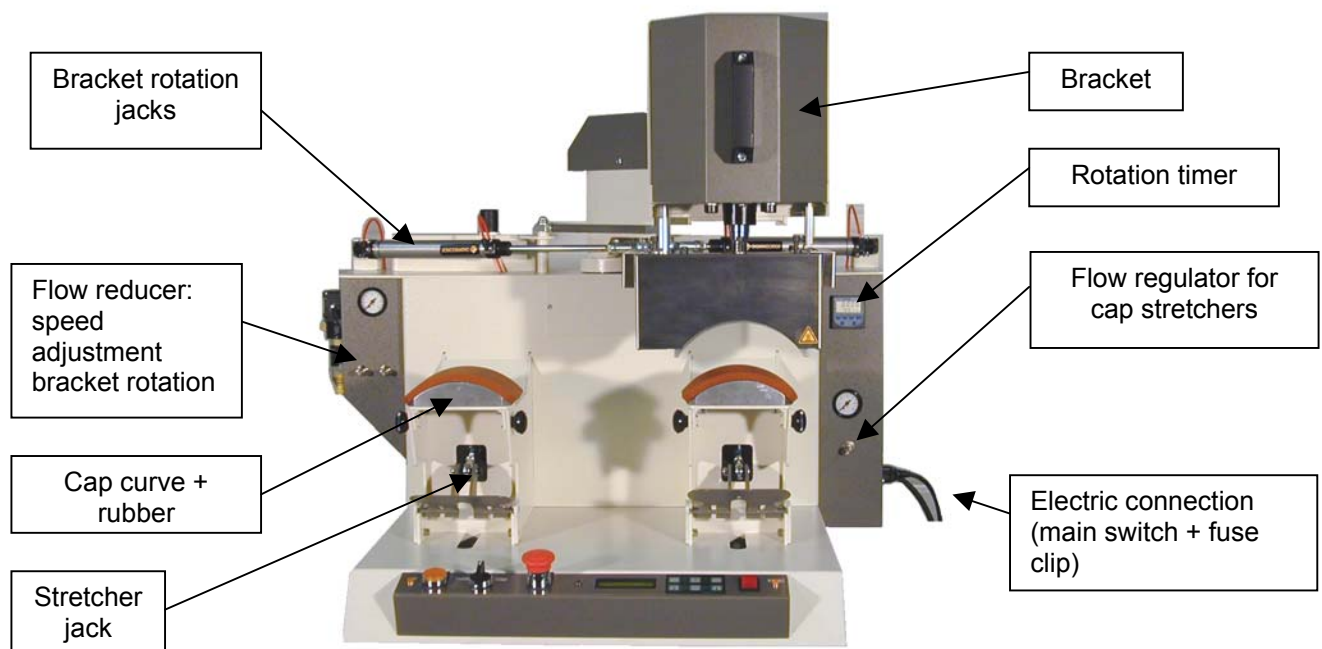
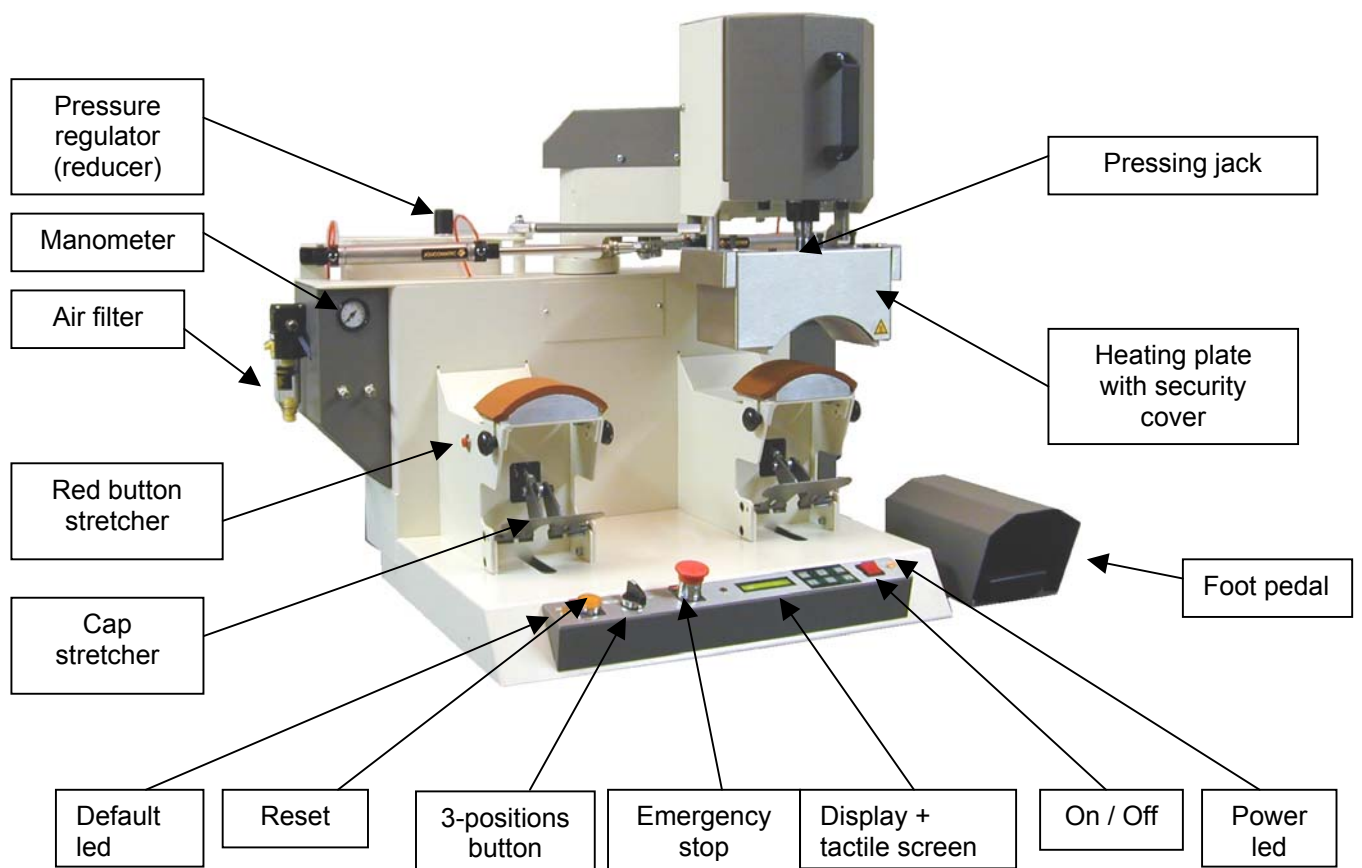
II. SPECIFICATIONS

