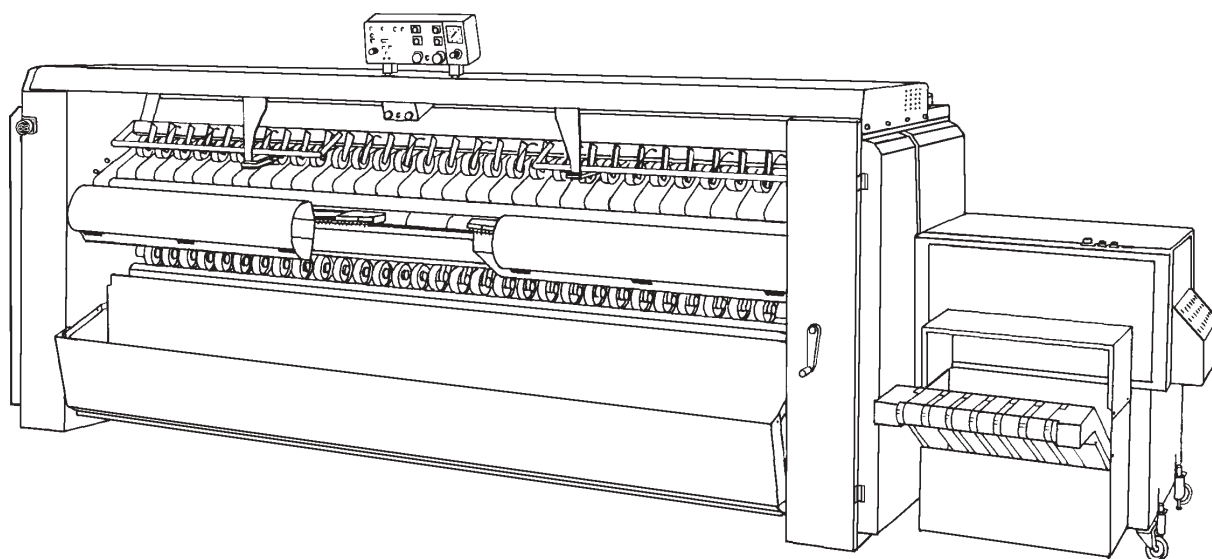


INSTRUCTION HANDBOOK

IC3 6431 FFS



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The machines described in this handbook have an ironing capacity of 310 cm wide.

They carry out five different operations with a single operator; the space required is very similar to the standard ironer.

The ironing speed can be adjusted according to the degree of moisture of the linen.

The temperature of the ironing cylinder depends on the steam pressure.

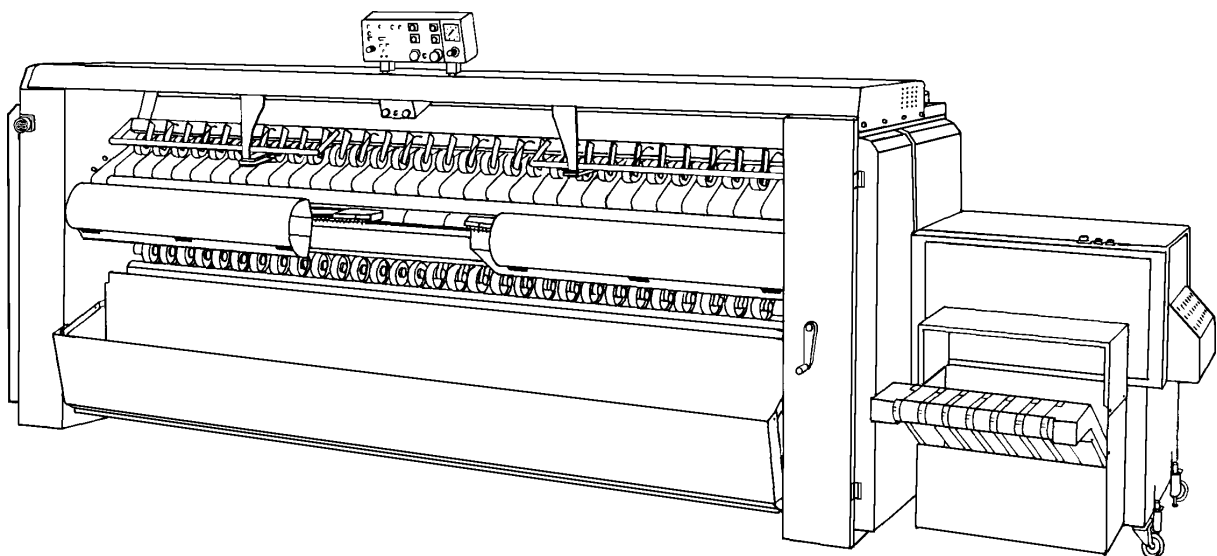
The ironing parameters that you have selected are permanently checked by a microprocessor.

These parameters are displayed in a real time on an electronic control panel in front of the operator.

The feeding of the linen is completely automatized and includes smoothing; a single operator is required; the folding of the items is calculated for each item fed.

Several piles of linen can be stored in the stacker with centering and numbering of the folded items.

The machine can be used like a standard ironer with or without the automatic feeding.



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WARNING

Before any use, it is advised to read the instruction handbook.

The identification plate is situated at the rear of the control board.

For safety reasons, never remove the protective casing while the machine is functioning. Installation and putting into service must be carried out by trained staff.

The machine should not be used by children.

Any repairing or maintenance operation should be carried out by a specialist.

Disconnect all sources of energy and let the ironing cylinder cool down before any intervention on the machine.

The high temperature of the ironing cylinder may cause serious burns; avoid touching the hot surfaces.

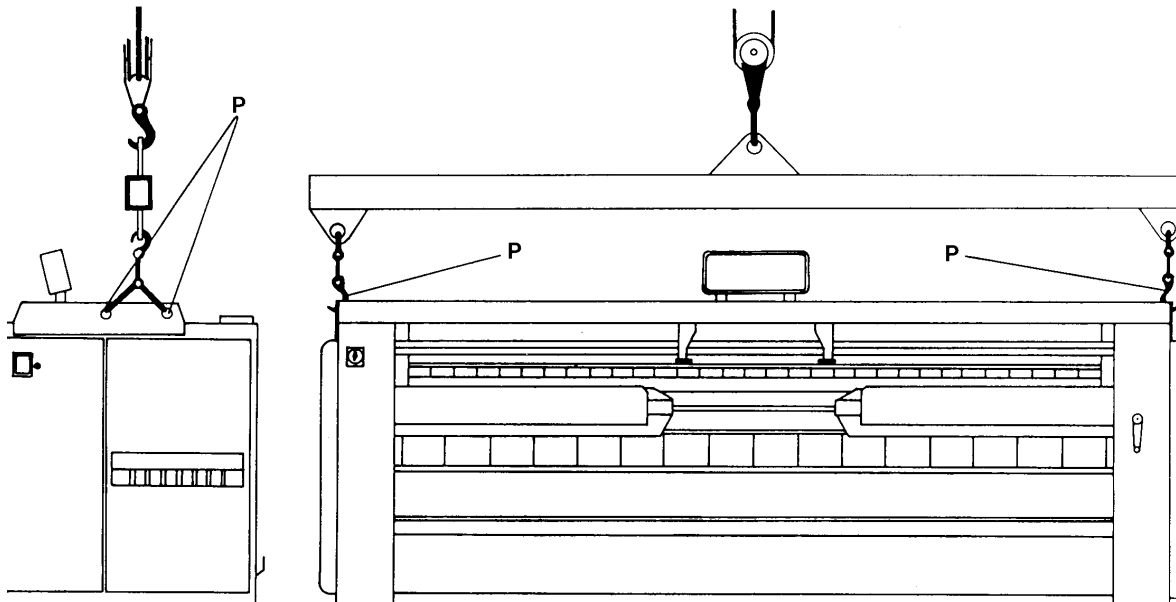
Never iron if the finger protection does not function.

In order to avoid any danger of fire or explosion, never use flammable products to clean the machine.

N.B. This machine has no part made of asbestos.

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D0274



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RECALL

All these operations should be carried out by handling specialists.

1 - HOOK LIFTING

Any lifting in this way should be carried out using a suitable crossbar.

Handle with a crossbar using the two hooking points (P).

2 - GROUND MOVING

The machine frame is made up of two parallel spars, making ground moving possible by means of rollers, grinding tracks or a trolley.

Stacker :

Small wheels are provided for ground moving.

t0104gb

WEIGHT OF MACHINE in kg		
Model	Heating oil	Steam
Ironer 3,10m	2625	2625
Stacker	225	

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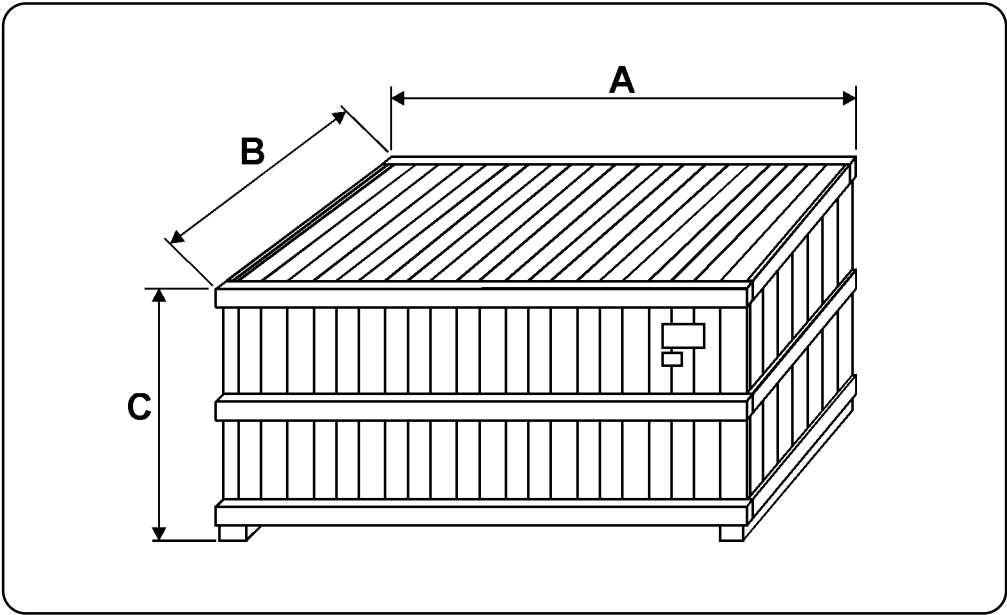
Outer dimensions for seafreight

t0105gb

Model	Length A in mm	Width B in mm	Height C in mm
Ironer 3,10 m	4110	1480	2025
Stacker	1850	1090	1320

t0106gb

Model	Weight of packing box in kg		Weight of crate in kg	
	Heating oil	Steam	Heating oil	Steam
Ironer 3,10m				
Stacker	410		410	



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We reserve the right to modify the characteristics of these machines.

LAYOUT :
FEEDER IRONER FOLDER STACKER
AND FEEDER IRONER FOLDER SIDE OUTLET

KEY TO DRAWING N° 07100010

BENCHMARKS

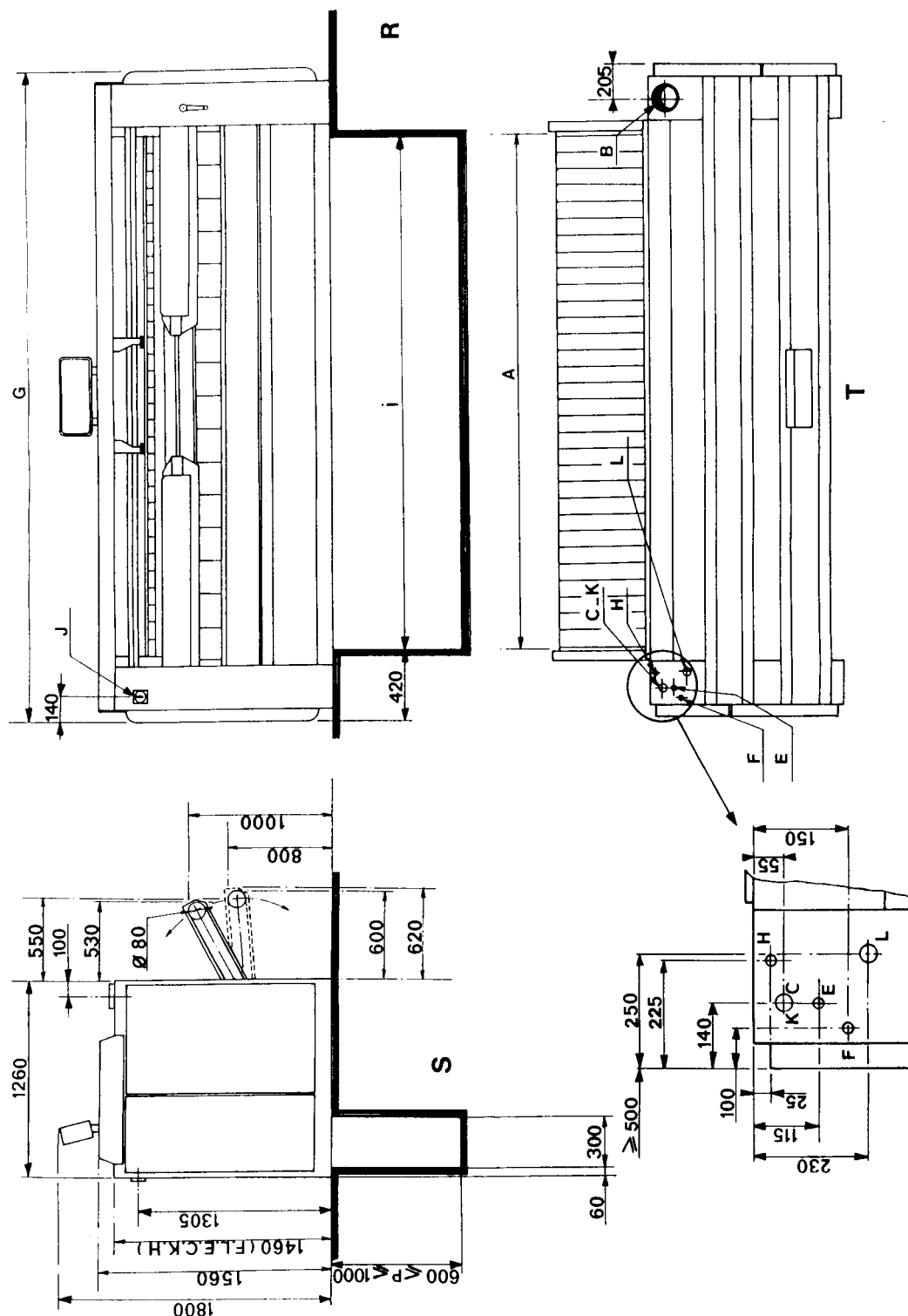
A	OVERALL LENGTH WITH STACKER
B	DRAIN OF VAPOUR DIRECT TO OUTSIDE
C	STEAM INLET : PRESSURE 12 BAR MAXI (CUSTOMER)
E	RETURN OF CONDENSATE
F	ELECTRIC POWER SUPPLY
G	OVERALL LENGTH (WITHOUT STACKER)
H	COMPRESSED AIR INLET : PRESSURE 8 BAR (CUSTOMER)
I	LENGTH OF FEEDING PIT
J	MAIN SWITCH AND ELECTRIC CONNECTION (EARTH CONNECTION COMPULSORY)
P	DEPTH OF FEEDING PIT
R	FRONT VIEW
S	SIDE VIEW
T	TOP VIEW
K	HEATING OIL INLET
L	HEATING OIL RETURN

t0103gb

dimensions in mm			Ironer 3,10m	
			Steam	Heating oil
A	mm		4910	4910
B	inner diameter		160	160
C	diameter		26/34	-
E	diameter		15/21	-
F	Amperes	230 V	16	16
		400 V	12	12
F	cable section in mm ²	230 V	4x2,5	4x2,5
		400 V	4x2,5	4x2,5
G	mm		3940	3940
H	diameter		15/21	15/21
I	mm		3100	3100
K	diameter		-	33/42
L	diameter		-	33/42

LAYOUT :

FEEDER IRONER WITH FRONT OR REAR OUTLET,
FEEDER IRONER WITH FRONT OR REAR OUTLET,
FEEDER IRONER WITH FRONT OR REAR OUTLET AND
FEEDER IRONER FOLDER WITH TRANSFER TABLE



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We reserve the right to modify the characteristics of these machines.

LAYOUT :

FEEDER IRONER WITH FRONT OR REAR OUTLET FEEDER IRONER WITH FRONT OR REAR OUTLET, FEEDER IRONER WITH FRONT OR REAR OUTLET AND FEEDER IRONER FOLDER WITH TRANSFER TABLE

KEY TO DRAWING N° 07100014

BENCHMARKS

A	LENGTH OF REAR DELIVERY TABLE
B	DRAIN OF VAPOUR DIRECT TO OUTSIDE
C	STEAM INLET : PRESSURE 12 BAR MAXI (CUSTOMER)
E	RETURN OF CONDENSATE
F	ELECTRIC POWER SUPPLY
G	OVERALL LENGTH
H	COMPRESSED AIR INLET : PRESSURE 8 BAR (CUSTOMER)
I	LENGTH OF FEEDING PIT
J	MAIN SWITCH AND ELECTRIC CONNECTION (EARTH CONNECTION COMPULSORY)
P	DEPTH OF FEEDING PIT
R	FRONT VIEW
S	SIDE VIEW
T	TOP VIEW
K	HEATING OIL INLET
L	HEATING OIL RETURN

t0141gb

dimensions in mm		Ironer3,10m	
		Steam	Heating oil
A	mm	3180	3180
B	inner diameter	160	160
C	diameter	26/34	-
E	diameter	15/21	-
F	Amperes	230 V	16
		400 V	12
F	Cable section in mm²	230 V	4x2,5
		400 V	4x2,5
G	mm	3940	3940
H	diameter	15/21	15/21
I	mm	3100	3100
K	diameter	-	33/42
L	diameter	-	33/42

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We reserve the right to modify the characteristics of these machines.

LAYOUT :

IRONER FOLDER WITH FRONT OR REAR OUTLET IRONER WITH FRONT OR REAR OUTLET AND IRONER WITH REAR OUTLET

KEY TO DRAWING N° 07100018

BENCHMARKS

- A** LENGTH OF REAR DELIVERY TABLE
- B** DRAIN OF VAPOUR DIRECT TO OUTSIDE
- C** STEAM INLET : PRESSURE 12 BAR MAXI (CUSTOMER)
- E** RETURN OF CONDENSATE
- F** ELECTRIC POWER SUPPLY
- G** OVERALL LENGTH
- H** COMPRESSED AIR INLET : PRESSURE 8 BAR (WITH FOLDER) (CUSTOMER)
- J** MAIN SWITCH AND ELECTRIC CONNECTION (EARTH CONNECTION COMPULSORY)
- R** FRONT VIEW
- S** SIDE VIEW
- T** TOP VIEW
- K** HEATING OIL INLET
- L** HEATING OIL RETURN

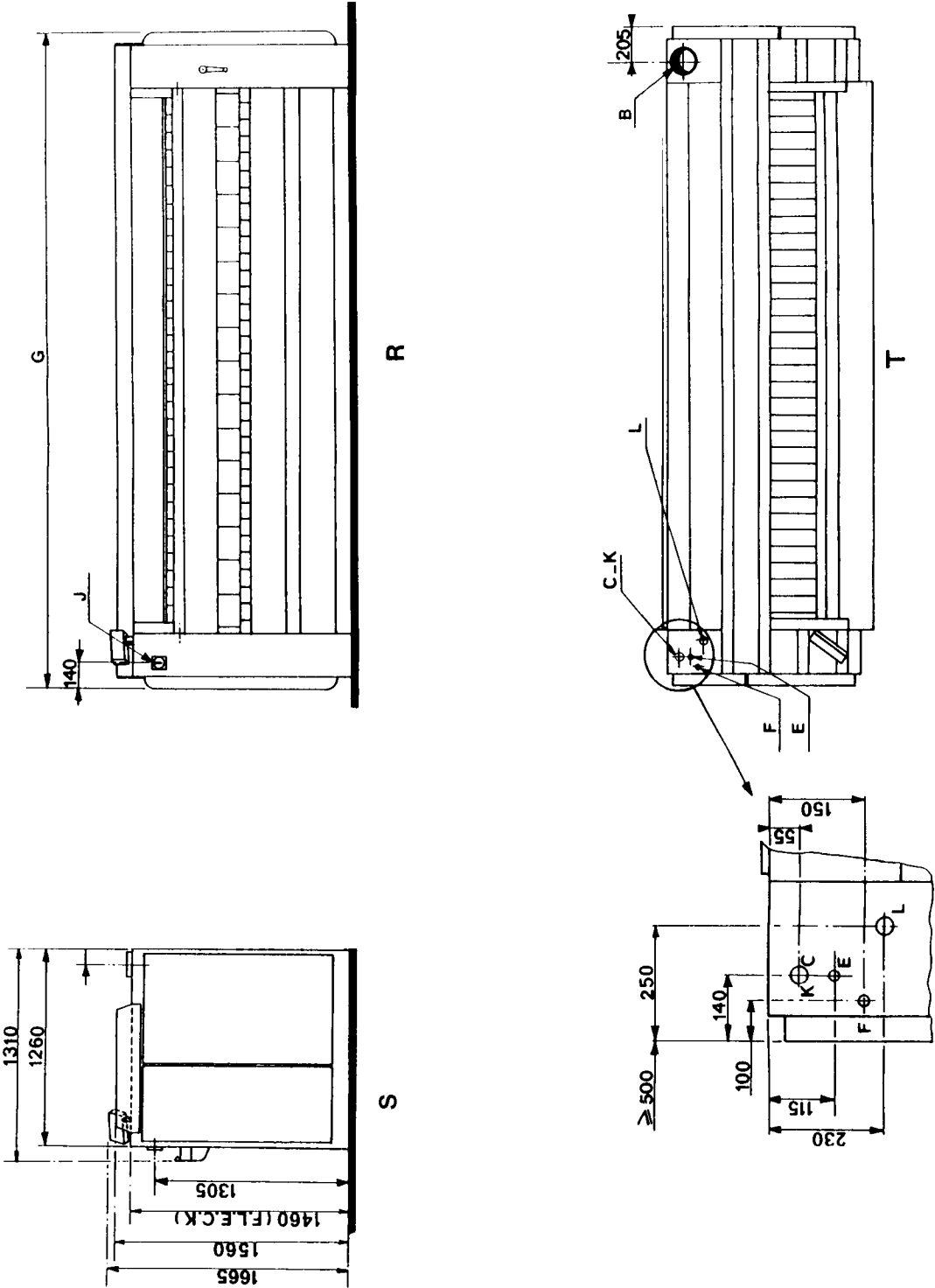
t0156gb

dimensions in mm			Ironer 3.10 m	
			Steam	Heating oil
A	mm		3180	3180
B	inner diameter		160	160
C	diameter		26/34	-
E	diameter		15/21	-
F	amperes	230 V	16	16
		400 V	12	12
F	Cable section in mm ²	230 V	4 x 2.5	4 x 2.5
		400 V	4 x 2.5	4 x 2.5
G	mm		3940	3940
H	diameter		15/21	15/21
K	diameter		-	33/42
L	diameter		-	33/42

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LAYOUT : IRONER

07100032



We reserve the right to modify the characteristics of these machines.

LAYOUT : IRONER

KEY TO DRAWING N° 07100032

BENCHMARKS

- A** LENGTH OF REAR DELIVERY TABLE
- B** DRAIN OF VAPOUR DIRECT TO OUTSIDE
- C** STEAM INLET : PRESSURE 12 BAR MAXI (CUSTOMER)
- E** RETURN OF CONDENSATE
- F** ELECTRIC POWER SUPPLY
- G** OVERALL LENGTH
- J** MAIN SWITCH AND ELECTRIC CONNECTION
(EARTH CONNECTION COMPULSORY)
- R** FRONT VIEW
- S** SIDE WIEW
- T** TOP WIEW
- K** HEATING OIL INLET
- L** HEATING OIL RETURN

t0177gb

dimensions in mm			Ironer3,10m	
			Steam	Heating oil
A	mm		3180	3180
B	inner diameter		160	160
C	diameter		26/34	-
E	diameter		15/21	-
F	Amperes	230 V	16	16
		400 V	12	12
F	Cable section in mm ²	230 V	4x2,5	4x2,5
		400 V	4x2,5	4x2,5
G	mm		3940	3940
K	diameter		-	33/42
L	diameter		-	33/42

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5. CHARACTERISTICS

HANDBOOK

t0107gb

CHARACTERISTICS			
Steam heating		Heating oil	
Maximum electric power installed in kW	3	Maximum electric power installed in kW	3
Maximum electric consumption for 1 hour use in kWh	3	Maximum electric consumption for 1 hour use in kWh	3
Consumption in kg/h steam 10 bars	175	Consumption in kWh (heat loss 3 bars)	120
Inner volume cylinder in dm ³	75	Inner volume cylinder in dm ³	48

COMPRESSED AIR CONSUMPTION AND OUTPUT

Screw-type compressor : 20 m³/h output on a 200 litres container (machine consumption)

Piston compressor : 25 m³/h output on a 500 litres container (machine consumption)

Instantaneous output : 25 litres/second

Maximum consumption : 20 Nm³/h to 8 bar.

The air should be perfectly dry and oil-free.

t0173gb

SIZE OF A FOLDED SHEET (in mm)	
Sheet	3rd fold
3,10m x 3,10m	80
2,40m x 3,10m	64
1,80m x 3,10m	48

t0174gb

CHARACTERISTICS OF THE FLAT LINEN FOLDING		
NATURE	WEIGHT	DIMENSION
SHEET	130-140 gr / m ²	standard
SHEET	160 gr / m ²	2,40m x 3,10m
SHEET	180 gr / m ²	2,40m x 3,10m
SHEET	200 gr / m ²	1,80m x 3,10m
DRAW-SHEET	200 gr / m ²	-
FEEDING LENGTH		mimimum 1,35 m
		maximum 3,10 m
FOLDING LENGTH (sheet dimension)		mimimum 0,90 m
		maximum 3,50 m

You must have found, together with this handbook, a crank for the manual drive of the cylinder, a set of keys to open the side casing and a shunt socket to make the machine work without stacker.

Depending on its destination, the ironer is delivered bare or placed on a transport pallet and packed with a transparent plastic film.

In certain cases, it may be packed for ocean shipment.

For any handling operation, see the handling chapter, page 2 chapter 3 of this handbook.

Take off the protection paper, and remove the transport flanges with an appropriately designed key in order to lift the machine from the transport pallet.

Check for damage caused during transport.

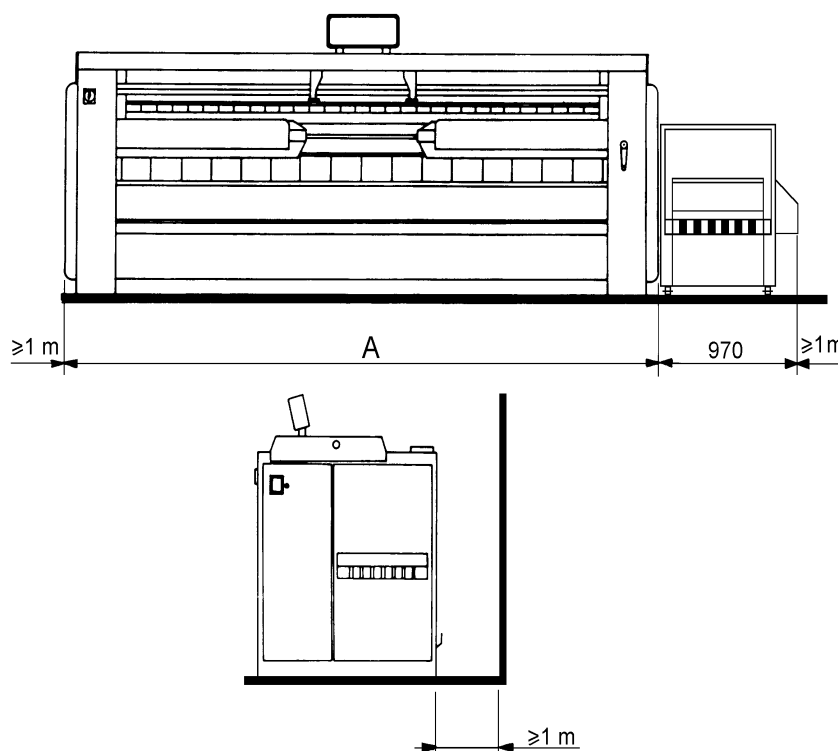
Leave at least 0.5 m between the machine and the wall or another machine on the left side in order to be able to carry out the necessary interventions in the caisson.

In order to avoid a displacement of the machine during an intervention on the heating box, it is advised, if possible, to provide sufficient space on the left side of the machine, minimum length A.

Leave at least 0.5 m between the machine and the wall against which it is placed.

Leave at least 1.47 m between the machine and a wall or another machine on the left side in order to be able to carry out the necessary interventions in the caisson.

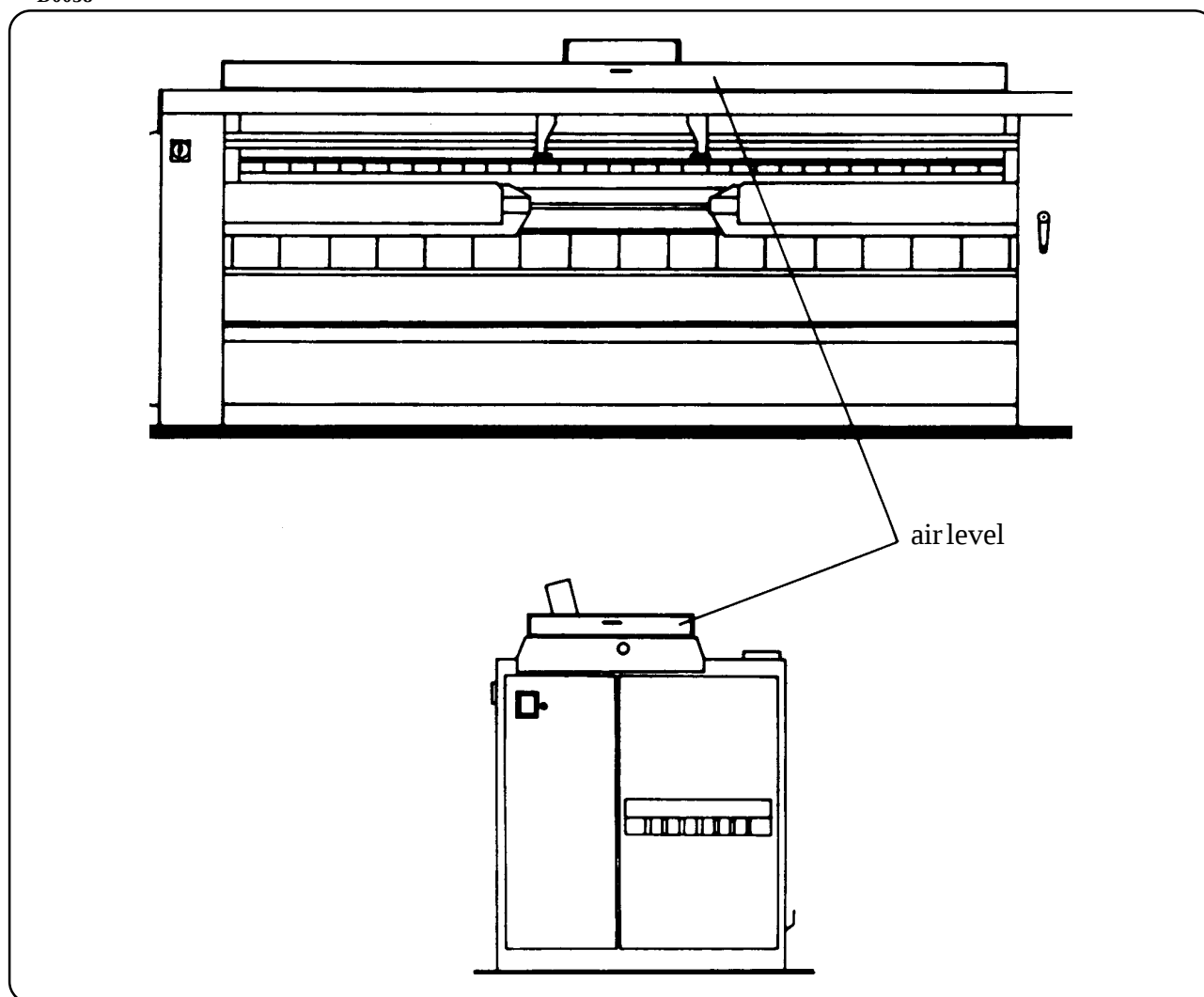
D0057



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The ironer should be put on a perfectly plain and level ground. Check this using to an air level placed on the upper hood of the machine (see photo D0058).

D0058



CAUTION

The frictional electricity may hinder the good working of the machine.

Earthing is compulsory.

It is specially advised not to install the machine on a synthetic floor covering.

