

User Manual

itek



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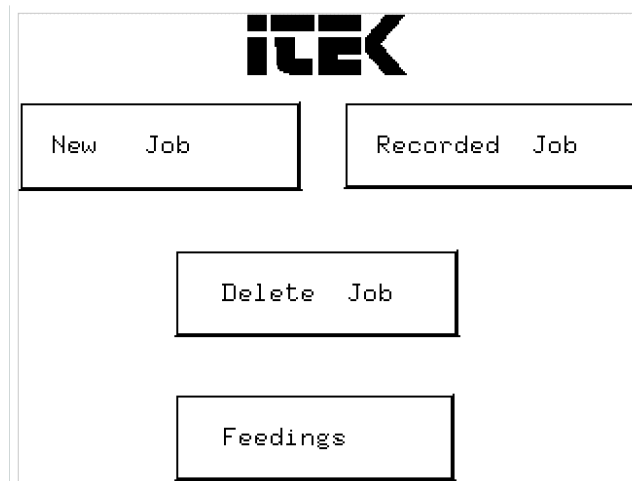
Switch on

Switching on the machine there appears on the monitor some words which are not necessary to use the machine, they can be ignored. After some seconds it appears this **starting page**:



The inscription near to “Serial”: indicates the machine serial number which has to be communicated to the constructor in case of trouble.

The bar under the inscription “Set up time” runs till the value 100, at this moment it appears the following page **Choose of work**:



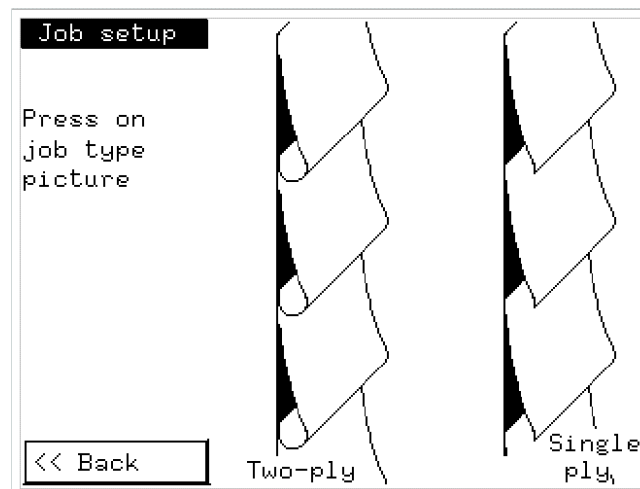
On the operator monitor four buttons appear:

- New job (see page 4)
- Recorded job (see page 7)
- Delete job (see page 12)
- Feedings (see page 13)

Note: pushing the button directly on the operator monitor it is possible to choose the desired function

New Job

If you choose the button “New job” it appears the following page of the **Choose of job type**:

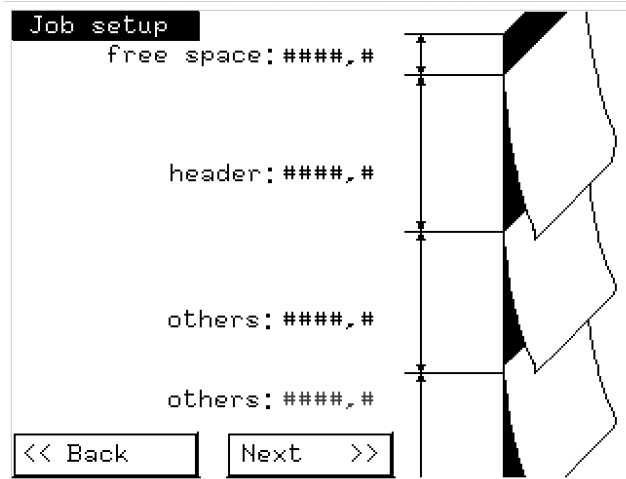


Pushing on the drawing of the job type, “Two-ply” or “Single ply “, you chose the type of job you can do.

Pushing on the button you turn back to the previous page **Choose of work**.

New Job single ply

If you push the drawing which represents the single ply fabric it appears this page relative to the **Measure of single ply**:



Note: in place of #### some numbers appear.

Pushing on numbers a keyboard appears on the monitor, with whom you can insert the desired measure; the measure indicates how much the support has to move on from an application to the sequent. To confirm the inserted measure push press ESC to cancel insertion. Measures are expressed in millimeter, when you write, for example 10,5, the support moves of 1 centimeter and 5 tenths.