Poids en ordre de marche / Weight in running order	155 kg
Hauteur / Height	570 mm
Profondeur / Depth	700 mm
Largeur / Width	970 mm
Dimension du plateau / Dimension of the heating plate	180 x 80 mm
Alimentation électrique / Electric power supply	220 V Monophased + earth 50/60 Hz
Alimentation pneumatique / Pneumatic power supply	10 bars maximum
Puissance / Power	900 W
Ampérage / Ampérage	4 A
Régulateur électronique de température à affichage digital / Thermoregulator	
Précis à / Accurate to	+/- 1%
Réglable de / Range of control	0 to 255 °C
Minuterie électronique/ Timer	
Précis à / Accurate to	+/- 2%
Réglable de / Range of control	1 to 255s
Minuterie électronique multigamme cycle / Timer	
Précis à / Accurate to	+/- 2%
Réglable de / Range of control	0.01s to 9999h
Pression de travail / Working pressure	
Mini	2 bars
Maxi	8 bars
Cadence	1 700 pieces / day

Non contractual document: according to the technical progress, we reserve the right to modify the characteristics of our products.

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11260 ESPERAZA	FAX: 33(0)4.68.74.24.08
FRANCE	
MODELE	
N° DE SERIE	
PUISSANCE	
VOLTS	
	Année de Fab.
Made in France By S.E.F.A 	

III. GENERALITIES



This heat seal press is conform to article L 233-5 of labour laws to ensure the user's security. Its design allows it to ensure an intensive production while keeping a total reliability.

This press was designed for an operator working opposite the machine.

IV. USE OF THE MACHINE

The BR 180 PCAS press was designed for transfer application of all qualities in great mass production. This equipment was tested in our workshops to obtain a one-year guarantee against any manufacturing vice.

The adjustments (pneumatic, electric and mechanic) carried out by our technicians (in workshop or in situ) as well as the securities introduced on the machine must not be modified in any case. Otherwise, the company SEFA deny all responsibility on potential problems linked to the so-called machine.

Before starting any operation of pressing, it is recommended to read carefully the safety instructions as well as the directions for use.

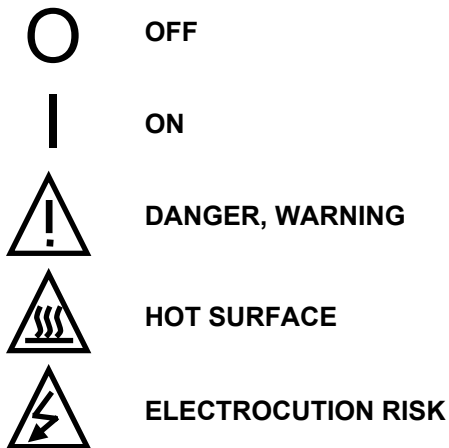
The press will have to be used by an enabled person who would have been informed of the risks which can be caused by wrong use of the equipment.

1. SAFETY

THIS EQUIPMENT IS DESIGNED FOR SINGLE USE ONLY

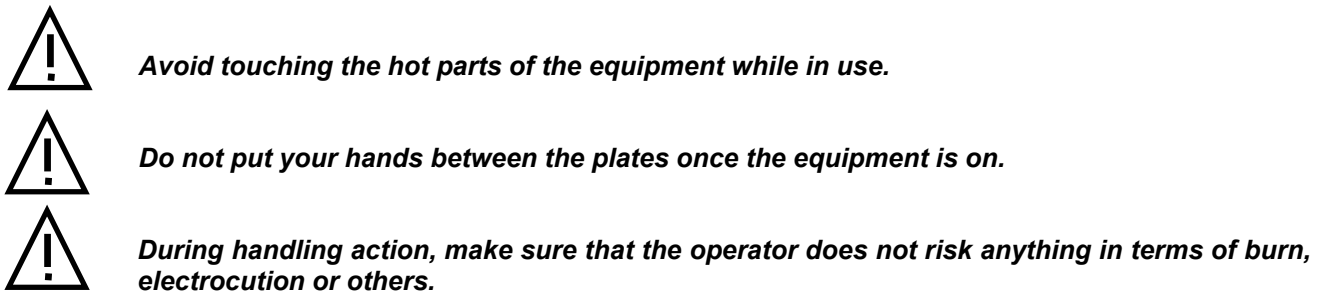
USE BY QUALIFIED STAFF ONLY

International symbols:



You will find most of these symbols on the SEFA machines.

Some important points for the staff safety:



Safety devices on the machine:



***The security protections and devices should not be modified. They must be put together again in case of possible removal for maintenance.
They must be kept in place and in good condition during normal operation.***

The BR 180 PCAS is equipped with safety devices protecting the operator from any risk of pinching. The main safety elements are:

The heating plate cover

It is linked to an electronic card by two cables. If one of them happened to be disconnected, the card would put itself in default and would block the machine.

This cover is positioned so that the heating plate is back inside this one: if the cover meets an obstacle, it will go back up and will touch the contacts situated on the top before the obstacle hits the heating plate.

If the operator hits the protection cover, the rotation is immediately interrupted and the left light will go on.

To restart the cycle, the operator will have to press on the "Réarmement" button so as to switch the right light. If this light does not go off, it means that the plate is not in thrust or that the security is not deactivated.