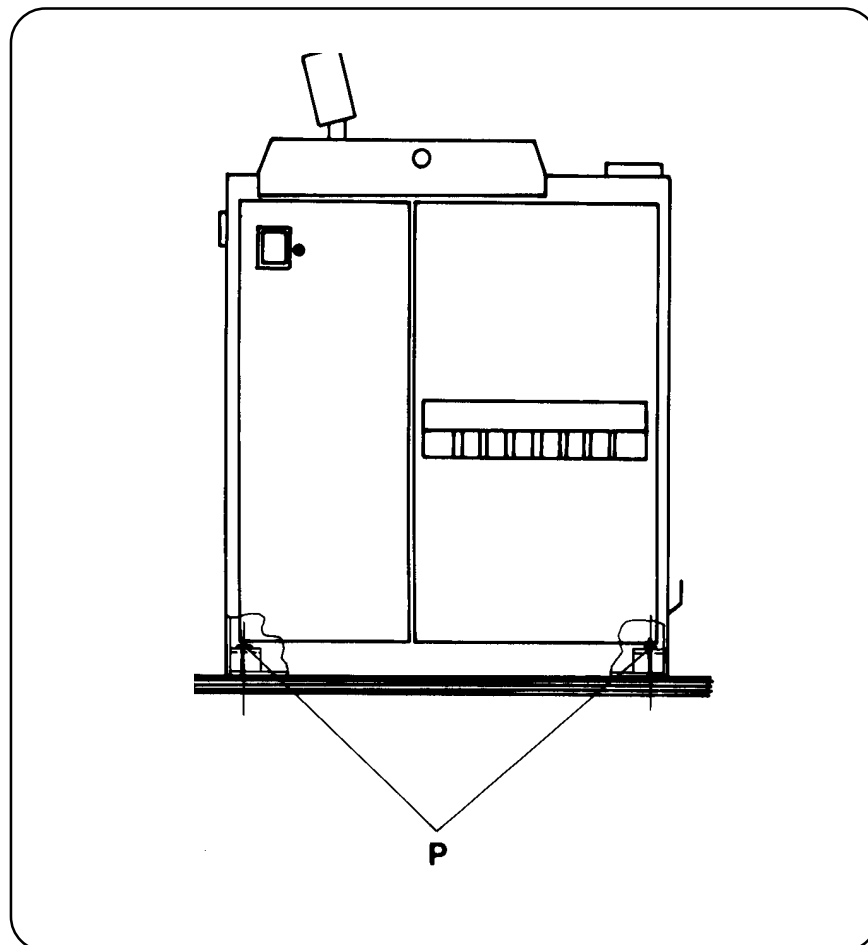
The warranty might be cancelled if these instructions are not complied with.

Dismantle the side casing in order to be able to reach the adjustment bolsters (P).

Turn the screws with a 22 mm wrench to level the machine. Lock the screws once the adjustment has been achieved.

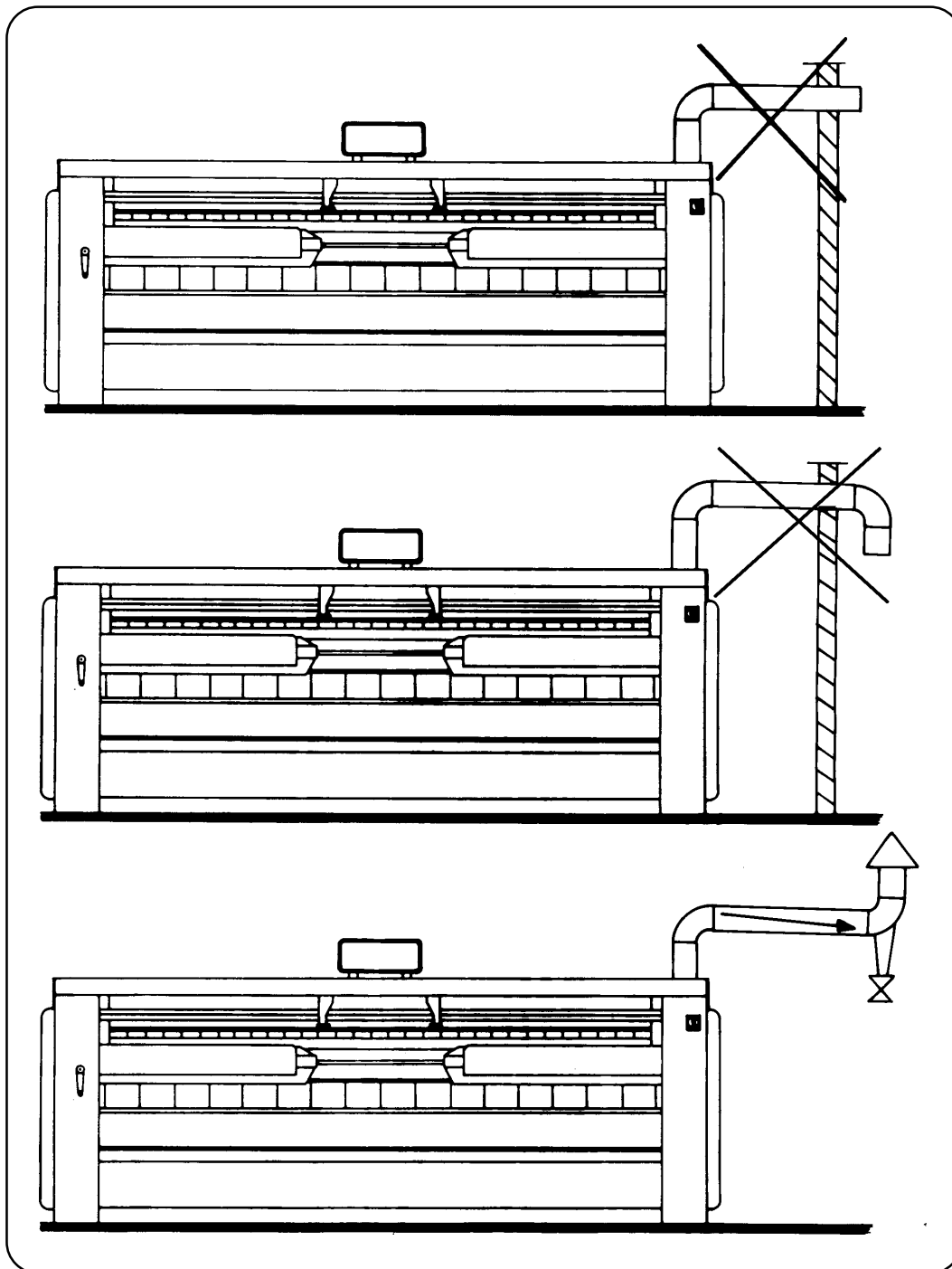
The technician should remove the protection paper from the cylinder just before putting the machine into service.

D0064



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D0059



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Airborne noise given out by the machine : sound level at work place : 62 dB(A)

The vapour exhaust must be separated from any other shaft and as direct as possible as indicated on diagram D0059.

Upper ventilation : 7 dm³

Lower ventilation : 14 dm³

Check that the shaft flow is at least twice that of the exhaust fan.

These conditions are **ABSOLUTELY ESSENTIAL** for the correct working of the machine.

Fan maximum flow rate with no pressure : 1000 m³/h.

Total pressure available with no flow : 105 mm WC.

Admissible heat loss on evacuation : 20 mm WC.

Temperature of air coming out of machine : 60 °C of relative humidity with steam heating.

The fresh air supply area should be five times that of the evacuation surface.

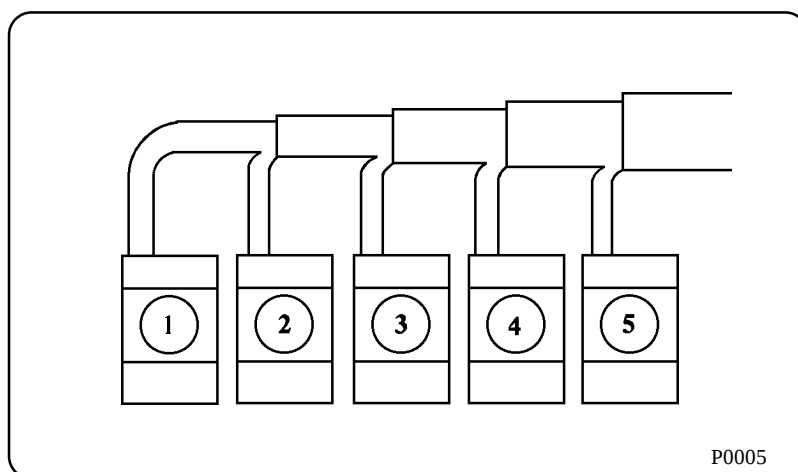
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If several ironers are installed with a single exhaust pipe in common (figure P0005), the latter should be of the growing section type according to the number of machines installed so that each of them can work with the same value of resistance of air.

The figure and table below show in a simplified way the skeleton diagram of the exhaust pipe, its outlet diameters and the required section for the ventilation aperture of the premises.

If in doubt regarding the exhaust device planning in case of modification of an existing device, please get in touch with our services.



t0008gb

Shape of the exhaust pipe if several ironers are installed						
Number of ironers		1	2	3	4	5
Outlet diameter of the exhaust pipe	in inches	10 "	14 "	18 "	20 "	22 "
	in mm	250	355	450	500	560
Ventilation aperture required section in m ²		0.3	0.5	0.8	1.0	1.3

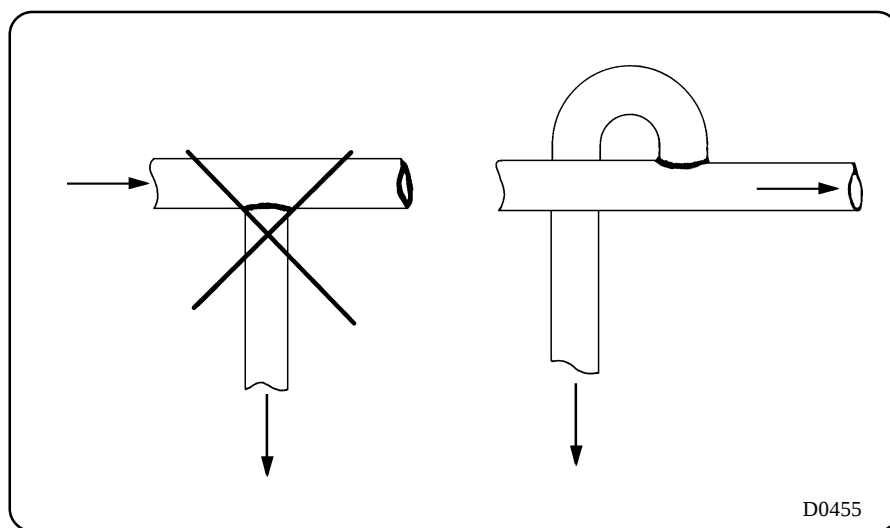
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STEAM HEATING

Steam always presents the risk of transporting a certain amount of water.

Water in that case will be transported on the lower part of the feeding pipes, and steam on the upper part.

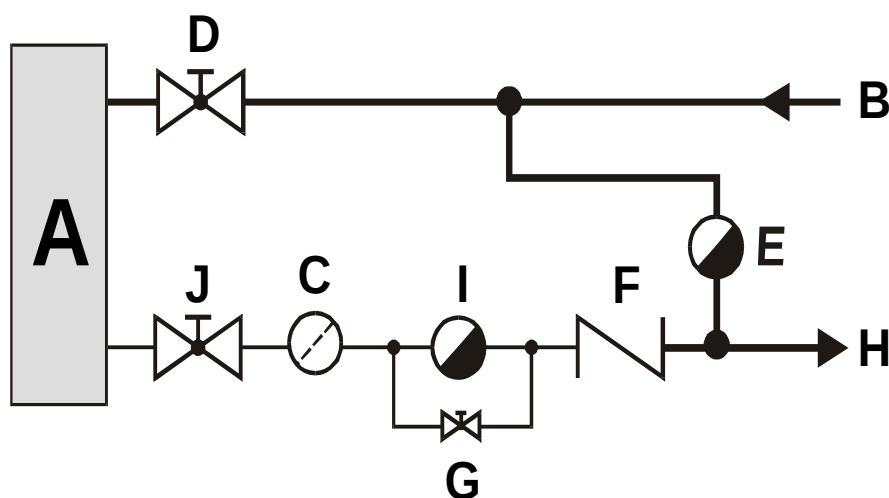
To prevent this water from harming the heating of the machine, the single vapour will be recovered with a throat-type connection piece as indicated on diagram d0455.



**STEAM CONNECTION
AND RETURN OF CONDENSATES
DIAGRAM IRONER**

Steam pressure : 12 bar maximum

- A** Ironer
- B** Steam admission diameter 26/34
- C** Y-shaped cast-iron filter with flanges
- D** Manual stop valve with flanges
- E** Drain cock to be provided before feeding the machine
- F** Non return valve with flanges
- G** Compulsory by-pass with flanges
- H** Return of condensates diameter 15/21
- I** Bucket steam trap (equipped with an incondensates evacuation system and a vapour anti-lock).
- J** Manual isolating valve with flanges



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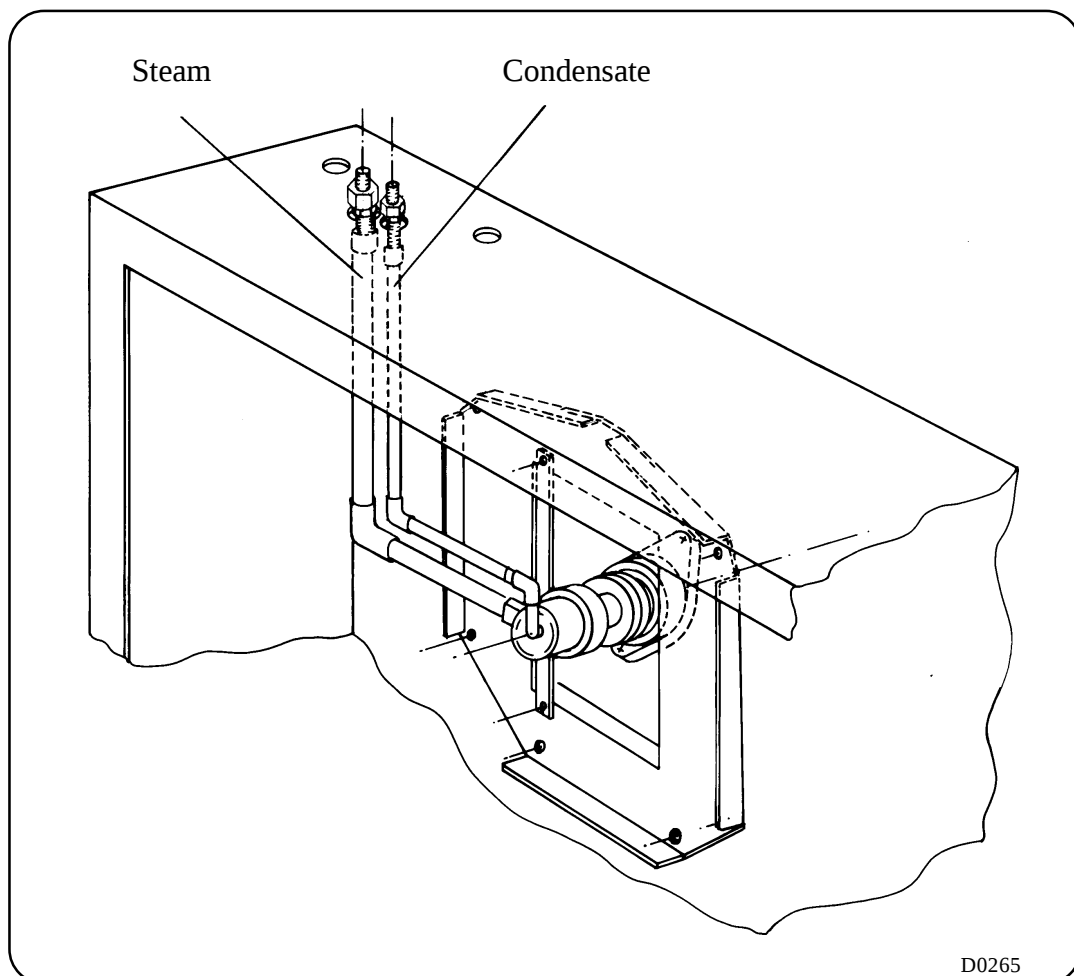
STEAM CONNECTION

Admissible steam pressure : **12 bar maximum.**

Provide a manual shut off valve (quarter turn valve forbidden).

Return of condensates : To be forecasted by the customer : a trap with closed ballcock with a device to remove all the no-condensable and with an against-steam top (example of recommendation ; Sarco Ref. FT10C-15/21-pn25, maximum condition of use at extraction 45l/h), a by-pass, a non-return valve, a manual stopping valve and a filter.

Connect the installation at the back of the machine to diameter 26/34 for the admission and to diameter 15/21 for the return of condensates.



POWER SUPPLY

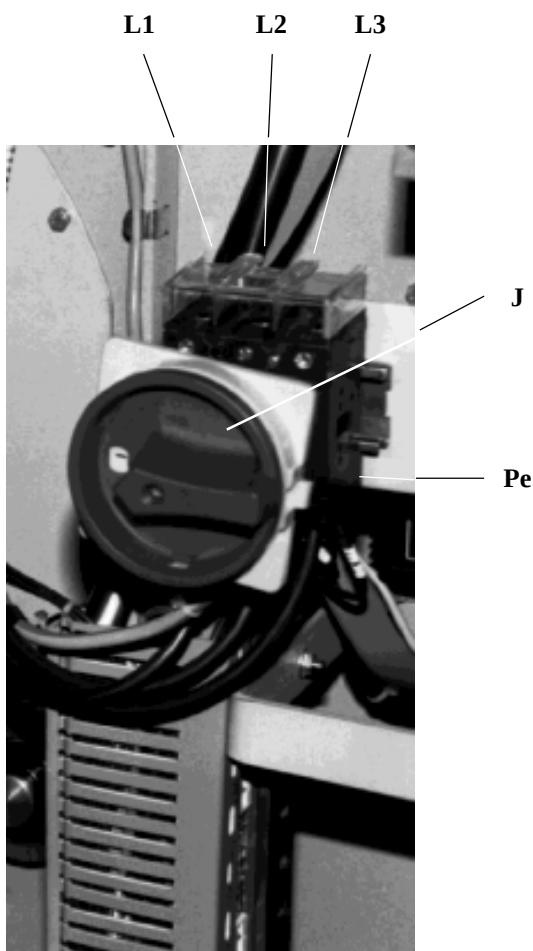
Provide a breaker in the general switch cabinet or HPC fuses.

Pass the feeding cable of the machine through the grommet (F on the foundation plan).
Connect this cable to the main switch of the machine (J) at L1, L2, L3, and Pe terminals.

IMPORTANT :

Check that the mains voltage is correct and that your installation is powerful enough before connecting the machine (see chapter 5 for the cross sectional areas of cables).

P0002



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COMPRESSED AIR SUPPLY

Provide a manual stop valve.

Admissible pressure 5 bar mini
8 bar maxi.

The air should be perfectly dry and oil-free.

COMPRESSED AIR CONSUMPTION AND DEBIT

Screw-type compressor : 20 m³/h output on a 200 litres container.

Piston compressor : 25 m³/h output on a 500 litres container.

Instantaneous output : 25 litres/second.

Maximum consumption : 20 Nm³/h.

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Before the very first starting operation, it is necessary to take off the protective paper rolled round the heating cylinder.

To do so, you have to install the crank (V) that you have found in the caisson together with this instruction handbook (see photo).

Turn the crank to make the cylinder rotate and remove the protective paper.

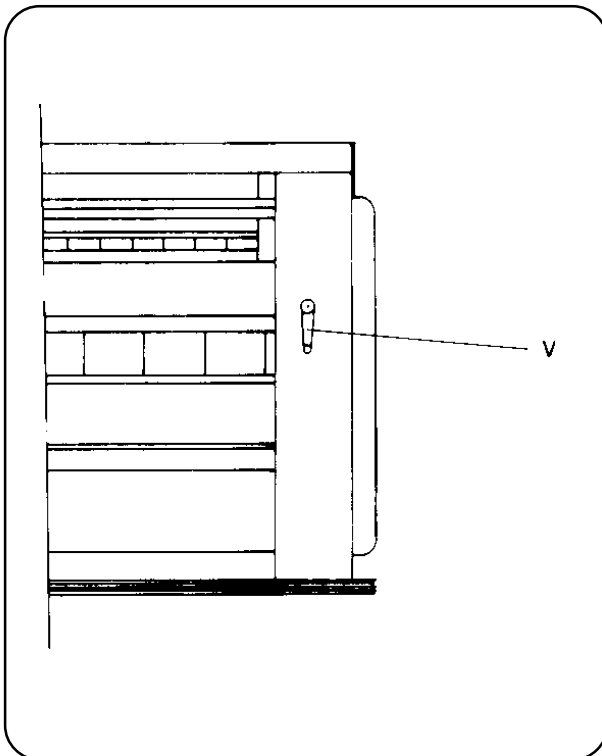
IMPORTANT

The fan may rotate in the wrong direction.

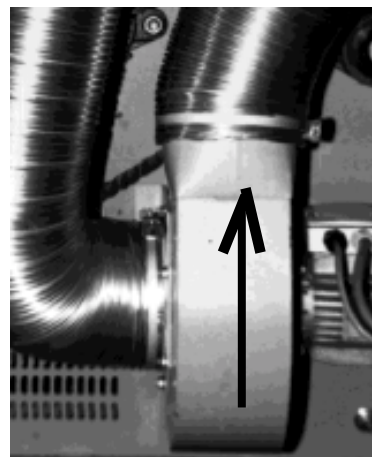
Check the direction of rotation of the fan.

If the fan of the ironer rotates in the wrong direction when the machine is three-phased, two of the three phases must be inverted on the supply section switch in order to change the direction of rotation of the fan.

P0063



P0024



When the side casings have been reassembled, please follow the instructions below :

Check that the installation is correct (see chapter «Installation»).

1. Turn main section switch to I «ON». The LED (1) «voltage» lights.
2. Turn the potentiometer (6) to the minimum speed: 3,2m/mn (maximum speed : 10 m/mn).
3. Press key (4) «ON». The machine sets to the position «without folding» (the feeding clamps spread, the feeding strip goes back, the evacuation table tilts after about thirty seconds).

LED (3) lights.

The cylinder and the guiding bands rotate.

The fan works and draws the air out of the machine outside the building.

The indicator (5) of ironing speed lights.

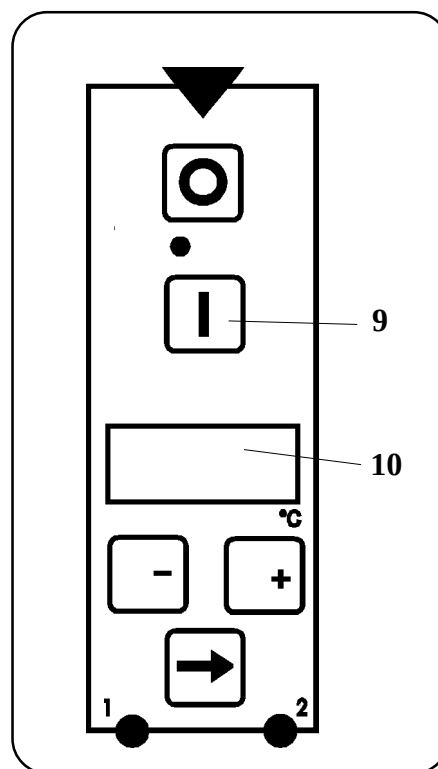
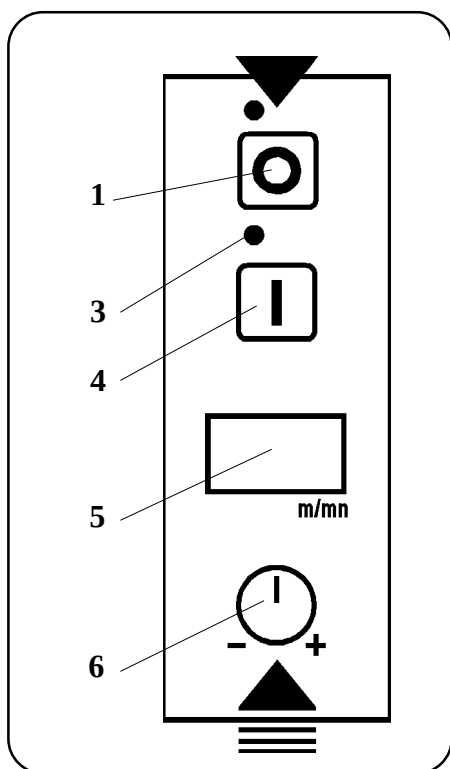
The indicator (10) of cylinder temperature lights.

The indicators (19) "sheet at feeding place" and (20) «front longitudinal folding» light.

Check that the finger protection is working. The finger protection must stop the machine when it is touched. LED (1) «voltage» is the only one that remains light.

To restart the ironing process, carry out the starting operations again.

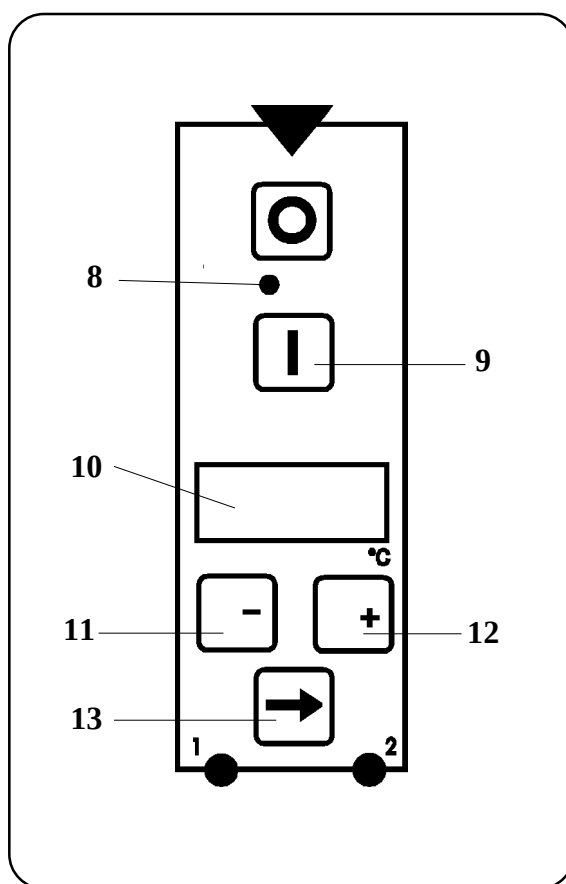
The machine will not start if the premises where it is installed have a temperature of less than 10 °C.



START-UP STEAM HEATING

1. Open the by-pass or the return of condensates cock to drain the pipes for one minute approximately ; the temperature of the cylinder will rise more quickly.
2. Slowly open the steam valve and check the temperature on indicator (10).
3. Press key (9) «HEATING ON».

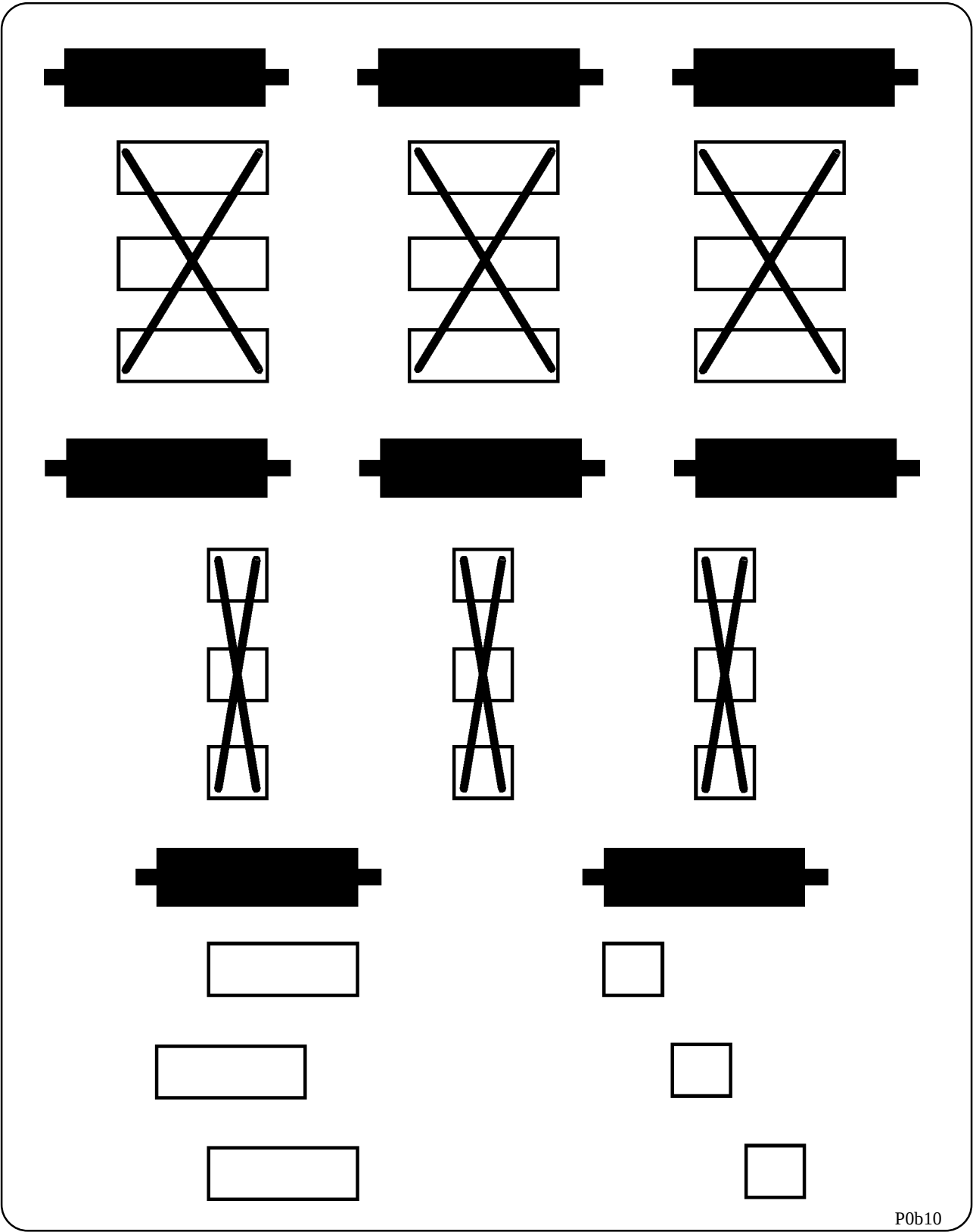
NOTA : keys (11, 12 and 13) have no action.



r0126gb

CORRESPONDENCE STEAM PRESSURE / TEMPERATURE												
Manometric pressure in bar	1	2	3	4	5	6	7	8	9	10	11	12
Temperature in °C	119	133	143	151	158	164	169	174	179	183	187	191

If you want to use the machine manually (without folding), alternate the ironing as indicated below.



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NOTA : All our machines are tested in the factory. However, when starting up the machine, a modification in the folding parameters may have to be done by a technician. This depends on the nature and texture of the customer's pieces of linen.

- The linen should be well-rinsed to avoid it from becoming discoloured and also to prevent any soiling of the drum.
 - Proceed to iron when the temperature has reached approximately 160° C.
 - Blankets should not be ironed.
 - Check that the linen tolerates ironing, and at which temperature.
 - Be careful with synthetic linen and also with linen having prints on. They can melt and stick on the cylinder.
 - In order to obtain the highest ironing quality, we advise that you feed the flat items (towels, sheets etc...) starting by the hem.
 - If the linen must be ironed twice to get dry, there is a risk of yellowing, and likewise if the speed is reduced.
 - If the linen is not dry after one ironing, it may be due to :
 - * a washing machine having a low extraction capacity (below 300 G) ; if this is so, a short pre-drying (5-10 min) in a tumble dryer is advised
 - * the thickness of the linen
 - * a too high ironing speed.
 - Do not iron pieces of linen folded in 4 given in this precise case and due to the considerable thickness, it is impossible to get the quality of drying/ironing/folding you may expect from your machine.
 - If linen coming out of the ironer is still damp, the ironing speed should be reduced (turn potentiometer 6 of the control panel) until a proper quality of ironing is achieved.
 - If the linen is starched, there is a risk of deposit on the cylinder because the linen sticks on the cylinder.
 - Check the quality of the main wash water (TH/TAC).
 - Check the washing and rinsing cycles (see running incidents "phenolphthalein).
 - Check the fur up in the linen (quantity of ash).
- Productivity and quality of the ironing/folding depend on the quality of the washing.
Make sure that all these condition are met.
Linen should not be too much extracted to allow a correct running of the machine.

IN CASE OF MANUAL IRONING.

- Feed carefully the item to be ironed, because it is impossible to remove a piece of linen that has not been properly fed.
- Leave 30 cm between the items to be ironed.
- Check that the pieces of linen are not wider than the guiding bands.
- If possible, use the whole ironing width (see fig. P0010).
- If small sheets or other small items are to be ironed, these should be fed alternately left and right of the heating drum (see fig. P0010).

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PRACTICES TO AVOID :

- Sheets folded double.
- Draw-sheets or any other double-layer sheet or sheet pulled into the machine side by side.
- Fitted-sheet ① : *May cause problem to smooth out; Measurements altered.*
- Comforter cases with flap ②
- Linen $\leq 80 \text{ gr /m}^2$: *gravitational pull difficult at lengthwise folding*
- Linen $\geq 200 \text{ gr/m}^2$.
- Linen $< 0.90\text{m} \times 1.35 \text{ m}$ (folder).

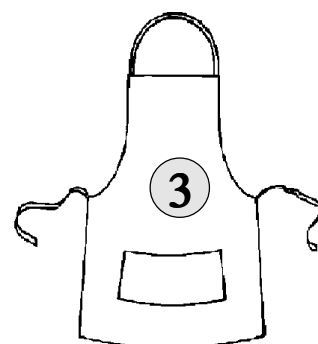
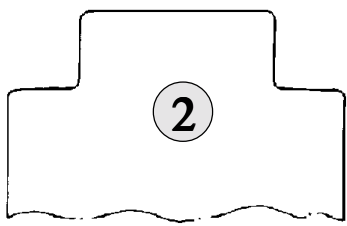
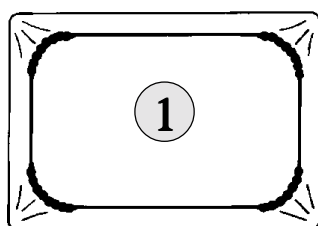
PRACTICES NOT ADVISABLE :

- Folding of tableclothes (of poor quality).
- Sizes not fitting the cylinder working length (partial use of the cylinder) except with steam heating.
- Worn polycotton sheets (cotton worn away) : *get out of shape when smoothed out, uneven finish look when folded, high static electricity.*
- Large cotton or flax-made sheets $> 200 \text{ gr/m}^2$ (80 mm layers after the 3rd cross fold $< \text{or} = 80 \text{ mm high!}$).
- Linen other than flatwork : (butcher's apron ③) : watch that the cords do not slide between the feeding belts).

