

# INSTRUCTION MANUAL P 540 PES



**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...  
does not enter the clauses of guarantee.

**For any technical information or spare part order:**

**Direct Tel N°: 04.68.74.79.54**



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### **III. SPECIFICATIONS**

<b>Poids en ordre de marche / Weight in running order</b>	<b>70 Kgs</b>
<b>Hauteur / Height</b>	<b>425 mm</b>
<b>Profondeur / Depth</b>	<b>805 mm</b>
<b>Largeur / Width</b>	<b>406 mm</b>
<b>Dimension du plateau / Dimension of the heating plate</b>	<b>400 x 500 mm</b>
<b>Alimentation électrique / Electric power supply</b>	<b>220 V Monophased + earth 50/60 Hz</b>
<b>Puissance / Power</b>	<b>2 250 W</b>
<b>Ampérage / Ampérage</b>	<b>10 A</b>
<b>Régulateur électronique de température à affichage digital / Thermoregulator</b>	
<b>Précis à / Accurate to</b>	<b>+/- 1%</b>
<b>Réglable de / Range of control</b>	<b>0 to 255 °C</b>
<b>Minuterie électronique multigamme / Timer</b>	
<b>Précis à / Accurate to</b>	<b>+/- 2%</b>
<b>Réglable de / Range of control</b>	<b>0 to 255 sec</b>

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

<b>S.E.F.A<sup>®</sup></b>	
Z.I. PASTABRAC 11260 ESPERAZA FRANCE	TEL: 33(0)4.68.74.05.89 FAX: 33(0)4.68.74.24.08
MODELE	<input type="text"/>
N° DE SERIE	<input type="text"/>
PUISSANCE	<input type="text"/>
VOLTS	<input type="text"/>
 Année de Fab.	<input type="text"/>
Made in France By S.E.F.A. 	

## **IV. INSTALLATION OF THE MACHINE**

### **1. HANDLING**

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

### **2. INSTALLATION**

After having positioned the machine on its working place,

- Electrically plug the press ( 220 Volt + Neutral + Earth / 50 or 60 Hertz )

## **V. PARTS SUBJECTED TO WEAR AND TEAR**

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

<b><u>Description</u></b>	<b><u>Reference</u></b>	<b><u>Ref Plan</u></b>	<b><u>Quantity</u></b>
<b><u>ELECTRIC &amp; PNEUMATIC EQUIPMENT</u></b>			
CAR-357	ELECTRONIC CARD		1
ECR-360	SCREEN		1
CLA-371°	KEYBOARD		1
RES-181	HEAT ELEMENT 100X100		9
VER-128	JACK D=80 C=240mm		1
DIS-125	DISTRIBUTOR P/R 1/8		1
SON-188	T° SENSOR		1
<b><u>PRESS COVER</u></b>			
MOU-540	RUBBER 9 MM	400 X 500 MM	

## **VI. GENERALITIES**



This heat seal press was designed to carry out a production while respecting article L 233-5 of the labour laws, to ensure the user's security.

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

## **VII. SECURITY**

*Any maintenance intervention has to be done  
when the machine is off and locked  
(electric energies unplugged)*

## **VIII. TIME/TEMPERATURE SETTING**

1. **TEMPERATURE SETTING** (See instruction manual REG 2000)
2. **TIME SETTING** (See instruction manual REG 2000)

## **IX. PRESSURE ADJUSTMENT :**

- ***The pressure adjustment can be modified according to the need of the user:***

### ***a. Mechanic adjustment***

In that case the operator can modify the pressure adjusting the heating plate height. He has to use the wheel which is on the arm holding the plate.

- Clockwise, he will obtain more pressure.
- Anticlockwise, he will obtain less pressure.

### ***b. Pneumatic adjustment***

The operator will have to operate on the pressure regulator which is on the left side of the machine,

- In screwing the regulator button, he will increase the pressure (the manometer hand will indicate a value higher than the one displayed previously)
- In unscrewing the regulator button, he will decrease the pressure (the manometer hand will indicate a value lower than the one displayed previously)

## **X. MAINTENANCE**

### **1. Code R1 :**

- Appear when the machine has been heating for **9 300 h** that is to say about 5 years
  - ◆ It will be necessary to carry out a general service. See your retailer.