The emergency stop

Situated in the middle of the front: if the operator uses it, it switches the machine off.

Checking of the operation of the safety device:

- Try the emergency stop periodically,
- Test the cover daily: in touching it, the security led on the front should light on.

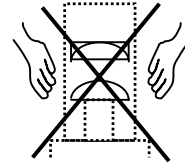
2. INSTALLATION

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Do not manipulate the machine by the plates!

Unpack the machine from its box.
Place it on a stable table manipulating it by its frame.



After having properly positioned the equipment on its working place:

- Electrically plug the press in (220 Volt + Neutral + Earth / 50 or 60 Hertz),
- Pneumatically connect the press (DN9 network pressure 8 bars).

3. DESCRIPTION OF THE RUNNING CYCLE

1. The operator will have to turn the main switch on so that the machine is powered up,
2. Press on the red switch On / Off and on the Réarmement button (order either way),
3. Set the temperature to 180° (or to define according to the type of transfer) See SETTING §1,
4. Set the application time to 15 seconds (or to define according to the type of transfer) See SETTING §1,
5. Set the pressure to 6 bars (or to define according to the type of transfer),
6. Position the cap on the curve,
7. Press on the red button situated on the curve support to action the cap stretcher,

(if the cap is not properly positioned on its curve, press on the stretcher red button (see photo page 4) of the opposite curve, without releasing, action the one which corresponds to the station used. The stretcher will release the cap and the user will be able to replace it. Then, press on the red button of the station used to stretch the cap)

8. Adjust the transfer sheet,
9. On the « 1P / Manu / Auto » button, select the mode you wish,
10. At the end of pressing, the stretcher will automatically release the cap.

1 POSTE: this selection allows the user to only work on one curve:

✓ An impulse on the foot pedal will make the heating plate swivel in order to press one curve. *If on the first impulse on the pedal, the heating plate swivel, but does not press, on the second impulse, the cycle will start normally.*

✓ At the end of the timer count down, the plate will go back up and will clear automatically to position itself above the opposite plate and will stay in position until the operator presses on the pedal to start a new cycle. The plate will then come back pressing the used curve.

MANU: this selection will authorize the use of the pedal:

✓ When the operator presses on the pedal, the heating plate will swivel to position itself above the opposite curve. Arrived in position, it will go down automatically. At the end of the timer countdown, the plate will go back up and will stay in position until the operator presses on the pedal to start a new cycle.

AUTO: this selection prohibits the use of the pedal but needs the programming of a time on the timer situated to the right of the machine.

The operator will have to start the cycle pressing on the pedal; the heating plate will swivel to position itself above the opposite curve. Arrived in position, it will go down automatically. At the end of the timer count down, the plate will go back up and will stay in position until the rotation time selected on the timer has run out.

✓ This time is the difference between the time of unloading / loading of an item on a curve and the pressing time. As soon as this time has run out, the plate rotation will happen automatically.

**THE PRESSING TIME CAN BE INTERRUPTED AT ANY TIME USING THE PEDAL
THE PLATE WILL THEN CLEAR THE PRESSING STATION AUTOMATICALLY**

V. SERVICE

USE BY QUALIFIED STAFF ONLY
**ANY SERVICE INTERVENTION MUST BE DONE WHEN THE MACHINE IS OFF AND LOCKED
(ELECTRIC AND PNEUMATIC ENERGIES UNPLUGGED)**

It is recommended to have the following tools within reach:

- End and cruciform screwdriver
- A set of spanners
- Small adjustable pliers
- Long and fine pliers with insulating handle
- A set of Allen keys



Before any handling, check that the heating plate temperature is lower than 25°C on the display unit.

1. PARTS SUBJECTED TO WEAR AND TEAR

On any order : precise the reference, the description and the quantity

<u>Reference</u>	<u>Description</u>	<u>Quantity</u>
<u>ELECTRIC EQUIPMENT</u>		
MIN-160	MULTIFONCTION TIMER 741	1
CAR-180	CARTRIDGE 300W	3
FUS-149	FUSIE 5 A	1
CAR-358	CONTROL ELECTRONIC CARD	1
FIN-231	MICRO SWITCH WITH TONGUE	2
AUT-195	PROGRAMMABLE AUTOMATON	1
<u>PNEUMATIC EQUIPMENT</u>		
VER-175	JACK Ø16 C50mm	2
VER-030	JACK Ø25 C140mm	1
VER-132	JACK Ø25 C140mm magnétique	1
VER-148	JACK Double Effect Ø80 C80	1
DIS-125	DISTRIBUTEUR 5/2 G1/8	3
DIS-136	DISTRIBUTEUR 5/3 G1/8	1
ELE-003	SOLENOID VALVE 220V	3
PNE-054	PNEUMO-ELECTRIC	2
<u>PRESS COVER</u>		
MOU-001	SILICONE RUBBER 914x914x9.53	0.5

2. REPLACEMENT OF USED PARTS

- **Silicone rubber mat**
 - a) Check that the plate is cold.
 - b) Make sure that the curve surface is thoroughly clean. Possibly use a soft solvent such as white spirit.
 - c) Use a tube of glue RTV-1 to stick the rubber to the curve in aluminium (NB: read the instructions on the tube packaging).
 - d) The mat and the plate must be clean and dry before starting gluing.
 - e) Spread a fine homogeneous coat of glue on the curve and immediately apply the cover making sure that there is no air lock (NB: an indented spatula similar to the one used to lay tiles would suit perfectly).
 - f) Leave to settle overnight at room temperature with slight pressure and without heat.

3. MAINTENANCE

The heal seal presses SEFA require hardly any maintenance. To ensure a good running, follow the preventive instructions indicated below:

- Do not heat up objects which could deteriorate or even cut the silicone rubber or damage the teflon surface of the heating plate
- Every so often and when the plate is cold, clean the machine with a clean cloth and white spirit (NB: as this product is flammable, use with care and keep it away from any heat source)
- When the heating plate is hot and unused, keep it in open position.