CAUTIONS :

- Prepare the large sheets before feeding : *ironing and folding defects, risks of jamming at cross folding.*
- Avoid the torn, worn or holed sheets : *that may hook and alter the measurements hampering proper lengthwise folding (back clearing).*
- Comply with the mini-maxi sizes.
- Avoid when running, too low or bad adjusted temperatures as consequence of :
 - A too high ironing speed with high moisture content in sheets : *bad sliding on metallic parts.*

D0411



SCHEDULER LEGEND FOR MACHINE WITH AUTOMATIC FEEDING AND FRONT OR REAR EVACUATION

A / GENERAL CONTROL AND MOVEMENT

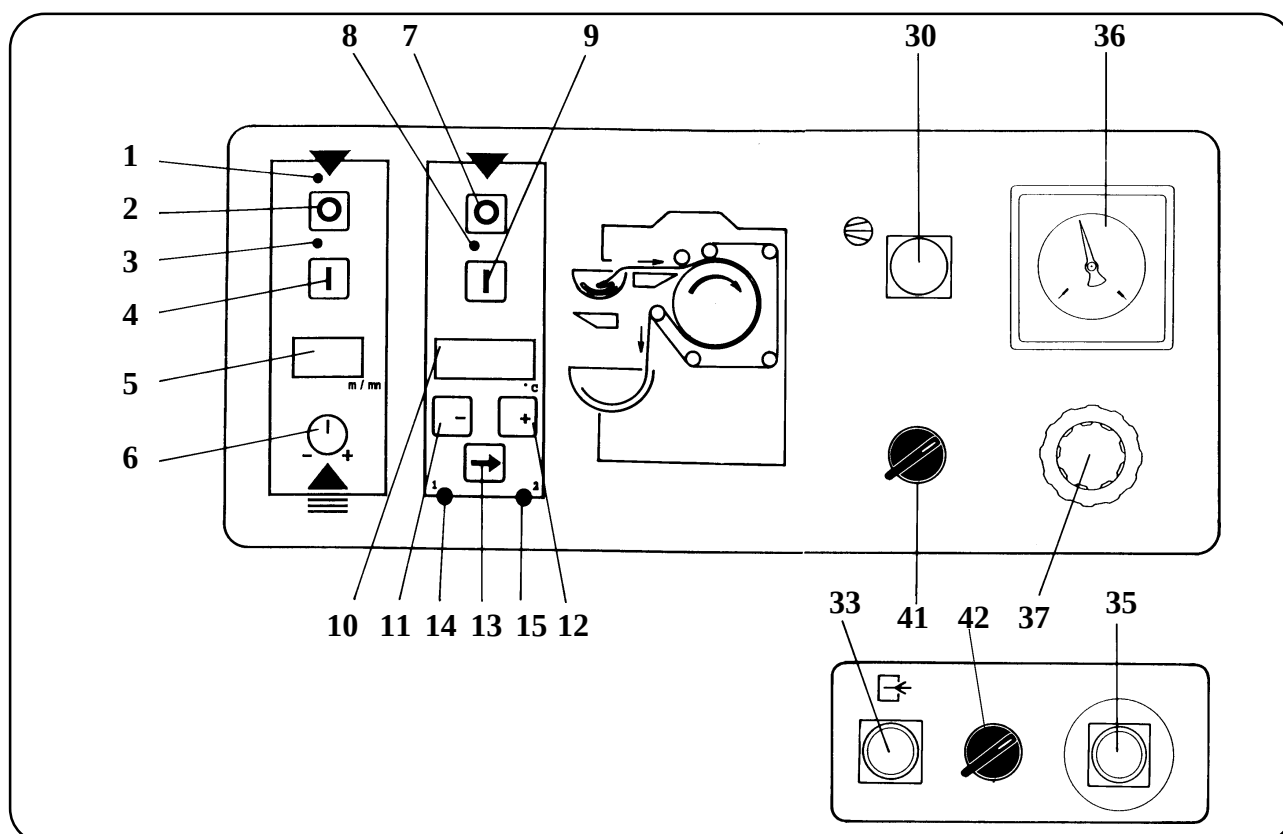
1. Voltage indicator
2. «OFF» key
3. «ON» indicator
4. «ON» key
5. Ironing speed indicators
6. Ironing speed adjustment button

C / FOLDING CONTROL

- 16 à 29. Not used
30. Air short supply indicator
- 31 et 32. Not used
33. Automatic feeding button
34. Not used
35. Emergency switch
36. Manometer
37. Sheet stretching tension knob
- 38 à 40. Not used
41. 2 positions switch with or without feeding
42. 2 positions switch front or rear evacuation

B / HEATING CONTROL

7. «HEATING OFF» key
8. «HEATING ON « indicator
9. «HEATING ON» key
10. Ironing temperature indicators
11. Key with no use
12. Key with no use
13. Key with no use
14. Indicator with no use
15. Indicator with no use



SCHEDULER LEGEND FOR FRONT OR REAR EVACUATION MACHINE

A / GENERAL CONTROL AND MOVEMENT

1. Voltage indicator
2. «OFF» key
3. «ON» indicator
4. «ON» key
5. Ironing speed indicators
6. Ironing speed adjustment button

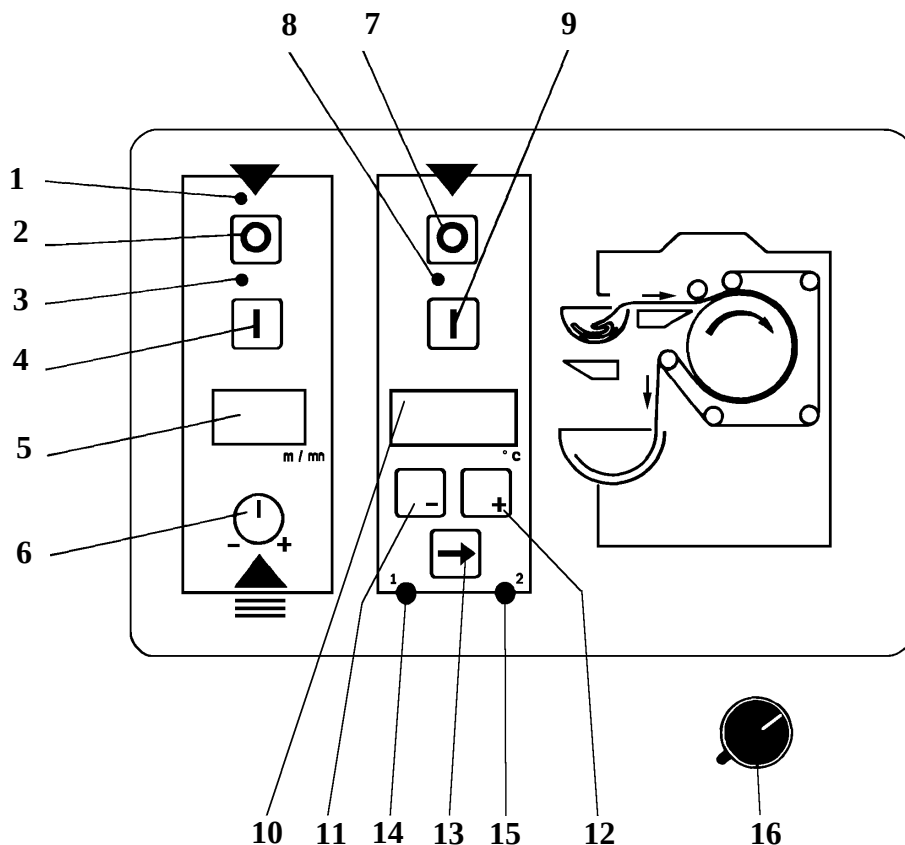
B / HEATING CONTROL

7. «HEATING OFF» key
8. «HEATING ON « indicator
9. «HEATING ON» key
10. Ironing temperature indicators
11. Key with no use
12. Key with no use
13. Key with no use
14. Indicator with no use
15. Indicator with no use

C / LINEN EVACUATION CONTROL

16. Linen evacuation front or rear control key

D0377



SCHEDULER LEGEND FOR MACHINE WITH AUTOMATIC FEEDING AND REAR EVACUATION

A / GENERAL CONTROL AND MOVEMENT

1. Voltage indicator
2. «OFF» key
3. «ON» indicator
4. «ON» key
5. Ironing speed indicators
6. Ironing speed adjustment button

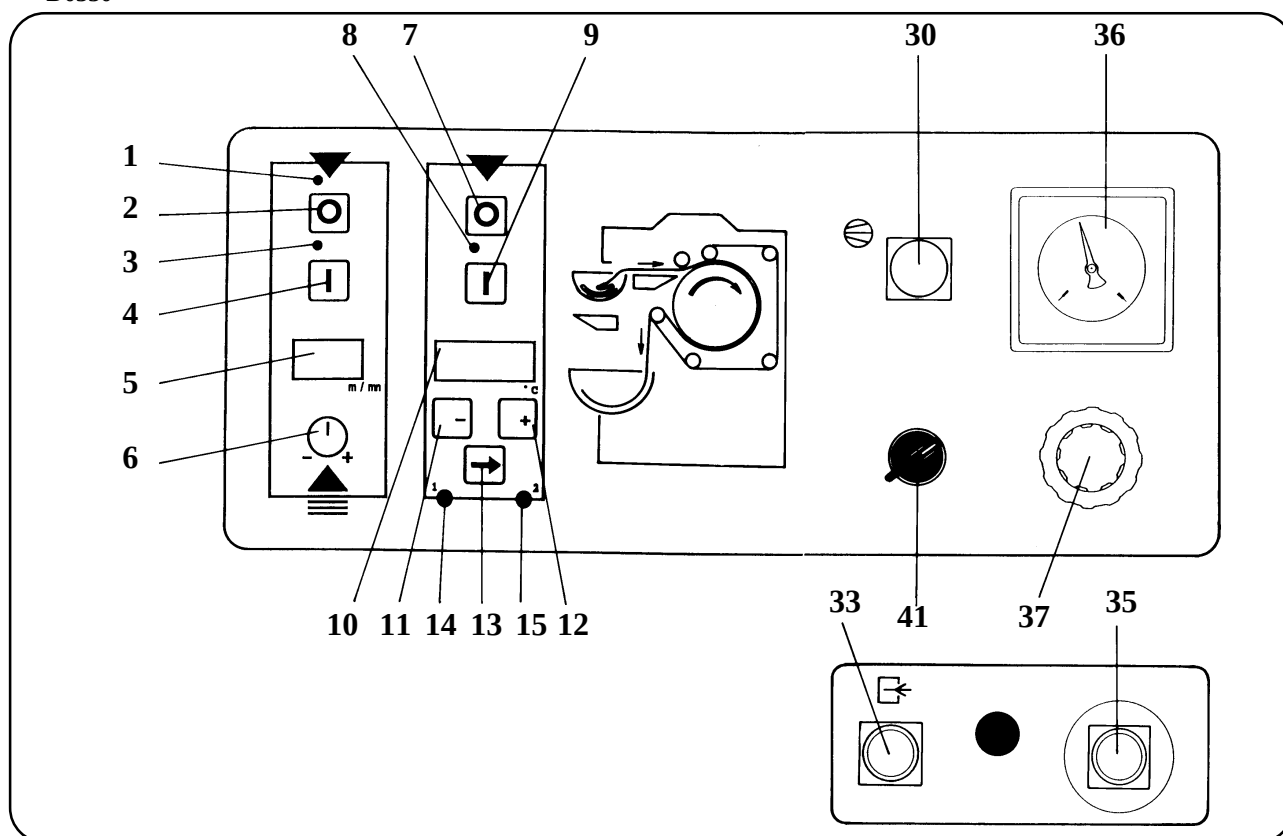
C / FOLDING CONTROL

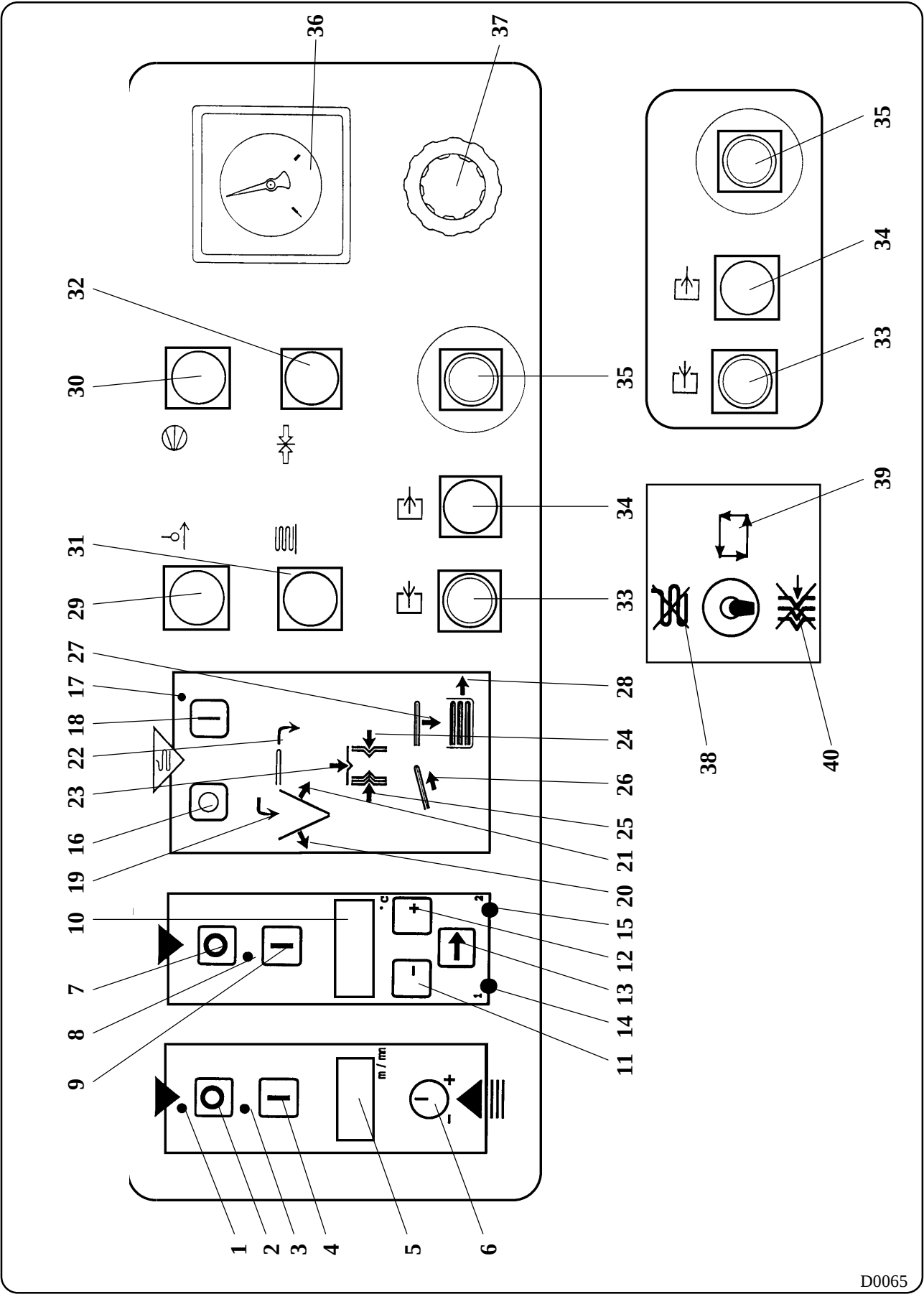
- 16 à 29. Not used
30. Air short supply indicator
- 31 et 32. Not used
33. Automatic feeding button
34. Not used
35. Emergency switch
36. Manometer
37. Sheet stretching tension knob
- 38 à 40. Not used
41. 2 positions switch with or without feeding

B / HEATING CONTROL

7. «HEATING OFF» key
8. «HEATING ON « indicator
9. «HEATING ON» key
10. Ironing temperature indicators
11. Key with no use
12. Key with no use
13. Key with no use
14. Indicator with no use
15. Indicator with no use

D0330





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SCHEDULER LEGEND FOR MACHINE WITH AUTOMATIC FEEDING, FOLDING AND STACKING DEVICES

A/ GENERAL CONTROL AND MOVEMENT

1. Voltage indicator
2. «OFF» key
3. «ON» indicator
4. «ON» key
5. Ironing speed indicators
6. Ironing speed adjustment button

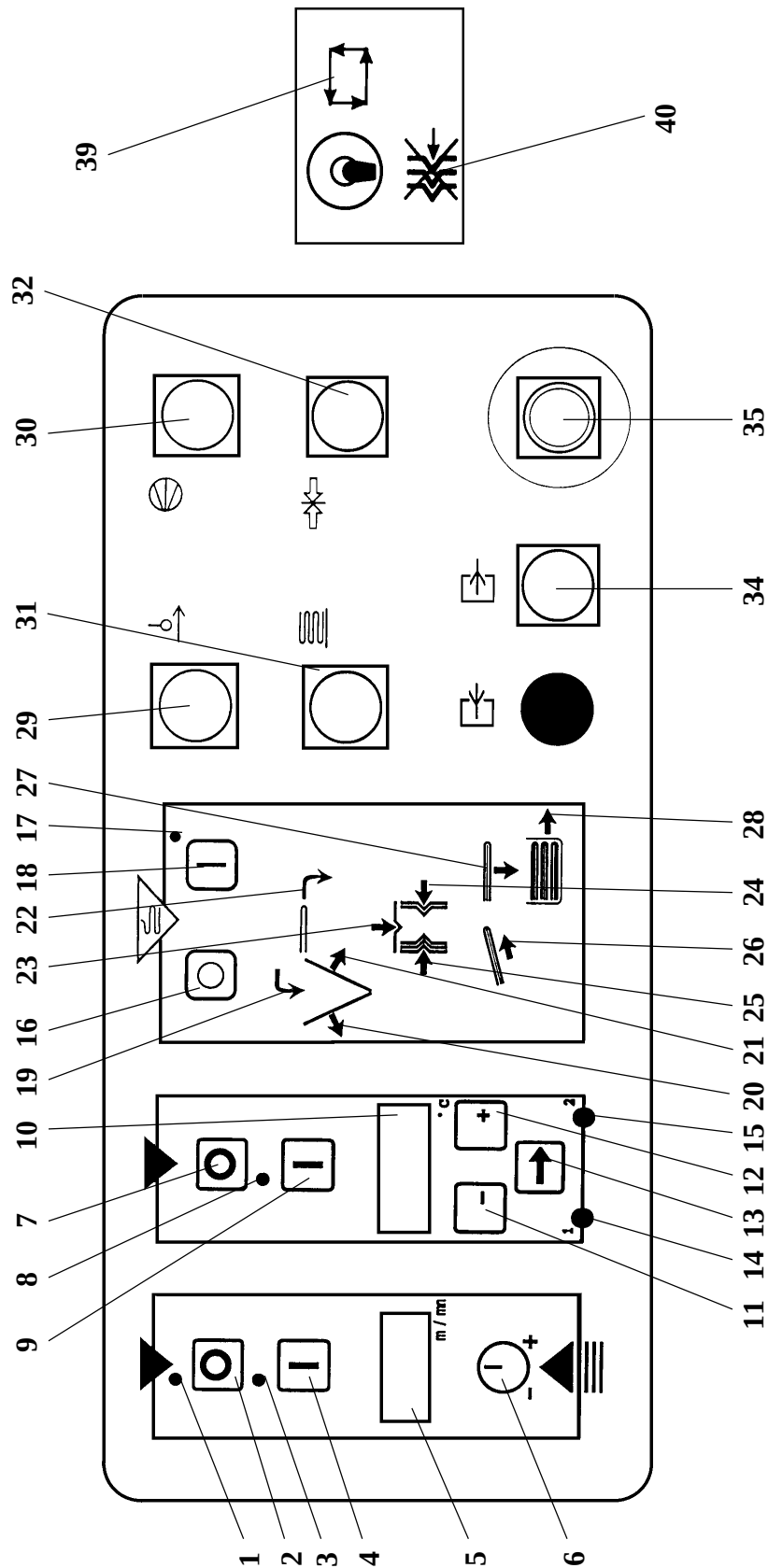
B/ HEATING CONTROL

7. «HEATING OFF» key
8. «HEATING ON « indicator
9. «HEATING ON» key
10. Ironing temperature indicators
11. Key with no use
12. Key with no use
13. Key with no use
14. Indicator with no use
15. Indicator with no use

C/ FOLDING CONTROL

16. «FOLDING OFF» key
17. «FOLDING ON» indicator
18. «FOLDING ON» key
19. Sheet at feeding place indicator
20. Lengthwise folding arm indicator - front position
21. Lengthwise folding arm indicator - back position
22. Sheet back clearing indicator
23. First cross fold indicator
24. Second cross fold indicator
25. Third cross fold indicator
26. Transfer onto stacker indicator
27. Transfer onto stacker indicator
28. Stack delivery indicator
29. Dirty cell indicator
30. Air short supply indicator
31. Full stacker indicator
32. Sheet jam security indicator
33. Automatic feeding button
34. Sheet back clearing indicator
35. Emergency switch
36. Manometer
37. Sheet stretching tension knob
38. Alternative function switch for automatic feeding without folding
39. Standard FFS function switch
40. Two cross fold-section switch

3 positions switch



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SCHEDULER LEGEND FOR MACHINE WITH FOLDING AND STACKING DEVICES

A/ GENERAL CONTROL AND MOVEMENT

1. Voltage indicator
2. «OFF» key
3. «ON» indicator
4. «ON» key
5. Ironing speed indicators
6. Ironing speed adjustment button

B/ HEATING CONTROL

7. «HEATING OFF» key
8. «HEATING ON « indicator
9. «HEATING ON» key
10. Ironing temperature indicators
11. Key with no use
12. Key with no use
13. Key with no use
14. Indicator with no use
15. Indicator with no use

C/ FOLDING CONTROL

16. «FOLDING OFF» key
17. «FOLDING ON» indicator
18. «FOLDING ON» key
19. Sheet at feeding place indicator
20. Lengthwise folding arm indicator - front position
21. Lengthwise folding arm indicator - back position
22. Sheet back clearing indicator
23. First cross fold indicator
24. Second cross fold indicator
25. Third cross fold indicator
26. Transfer onto stacker indicator
27. Transfer onto stacker indicator
28. Stack delivery indicator
29. Dirty cell indicator
30. Air short supply indicator
31. Full stacker indicator
32. Sheet jam security indicator
33. Not use
34. Not use
35. Emergency switch
36. Not use
37. Not use
38. Not use
39. Standard FFS function switch
40. Two cross fold-section switch

3 positions switch

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I - FOLDING MODE

A/ To set the machine to work, proceed as indicated on page 1, paragraph 7.

B/ Press key (18) "FOLDING ON". The machine sets to the folding position (the feeding clamps draw nearer, the feeding strip moves forward, the evacuation table tilts vertically).

C/ Indicator (17) lights.

II - UTILIZATION

The spreading tension of the feeding clamps can be adjusted thanks to the pressure reducing valve (37).

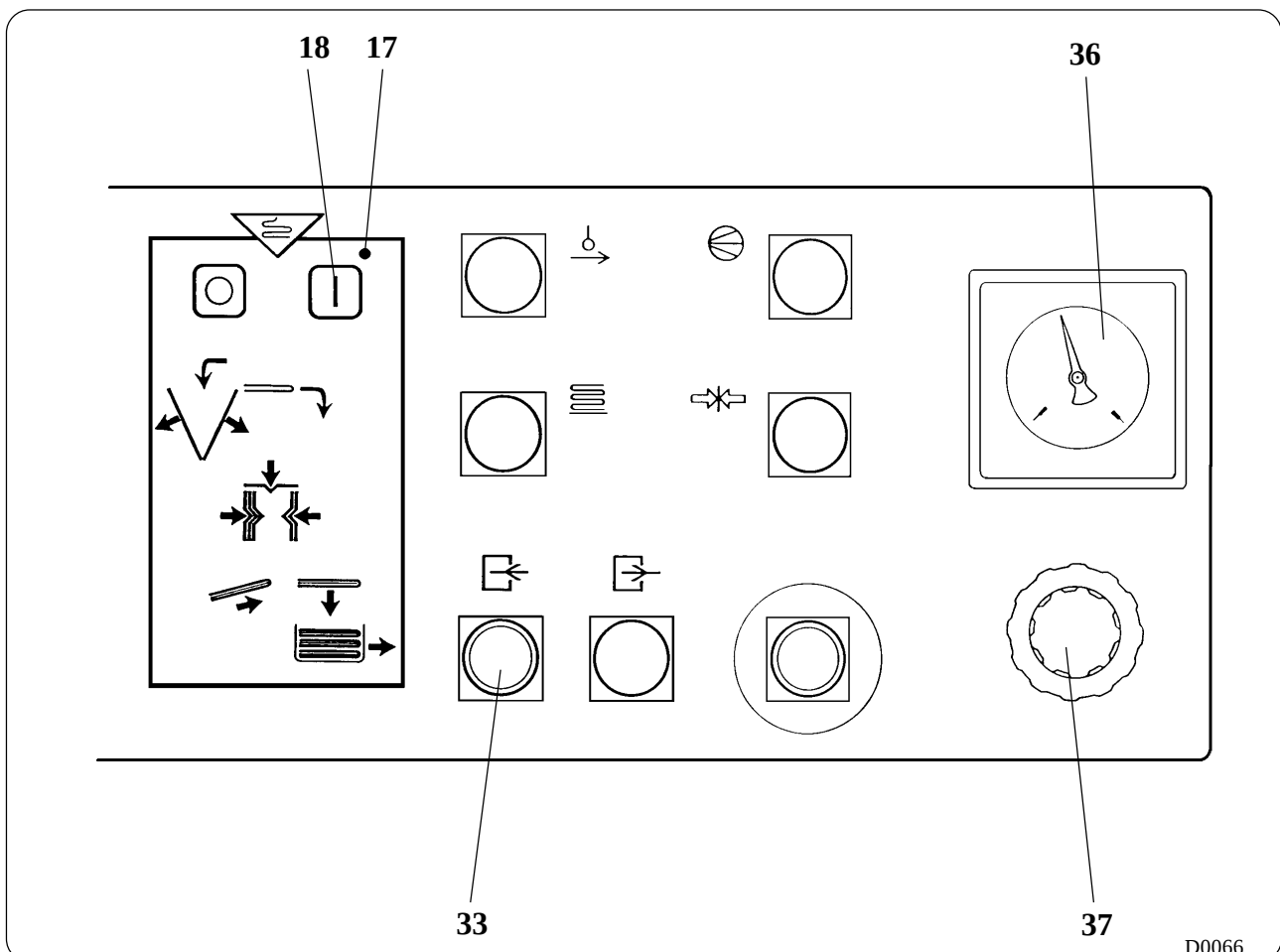
The manometer (36) displays the required tension. A working pressure between 1 and 2 bar is advised.

A/ Take the sheet (by a long side) and insert its extremities in the feeding clamps.

B/ Press the feeding button (33), the clamps spread, stretch the sheet, the smoothing operation starts and the clamps place the sheet on the guiding bands.

A display on the control panel shows the progression of the sheet.

Nota : the ironing process can be carried out even when the folding mode is not used.



SCHEDULER LEGEND FOR MACHINE WITH FOLDER, FRONT OUTLET OR REAR OUTLET

A/ GENERAL CONTROL AND MOVEMENT

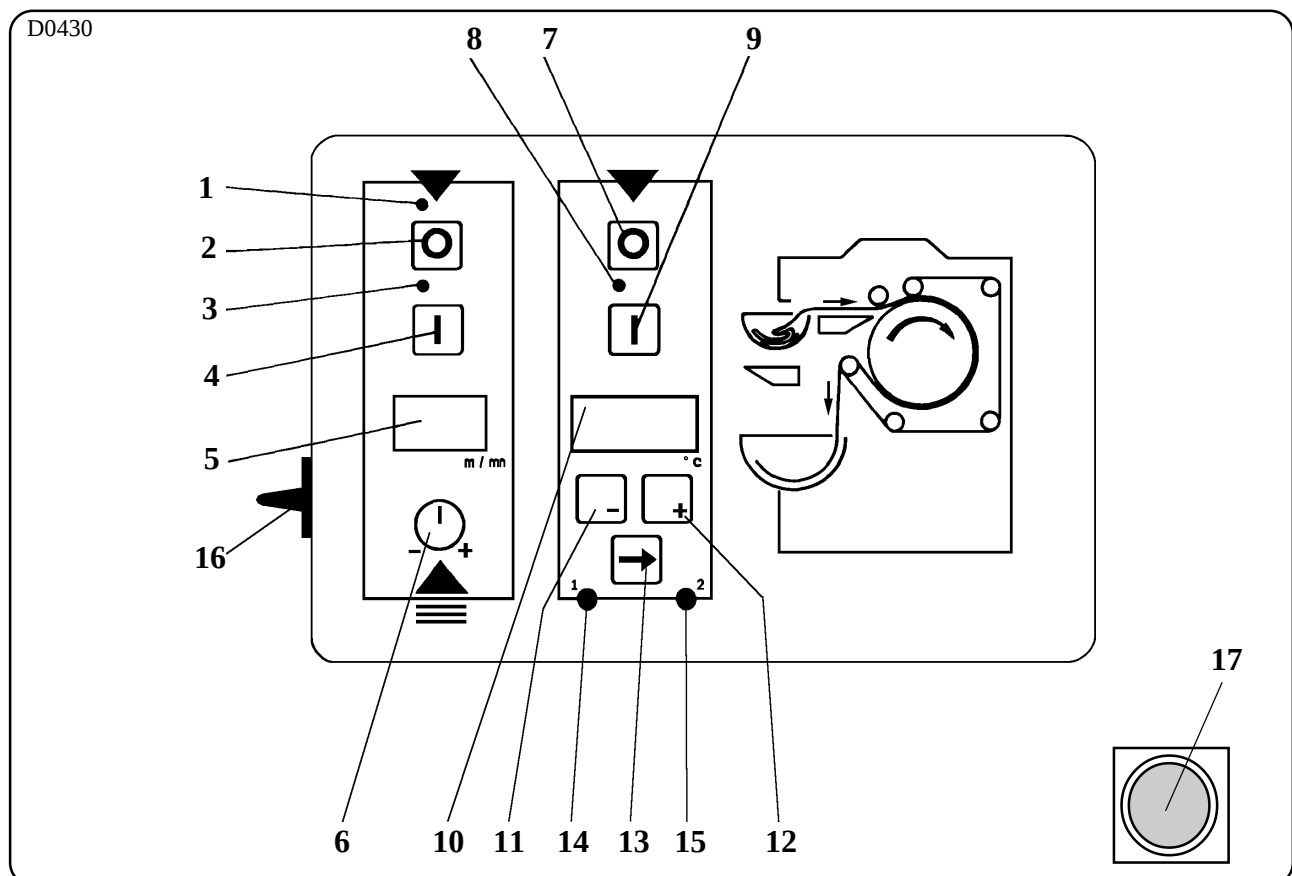
1. Voltage indicator
2. "OFF" key
3. "ON" indicator
4. "ON" key
5. Ironing speed indicators
6. Ironing speed adjustment button

B/ HEATING CONTROL

7. "HEATING OFF" key
8. "HEATING ON" indicator
9. "HEATING ON" key
10. Ironing temperature indicators
11. Key with not use
12. Key with not use
13. Key with not use
14. Key with not use
15. Key with not use

C/ FOLDING CONTROL

16. Select switch for front outlet or rear outlet with folding
17. Eject / initialize push-button



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USE OF THE PUSH-BUTTON ON THE CASING

An action on the button fitted on the ironer's casing ejects the last sheet during the folding process. The sheet is ejected before the end of the folding process and all sheets on the evacuation table are ejected.

Push the button for 4 sec. to re-initialize the automate after an incident during the folding process or after a forced ejection.

SHEETS FEEDING

The positionning of the sheets on the feeding table has to be done with care.

The sheet has to be positionned in front of the detection cell, in the middle of the feeding table, so as the machine can measure the lenght of the piece to be ironeed.

If you put the sheet on the detection cell, the lenght measured will be unaccurate and the folding will be defective.

HOW TO STOP THE MACHINE

In order to extend the lifetime of your machine and its components, observe the following instructions to stop the heating.

Shut the steam inlet valve or the fuel gas valve.

Press key (7) "HEATING OFF" and only that one. Keep on feeding linen to lower the cylinder temperature down to approximately 120 °C.

Do not use the folding mode during the cooling process.

The machine will automatically stop when the temperature falls below 70 °C.