The measures meaning is explained in the following table:

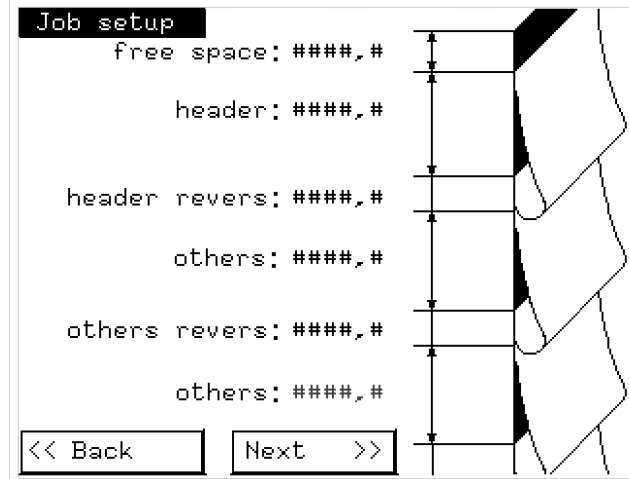
free space	Support millimeters that you want leave from a “waterfall” to the following
header	Moving dimensions (in millimeters) of the support which is necessary to glue the first fabric at the desired distance
others	Moving dimension (in millimeters) of the support which is necessary to glue the following fabrics at the desired distance

Pushing on the button you turn back to the page of **Choose of job type** .

Pushing on the button you enter in the page of **Start working**.

New job two-ply

If you push the drawing which represents the two-ply fabric it appears this page relative to the **measure of two-ply**:



Note: in place of ##### some numbers appear.

Pushing on numbers a keyboard appears on the monitor, with whom you can insert the desired measure; the measure indicates how much the support has to move on from an application to the sequent. To confirm the inserted measure push press ESC to cancel insertion. Measures are expressed in millimeter, when you write, for example 10,5, the support moves of 1 centimeter and 5 tenths.

The measures meaning is explained in the following table:

free space	Support millimeters that you want leave from a “waterfall” to the following
header	Moving dimensions (in millimeters) of the support which is necessary to glue the first fabric at the desired distance
Header revers	Moving dimensions (in millimeters) of the support which is necessary to glue the first fabric revers at the desired distance
others	Moving dimension (in millimeters) of the support which is necessary to glue the following fabrics at the desired distance
Others revers	Moving dimension (in millimeters) of the support which is necessary to glue the following fabrics revers at the desired distance

Pushing on the button you turn back to the page of **Choose of job type** .




Pushing on the button you enter in the page of **Start working**.


Recorded job selection


If in the page **Choose of work** you push “recorded job” it appears the following page, **recorded job selection**:



Note: instead of \$\$\$ the name of the last used program or some exclamation points appear.

Pushing on  (button (index-book) you find the list of the memorized work programs; using the buttons  you roll by the list of the program names; pushing on  you confirm the chosen program, pushing ESC you cancel your choice.

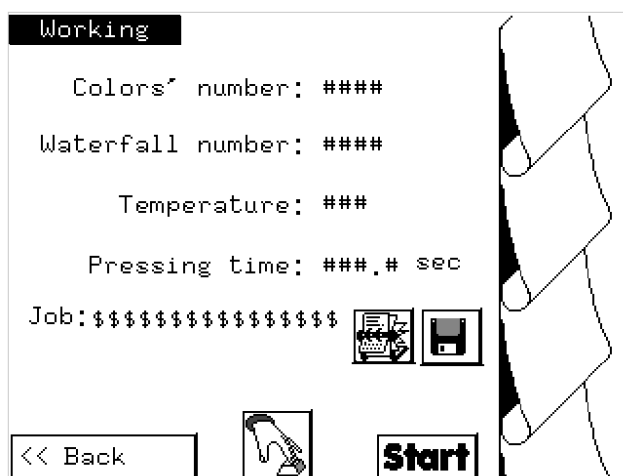
If you remember by heart the program name to be used you can push on the symbols \$\$\$, and the keyboard appears with which you can insert the desired name; pushing on  you confirm the program name written, ESC you cancel your choice

Pushing on the  button you turn back to the page of **Choose of job type** .

Pushing on the button you enter in the page of **Start working**.