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Different codes delivered by the regulation card call for a service:

<u>Code R1 :</u>	Appears on the screen when the machine has been heating for 9 300 h that is to say about 5 years ◆ Do a general servicing. See your retailer.
<u>Code R2 :</u>	Appears on the screen when the machine has reached 60 000 knocks ◆ Check the moving parts + code R4.
<u>Code R3 :</u>	Appears on the screen when the machine has reached 240 000 knocks ◆ Change the pads (Teflon) and control the state of the micro switch and the resistors electric wires.
<u>Code R4 :</u>	Appears on the screen when the machine has reached 30 000 knocks ◆ Visually control the state of the electrical and pneumatic components as well as the state of the materials.
<u>Code R5 :</u>	Appears on the screen when the machine has reached 600 000 knocks ◆ Change the jack joints + code R4.
⇒	TO DELETE THE MESSAGE REGARDING THE SERVICING : REFER TO THE USER MANUAL REG 2000

4. POSSIBLE BREAKDOWNS

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a) ELECTRICAL BREAKDOWNS

SYMPTOMS	POSSIBLE BREAKDOWNS	REPAIRS
The plate will not heat	➤ The fuses are out of order ➤ See messages displayed on the LCD screen	➤ If no light on the press goes on, check the fuse, change it if necessary. GENERAL FUSE situated in a casing next to the power cable plug (5 A). To access it, remove the power cable, with the tip of a pen or a screwdriver lift the casing of the fuse. You will find a replacement fuse in the square tube to put instead of the one in the clip. CARD FUSE situated on the electronic card (0,8A). ➤ Use the manual REG 2000 and/or contact your retailer.
The plate overheats	➤ See messages displayed on the LCD screen	➤ Use the manual REG 2000 and/or contact your retailer.
The pressing count down will not count down	➤ The pneumo-electric is not activated or is faulty	➤ Check if the pneumo-electric is not faulty. Replace it if necessary.
The rotation timer will not count down	➤ The connections are disconnected	➤ Check the state of the connections.
The rotation will not happen	➤ The security cover is activated ➤ The magnetic microswitch of the rotation jack is not activated or is faulty	➤ Check that the security microswitches are not actionned. ➤ Check that it goes on when it is activated. Replace it if necessary.
The plate stays in low position	➤ The timer will not count down	➤ Check it and change it if necessary. ➤ Check if the pneumo-electric is properly activated.

b) PNEUMATIC BREAKDOWNS

The plate will not go down	➤ The pneumo-electric connection is faulty ➤ The compressed air pressure is not sufficient	➤ Check it and change it if necessary ➤ Check if the network pressure is sufficient(min 2.5 bars)
The rotation will not happen	➤ The jacks are faulty	➤ Check them and change them if necessary
The stretchers will not work	➤ The jacks are faulty	➤ Check them and change them if necessary

VI. PRESS SETTINGS

UTILISATION PAR DU PERSONNEL QUALIFIE

1. TEMPERATURE SETTINGS / PRESSURE TIME

These parameters must be programmed in the control electronic card thanks to the keyboard.

- a) **TEMPERATURE SETTING** (See instruction manual REG 2000)
- b) **TIME SETTING** (See instruction manual REG 2000)

2. PRESSURE ADJUSTMENT

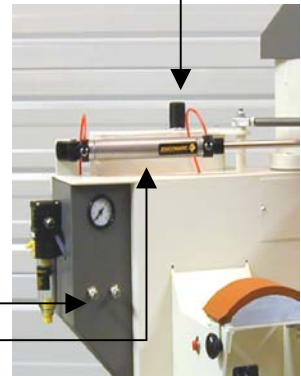
The jack pressure can be modified according to the user's need.

Use the pressure regulator situated on the left of the press
The pressure will be displayed on the manometer dial:

- ↻ in actioning the regulator clockwise
you will increase the pressure,
- ↻ in actioning the regulator anticlockwise
you will decrease it.

3. ROTATION SPEED ADJUSTMENT

Use the flow reducers situated on the left of the machine.
They act on two small jacks visible on the frame.



4. STRETCHER STRENGTH ADJUSTMENT

Use the flow regulator situated on the right of the machine.
They act on the 2 small jacks, cap stretchers.

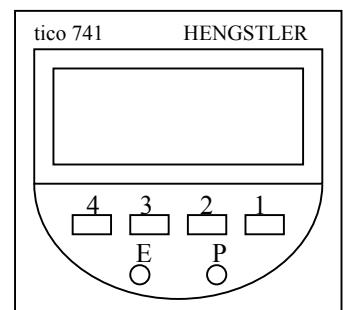
5. ROTATION TIME SETTING

This setting is executed by the timer on the right of the press.
To modify the rotation time of the machine head:

- Press on the keys 1 to 4
(they allow to modify the figures of which they hold the number),

In any case do not touch keys P and E (programming mode).

NB: The time indicated must not be lower than 2 seconds.



VII. HEATING ELEMENT

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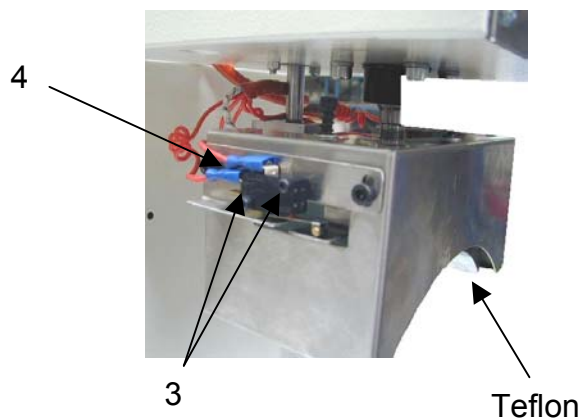
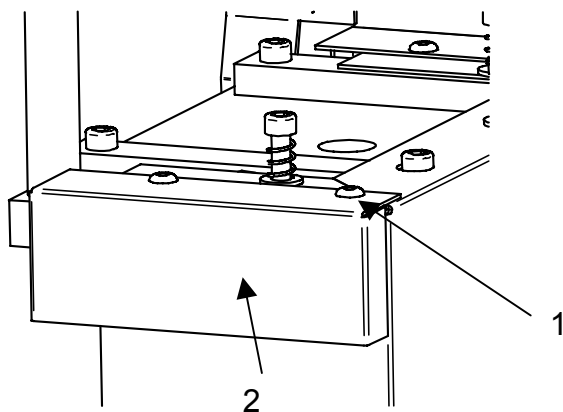
CAUTION : operation to be done on cold plate