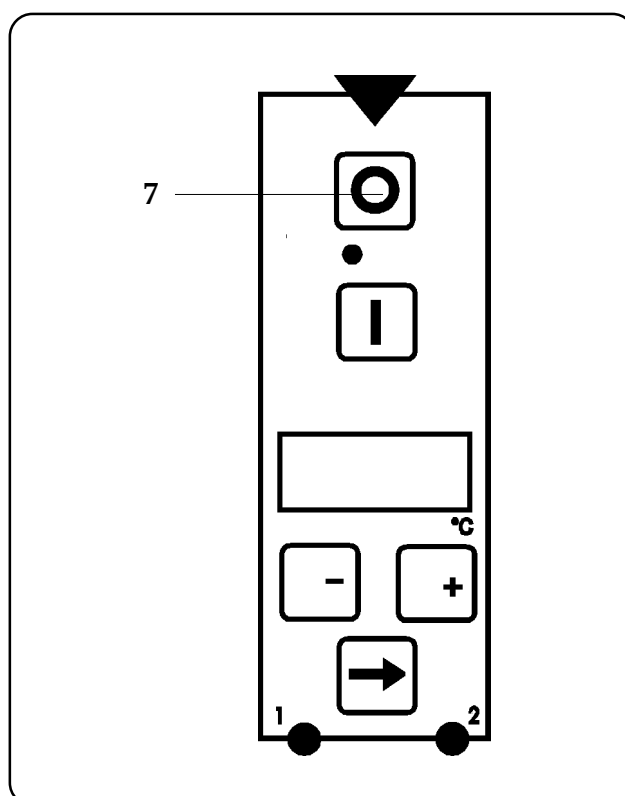
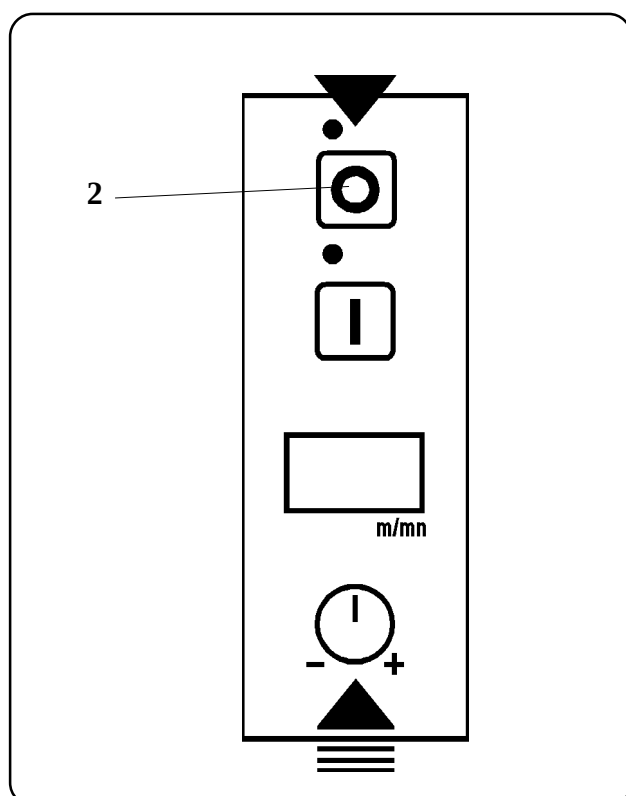
To obtain the automatic stop at 70 °C, it is essential not to press key (2) "GENERAL STOP" otherwise, the automatic temperature lowering function would be cancelled.

When the machine is stopped :

Turn the general switch situated on the left casing to O (OFF).

At any time, it is possible to stop the machine by pressing key (2) - GENERAL STOP.

(Careful : a high temperature of the ironing cylinder may damage the ironing strips).



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SAFETY DEVICES

Safety feeding device.

It is not possible for hands to be inserted into the space between the safety feeding flap and the conveyor strips. The machine stops immediately when the flap is pushed down.

Safety positive device.

If a sheet fed is not transferred to the stacker, the jam indicator (32) signals. The feeding cycle is interrupted. It is then absolutely necessary to evacuate the jammed sheet (see chapter «MACHINE MALFUNCTIONS»).

Safety dirty cells device.

When indicator (29) «DIRTY CELLS» blinks, clean the detection cells and the dirty reflectors.

Safety air short device.

When the compressed air supply pressure is lower than 4 bar, indicator (30) «AIR SHORT» signals.

Safety longitudinal folding device.

When a sheet is not correctly folded longitudinally, it is evacuated in the reception vat at the rear of the machine.

Safety cross-folding device.

When a sheet is not correctly cross-folded, it is evacuated at the right side of the stacker.

Motor protection.

Motors are protected against overheating by thermal protections and a breaker.

Re-starting of the machine.

After any interruption of the machine, power failure, emergency stop, action on the safety feeding device, the machine can only be re-started by pushing the «ON» button (key 3).

Accessibility.

All protective casing can be dismantled with a specially designed tool or with key locks.

Power failure.

In case of power failure, the piece of linen, if any, should be removed with the crank (on the right side of the machine).

If the temperature is too high, it is possible to feed a piece of damp linen to protect the ironing strips.

Safety positive device.

If a sheet fed is not transferred to the stacker, the jam indicator (32) signals. The feeding cycle is interrupted.

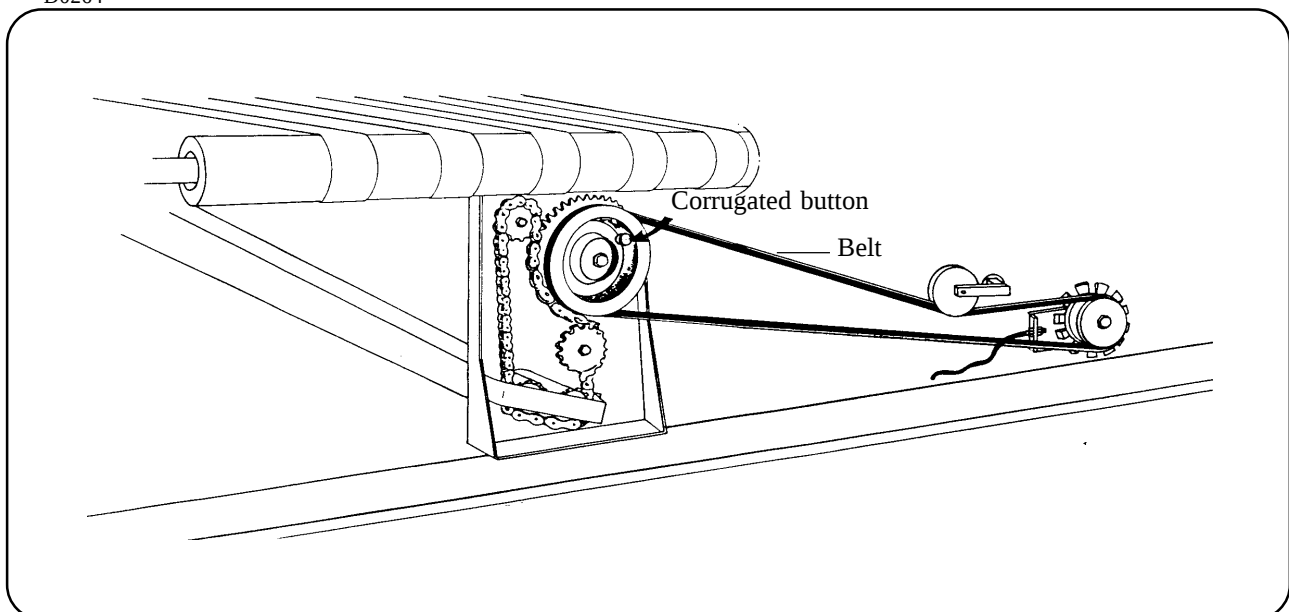
Check that a sheet is not jammed in the cross-folding device at the rear of the machine. If it is the case, it is absolutely compulsory to evacuate it.

Unlock the locking of the driving pulley by pulling the corrugated button and turning it quarter turn to make the pulley idle (**Do not use the corrugated button as a handle**). Act **slowly and only** upon the driving belt to evacuate the sheet.

Lock the pulley again (reclose the corrugated button) and check that it works.

Reset the safety jam button until the jam indicator (32) switches off.

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The linen gets stuck on the cylinder.

- * Check the rinsing result with a 1 % phenolphthalein solution diluted in alcohol. If this colourless liquid turns pink on the linen coming out of the machine, your linen is not properly rinsed and detergents remain.
- * Check the doses of detergent, starch etc. The linen has not been properly rinsed. Increase the number of rinses if necessary or decrease the doses of products.
- * Check that the temperature of the cylinder is correct.
- * The linen is not properly extracted.

The folding device works uninterruptedly.

- * Check that the photocells are opposite their reflectors.
- * Check their cleanliness and clean if necessary.

The folding system is faulty.

- * Check that the photocells and their reflectors are clean.
- * Check the limit switches of the folding arm.
- * Check that the linen is completely dry after the ironing. If it is not, vapours coming from the linen still wet will disturb the detection photocell working

The linen is not dry when it comes out of the ironer.

- * Check the ironing speed.
- * Check the extracting quality of your washer-extractor. The residual moisture ratio should be approximately 50 %.
- * Check that the heating works properly.
- * Check the working and cleanliness of the induction device.
- * Check the condition of the ironing strips (calcareous fibers).
- * Check the pressure of the roller on the ironing cylinder.

Discoloration.

- * The brown coloration arises from washing powder slurries ; it will disappear in the following wash.
- * The coloration caused by a too high temperature cannot be removed.

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The heating does not work or does not work properly.

a) Steam heating.

- * Check the vapour admission and the pressure at the boiler.
- * Check the steam quality.
- * Check the drain cock.
- * Check the nonreturn valve and steam trap.

The ironer is overheated.

- * Check the vapour admission and the pressure at the boiler.

The machine suddenly stops.

- * Check the switches I14 and I5 of the finger protection flap.
- * Check the motion and fan motors.
- * Check the breakers.
- * Check the fuse of the variable speed drive.
- * Check the fuse of the control panel.

The feeding strips do not turn :

- * That kind of malfunction is normal when it only affects some strips.
- * When the pieces of linen can not be fed into the machine anymore, it is necessary to change the tension of every strip in acting on the adjustment of the satellite feeding bearings.
- * Take care that you do not tighten the strips too much. The strip must stop turning with the pressure of one finger. It must restart when the finger stops the pressure.

Check of the control unit.

- * Press key (2) «GENERAL STOP».
- * Press key (7) «HEATING OFF» to cut off the heating.
- * Then press at the same time key (7) «HEATING OFF» and key (4) «ON».

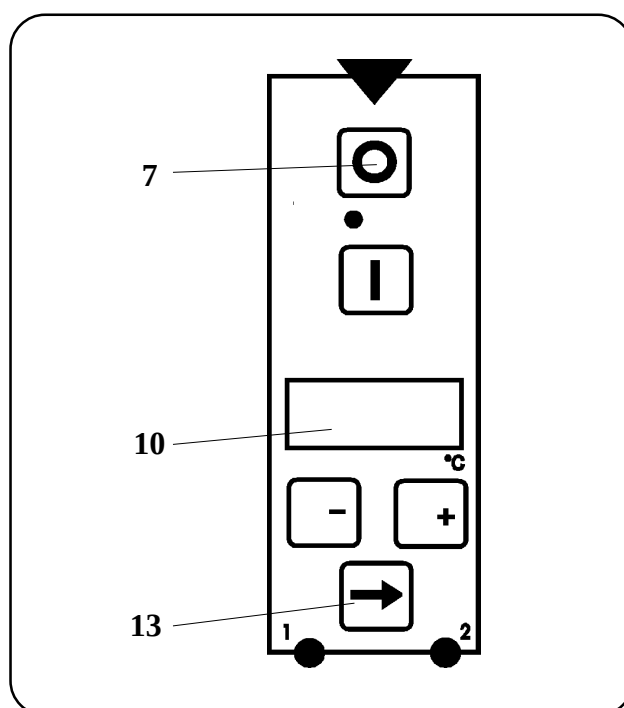
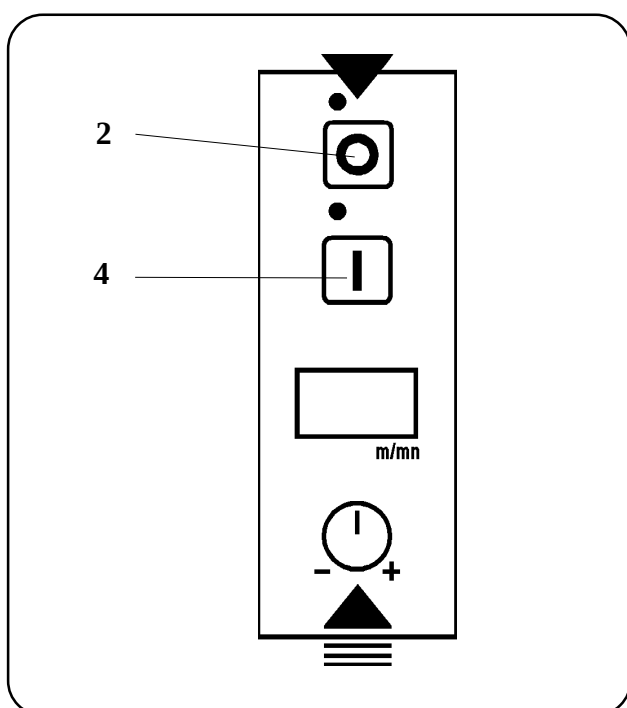
The temperature of the cylinder can now be read on the indicator.

- * Then press key (13) «STORAGE OF THE IRONING TEMPERATURE» ; the figure 100 should be displayed. If it is not the case, repeat the sequence.

Should it fail again, there is probably a breakdown on the printed circuit of the control unit.

GET IN TOUCH WITH YOUR AFTER SALES'SERVICE.

If the figure 100 is displayed, it is necessary to reprogram the programmer.

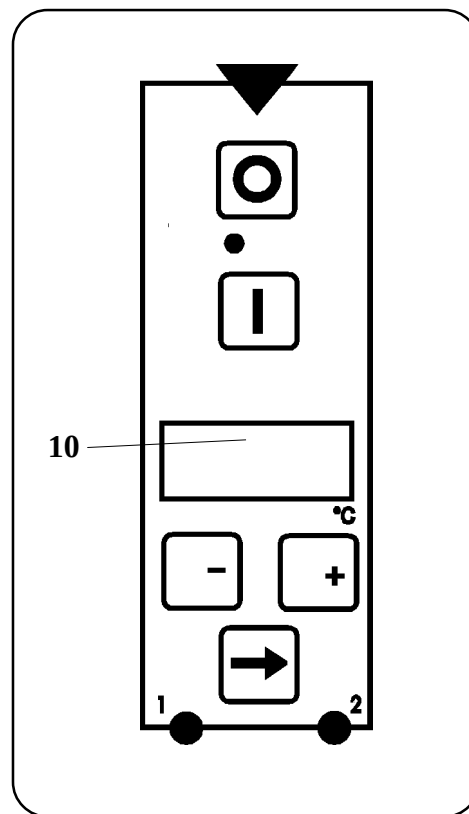


The temperature indicator (10) can display one of the two following values :

254 : indication of a short circuit of the PT100 probe of the adjustment shoe of the cylinder temperature.

255 : indication of a cutoff of the PT100 probe of the adjustment shoe of the cylinder temperature.

It is, in this case, necessary to change the probe of the adjustment shoe of the cylinder temperature.



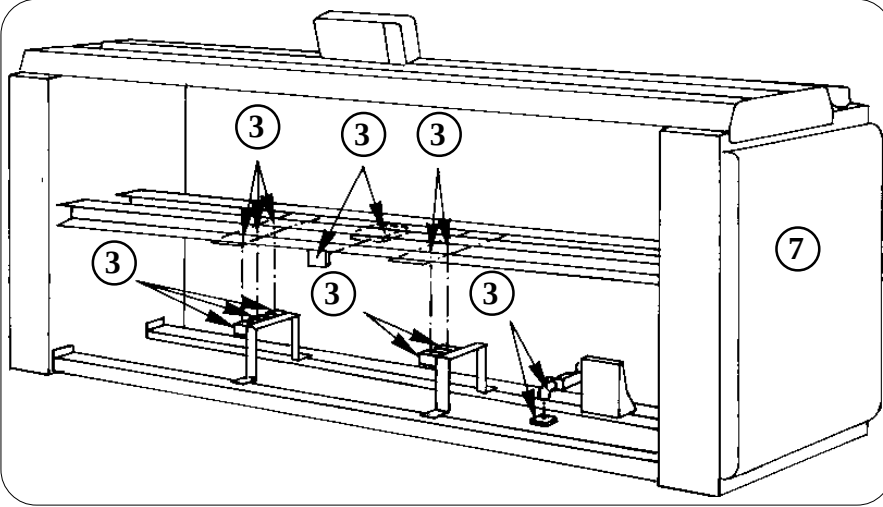
Check the water quality (TH / TAC).

Check the calcareous rate of the linen (ash rate).

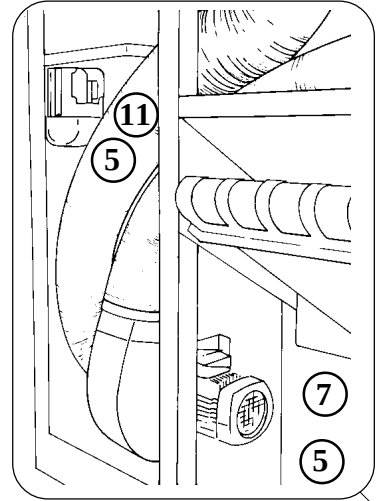
The productivity and the quality of ironing/folding are directly linked to the washing quality.

Check that all these conditions are fulfilled.

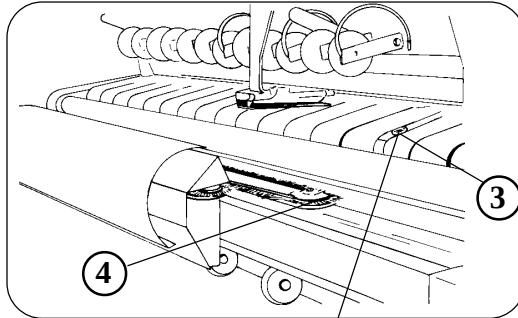
D0085



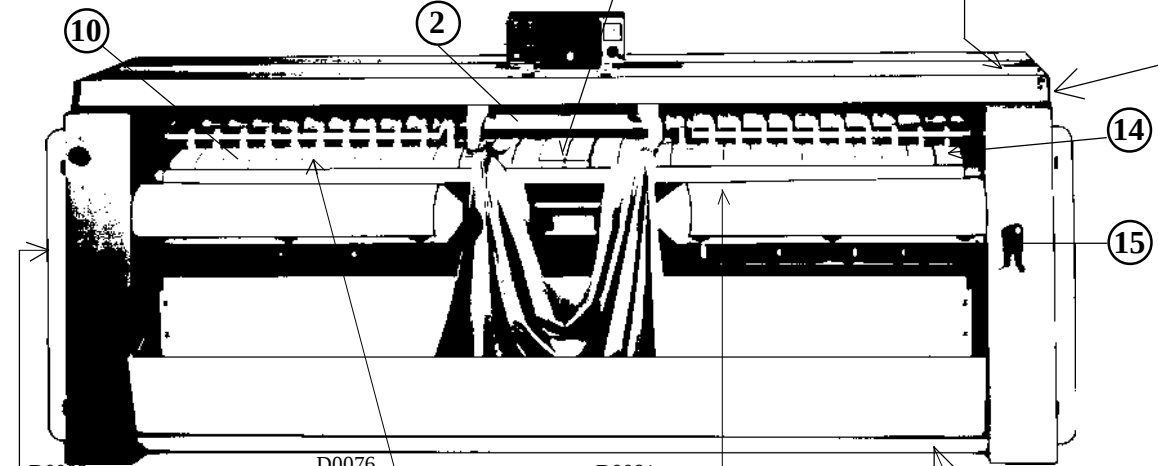
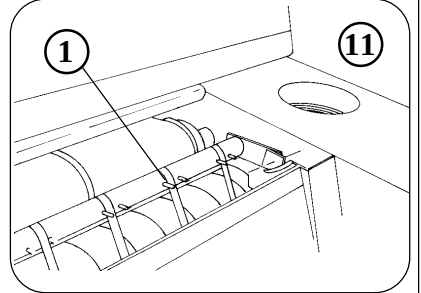
D0082



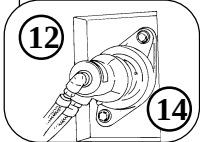
D0074



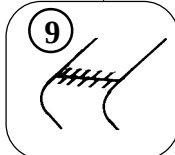
D0073



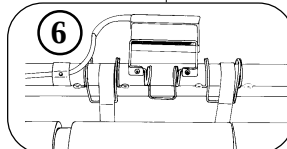
D0083



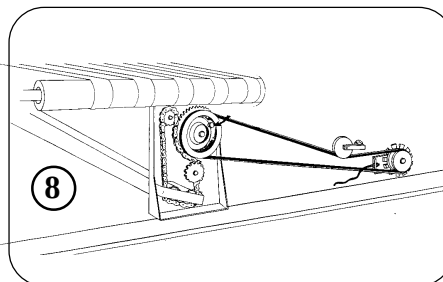
D0076



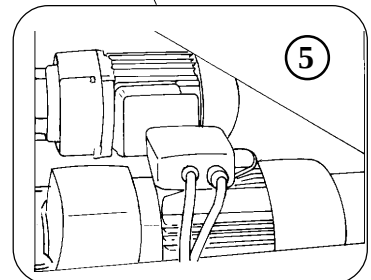
D0081



D0264



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CAREFUL :

SHUT OFF THE POWER SUPPLY OF THE MACHINE BEFORE ANY MAINTENANCE OR REPAIR INTERVENTION IS CARRIED OUT AND MAKE SURE THAT THE CYLINDER IS COLD.

DAILY.

1. Check that the parting strips are intact and replace if necessary.
2. Check that the finger protection is working.
3. Clean the photocells and the reflectors.
4. Clean the smoothing brushes.

WEEKLY.

5. Clean the fan grates of motors.
6. Clean the stripper fingers.
7. Clean the ironer, internal and external, from dust.

MONTHLY.

8. Grease the chains and bearings (see lubrication table on the following pages).
9. Check the condition of the ironing strips and of the clips. Change if necessary.
10. Check the feeding bands and their drive.
11. Clean the whole suction device.
12. Grease the bearing of the steam cylinder with a high temperature grease (see lubrication table).

EVERY SIX MONTHS.

13. Check that the crank is working.
14. Check that the steam turning pair doesn't leak.

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ONCE A YEAR.

15. Check the cleanliness of the cylinder.
16. Check and clean the outer pipes.

CAUTION

**TO ENSURE THAT YOUR MACHINE GIVES THE VERY BEST SERVICE,
PLEASE TAKE CARE THAT MAINTENANCE IS CARRIED OUT IN STRICT
ACCORDANCE WITH THE INSTRUCTIONS ABOVE MENTIONED.**

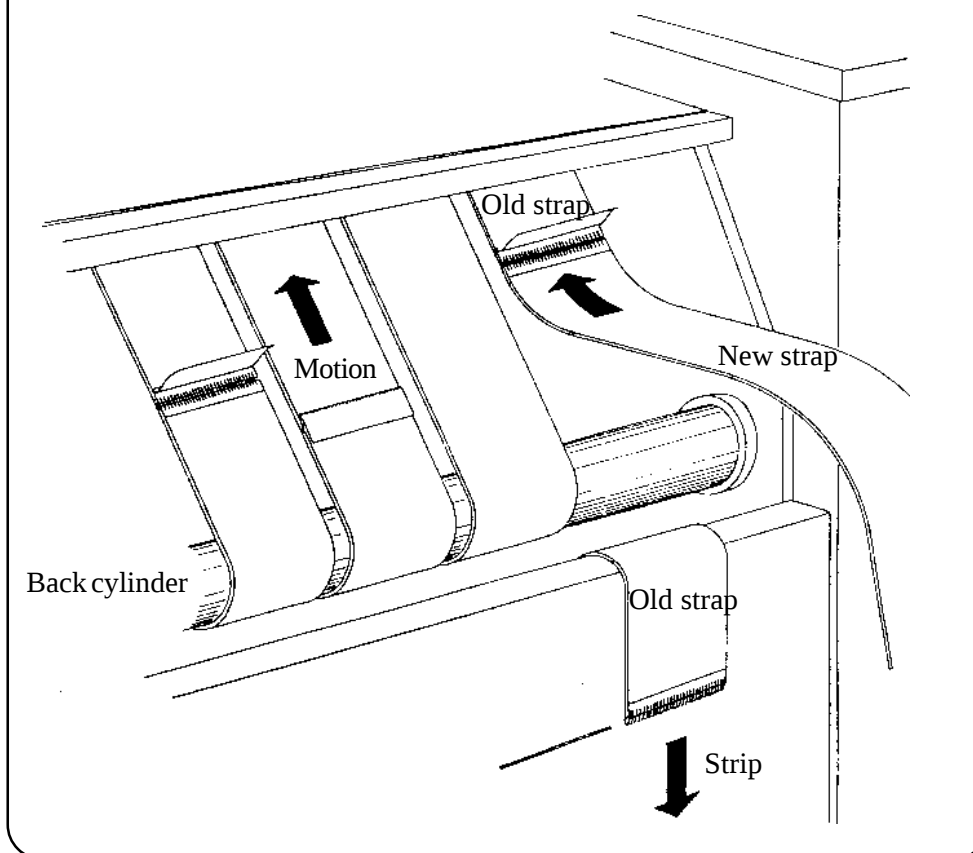
CAUTION.

THE STRIPS TENSION HAS BEEN ADJUSTED AT THE FACTORY WHEN THE MACHINE WAS HOT.

NEVER TIGHTEN THEM AGAIN. THEIR TENSION SHOULD BE AS LOW AS POSSIBLE (JUST ENOUGH TO ALLOW THEM TO BE DRIVEN CORRECTLY).

IF THE STRIPS ARE TOO MUCH TIGHTENED, THEY WILL SOON DETERIORATE. IF YOU HAVE TO MAKE AN ADJUSTMENT, PLEASE TAKE THESE INSTRUCTIONS INTO ACCOUNT.

D0089

REPLACEMENT OF STRAPS

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Motors :

The fan motor is permanently lubricated.

The movement back-gear motor is permanently lubricated.

Bearings :

They are permanently lubricated, except the two steam cylinder bearings, that should be greased with high temperature grease.

Heat control :

Make sure that the shoes of the thermostatic control and of the safety control devices are always clean and in cylinder contact.

Cylinder :

The cylinder must be kept very clean to make ironing easier and of a very high quality.

Deposits of washing powder or lime must be removed as soon as they start to affect the quality of the ironing.

The use of VERY FINE saddle grinder ONLY is recommended (grain 180 or Scotch Brite 3M BFB-AM).

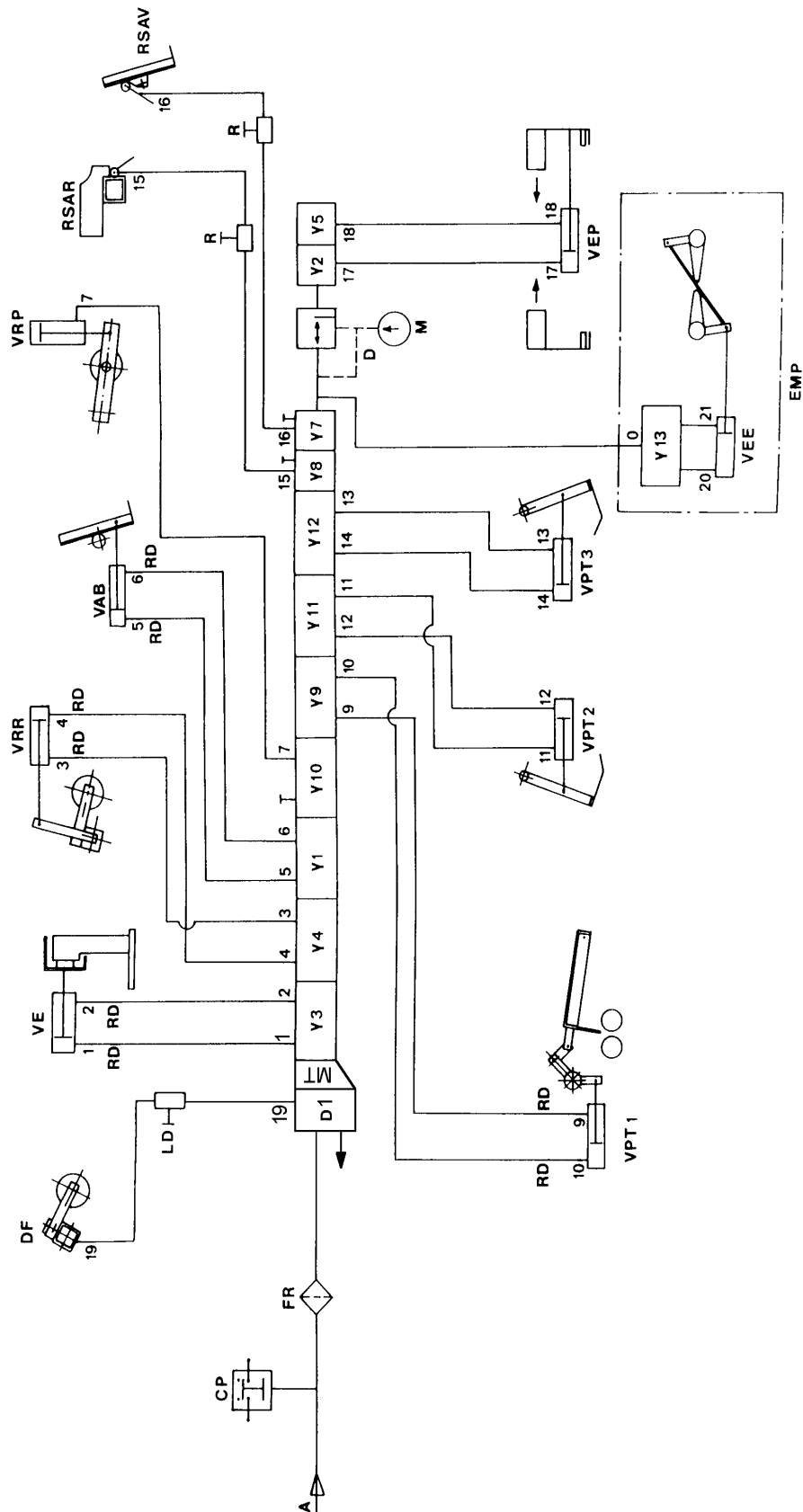
THIS SHOULD BE RUBBED IN THE SAME DIRECTION AS THE LINEN IS PASSED THROUGH THE MACHINE.

Should the machine be stopped for a long period, in order to avoid any oxidation of the cylinder, a sheet impregnated with paraffin wax should be fed through the machine.

Using an old sheet, grate a little paraffin wax onto half of the unfolded sheet, fold in half and then run it through the flatwork-ironer while it is still hot enough.