Start working




If you decide to start a new job or you choose a memorized work, you push Next >> and you will find the following page relative to the **start working**:




Note: in place of #### some numbers appear, instead of \$\$\$ the name of the last used program or some exclamation points appear.


In the table are shown the work parameters You can insert:


Colors' number	Number of different fabric per waterfall.
Waterfalls number	Numbers of waterfalls to be done.
Temperature	Temperature of malting of the glue over the support (must be set up according to the type of glue and support).
Pressing time	Enduring of the pressing time (the base time is the tenth of second so inserting 3.3 the fabric will be pressed for 3 second and 3 tenths).
Job	The name of the program we are using.

Pushing on  button (index-book) you find the list of the memorized work programs; using the buttons  you roll by the list of the program names; pushing on  you confirm the chosen program, pushing ESC you cancel your choice. You can for example, update a work, which has just been used with the one which is in use.

note: if you edit the name you don't select a new program, you only write the name of it, so the measure remain the same.

If you want to record the program with the current name you have to push the button .

If you want to modify the program name (only the name not the measures) to be used you can push on \$\$\$, so it appears a keyboard with whom you can insert the desired name; pushing on  you confirm the written name, pushing on ESC you cancel your Choice.

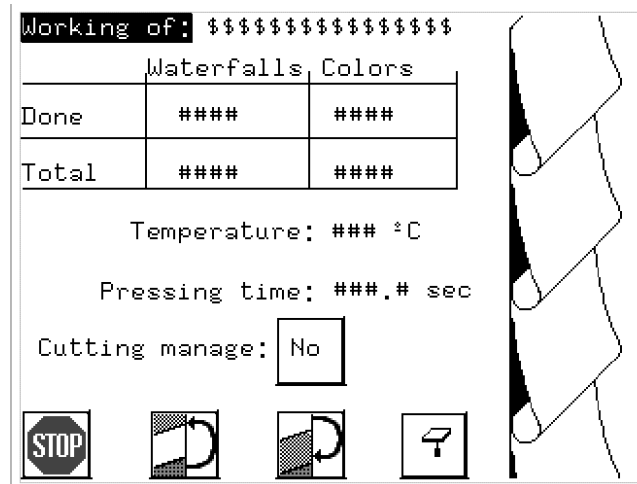
Pushing on the  button you can modify the measures coming back to the pages of **measure of single ply** or **measure of two-ply** according to the type of work you choose.

Pushing on the button you turn back to the page of **Choose of work**.

Pushing on the **Start** button you find the **working** page and you will begin to work.

Working

If you pushed the **Start** button you arrive at the **working** page.




Note: In place of ### some number appear, instead of \$\$\$ the name of the last used program or some exclamation points appear.


Working sequence:


1. Insert a fabric under the clamp
2. Take your hands away, but keep the fabric stopped
3. Push the pedal (or the green button on the control panel)
4. The machine sticks your fabric:
 1. the heater rises
 2. as the heater is high the clamp begins to move down
 3. as the clamp is down, the fabric is pressed, the machine waits for “Pressing time:” seconds
 4. then the clamp rises
 5. as the clamp is high the heater will move down
5. The support moves to reach the position where you have to stick the next fabric.

The button “No” on the side of “Cutting manage” allow you to enable the cutting of the waterfall as you glue the last color. If you press the button it will change in “Yes” to remind you that the cutting function is enabled. Press the button again to disable the cutting manage, it will change in “No”.

Pushing the button  you stop the work.

The button  permits you to repeat the last measure (eg: if the fabric is the wrong one), but only the last one. The machine unroll back to the previous measure and it permits to repeat the application and positioning cycle.

The button  permits to avoid gluing a fabric (it leaves an empty space on the support), simply moving without pushing the support.

The  button permits to always maintain high the heater for particular working types, it permits to heat immediately the support.




PAY ATTENTION!!!
Always maintaining the heater high increases the danger of burning hands and fingers.
To avoid burns use gloves with an adequate thermal protection.


Delete recorded job



If in the page **Choose of work** you push “delete job” it appears the following page, **delete recorded job**:

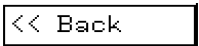


Note: instead of \$\$\$ the name of the last used program or some exclamation points appear

Pushing on  button (index-book) you find the list of the memorized work programs; using the buttons  you roll by the list of the program names; pushing on  you confirm the chosen program, pushing ESC you cancel your choice.