***Protections and security devices should not be modified. They must be put together again in case of possible removal for maintenance.
They must be kept in place and in good condition during normal operation.***

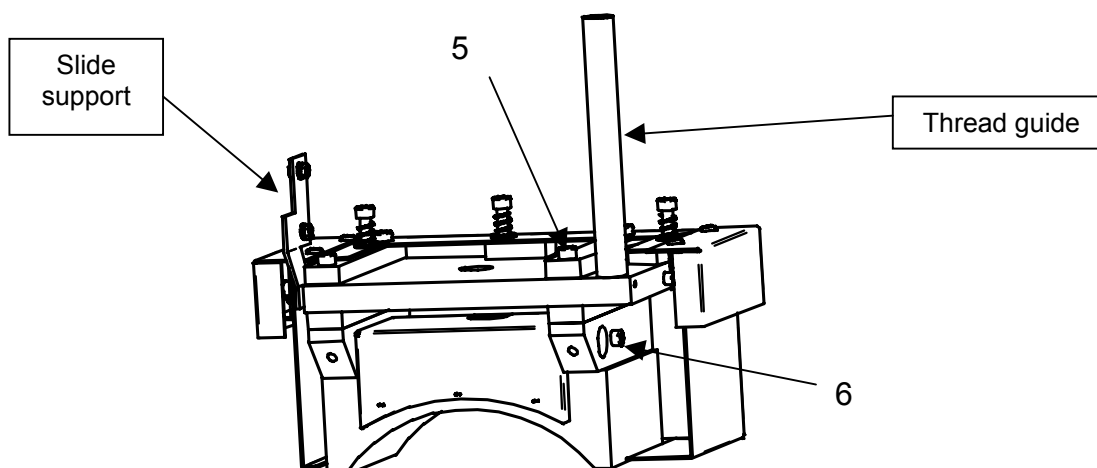
1. SECURITY MICRO SWITCH ADJUSTMENT

- Use an Allen key of 5 to remove the roundhead screws on top of the cover (1),
- Remove the protection cover (2),
- Unscrew the micro switch screws (3),
- Adjust the micro switch (4) for the sensitivity of the required security.



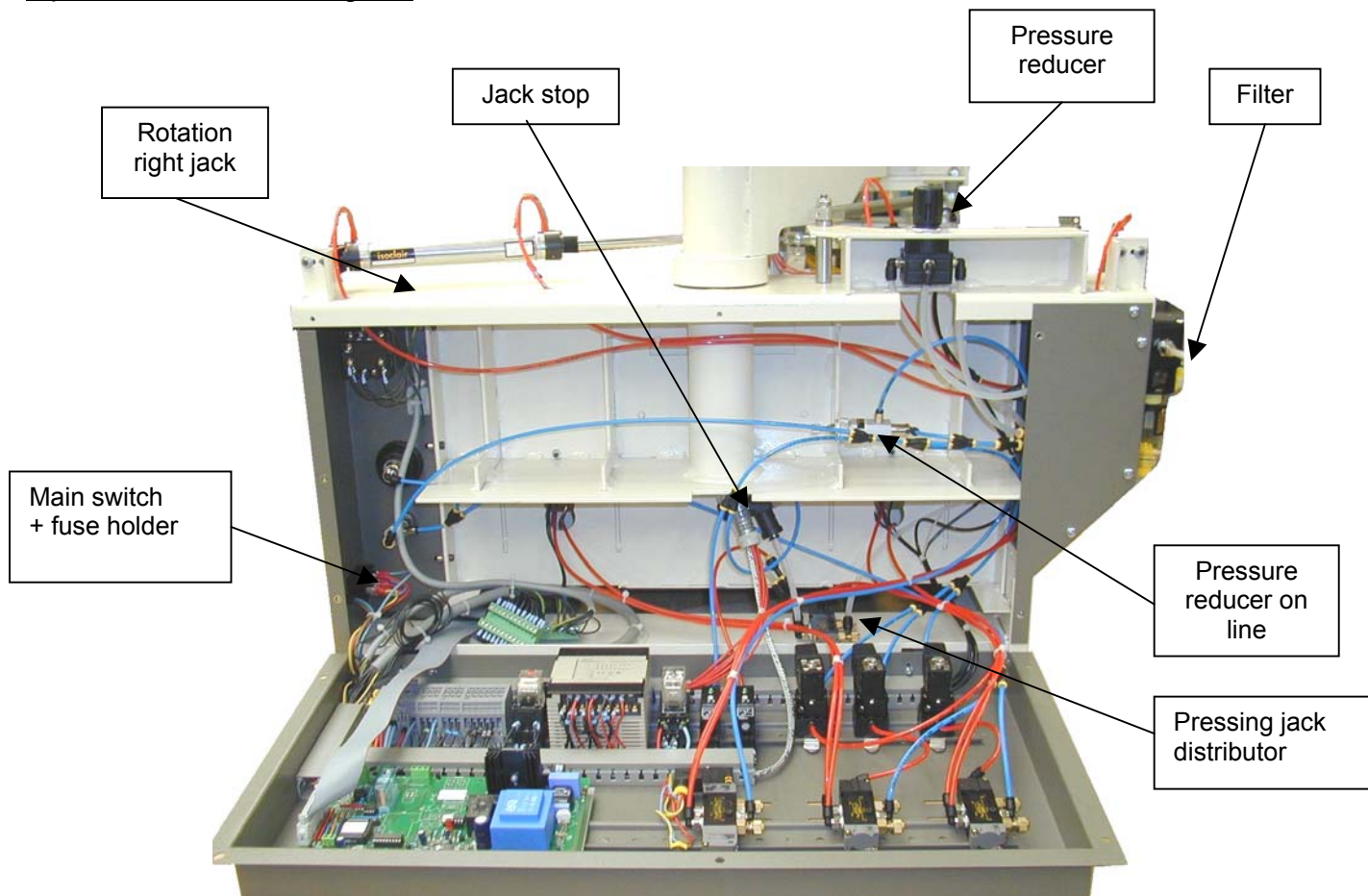
2. DISMANTLING FOR RESISTOR REPLACEMENT

- Unscrew the 4 screws M6 (5) which hold the glastherms and the aluminium plaques,
- Rock the security cover to reach the 2 screws fixing the back cover (6),
- Remove the heat element pulling them out of their casing.