If the machine is to be left unused for a longer period, it is advisable to oil the cylinder slightly (anti-rust oil ref. 96010012)

t0130gb									
LUBRICATION TABLE									
USES	Rolling bearings	Rolling bearings	Assembly paste	Bare gears	Flange joints	Reducers with	Reducers with	Circuits and	
	Bearings	Bearings high	(fretting	Chains shafts	Union pipes	wheels and	gears	pneumatic	
		temperature	corrosion)	Thread	Steam circuits	screws		devices	
				Slides					
TYPES OF LUBRICANTS AND STANDARDIZATION	Lithium soap grease	Lithium soap grease	Lithium soap paste +	Lithium soap grease	Graphite grease mini	Extreme high	Extreme high	Inhibited oil	
		+ silicone oil	mineral oil + mineral	with MO SE additive	60% graphite special	pressure oil	pressure oil	SAE5	
			solid greases		leakproof				
	Grade ISO NLGI 2	Grade ISO NLGI 3	Grade ISO NLGI 1	Grade ISO NLGI 2	Grade ISO NLGI 2	Grade ISO VG 150	Grade ISO VG 220	Grade ISO VG 22	
TEMPERATURE LIMIT RANGE	- 20°C + 140°C	- 40°C + 200°C	- 20°C + 150°C	- 20°C + 135°C	- 30°C + 700°C	0°C + 100°C	0°C + 120°C	- 10°C + 65°C	
RECOMMENDED	ALVANIA R2	NTN SH 44 M	ALTEMP Q.NB.50	MI-SETRAL 43N		REDUCTELF SP150	REDUCTELF SP220	LUBRA K ATL SAE5W	
CODE PRODUCT	96011008	-	96011014	96011000	96011004	96010001	96010004	96010030	
C O R R E S P O N D E N C E	ANTAR	ROLEXA 2		EPOXA MO 2		EPONA Z 150	EPONA Z 220	MISOLA AH	
	BP	LS EP2				ENERGOL CRXP 150	ENERGOL CRXP 220	SHF 22	
	CASTROL	SPEEROL EP 2				ALPHA SP 150	ALPHA SP 220		
	ELF	EP2		STATERMA MO 10		REDUCTELF SP 150	REDUCTELF SP 220	SPINEF 22	
	ESSO	BEACON EP2		MULTI PURPOSE GREASE MOLY		SPARTAN EP 150	SPARTAN EP 220	SPINESSO 22	
	FINA	MARSON EP2				GIRAN SR 150	GIRAN SP 220		
	GBSA				BELLEVILLE N				
	GRAFOIL				GRACO AF 309				
	KLUBER	CENTOPLEX 2	UNISILKON L50Z	ALTEMP Q.NB.50	UNIMOLY GL 82	WOLFRACOAT C	LAMORA 150	LAMORA 220	CRUCOLAN 22
	MOBIL	MOBILUX				MOBILGEAR 629	MOBILGEAR 630	DTE 24	
	KERNITE	LUBRA K LC		LUBRA K MP		TOP BLENB ISO 80W90	TOP BLEND ISO 220	LUBRA K ATL SAE 5W	
	SETRAL			MI-SETRAL 43N					
	SHELL	ALVANIA R2		RETINA AM		OMALA 150	OMALA 220	TELLUS 22	
	TOTAL	MULTISS EP2				CARTER EP 150	CARTER EP 220	EQUIVIS 22	
	MOLYKOTE		MOLYCOTE 44	PATE DX					
	OPAL	GEVAIR SP		SUPER MOS 2		GEAROPAL GM 65 ISO 150	GEAROPAL GM75 ISO 220	HYDROPAL HO 110 HM ++22	
	ITECMA	GRL-ULTRA	VULCAIN		GMO	LHT-C	DURAGEAR 80 W 140		AEROSYN

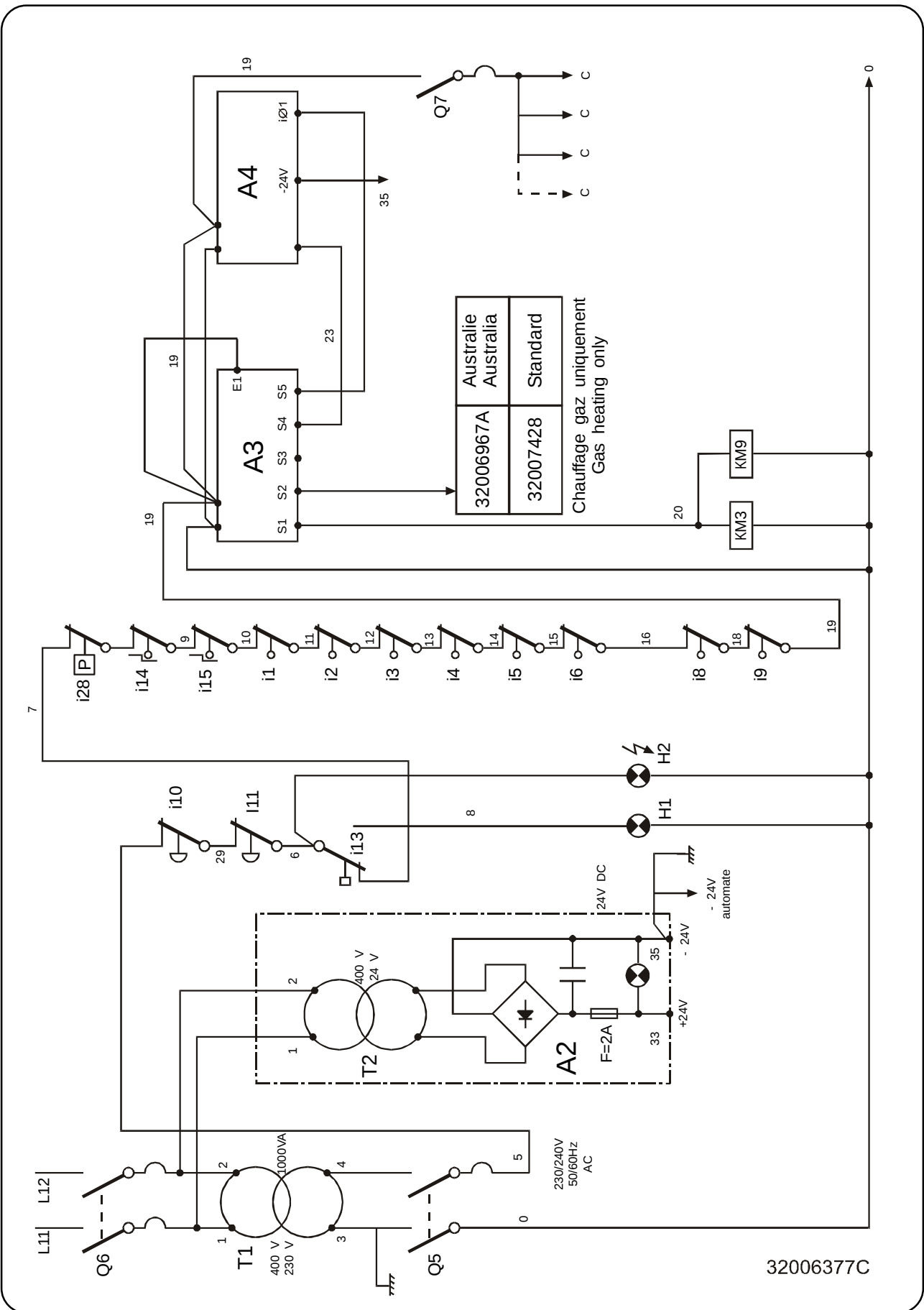


PNEUMATIC DIAGRAM
(feeder, ironer, folder and stacker)
32005552

A	Compressed air supply 8 bar maxi
CP	Air shortage pressostat
FR	Regulating filter 5 microns (adjustment 5 bar)
DF	Feeding blowing supply
VE	Feeding jack
VRR	Small wheels lift jack
VAB	Vat joint jack
VRP	Roller lift jack
RSAR	Rear blowing burner supply
RSAV	Front blowing burner supply
LD	Flow limiter
RD	Flow reducer
R	Adjusting valve
D1	Distributor
MT	Transfer module
Y2 to Y13	Distributor
D	Pressure reducing valve 2/3 bar
M	Manometer
Y2-Y5	NF electrovalve
VPT1	First fold cross-folding jack
VPT2	Second fold cross-folding jack
VPT3	Third fold cross-folding jack
VEP	Feeding clamps spreading jack
EMP	Stacker
VEE	Sheet stacking jack

PNEUMATIC DIAGRAM
(feeder, ironer, folder and stacker)
32005552B

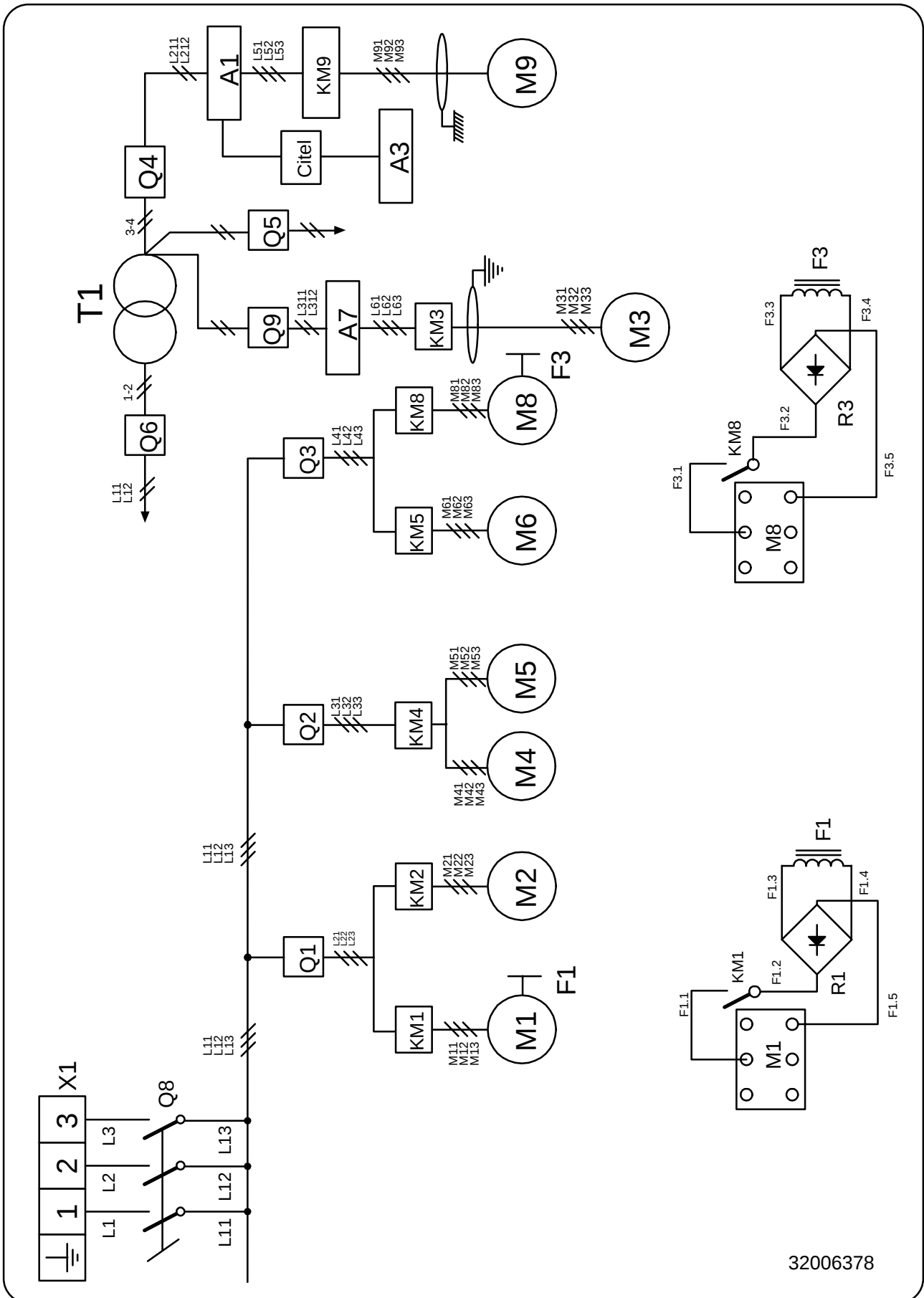
A	Compressed air supply 8 bar maxi
CP	Air shortage pressostat
FR	Regulating filter 5 microns (adjustment 5 bar)
DF	Feeding blowing supply
VE	Feeding jack
VRR	Small wheels lift jack
VAB	Vat joint jack
VRP	Roller lift jack
RSAR	Rear blowing burner supply
RSAV	Front blowing burner supply
LD	Flow limiter
RD	Flow reducer
R	Adjusting valve
Y1 to Y13	Distributor
D	Pressure reducing valve 2/3 bar
M	Manometer
Y2-Y5-Y6	NF electrovalve
VPT1	First fold cross-folding jack
VPT2	Second fold cross-folding jack
VPT3	Third fold cross-folding jack
VEP	Feeding clamps spreading jack
EMP	Stacker
VEE	Sheet stacking jack



CONTROL CIRCUIT (feeder, ironer, folder and stacker)

32006377C

T1	Isolating transformer 1000 VA	
T2	Distribution circuit transformer 24 V	] same part
A2	Distribution circuit rectifier 24 V DC	
A3	Programmer/block diagram	
A4	Programmable automate	
H1	Air shortage indicator	
H2	Stacker indicator	
Q5	Two-pole breaker ph + N 2A secondary	
Q6	Two-pole breaker 2 A primary	
Q7	Two-pole breaker 2 A (common outputs)	
i1	Thermal contact stacker table motor	
i2	Thermal contact pile evacuation motor	
i3	Thermal contact fan motor	
i4	Thermal contact smoothing motor	
i5	Thermal contact smoothing motor	
i6	Thermal contact cross-folding motor	
i8	Thermal contact rear evacuation motor	
i9	Thermal contact motion motor	
i10	Ironer emergency stop	
i11	Stacker emergency stop	
i13	Air shortage pressostat	
i14	Finger protection right flap position switch	
i15	Finger protection left flap position switch	
i28	Gas pressure switch (optional or Australia machine) (for gas heating machine only)	
KM3	Fan contactor	
KM9	Motion contactor	

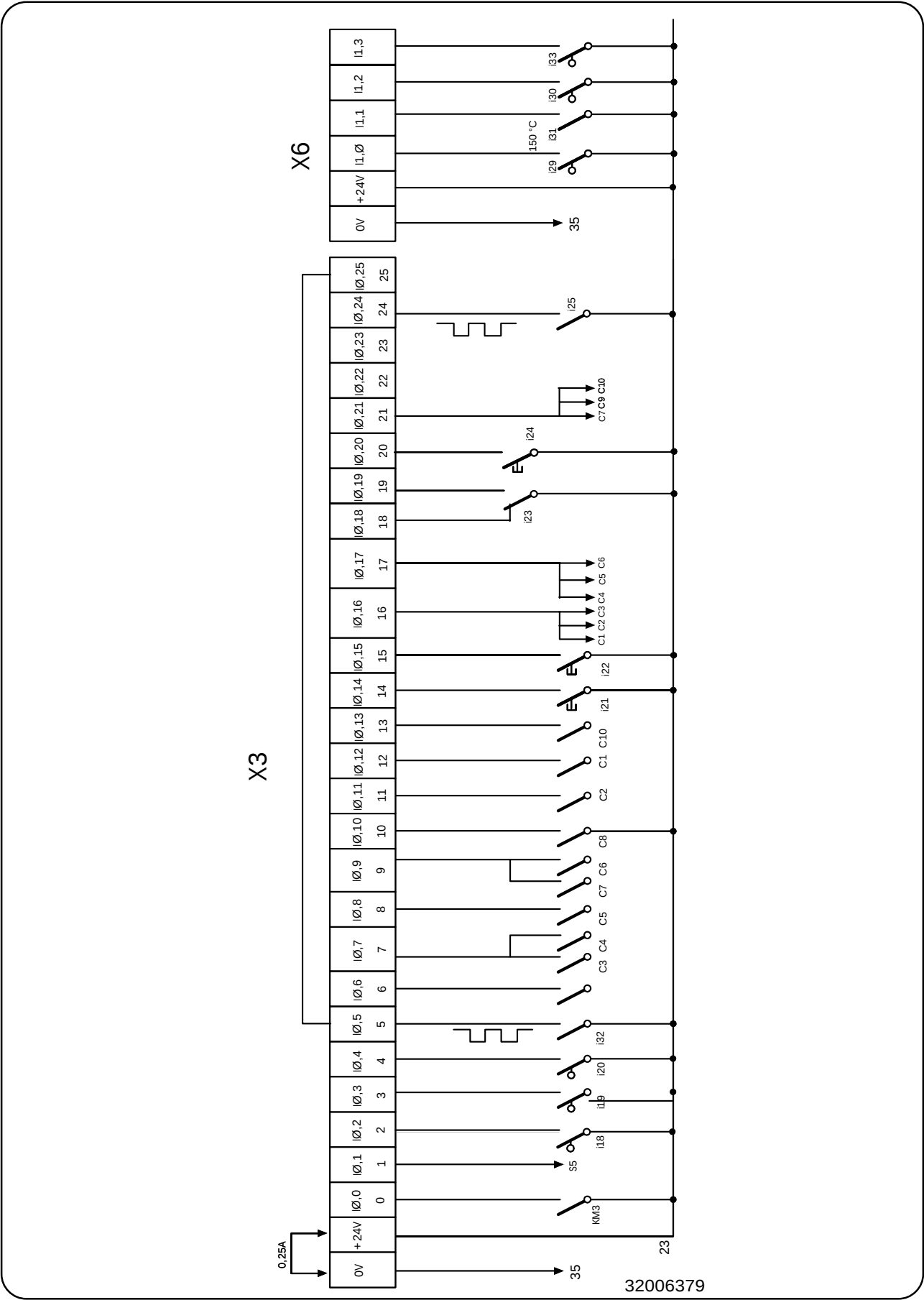


32006378

POWER CIRCUIT (feeder, ironer, folder and stacker)

32006378

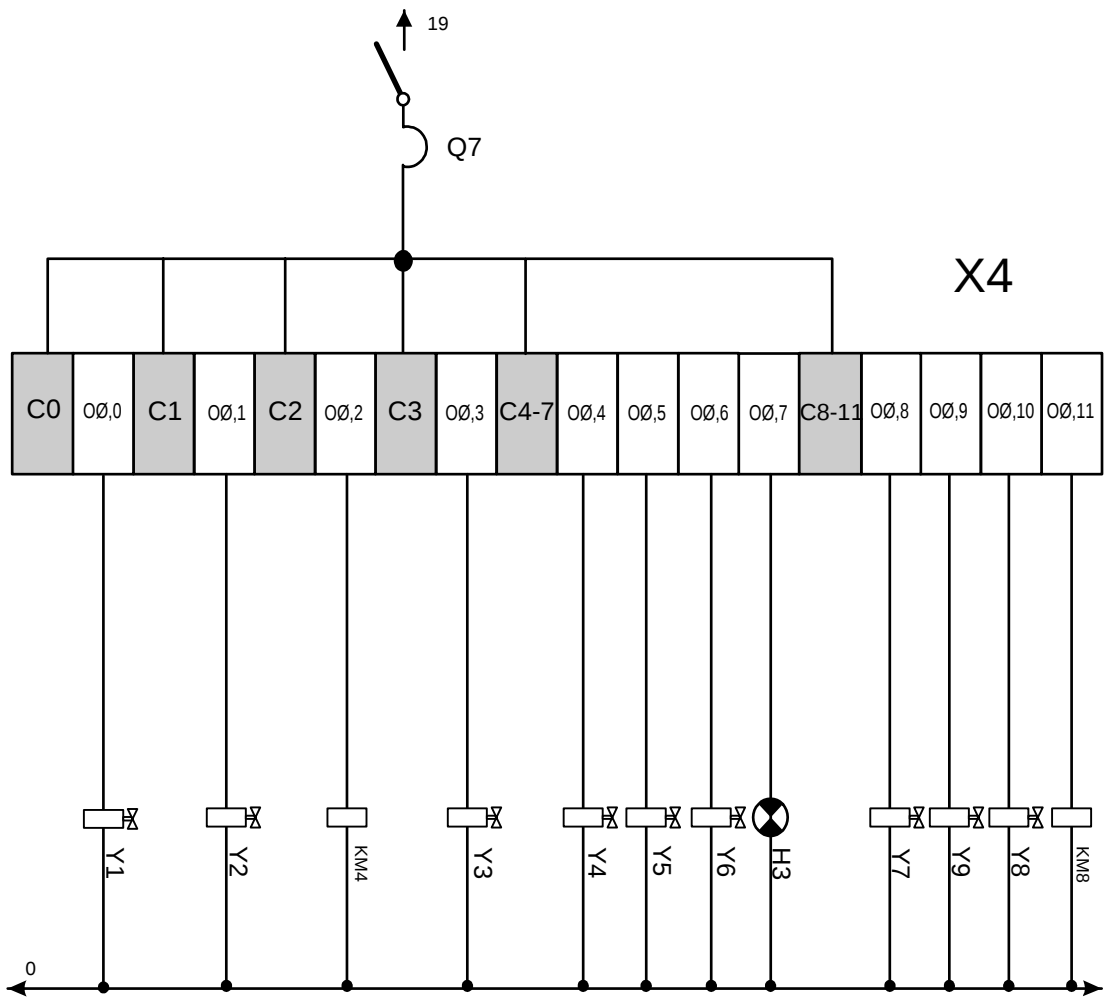
X1	General supply terminal
Q1	Three-pole motor breaker
Q2	Three-pole motor breaker
Q3	Three-pole motor breaker
Q4	Two-pole breaker 4 A
Q5	Two-pole breaker ph + N 2A
Q6	Two-pole breaker 6 A
Q8	General switch
Q9	Two-pole breaker 6 A
T1	Isolating transformer 1000 VA
A1	Motion frequency converter (ATV16)
A3	Programmer
A7	Fan frequency converter (ATV16)
Citel	Accommodating connection
F1	Stacker table brake
F3	Rear evacuation brake
M1	Stacker table motor
M2	Pile evacuation motor
M3	Fan motor
M4	Smoothing right motor
M5	Smoothing left motor
M6	Cross-folding motor
M8	Rear evacuation motor
M9	Motion motor
KM1	Stacker table motor contactor
KM2	Pile evacuation motor contactor
KM3	Fan motor contactor
KM4	Smoothing motor contactor
KM5	Cross-folding motor contactor
KM8	Rear evacuation motor contactor
KM9	Motion motor contactor
R1	Rectifier for brake F1
R3	Rectifier for brake F3



AUTOMATE INPUTS (feeder, ironer, folder and stacker)

32006379

X3	Inputs connection terminal on automate A4
X6	Extension inputs connection terminal
IØ,0	Run / stop
IØ,1	With/without folding
IØ,2	Feeding push button
IØ,3	Jack sensor feed motion
IØ,4	Stacker jack closed flaps sensor
IØ,5	Longitudinal sheet measurement
IØ,6	Sheet at stacker (C9)
IØ,7	Longitudinal folding safety device (C3-C4)
IØ,8	Cross-folding (C5)
IØ,9	Detector for transversal measurement (C6-C7)
IØ,10	Sheet detection at ironer delivery (C8)
IØ,11	Longitudinal folding (C2)
IØ,12	Sheet at feeding (C1)
IØ,13	Pile completed on stacker (C10)
IØ,14	Pile evacuation push-button
IØ,15	Reclosing/initialization push-button
IØ,16	Dirty cell detection (C1-C2-C3)
IØ,17	Dirty cell detection (C4-C5-C6)
IØ,18	Feeding switch without folding
IØ,19	Third fold suppression switch
IØ,20	Rear ejection push-button
IØ,21	Dirty cell detection (C7-C8-C9-C10)
IØ,24	Cross-folding measurement / stacker centering
IØ,25	Longitudinal folding shunted at IØ,5 quick metering input
I1,Ø	Feeding return jack sensor
I1,1	Ironing admission
I1,2	Rear longitudinal arm
I1,3	Small wheels lowering jack sensor
C1	Feeding sheet photocell
C2	Longitudinal folding photocell
C3	Longitudinal folding safety device photocell
C4	Longitudinal folding safety device photocell
C5	Cross-folding photocell
C6	Detection for transversal measurement photocell
C7	Detection for transversal measurement photocell
C8	Ironer delivery detection photocell
C9	Sheet detection on stacker photocell
C10	Pile completed on stacker photocell
KM3	Fan contactor
i18	Feeding push-button
i19	Feeding position switch
i20	Stacker jack position switch
i21	Pile evacuation push-button
i22	Reclosing initialization push-button
i23	Switch without folding / without third fold] 3 positions
i24	Rear ejection push-button
i25	Cross-folding measurement inductive detector
i29	Return feeding position switch
i30	Rear longitudinal arm position switch
i31	150°C safety thermostat
i32	Longitudinal folding measurement inductive detector
i33	Small wheels lowering jack position switch

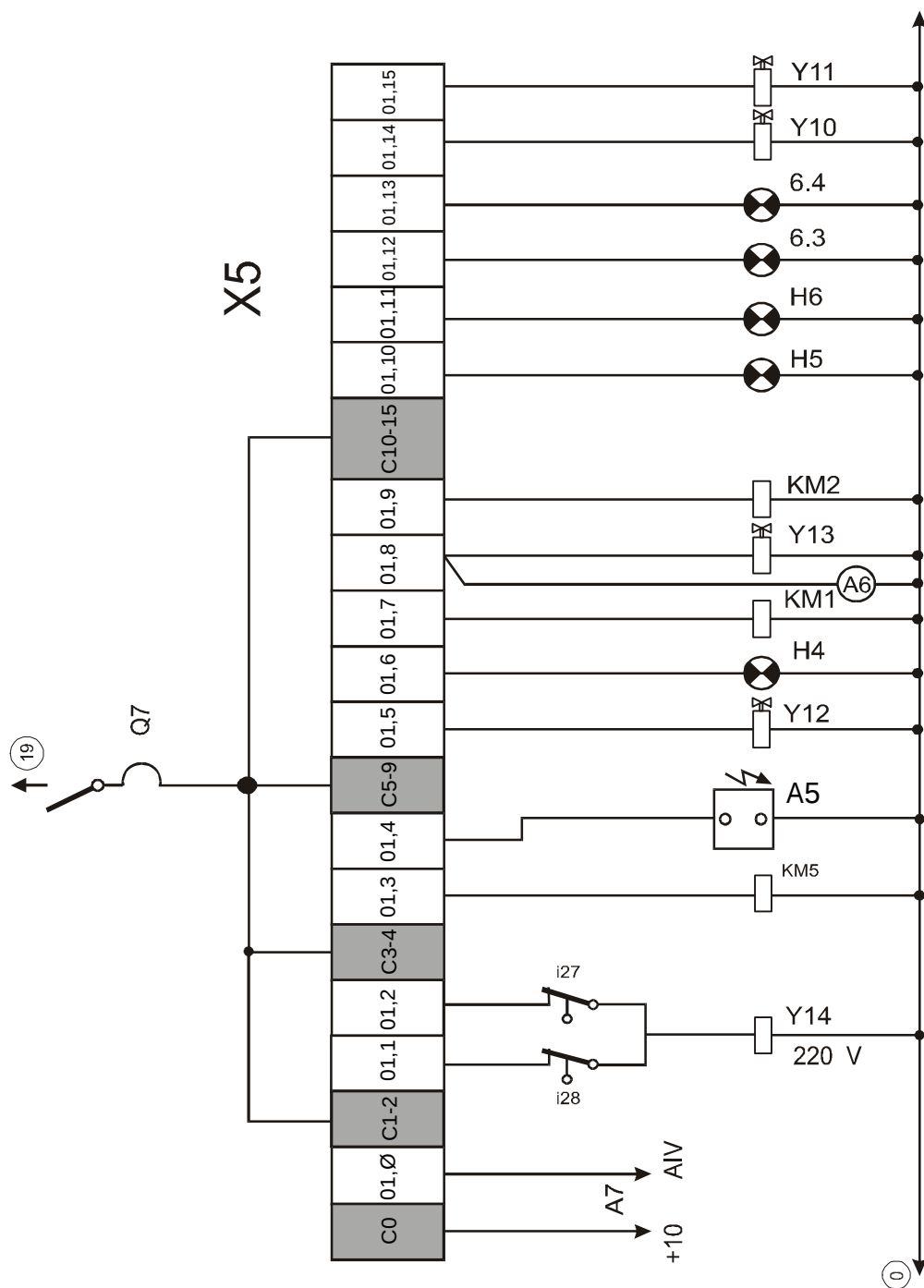


32006380

AUTOMATE OUTPUTS (feeder, ironer, folder and stacker)

32006380

X4	Outputs on automate A4 connection terminal
Q7	Two-pole breaker 2 A (common outputs)
OØ,0	Vat without folding
Y1	Vat without folding pneumatic distributor
OØ,1	Clamps spreading
Y2	Clamps spreading pneumatic distributor
OØ,2	Smoothing
KM4	Smoothing motor contactor
OØ,3	Clamps movement
Y3	Clamps movement pneumatic distributor
OØ,4	Clamps unblocking (small wheels)
Y4	Clamps unblocking pneumatic distributor
OØ,5	Clamps drawing nearer
Y5	Clamps drawing nearer pneumatic distributor
OØ,6	Feeding blow
Y6	Feeding blow pneumatic distributor
OØ,7	Rear evacuation indicator (led 6-3)
H3	Sheet evacuation indicator
OØ,8	Front blow
Y7	Front blow pneumatic distributor
OØ,9	1st fold blade lowering (led 6-6)
Y9	First fold blade lowering pneumatic distributor
OØ,10	Rear blow
Y8	Rear blow pneumatic distributor
OØ,11	Sheet evacuation
KM8	Rear evacuation motor contactor



32006385B

AUTOMATE OUTPUTS (continued)

(feeder, ironer, folder and stacker)

32006385B

X5	Connection terminal on outputs extension
Q7	Two-pole breaker 2 A (common outputs)
A5	Control box for antistatic bar
A 7	Fan frequency converter
O1,Ø	Maximum speed fan control
O1,1	Front longitudinal folding arm
i 28	Rear folding position switch
O1,2	Rear longitudinal folding arm
i 27	Front folding position switch
Y14	Longitudinal folding arm clutch (clutch/brake, 2 stops/turn).
O1,3	Drive of transversal bands
KM5	Cross-folding motor contactor
O1,5	Third cross-folding blade folding (led 6-8)
Y12	Third fold blade folding pneumatic distributor
O1,6	Safety positive device indicator
H4	Safety positive device indicator
O1,7	Stacker table bands "ON"
KM1	Table motor contactor
O1,8	Stacker table opening (led 6-11)
A6	Stacker meter
Y13	Stacker table opening pneumatic distributor
O1,9	Pile evacuation
KM2	Pile evacuation motor contactor
O1,10	Completed pile indicator
H5	Completed pile indicator
O1,11	Dirty cell
H6	Dirty cell indicator
O1,12	Front longitudinal folding led (6-3)
O1,13	Rear longitudinal folding led (6-4)
O1,14	Roller lifting
Y10	Roller lifting pneumatic distributor
O1,15	Second cross-folding blade folding (led 6-7)
Y11	Second fold blade folding pneumatic distributor

A

M11	—	1	9	—	10
M12	—	2	10		
M13	—	3	11	—	12
M21	—	4	12	—	33
M22	—	5	13	—	35
M23	—	6	14	—	Ø,6
F1.1	—	7	15	—	Ø,13
F1.2	—	8	16	—	Ø,21

23	—	17	25
Ø,4	—	18	26
0	—	19	27
01,8	—	20	28
Ø,14	—	21	29
		22	30
6	—	23	31
29	—	24	32

B

25	17	—	23
26	18	—	Ø,4
27	19	—	0
28	20	—	01,8
29	21	—	Ø,14
30	22		
31	23	—	6
32	24	—	29

10	—	9	1	M11
		10	2	M12
12	—	11	3	M13
33	—	12	4	M21
35	—	13	5	M22
Ø,6	—	14	6	M23
Ø,13	—	15	7	- F1-1
Ø,21	—	16	8	- F1-2

C

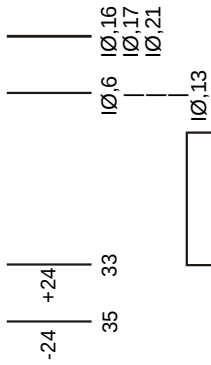
1	9	—		25
2	10			26
3	11	—		27
4	12			28
5	13			29
6	14			30
7	15			31
8	16			32

17	25
18	26
19	27
20	28
21	29
22	30
23	31
24	32

D

OMR 1 PA
400 W 3

1 . 2 . 3 . 4 . 5 . 6 . XUJ



(feeder, ironer, folder and stacker)

32006381

(A) Plug on stacker (front view) connection side

1 to 16 and 17 to 32 tags on plug
M11 to IØ,17 and 23 to 29 tags of threads

(B) Socket on ironer (front view) connection side

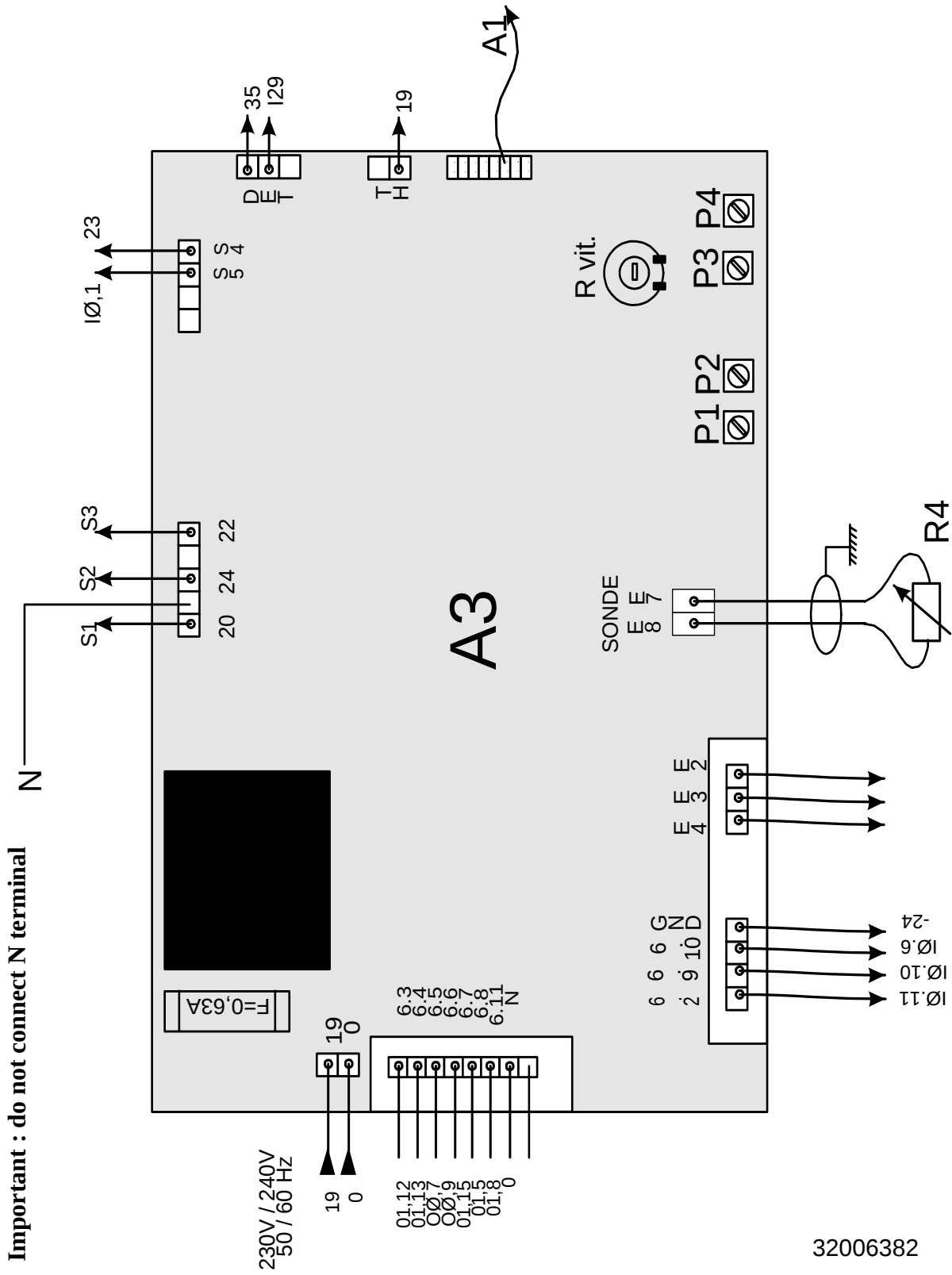
1 to 16 and 17 to 32 tags on socket
M11 to IØ,17 and 23 to 29 tags of threads

(C) Plug shunt (front view) connection side

Shunt between 9 and 11 and shunt between 23 and 24

(D) Cells connection example

XUJ, XUM and OMR 1 PA 400 W 3 types.