### **2. Code R2 :**

- Appears when the machine has realized **60 000 knocks**
  - ◆ It will be necessary to grease the axles, oil and lubricate all the moving parts.

### **3. Code R3 :**

- Appears when the machine has realized **240 000 knocks**
  - ◆ It will then be necessary to change the pads(silicone rubber)

### **4. Code R4 :**

- Appears when the machine has realized **30 000 knocks**
  - ◆ It will be necessary to grease the axles.

### **5. Code R5 :**

- Appears when the machine has realized **600 000 knocks**
  - ◆ It will be necessary to change the jack's joints which ensure the plate movement and pressure.

***TO DELETE THE MESSAGE REGARDING THE SERVICE:  
REFER TO THE USER MANUAL REG 2000***

## **XI. DESCRIPTION OF THE CYCLE**

1. The operator will have to action the main switch to power up the machine
2. Set the temperature to 180° (or *to define according to the type of transfer*) See SETTING § 1
3. Set the application time to 15 seconds (or *to define according to the type of transfer* ) See SETTING §2
4. Adjust the pressure (or *to define according to the type of transfer*)
5. Position the T-shirt on the lower plate
6. Adjust the transfer sheet
7. Lower the heating plate actioning the 2 lowering plate buttons
8. When the plate is in contact with the T-shirt, the timer will take over and the electro-magnet will maintain the plate in low position
9. At the end of the countdown, the plate will go back up automatically

## **XII. ACCESSORIES FITTING**

This machine offers the advantage to be able to receive various accessories:

### ***LOWER PLATES OF VARIOUS FORMATS***

Remove the lower plate unscrewing the screws which fix the sleeve-board to the frame and fit the appropriate plate instead of the one which has been taken off.

### ***CARRIAGE FOR WORK IN MASKED TIME***

If you choose to acquire this accessory subsequently, there will be 4 set squares to fix on the frame as the plan attached will represent it.

1. Slide the carriage so that the casters are trapped in the carriage.
2. Fix the thrusts once the carriage is in place.
3. Put the 2 sleeve-boards in place.
4. Adjust the thrusts so that the heating plate is centered with regard to the sleeve-boards.