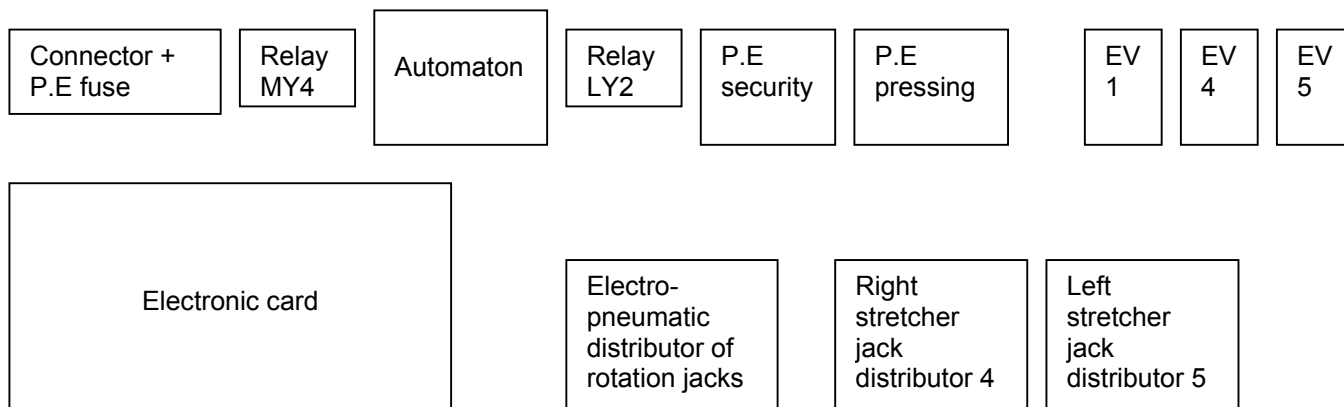


VIII. IMPLANTATION OF THE EQUIPMENT

Opened back cover diagram



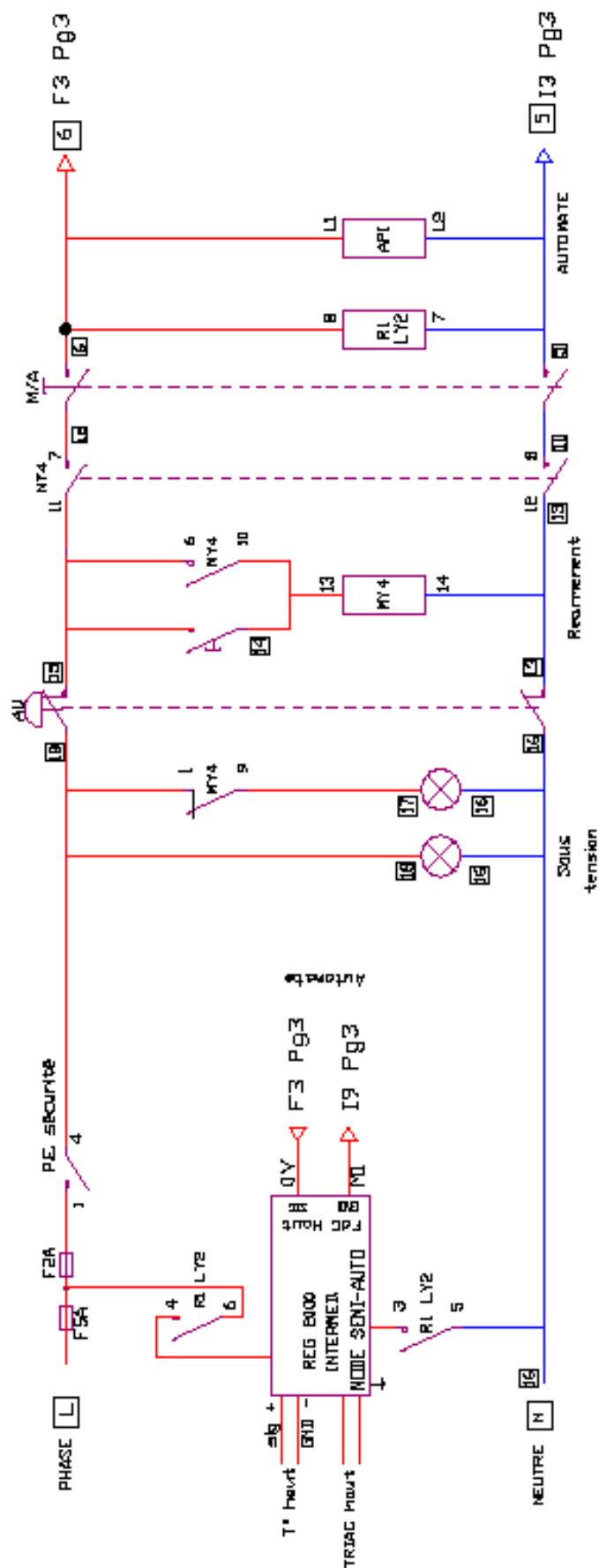
Cover elements diagrammatic



PE : pneumo-electric
EV : solenoid valve