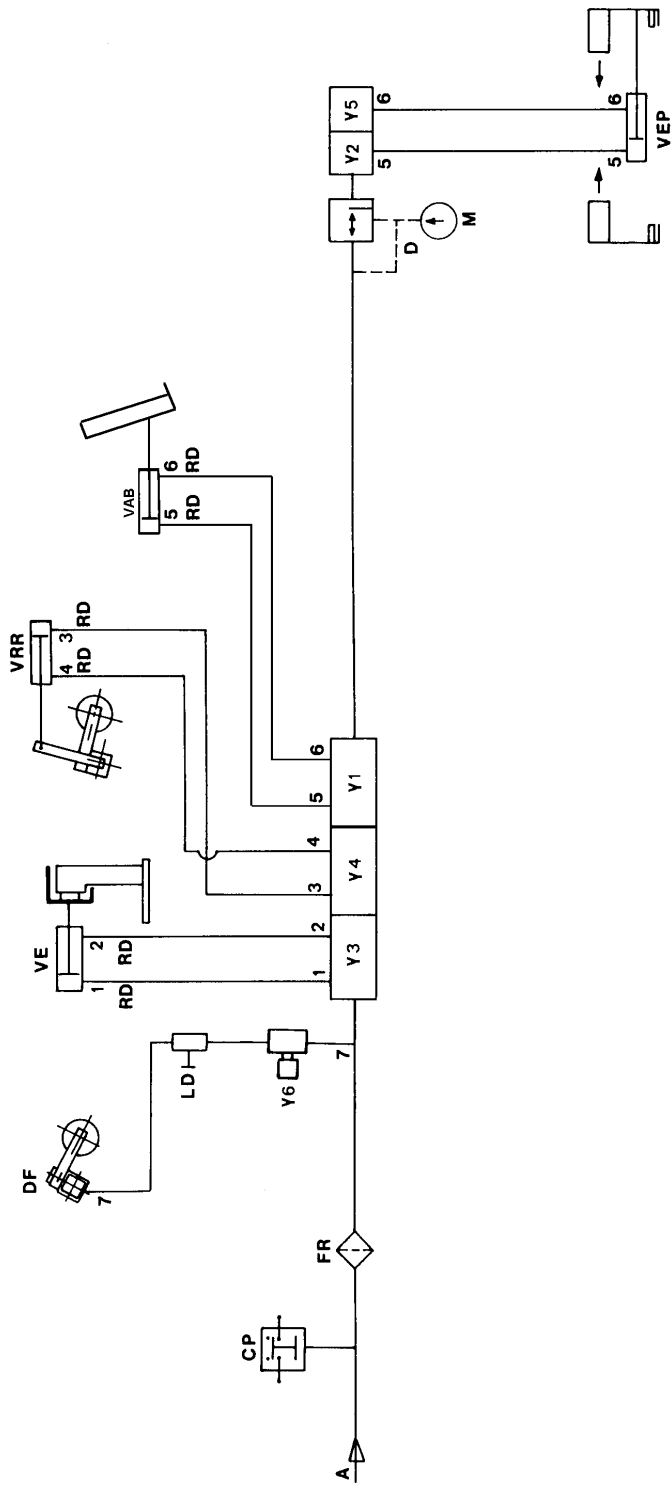
INPUTS / OUTPUTS CARD (feeder, ironer, folder and stacker)

32006382

A1	Frequency converter
A3	Programmer / synoptic
P1	Temperature adjustment potentiometer (do not touch)
P2	Temperature adjustment potentiometer (do not touch)
P3	Maximum speed adjustment potentiometer
P4	Minimum speed adjustment potentiometer
R4	Temperature adjustment PT100 probe
i29	Speed display detector
KM3	Fan motor contactor
KM9	Motion motor contactor
S1	Fan control output
S2	Adjusted heating control output
S3	Direct heating control output
S4 and S5	Outputs for automate control with or without folding
E2	Ignitor indicator input
E3	Ignitor indicator input
E4	Ignitor indicator input
E7	Temperature probe input
E8	Temperature probe input

Synoptic led assignment

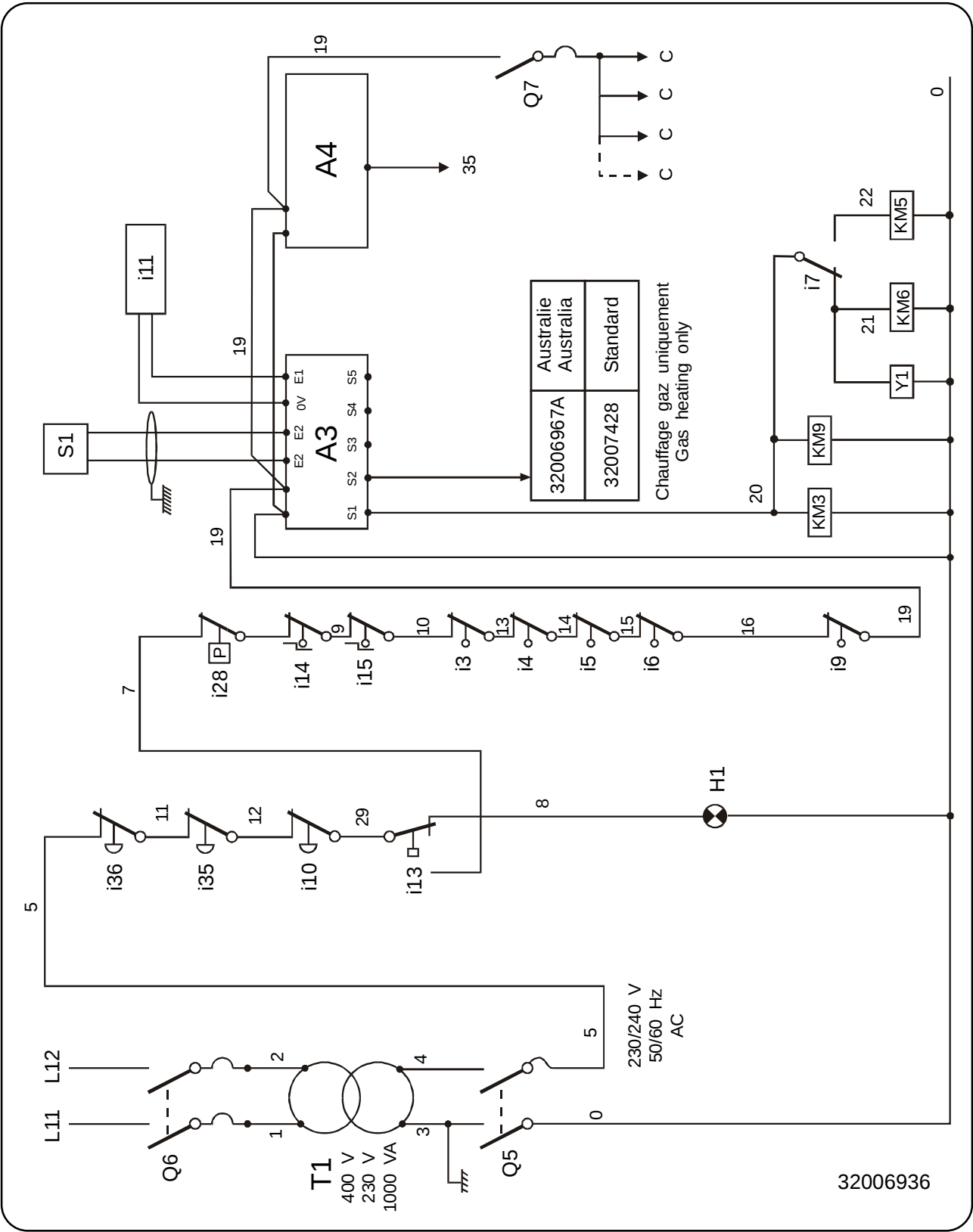
led 6.2	Ironing output
led 6.3	Front folding
led 6.4	Rear folding
led 6.5	Rear evacuation
led 6.6	First fold
led 6.7	Second fold
led 6.8	Third fold
led 6.9	Folding output
led 6.10	Stacker
led 6.11	Completed pile



PNEUMATIC DIAGRAM
(feeder, ironer with front or rear outlet)

32006916

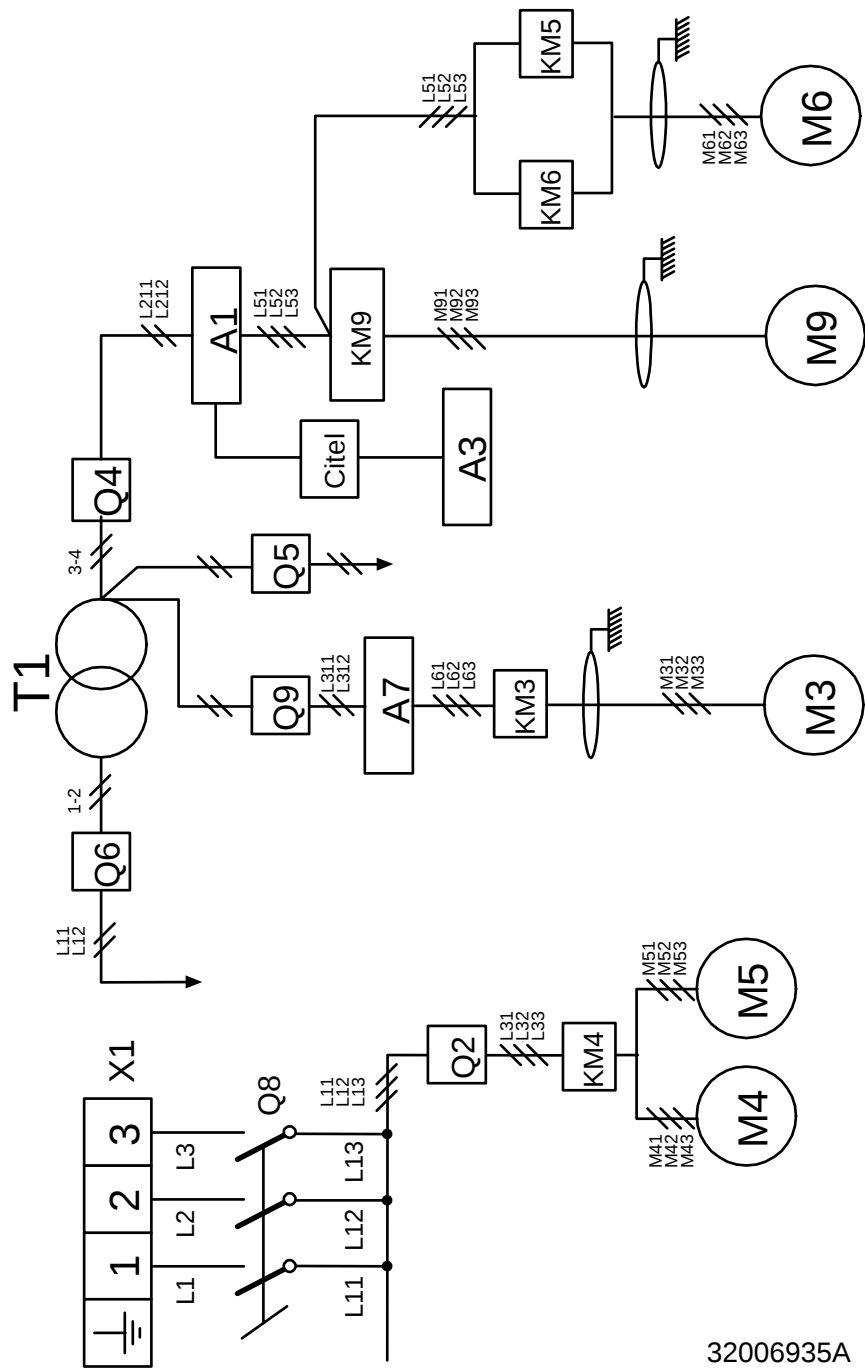
A	Compressed air supply 8 bar maxi
CP	Air shortage pressostat
FR	Regulating filter 5 microns (adjustment 5 bar)
DF	Feeding blowing supply
VE	Feeding jack
VAB	Vat joint jack
VRR	Small wheels lift jack
LD	Flow limiter
RD	Flow reducer
Y1-Y3-Y4	Distributor
D	Pressure reducing valve 2/3 bar
M	Manometer
Y2-Y5-Y6	NF electrovalve
VEP	Feeding clamps spreading jack



CONTROL CIRCUIT (feeder, ironer with front or rear outlet)

32006936

T1	Insulating transformer 1000 VA
A3	Programmer
A4	Programmable automate
H1	Air shortage indicator
Q5	Two-pole breaker ph + N 2A secondary
Q6	Two-pole breaker 6 A primary
Q7	Two-pole breaker 2 A (common outputs)
i3	Thermal contact fan motor
i4	Thermal contact smoothing motor
i5	Thermal contact smoothing motor
i6	Thermal contact front or rear motor
i7	Front or rear outlet switch
i9	Thermal contact motion motor
i10	Ironer emergency stop
i13	Air shortage pressostat
i14	Finger protection right flap position switch
i15	Finger protection left flap position switch
i28	Gas pressure switch (optional or Australia machine) (for gas heating machine only)
i35	Ironer emergency stop
i36	Ironer emergency stop
KM3	Fan contactor
KM5	Front outlet contactor
KM6	Rear outlet contactor
KM9	Motion contactor
S1	Thermic probe PT100
Y1	Table articulation distributor



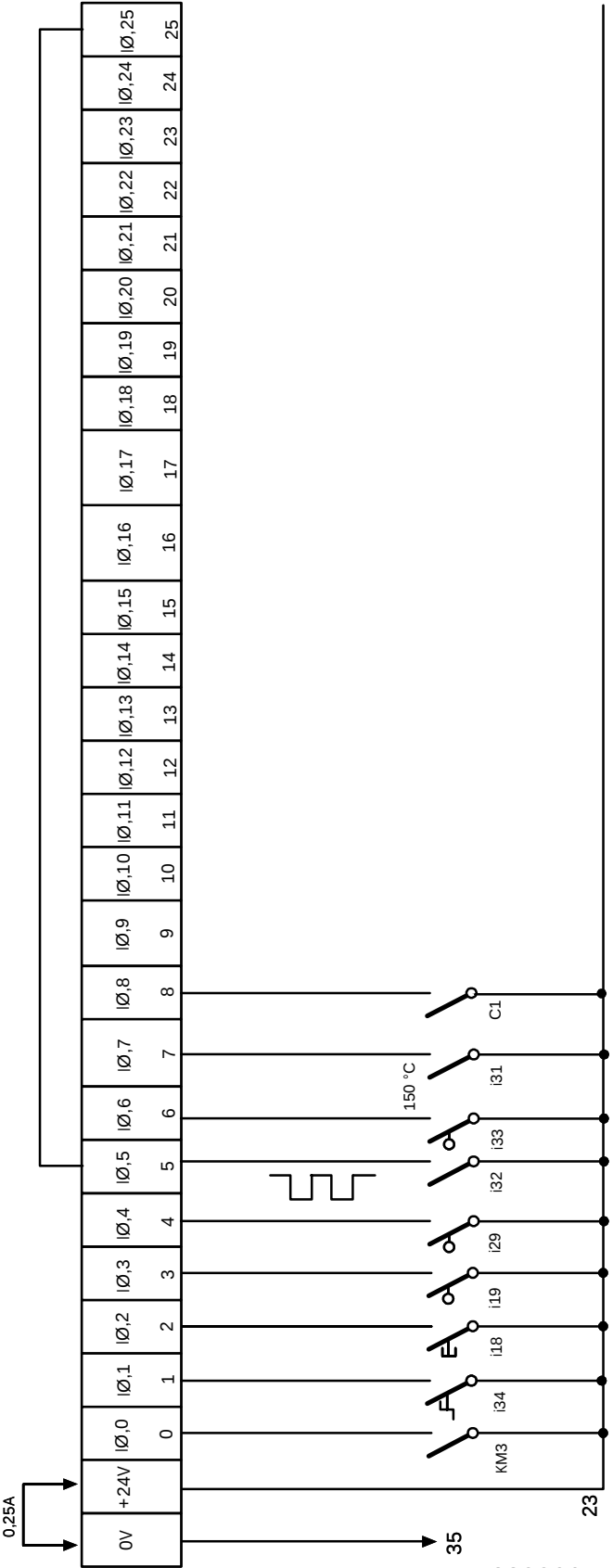
32006935A

POWER CIRCUIT
(feeder, ironer with front or rear outlet)

32006935A

X1	General supply terminal
Q2	Three-pole motor breaker
Q4	Two-pole breaker 4 A
Q5	Two-pole breaker ph + N 2A
Q6	Two-pole breaker 6A
Q8	General switch
Q9	Two-pole breaker 6A
T1	Isolating transformer 1000 VA
A1	Motion frequency converter (ATV16)
A3	Programmer
A7	Fan frequency converter (ATV16)
Citel	Accommodating connection
M3	Fan motor
M4	Smoothing right motor
M5	Smoothing left motor
M6	Front or rear outlet motor
M9	Motion motor
KM3	Fan motor contactor
KM4	Smoothing motor contactor
KM5	Front outlet motor contactor
KM6	Rear outlet motor contactor
KM9	Motion motor contactor

X3



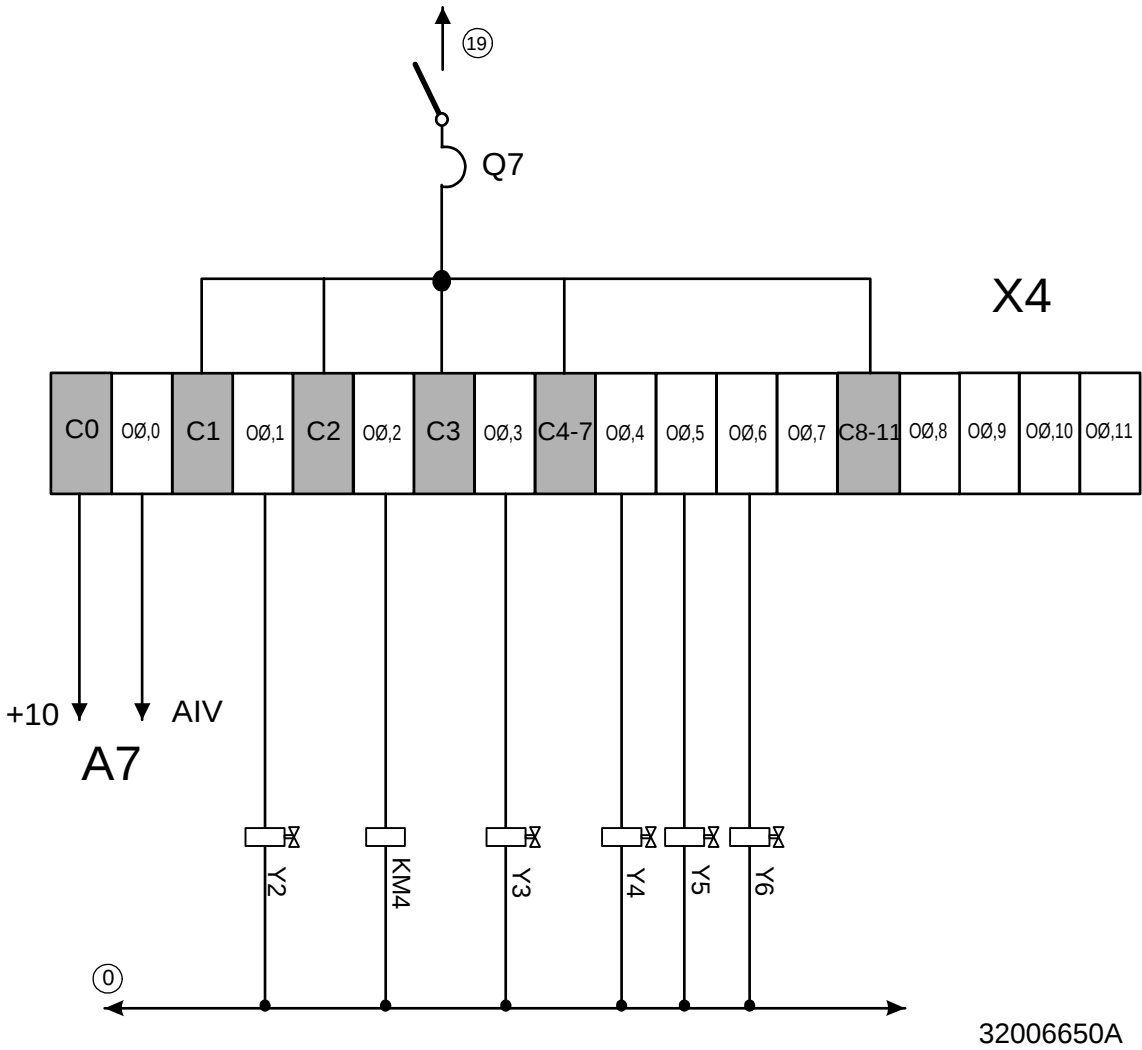
32006651

AUTOMATE INPUTS

(feeder, ironer with front or rear outlet)

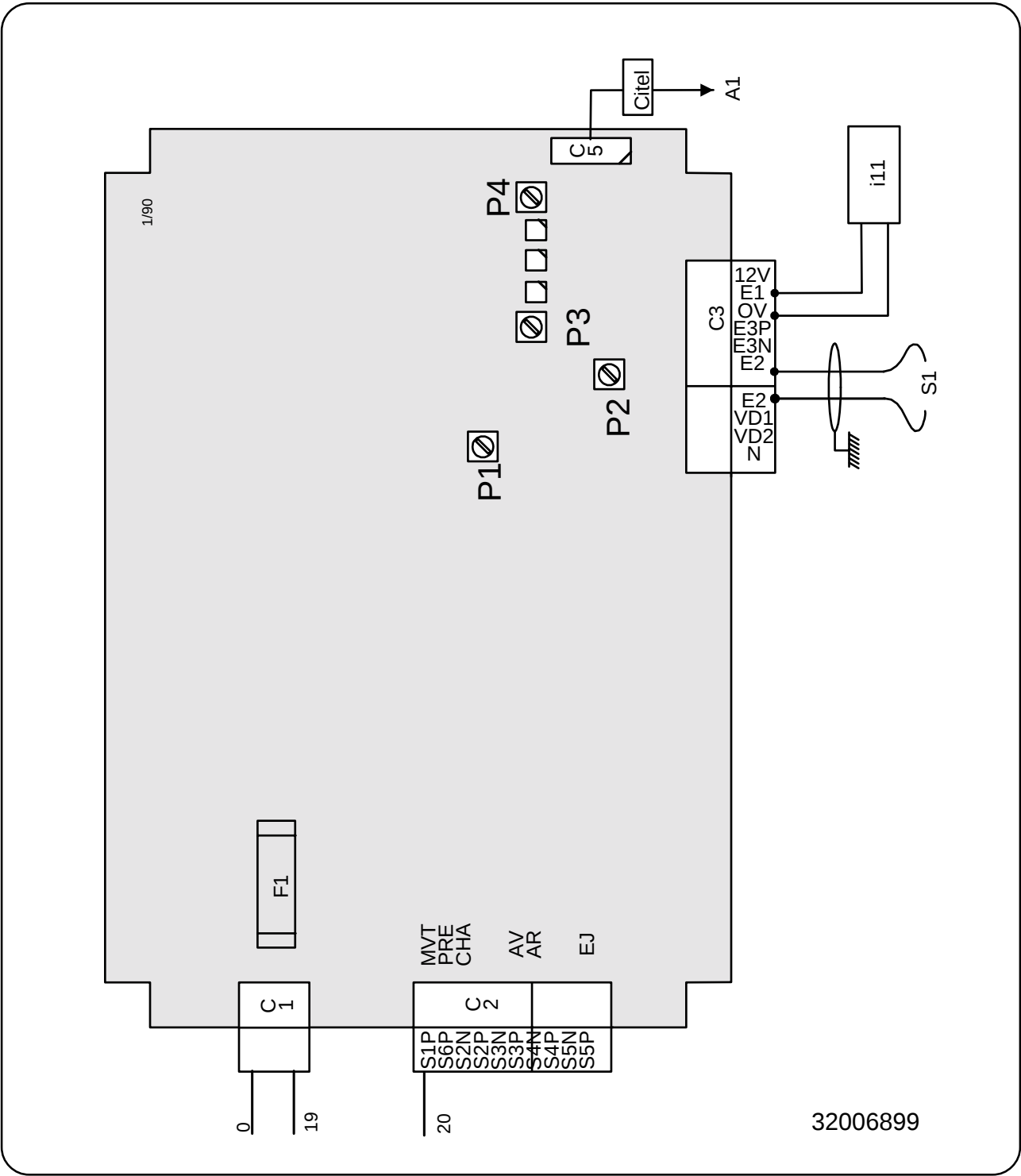
32006651

X3	Inputs connection terminal on automate A4
IØ,0	Run / stop
IØ,1	With / without feeding
IØ,2	Feeding push button
IØ,3	Feed motion jack sensor
IØ,4	Feeding return jack sensor
IØ,5	Longitudinal sheet measurement
IØ,6	Small wheels lowering jack sensor
IØ,7	Ironing admission
IØ,8	Sheet at feeding (C1)
IØ,25	Longitudinal folding shunted at IØ,5 quick metering input
C1	Feeding sheet photocell
KM3	Fan contactor
i18	Feeding push-button
i19	Feeding position switch
i29	Return feeding position switch
i31	150 °C safety thermostat
i32	Longitudinal-folding measurement inductive detector
i33	Small wheels lowering jack position switch
i34	With and without feeding switch



AUTOMATE OUTPUTS
(feeder, ironer with front or rear outlet)
32006650A

X4	Outputs on automate A4 connection terminal
Q7	Two-pole breaker 2 A (common outputs)
A 7	Fan frequency converter
OØ,0	Maximum speed fan control
OØ,1	Clamps spreading
Y2	Clamps spreading pneumatic distributor
OØ,2	Smoothing
KM4	Smoothing motor contactor
OØ,3	Clamps movement
Y3	Clamps movement pneumatic distributor
OØ,4	Clamps unblocking (small wheels)
Y4	Clamps unblocking pneumatic distributor
OØ,5	Clamps drawing nearer
Y5	Clamps drawing nearer pneumatic distributor
OØ,6	Feeding blow
Y6	Feeding blow pneumatic distributor



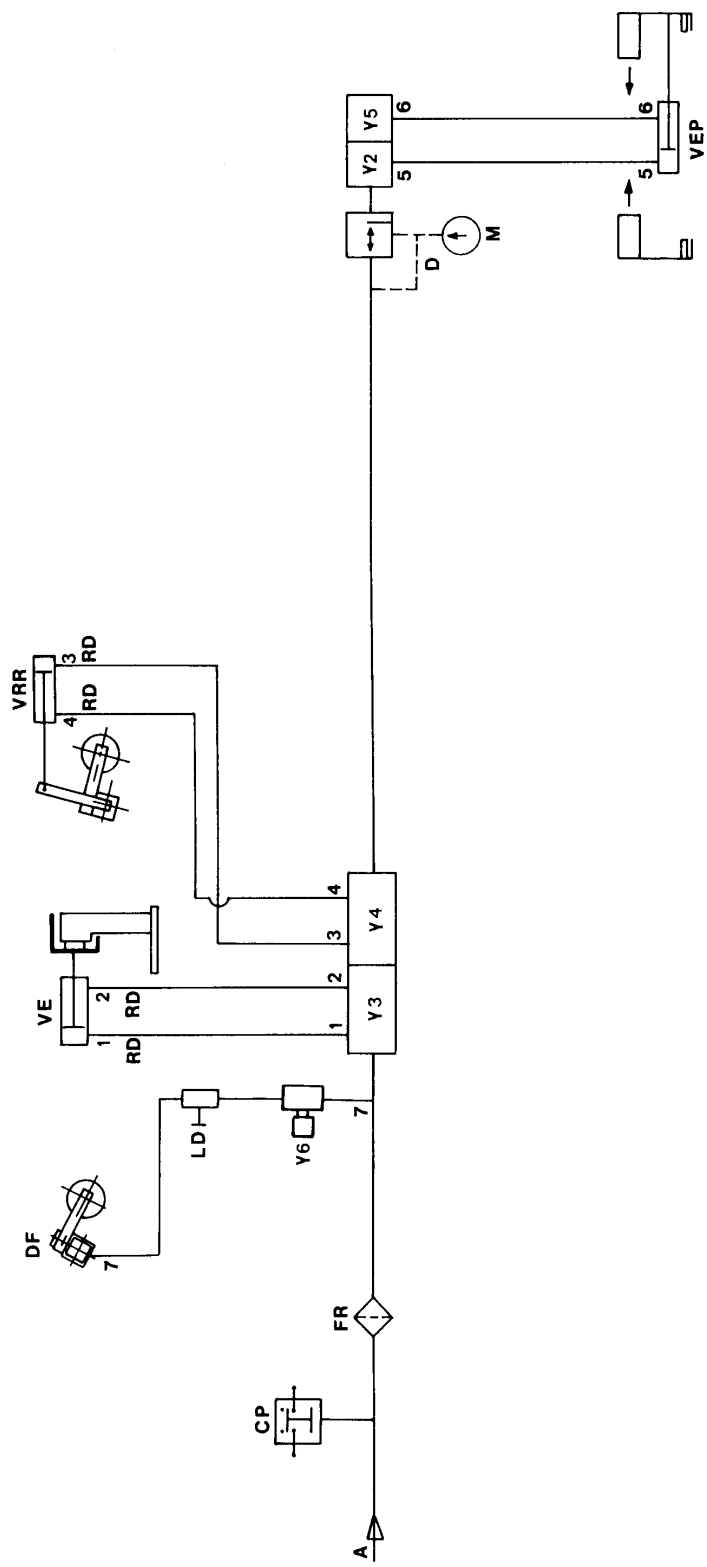
INPUTS / OUPUTS CARD
(feeder, ironer with front or rear outlet)
32006899

F1	General fuse 2 A
A1	Frequency converter
C1	Feeding connector 230 V
C2	Outputs connector 230 V
C3	Inputs connector
C5	Connector for converter flat cable
i11	Photocell detection speed
S1	Thermic probe PT100
Citel	Accomodating connection

Adjustment potentiometers

P1	Adjustments of gain in temperature
P2	Adjustments of temperature zero
P3	Adjustments of minimum ironing speed
P4	Adjustments of maximum ironing speed

These adjustments should only
be carried out by a technician.