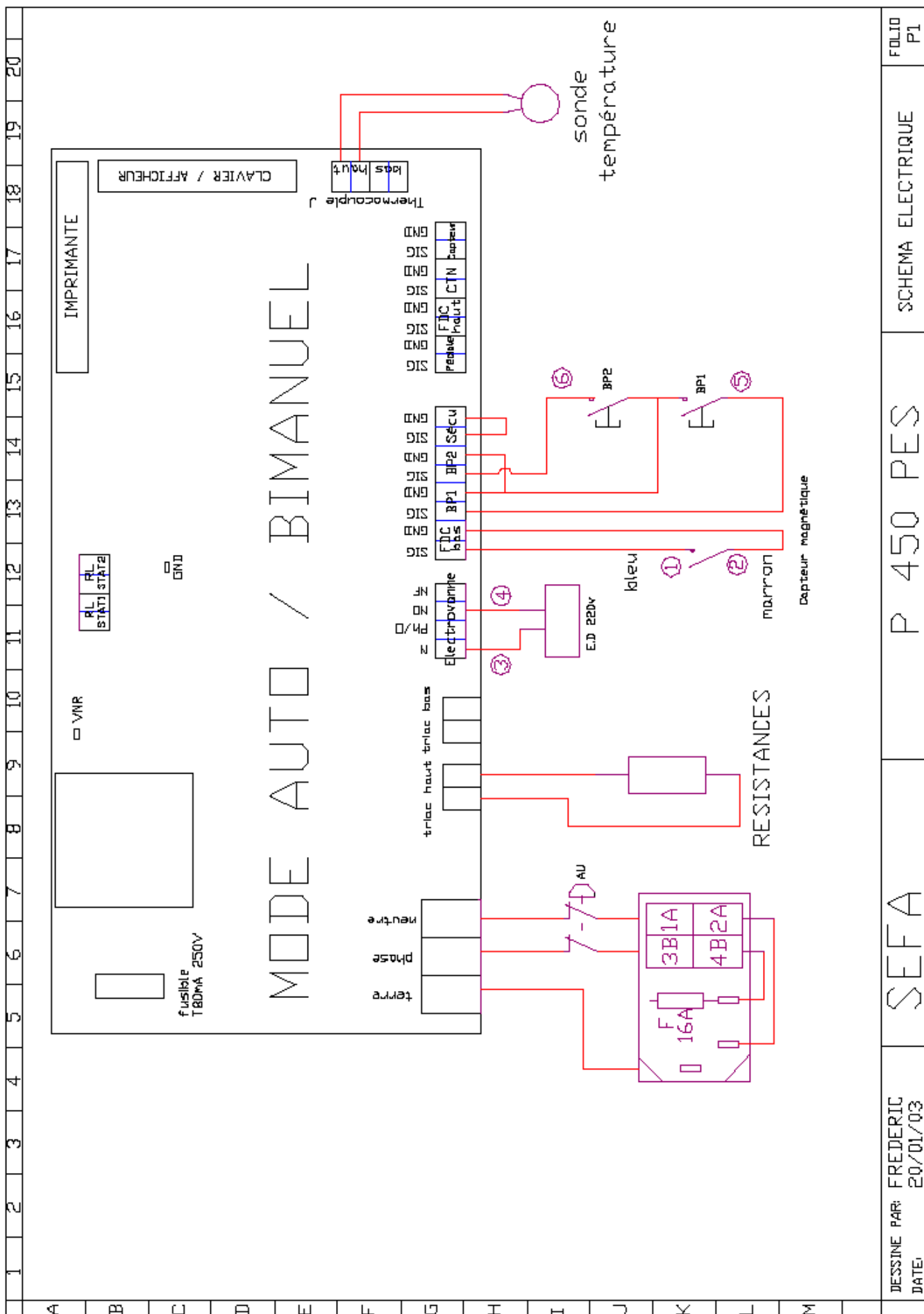
### **XIII. POSSIBLE BREAKDOWNS**

#### ***1. ELECTRIC BREAKDOWNS***

<b><u>SYMPTOMS</u></b>	<b><u>POSSIBLE BREAKDOWNS</u></b>	<b><u>REPAIRS</u></b>
The plate will not heat	<ul style="list-style-type: none"> <li>➤ The fuses are out of order</li> <li>➤ See the messages displayed on the LCD screen</li> </ul>	<ul style="list-style-type: none"> <li>➤ If no light on the press goes on, check the fuse, change it if necessary – <b><u>GENERAL FUSE</u></b> situated in a casing next to the power cable plug ( 10 A ). To access it, remove the power cable, with the tip of a pen or a screwdriver, lift the fuse casing. In the square tube you will find a replacement fuse to put instead of the one in the clip. <b><u>CARD FUSE</u></b> situated in the electronic card ( 0,8A )</li> <li>➤ Get in touch with your retailer</li> </ul>
The plate overheats	See the messages displayed on the LCD screen	<ul style="list-style-type: none"> <li>➤ Get in touch with your retailer</li> </ul>
The timer will not count down	<ul style="list-style-type: none"> <li>➤ The micro switch is not activated or is faulty</li> </ul>	<ul style="list-style-type: none"> <li>➤ Check if the pneumo-electric is not faulty. Replace it if necessary</li> </ul>
The plate will not go down	<ul style="list-style-type: none"> <li>➤ The gas spring is stuck</li> </ul>	<ul style="list-style-type: none"> <li>➤ Check it, change it if necessary</li> </ul>
The plate stays in low position	<ul style="list-style-type: none"> <li>➤ The jack is faulty</li> </ul>	<ul style="list-style-type: none"> <li>➤ There is a leak on the jack or on the distributor, there is not enough pressure for the plate to go up. Change the joints and the jack.</li> </ul>