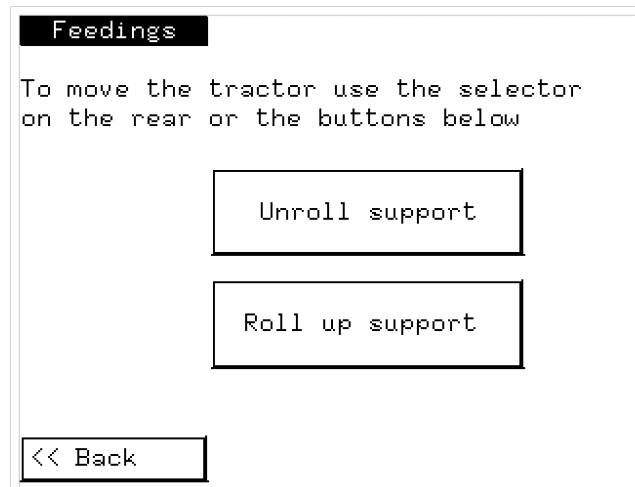
If you remember by heart the program name to be used you can push on the symbols \$\$\$, and the keyboard appears with which you can insert the desired name; pushing on  you confirm the program name written, ESC you cancel your choice.

Pushing on  the program whose name is written near to “name”: is deleted; pushing on  you confirm the program to be deleted, pushing ESC you cancel the erasing process.

Pushing on the button  you turn back to the page of **Choose of work**.

Support Feeding

If in the page **Choose of work** you push “feeding” it appears the following page, **support feeding**:

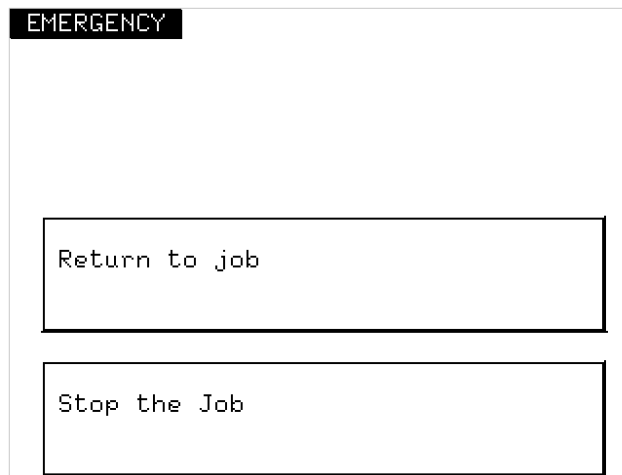


At this moment the selector on the rear of the machine is enabled. The selector allow to move the tractor cylinder to help you to insert the support in the machine. Once you have introduced the support from rear you can move to the front of machine and use the two buttons “Unroll Support” and “roll up support” to place the support.

Pushing on the button you turn back to the page of **Choose of work**.

Emergency

If you pushed the red button “EMERGENCY” the machine immediately stops, and the following page appear:



Pushing the “Return to job” button you can resume what you were doing before the emergency.

Pushing the “Stop the job” button you turn back to the page of **Choose of working**.

Troubleshooting

Problem:

- the support doesn't move

Possible causes:

- if the clamp isn't in high position the roll can't move
- the inverter is not Ready

Possible solution:

- check if the sensor placed over the pneumatic pistons are well placed and firmly blocked, eventually move the sensor up and down or replace it.
- switch off the machine per three minutes, check if something block the roll or make it hard to move

Problem:

- the clamp doesn't move down

Possible causes:

- the sensor of heater in high position doesn't work properly. This sensor allow the clamp to come down

Possible solution: the clamp can't move down if the heater is not high.

- check if something (fabric or something else) blocks the run of the heater
- check if the sensor over the pistons are well placed and firmly blocked, eventually move the sensor or replace it

Problem:

- the clamp remains down indefinitely

Possible causes:

- the sensor of clamp in low position starts the pressing time counting. If the sensor doesn't work properly the pressing time never last

Possible solution:

- check if something (fabric or something else) blocks the run of the clamp
- check if the sensor over the pistons are well placed and firmly blocked, eventually move the sensor or replace it.

Problem:

- on the control panel question marks appear instead of number, water fall type drawing and job name

Possible causes:

- the data connection cable between PLC Siemens and control panel is unplugged
- the PLC Siemens is off
- the PLC Siemens is broken

Possible solution:

- check the cable on both side, PLC and control panel , and if the plug screw are locked
- check the fuse F6
- replace the PLC with a new one