PNEUMATIC DIAGRAM
(feeder, ironer with rear outlet)

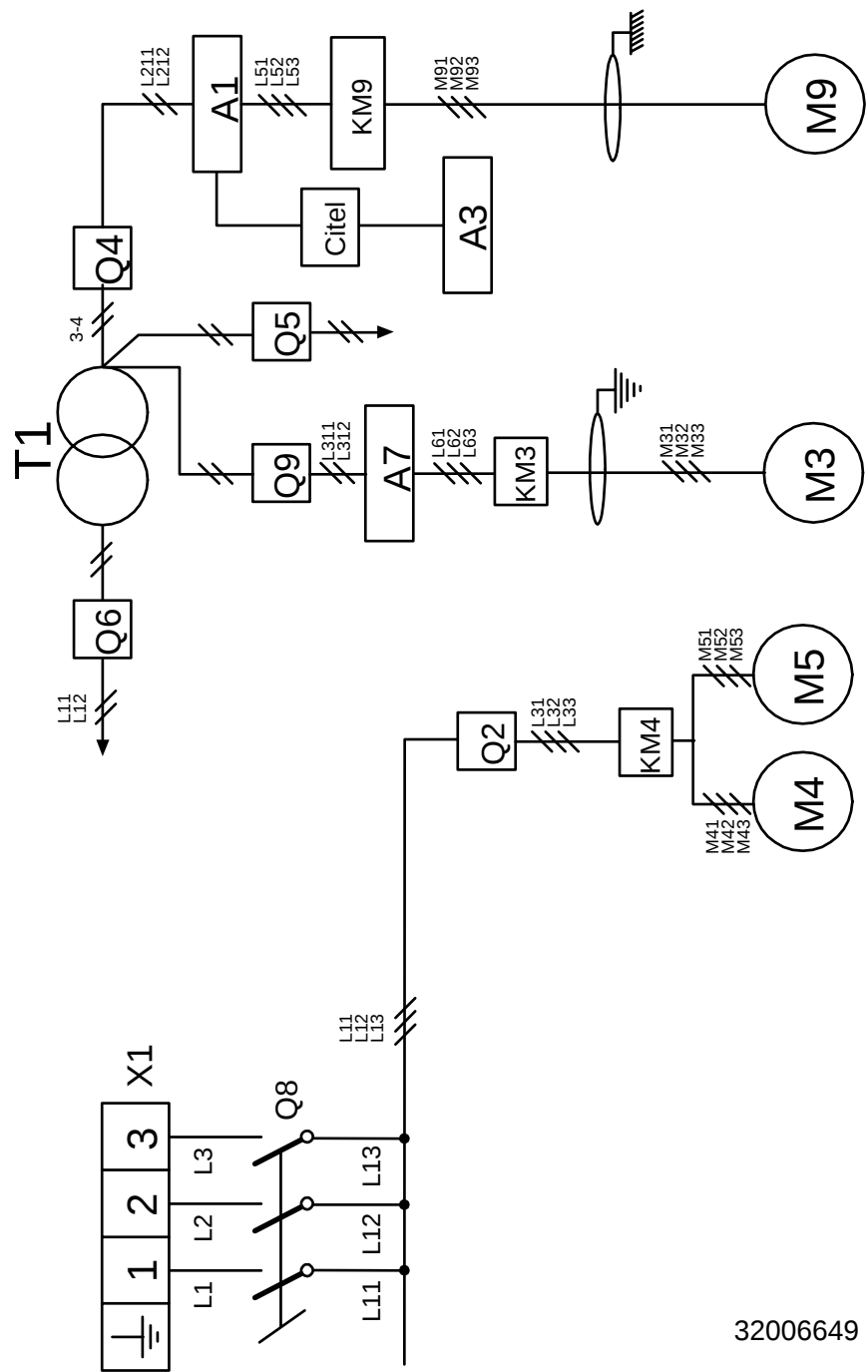
32006585

A	Compressed air supply 8 bar maxi
CP	Air shortage pressostat
FR	Regulating filter 5 microns (adjustment 5 bar)
DF	Feeding blowing supply
VE	Feeding jack
VRR	Small wheels lift jack
LD	Flow limiter
RD	Flow reducer
Y3-Y4	Distributor
D	Pressure reducing valve 2/3 bar
M	Manometer
Y2-Y5-Y6	NF electrovalve
VEP	Feeding clamps spreading jack

CONTROL CIRCUIT (feeder, ironer with rear outlet)

32006653A

T1	Insulating transformer 1000 VA
A3	Programmer
A4	Programmable automate
H1	Air shortage indicator
Q5	Two-pole breaker ph + N 2A secondary
Q6	Two-pole breaker 6 A primary
Q7	Two-pole breaker 2 A (common outputs)
i3	Thermal contact fan motor
i4	Thermal contact smoothing motor
i5	Thermal contact smoothing motor
i9	Thermal contact motion motor
i10	Ironer emergency stop
i13	Air shortage pressostat
i14	Finger protection right flap position switch
i15	Finger protection left flap position switch
i28	Gas pressure switch (optional or Australia machine) (for gas heating machine only)
i35	Ironer emergency stop
i36	Ironer emergency stop
KM3	Fan contactor
KM9	Motion contactor
S1	Thermic probe PT100



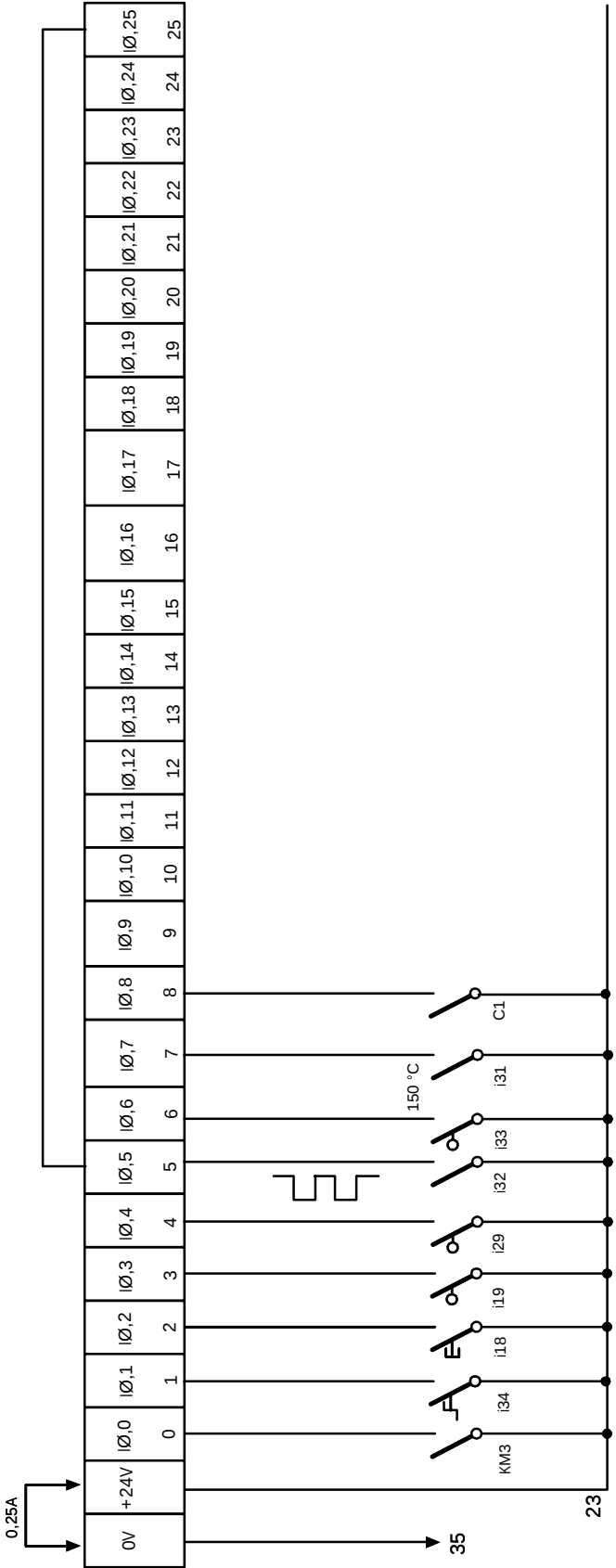
32006649

POWE CIRCUIT
(feeder, ironer with rear outlet)

32006649

X1	General supply terminal
Q2	Three-pole motor breaker
Q4	Two-pole breaker 4 A
Q5	Two-pole breaker ph + N 2A
Q6	Two-pole breaker 6A
Q8	General switch
Q9	Two-pole breaker 6A
T1	Isolating transformer 1000 VA
A1	Motion frequency converter (ATV16)
A3	Programmer
A7	Fan frequency converter (ATV16)
Citel	Accomodating connection
M3	Fan motor
M4	Smoothing right motor
M5	Smoothing left motor
M9	Motion motor
KM3	Fan motor contactor
KM4	Smoothing motor contactor
KM9	Motion motor contactor

X3

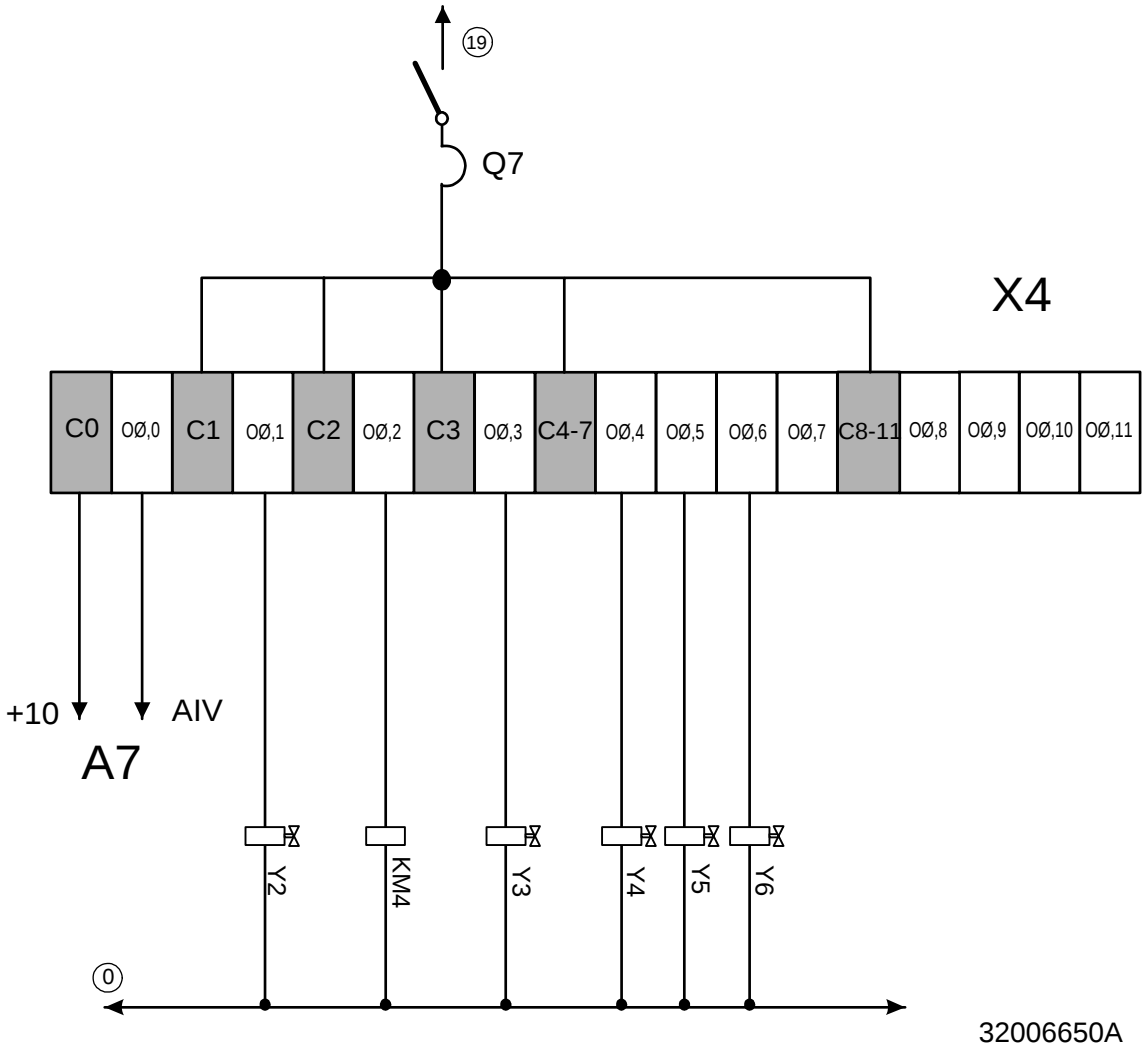


32006651

AUTOMATE INPUTS (feeder, ironer with rear outlet)

32006651

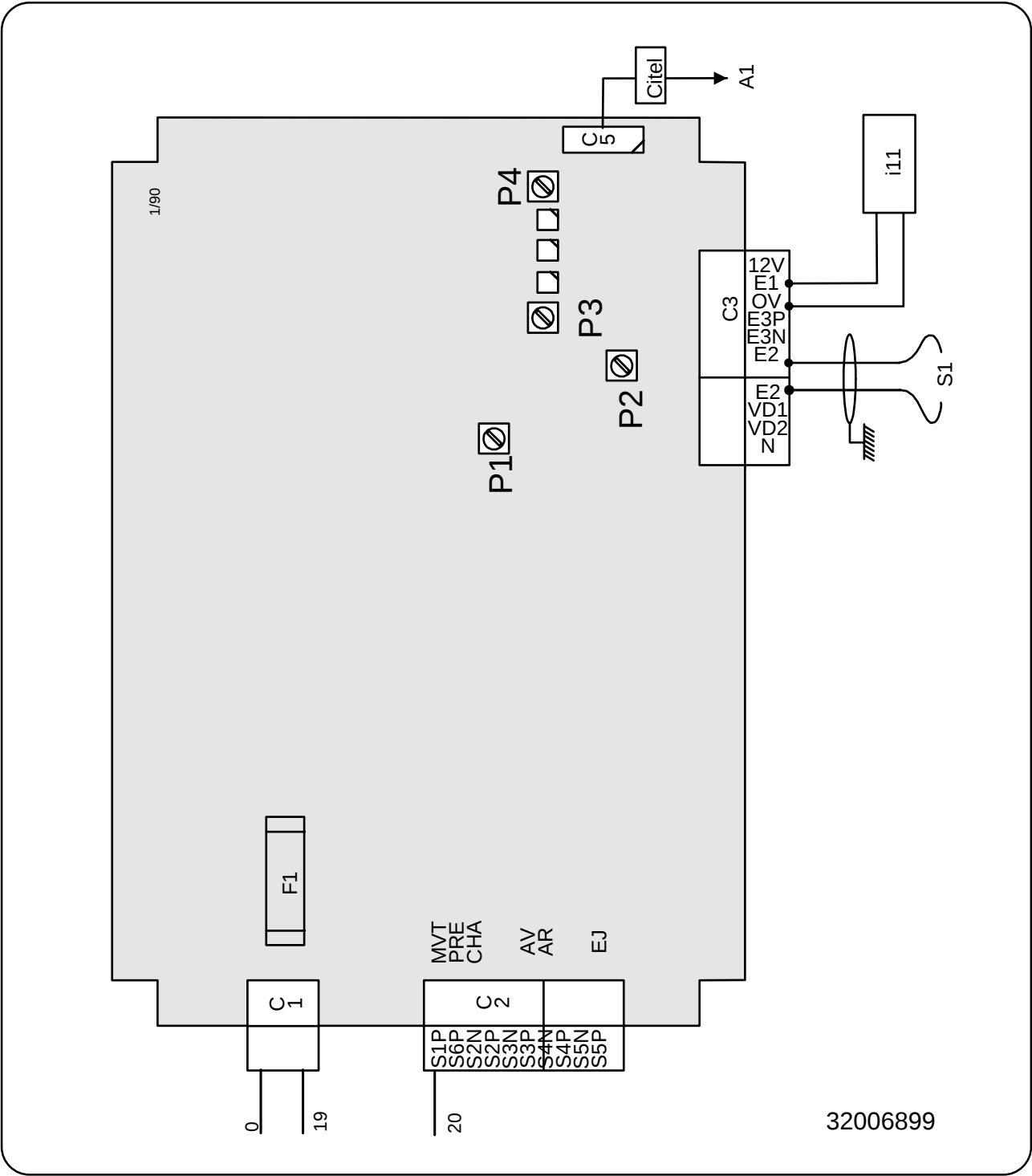
X3	Inputs connection terminal on automate A4
IØ,0	Run / stop
IØ,1	With / without feeding
IØ,2	Feeding push button
IØ,3	Feed motion jack sensor
IØ,4	Feeding return jack sensor
IØ,5	Longitudinal sheet measurementl
IØ,6	Small wheels lowering jack sensor
IØ,7	Ironing admission
IØ,8	Sheet at feeding (C1)
IØ,25	Longitudinal folding shunted at IØ,5 quick metering input
C1	Feeding sheet photocell
KM3	Fan contactor
i18	Feeding push-button
i19	Feeding position switch
i29	Return feeding position switch
i31	150 °C safety thermostat
i32	Longitudinal-folding measurement inductive detector
i33	Small wheels lowering jack position switch
i34	With and without feeding switch



AUTOMATE OUTPUTS
(feeder, ironer with rear outlet)

32006650A

X4	Outputs on automate A4 connection terminal
Q7	Two-pole breaker 2 A (common outputs)
A 7	Fan frequency converter
OØ,0	Maximum speed fan control
OØ,1	Clamps spreading
Y2	Clamps spreading pneumatic distributor
OØ,2	Smoothing
KM4	Smoothing motor contactor
OØ,3	Clamps movement
Y3	Clamps movement pneumatic distributor
OØ,4	Clamps unblocking (small wheels)
Y4	Clamps unblocking pneumatic distributor
OØ,5	Clamps drawing nearer
Y5	Clamps drawing nearer pneumatic distributor
OØ,6	Feeding blow
Y6	Feeding blow pneumatic distributor



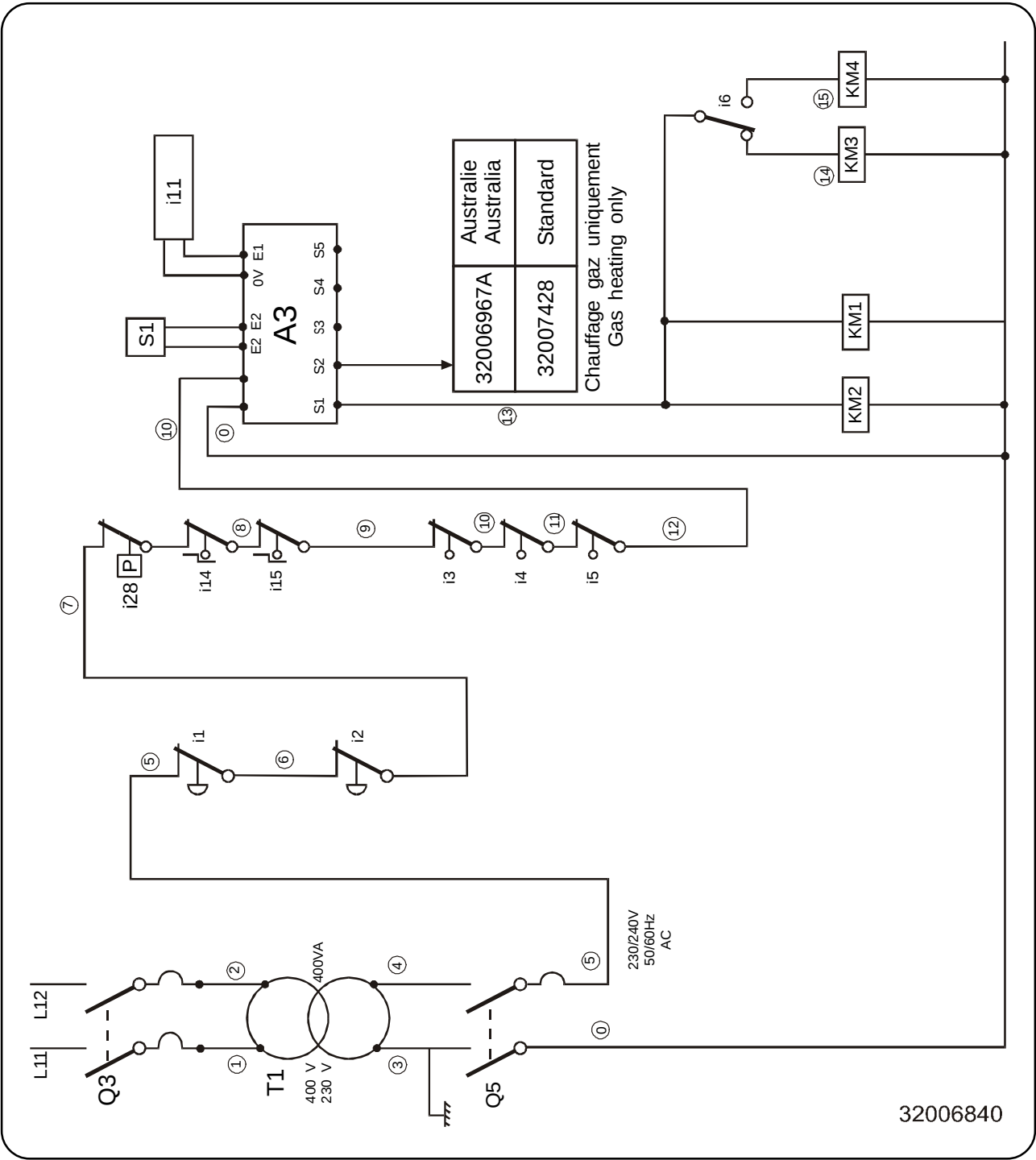
INPUTS / OUPUTS CARD
(ironer with front or rear outlet)
32006899

F1	General fuse 2 A
A1	Frequency converter
C1	Feeding connector 230 V
C2	Outputs connector 230 V
C3	Inputs connector
C5	Connector for converter flat cable
i11	Photocell detection speed
S1	Thermic probe PT100
Citel	Accomodating connection

Adjustment potentiometers

P1	Adjustments of gain in temperature
P2	Adjustments of temperature zero
P3	Adjustments of minimum ironing speed
P4	Adjustments of maximum ironing speed

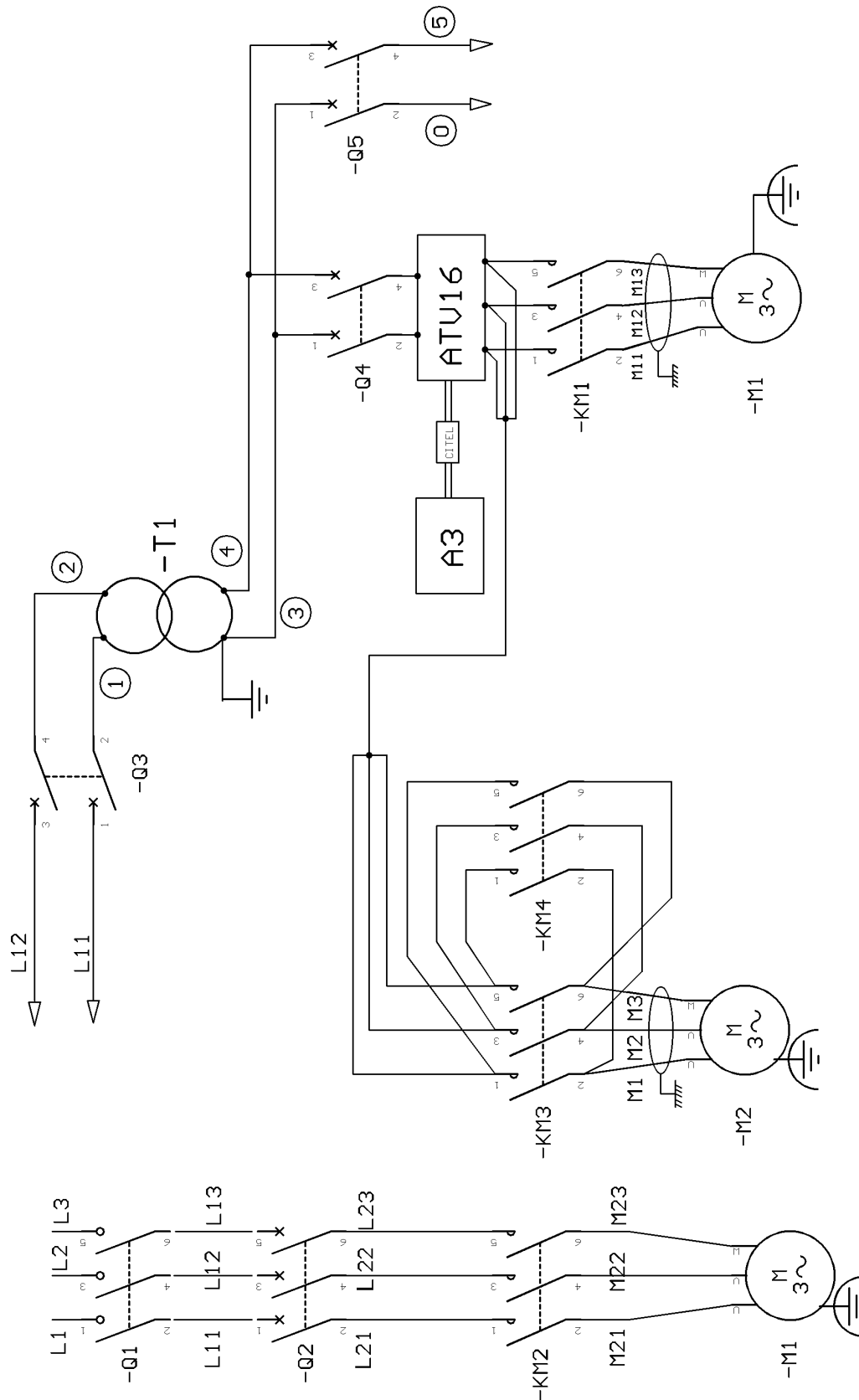
These adjustments should only
be carried out by a technician.



CONTROL CIRCUIT
(ironer with front or rear outlet)

32006840

A3	Programmer
i1-i2	Ironer emergency stop
i3	Thermal contact fan motor
i4	Thermal contact smoothing motor
i5	Thermal contact smoothing motor front or rear outlet
i6	Front or rear outlet switch
i11	Speed inductive detector
i14	Finger protection left flap position switch
i15	Finger protection right flap position switch
i28	Gas pressure switch (optional or Australia machine) (for gas heating machine only)
KM1	Motion contactor
KM2	Fan contactor
KM3	Front outlet contactor
KM4	Rear outlet contactor
Q3	Primary breaker transformer
Q5	Secondary breaker control circuit
S1	Thermic probe PT100
T1	Isolating transformer 400 VA



POWER CIRCUIT
(ironer with front or rear outlet)

32006841A

A3	Programmer
ATV16	Frequency converter
CITEL	Connexion circuit
KM1	Motion contactor
KM2	Fan contactor
KM3	Front outlet contactor
KM4	Rear outlet contactor
M1	Motion motor
M2	Front or rear outlet motion motor
M3	Fan motor
Q1	General switch
Q2	Three-pole breaker
Q3	Primary breaker transformer
Q4	Secondary breaker motion motor
Q5	Secondary breaker control circuit
T1	Isolating transformer 400 VA

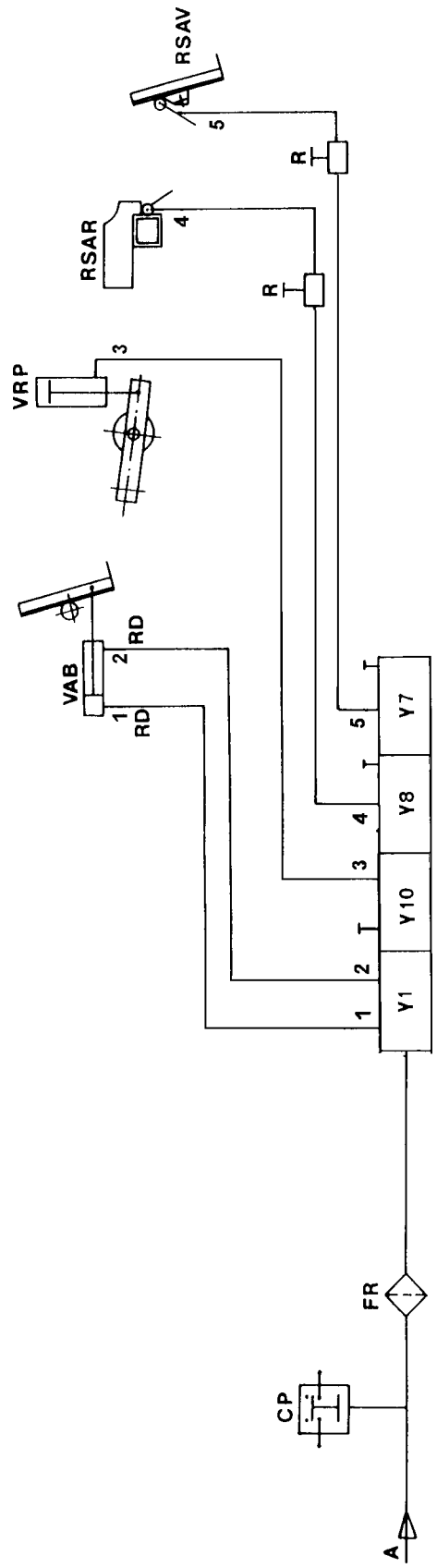
INPUTS / OUPUTS CARD
(ironer with front or rear outlet)
32006968

F1	General fuse 2 A
ATV16	Frequency converter
C1	Feeding connector 230 V
C2	Outputs connector 230 V
C3	Inputs connector
C5	Connector for converter flat cable
i11	Photocell detection speed
S1	Thermic probe PT100
Citel	Accomodating connection

Adjustment potentiometers

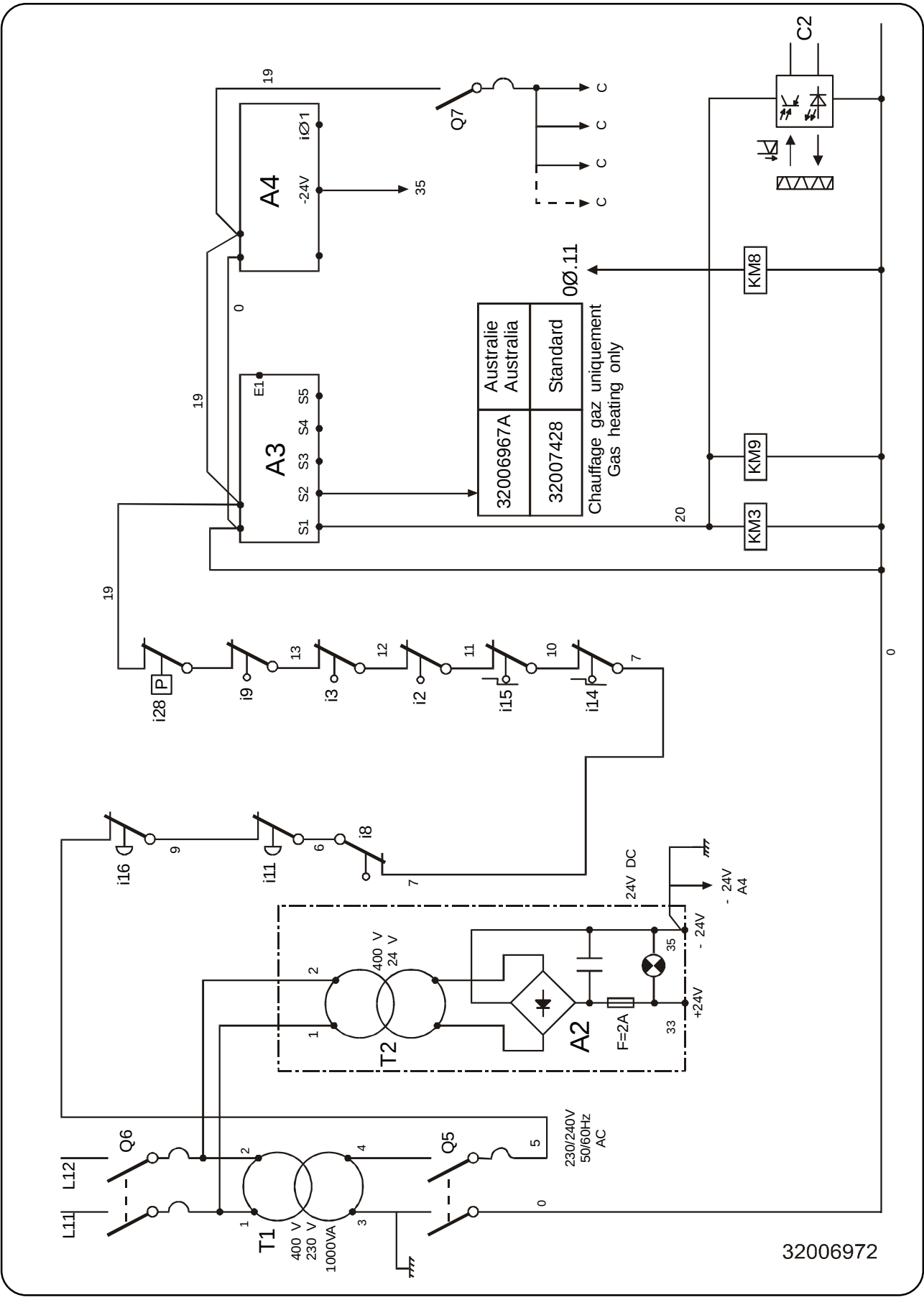
P1	Adjustments of gain in temperature
P2	Adjustments of temperature zero
P3	Adjustments of minimum ironing speed
P4	Adjustments of maximum ironing speed

These adjustments should only
be carried out by a technician.