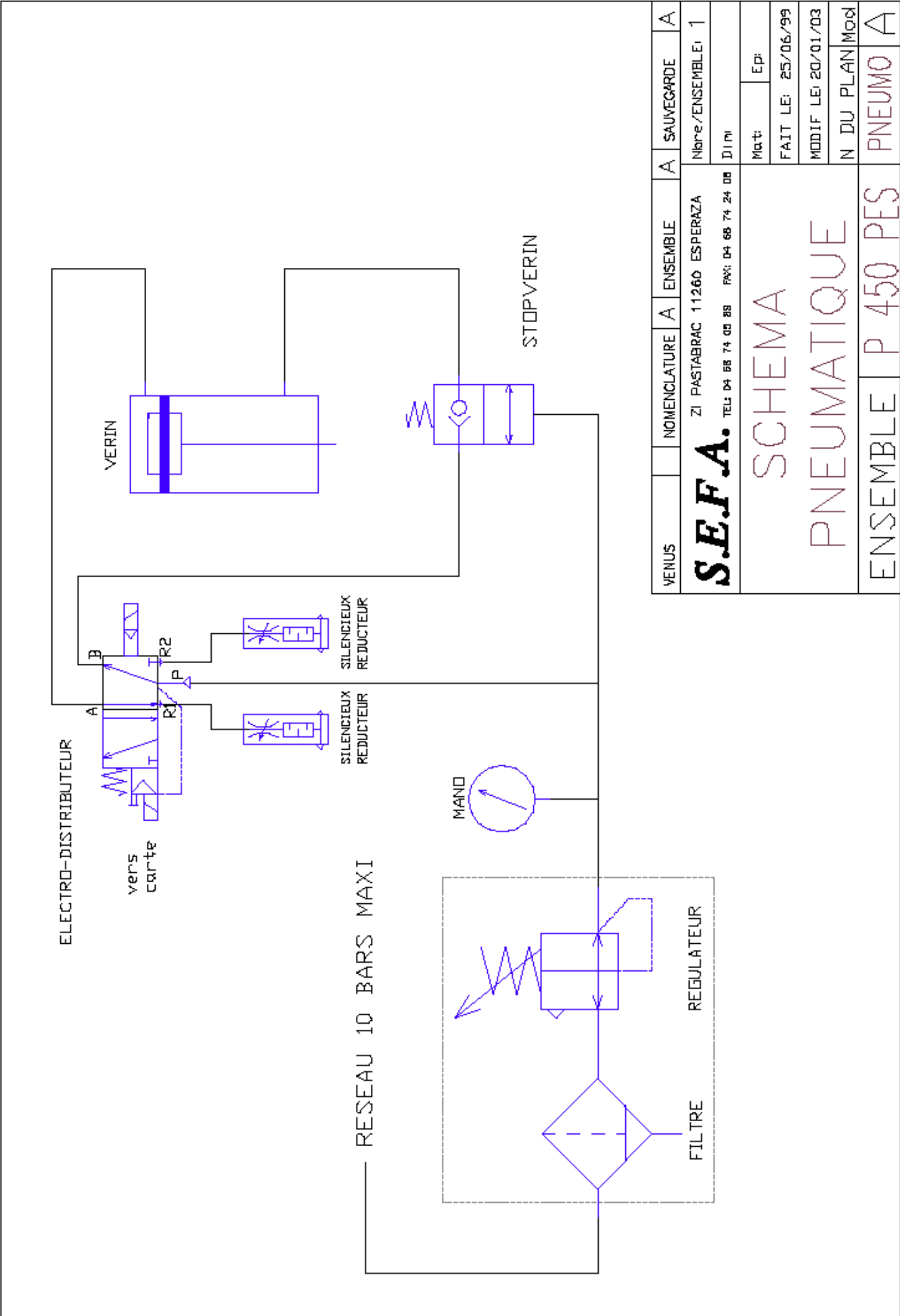
***XIV. ELECTRIC DIAGRAM***

**ELECTRIC  
DIAGRAM**



***XV. PNEUMATIC DIAGRAM***

**PNEUMATIC  
DIAGRAM**



VENUS	NOMENCLATURE	A	ENSEMBLE	A	SAUVEGARDE	A
<b>S.E.F.A.</b>		ZI PASTABRAC 11260 ESPERAZA		Nbre/ENSEMBLE: 1		
		TEL: 04 68 74 03 88		DIM		
		FAX: 04 68 74 24 08		Mat: Ep:		
				FAIT LE: 25/06/99		
				MODIF LE: 20/01/03		
				N DU PLAN		
ENSEMBLE		P 450 PES		PNEUMO A		

## **XVI. MAINTENANCE LOG**

The operations of control and maintenance indicated in this table must be done regularly so as to check the state of running and the reliability of the press.

Date	Number of hours	Pressure control	Air filter control	Jacks control	Rubber state	Axis control	Parts changed	Observations

In order to make the filling in of the table easy, it can be useful to use the following code:

C :Control      CI : Cleaning      R : Replacement

***XVII. NOTES***

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