IX. ELECTRIC AND PNEUMATIC DIAGRAMS

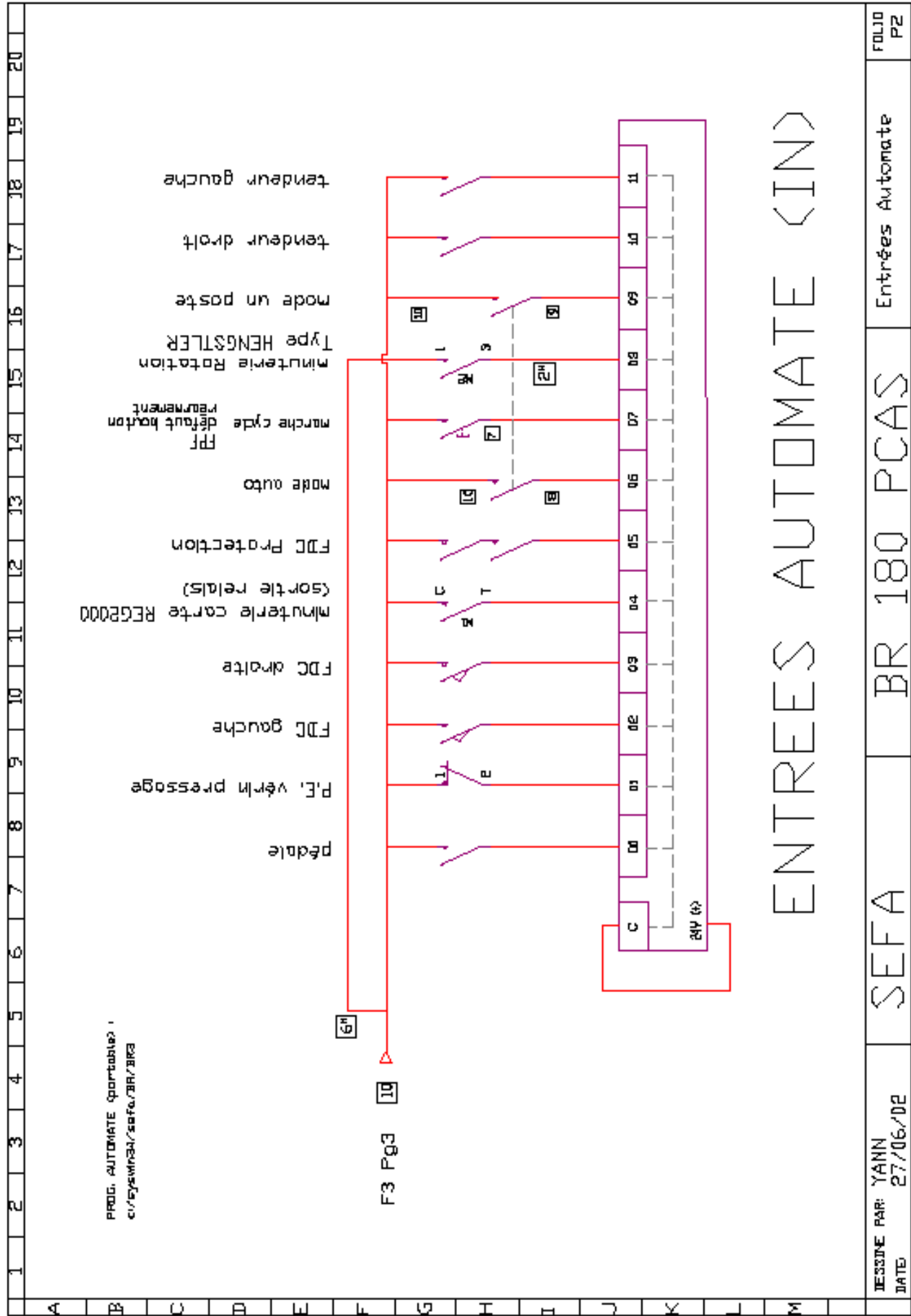
**ELECTRIC
DIAGRAMS
+
PNEUMATIC
DIAGRAM**



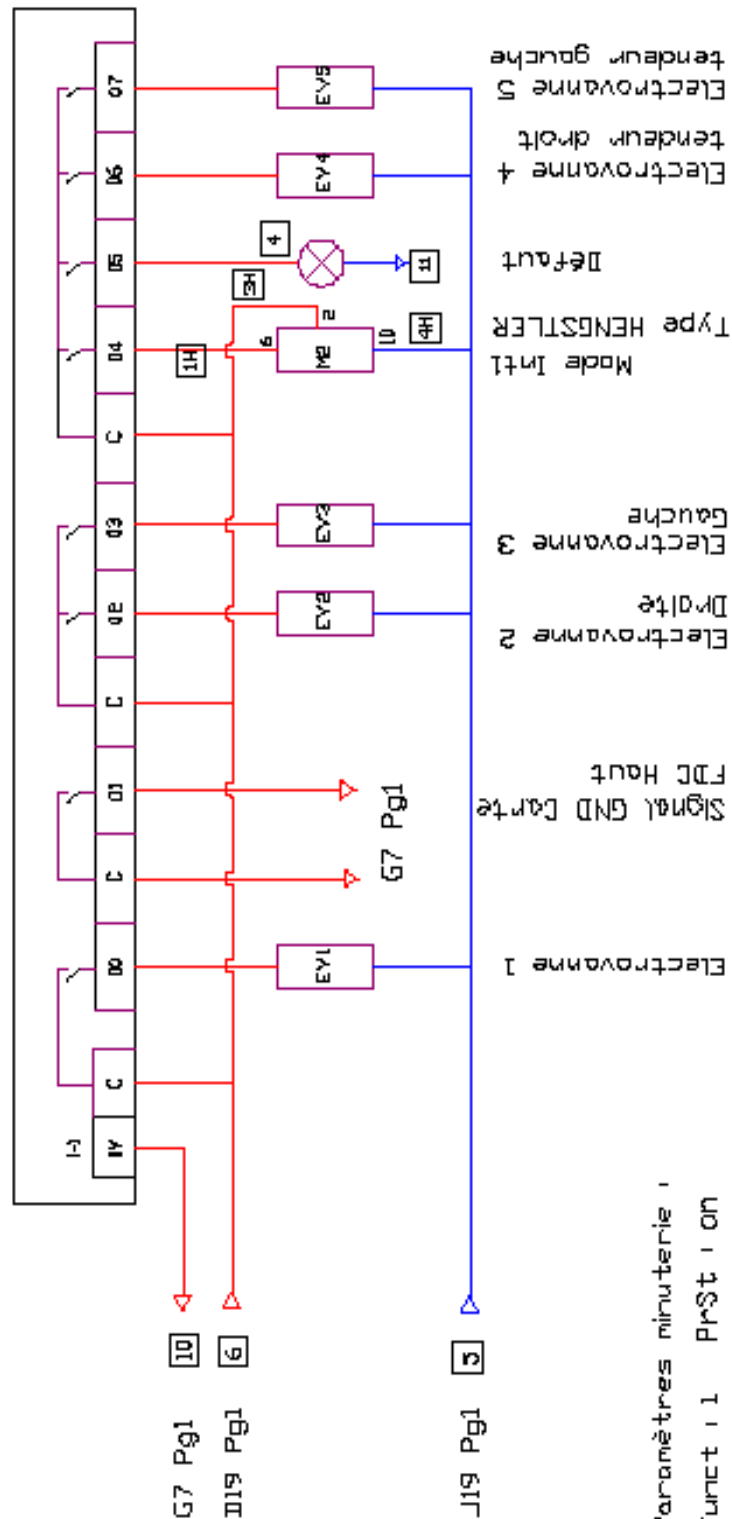
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Multi brin			

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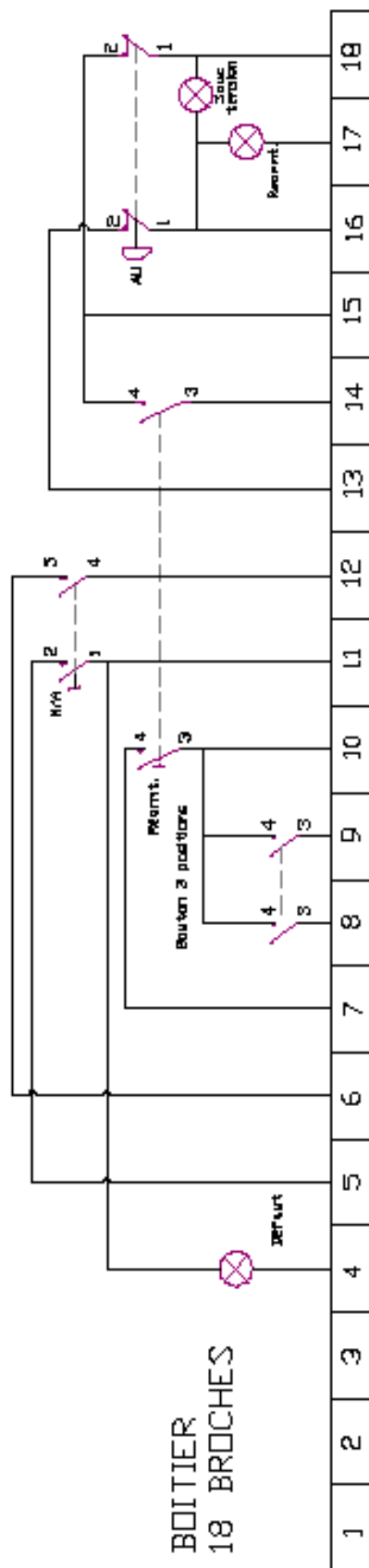
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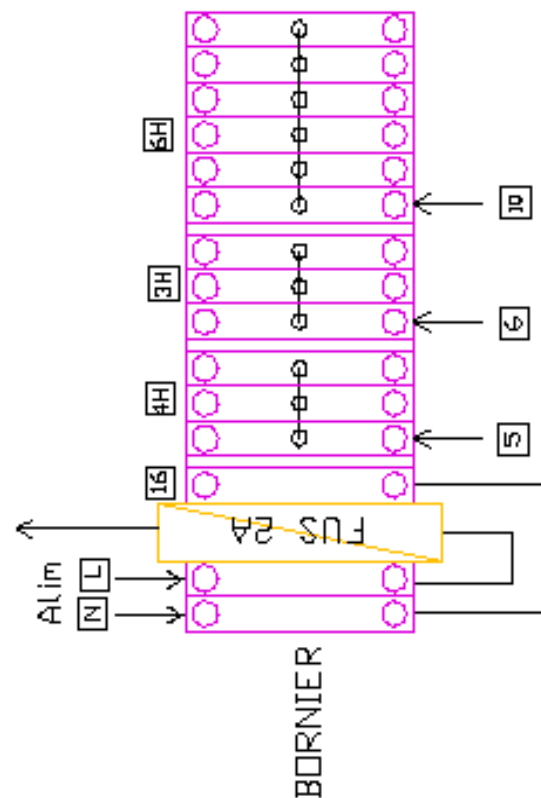
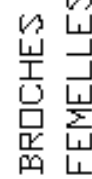
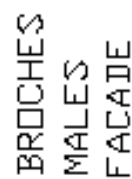
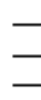
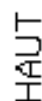
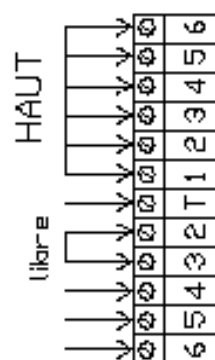
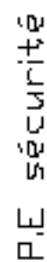
SORTIES AUTOMATE (OUT)



```
Paramètres minuterie :
Funct : 1   PrSt : on
trng : 5    FrSt : on
dEcP : 0    StUL : 2
tdir : dh
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AUTO
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BORNIER

Multi korin 19G L=1100