PNEUMATIC DIAGRAM
(ironer, folder with front or rear outlet)
32006944

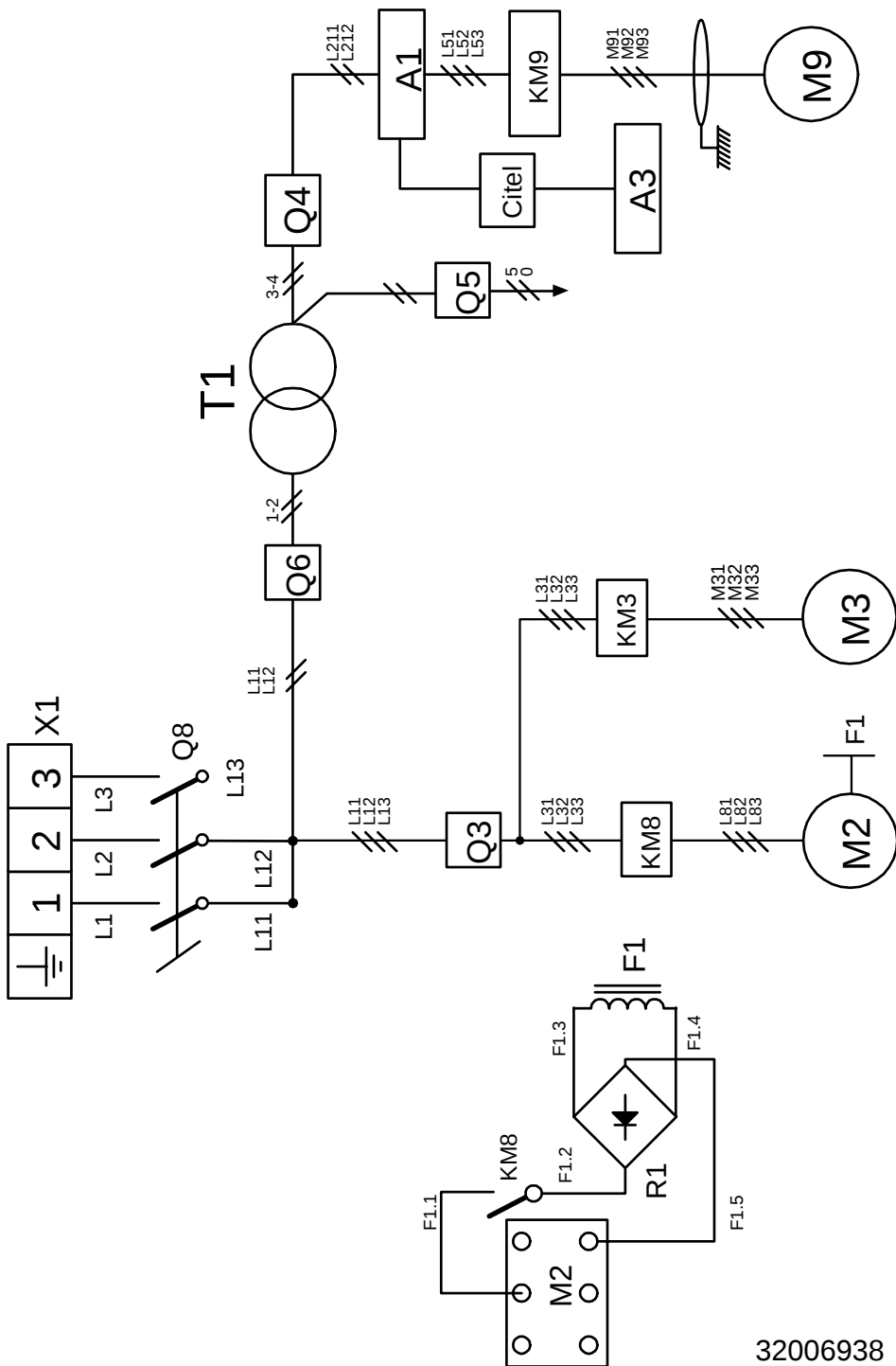
A	Compressed air supply 8 bar maxi
CP	Air shortage pressostat
FR	Regulating filter 5 microns (adjustment 5 bar)
VAB	Vat joint jack
VRP	Roller lift jack
RSAR	Rear blowing burner supply
RSAV	Front blowing burner supply
Y1 to Y10	Distributor



CONTROL CIRCUIT (ironer, folder with front or rear outlet)

32006972

T1	Isolating transformer 1000 VA	
T2	Distribution circuit transformer 24 V	same part
A2	Distribution circuit rectifier 24 V DC	
A3	Programmer / block diagram	
A4	Programmable automate	
Q5	Two-pole breaker ph + N 2 A secondary	
Q6	Two-pole breaker 6 A primary	
Q7	Two-pole breaker 2 A (common outputs)	
i2	Thermal contact rear outlet motor	
i3	Thermal contact fan motor	
i8	Air shortage pressostat	
i9	Thermal contact motion motor	
i11	Left rear outlet emergency stop	
i14	Finger protection right flap position switch	
i15	Finger protection left flap position switch	
i16	Right rear outlet emergency stop	
i28	Gas pressure switch (optional or Australia machine) (for gas heating machine only)	
KM3	Fan contactor	
KM8	Rear outlet motion contactor	
KM9	Motion contactor	
C2	230 V AC longitudinal folding photocell supply	

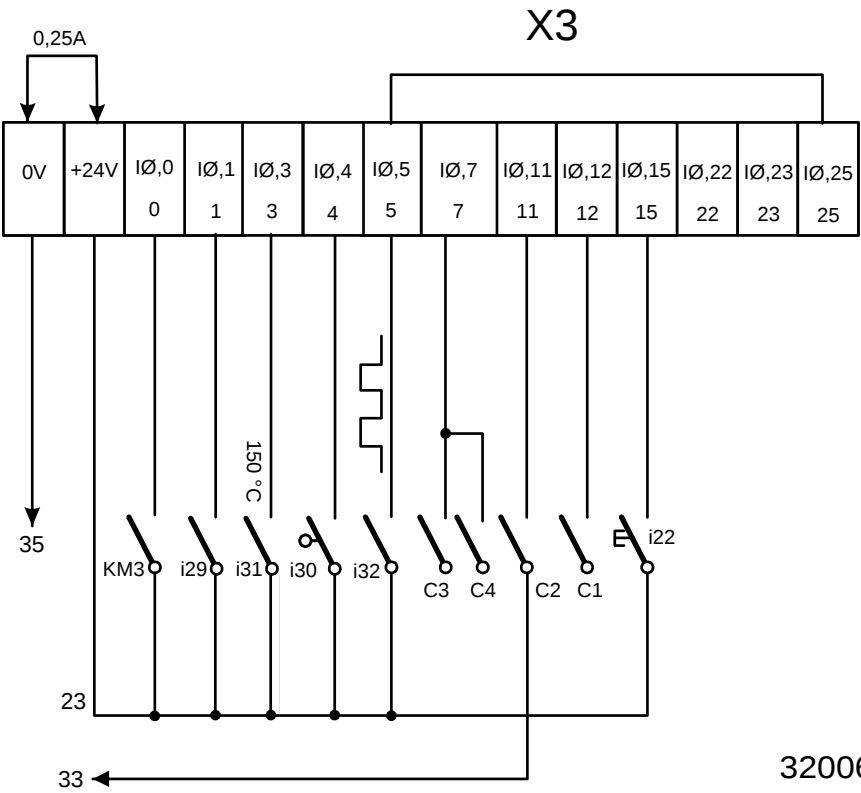


32006938

POWER CIRCUIT
(ironer, folder with front or rear outlet)

32006938

X1	General supply terminal
Q3	Three-pole breaker 6 A
Q4	Two-pole breaker 4 A
Q5	Two-pole breaker ph + N 2 A
Q6	Two-pole breaker 6 A
Q8	Main switch
Q9	Two-pole breaker 6 A
T1	Isolating transformer 1000 VA
A1	Motion frequency converter (ATV16)
A3	Programmer
Citel	Accommodating connection
M2	Rear outlet motor
M3	Fan motor
M9	Motion motor
KM3	Fan motor contactor
KM8	Rear outlet motor contactor
KM9	Motion motor contactor
R1	Rectifier for brake F1
F1	Rear outlet brake

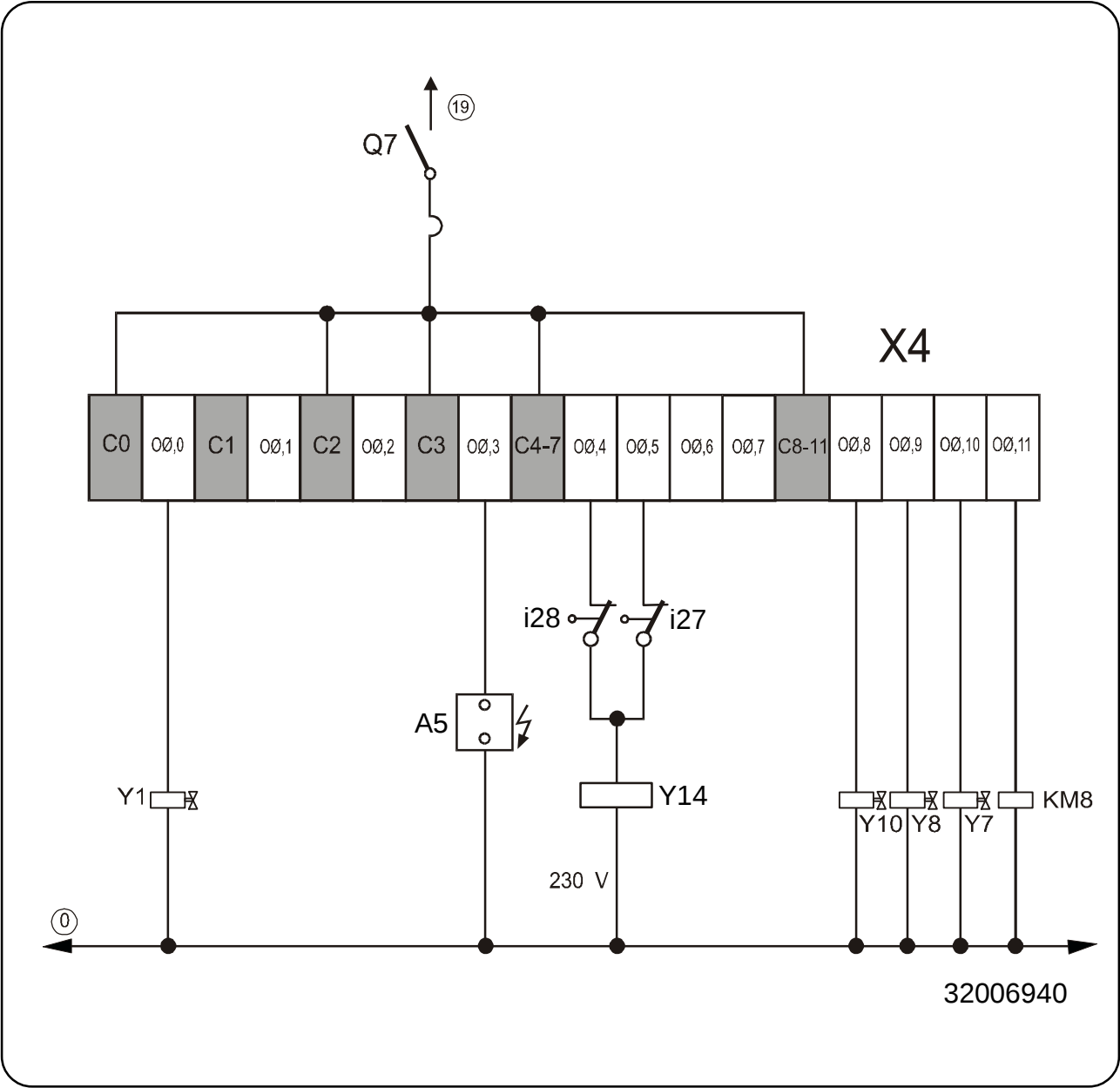


32006974

AUTOMATE INPUTS (ironer, folder with front or rear outlet)

32006974

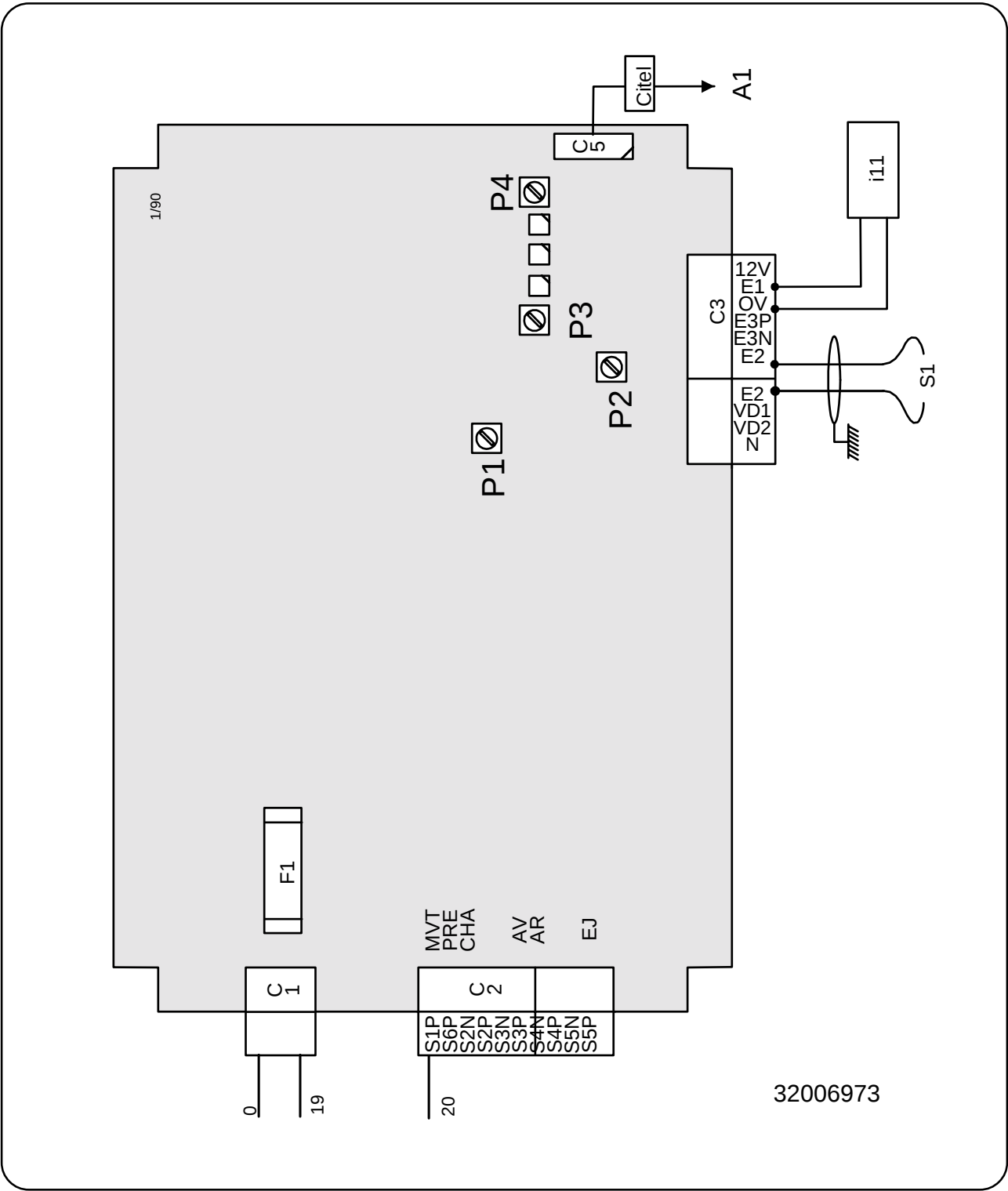
X3	Inputs connection terminal on automate A4
IØ,0	Run / stop
IØ,1	With/without folding
IØ,5	Longitudinal sheet measurement
IØ,7	Longitudinal folding safety device
IØ,11	Longitudinal folding
IØ,12	Sheet at feeding
IØ,15	Reclosing/initialization push-button
IØ,25	Longitudinal folding shunted at IØ,5 quick metering input
IØ,3	Ironing admission
IØ,4	Rear longitudinal arm
C1	Feeding sheet photocell
C2	Longitudinal folding photocell
C3	Longitudinal folding safety device photocell
C4	Longitudinal folding safety device photocell
KM3	Fan contactor
i22	Reclosing initialization push-button
i29	With/without folding switch
i30	Rear folding position switch
i31	150 °C safety thermostat
i32	Longitudinal folding measurement inductive detector



AUTOMATE OUTPUTS (ironer, folder with front or rear outlet)

32006940

X4	Outputs on automate A4 connection terminal
Q7	Two-pole breaker 2 A (common outputs)
OØ,0	Vat without folding
Y1	Vat without folding pneumatic distributor
A5	Control box for antistatic bar
OØ,4	Front longitudinal folding arm
i 27	Front folding position switch
i 28	Rear folding position switch
OØ,5	Rear longitudinal folding arm
Y14	Longitudinal folding arm clutch (clutch/brake, 2 stops/turn)
OØ,8	Roller lifting pneumatic distributor
Y10	Pressure roller lifting pneumatic distributor
O1,1	Front longitudinal folding arm
OØ,9	Rear blow pneumatic distributor
Y8	Rear blow pneumatic distributor
OØ,10	Front blow pneumatic distributor
Y7	Front blow pneumatic distributor
OØ,11	Rear outlet motor contactor
KM8	Rear outlet motor contactor



INPUTS/OUTPUTS CARD
(ironer, folder with front or rear outlet)
32006973

F1	General fuse 2 A
A1	Frequency converter
C1	Feeding connector 230 V
C2	Outputs connector 230 V
C3	Inputs connector
C5	Connector for converter flat cable
i11	Speed display detector
S1	Thermic probe PT100
Citel	Accomodating connection

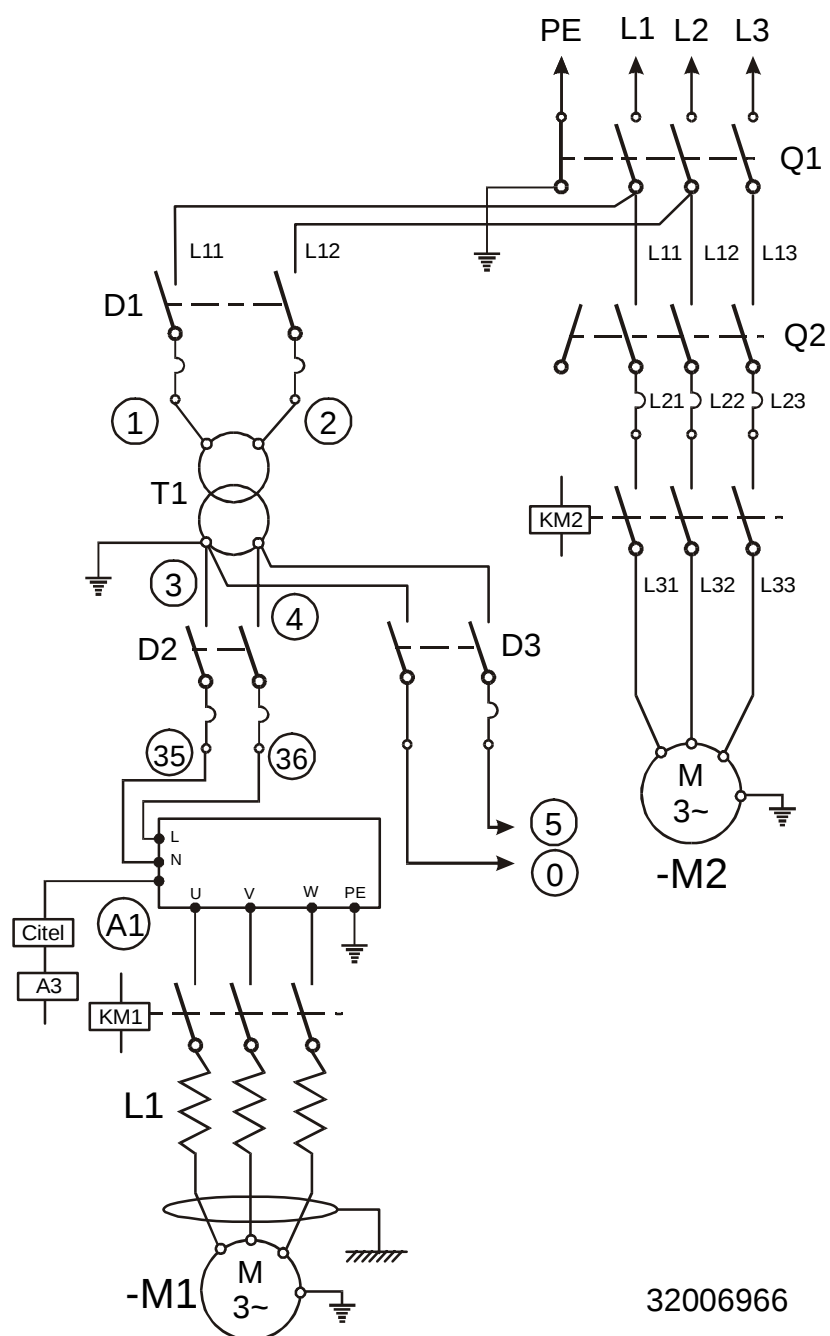
Adjustment potentiometers

P1	Adjustments of gain in temperature	These adjustments should only be carried out by a technician.
P2	Adjustments of temperature zero	
P3	Adjustments of minimum ironing speed	
P4	Adjustments of maximum ironing speed	

CONTROL CIRCUIT**(ironer)**

32006970

A4	Electronic scheduler
i1	Switch of position safety-hand shutter (left)
i2	Switch of position safety-hand shutter (right)
i3	Thermal contact motor fan
i4	Thermal contact motion motor
i11	Photocell detection speed
Q2	Contact breaker fan motor
R1	Thermic probe PT100



32006966

POWER CIRCUIT**(ironer)**

32006966

A1	Variable speed drive
A3	Programmer
Citel	Accommodating connection
D1	Primary breaker 4 A
D2	Secondary breaker motion motor 4 A
D3	Secondary breaker control circuit PH + N 2 A
KM1	Motion motor contactor
KM2	Fan motor contactor
Q1	Mainswitch
Q2	Three-pole motor breaker 2.4 A star - 6 A triangle
L1	Coil
M1	Motion motor
M2	Fan motor
T1	Control circuit transformer 750 VA

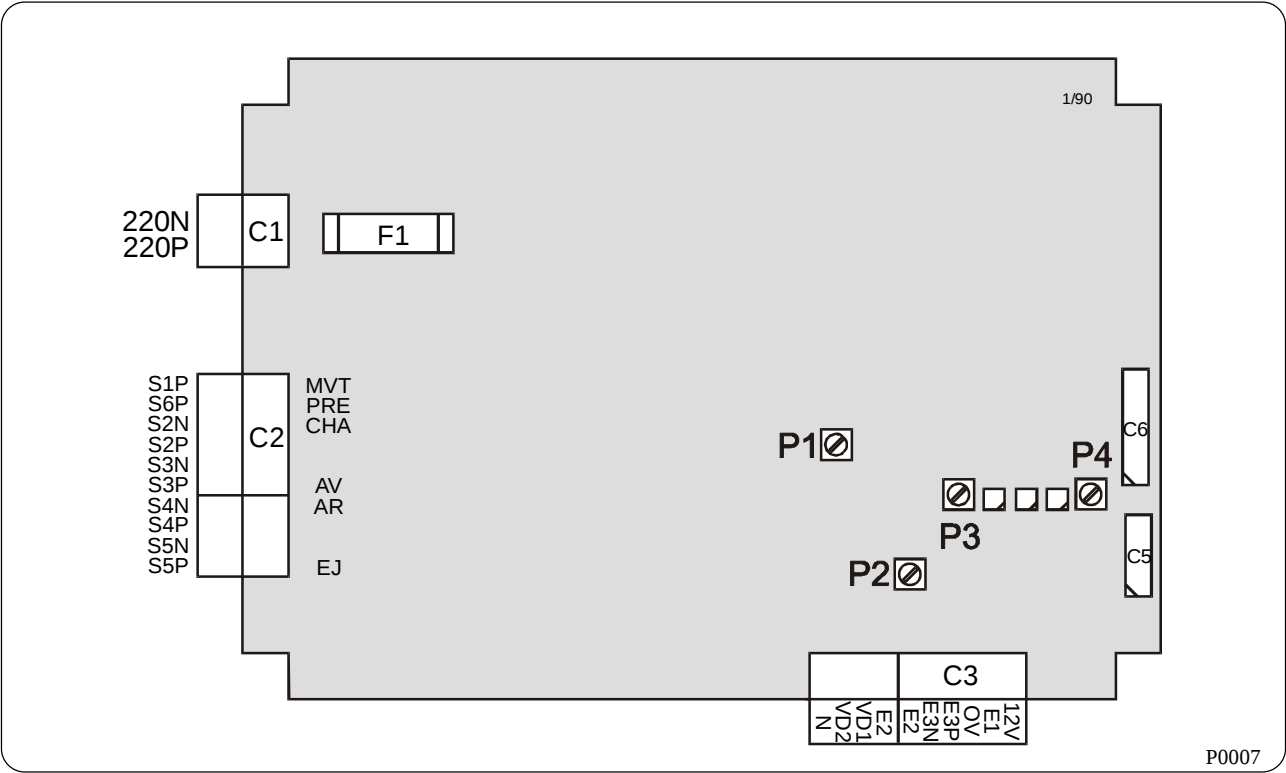
INPUTS / OUPUTS CARD (ironer)

- F1 General fuse 2 A
- C1 Feeding connector 230 V
- C2 Outputs connector 230 V
- C3 Inputs connector
- C5 Connector for converter flat cable
- C6 Connector for extension connection

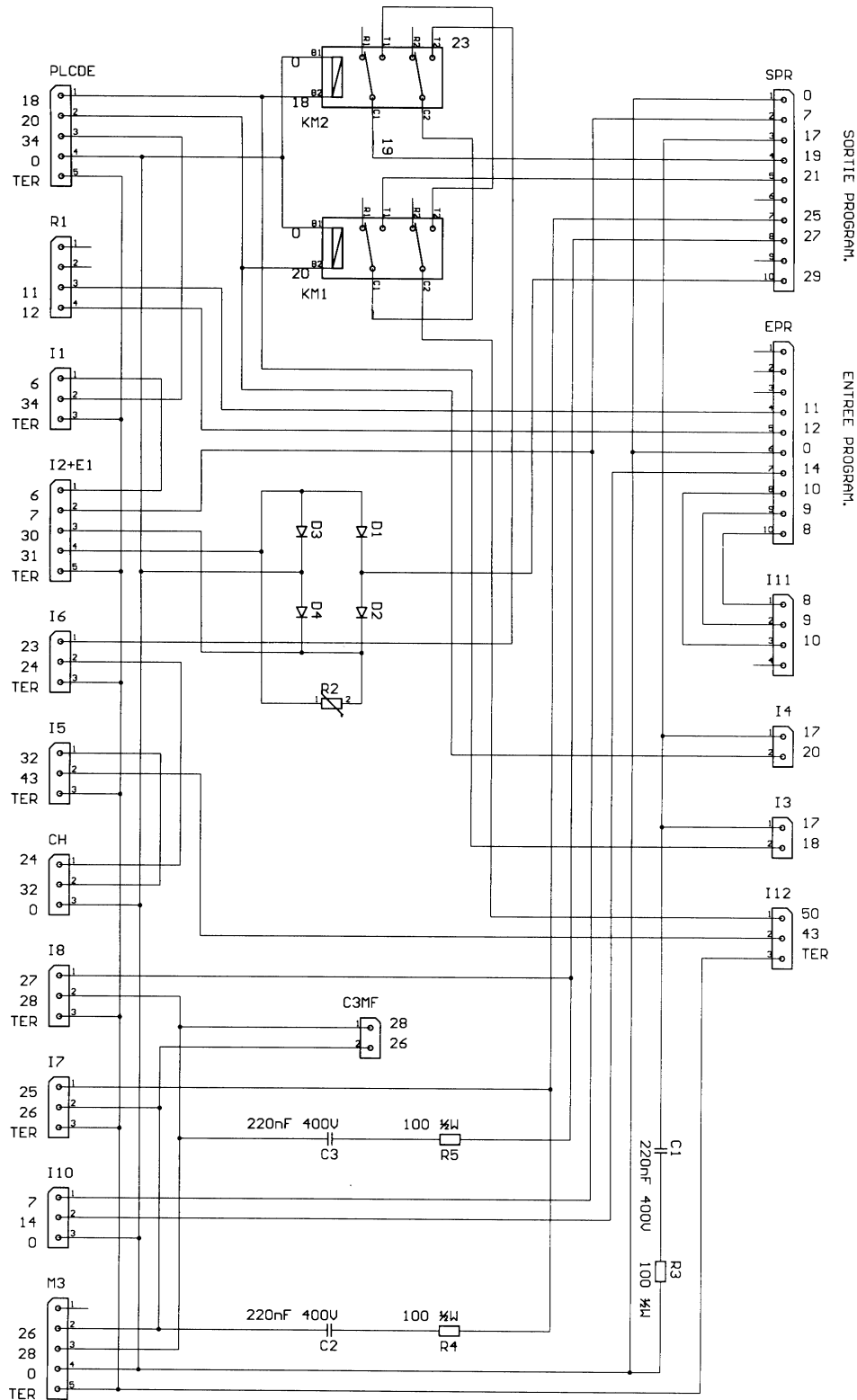
Adjustment potentiometers

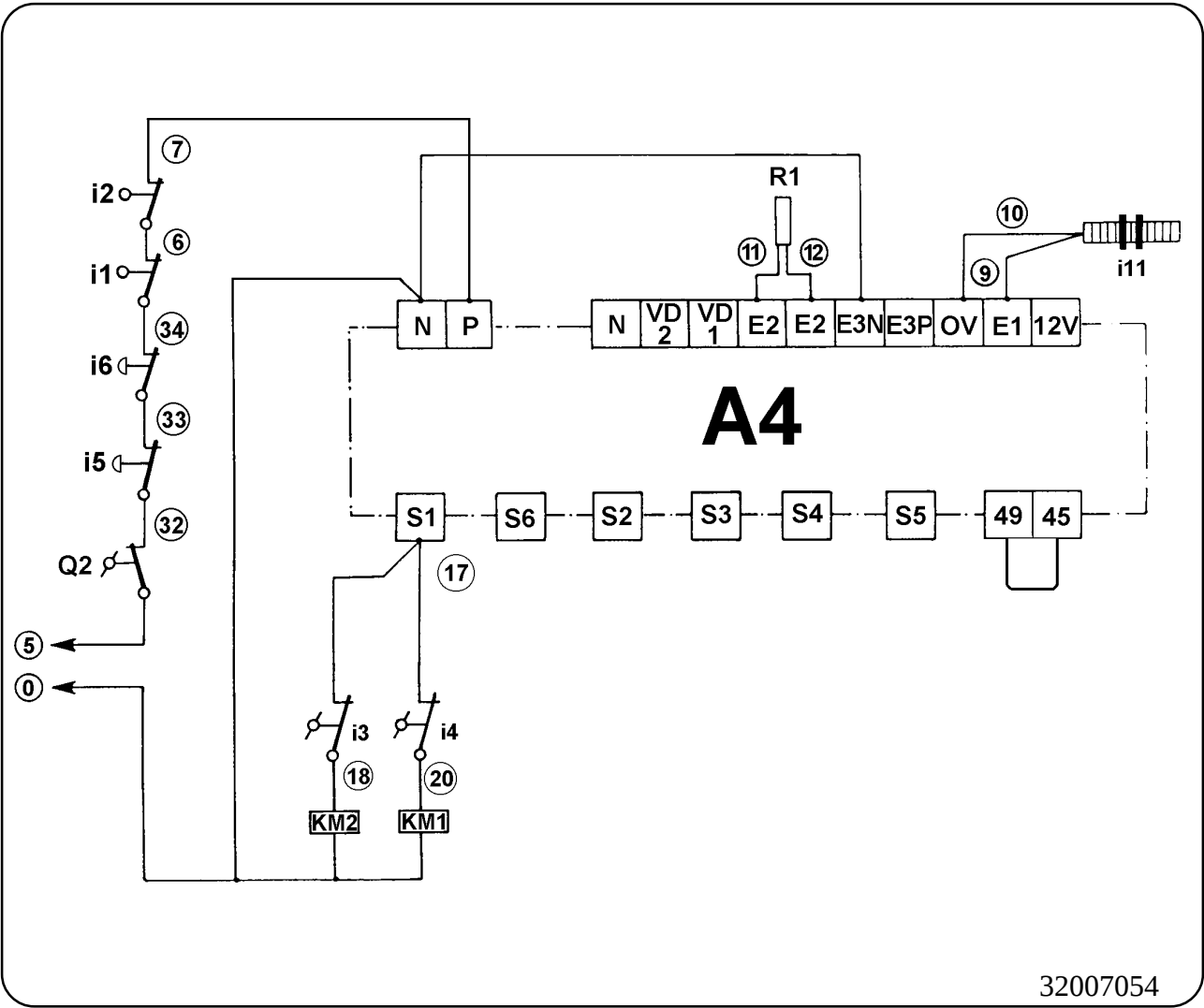
- P1 Adjustments of gain in temperature
- P2 Adjustments of temperature zero
- P3 Adjustments of minimum ironing speed
- P4 Adjustments of maximum ironing speed

These adjustments should only be carried out by a technician.



INTERCONNECTION CIRCUIT (ironer)

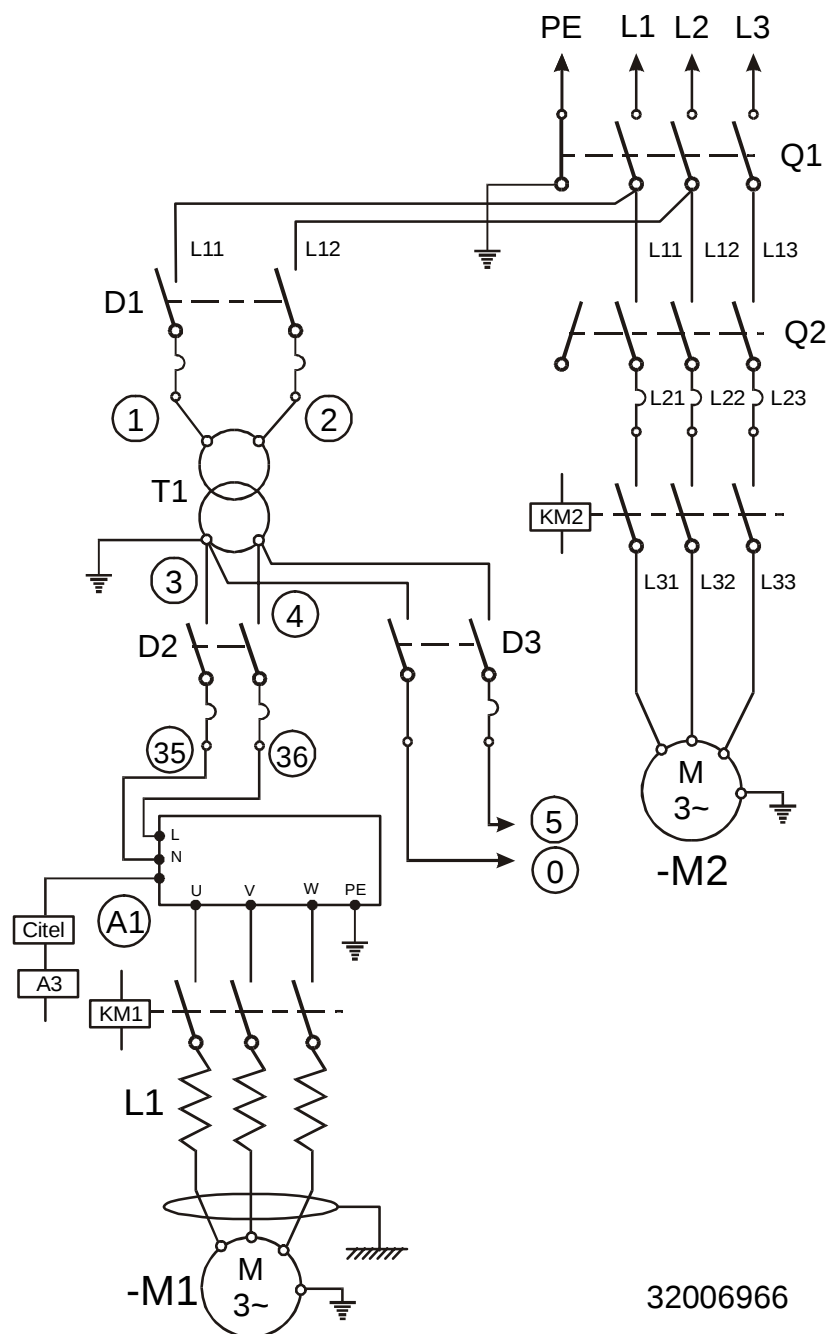




CONTROL CIRCUIT
(ironer with rear outlet)

32007054

A4	Electronic scheduler
i1	Switch of position safety-hand shutter (left)
i2	Switch of position safety-hand shutter (right)
i3	Thermal contact motor fan
i4	Thermal contact motion motor
i5	Right rear outlet emergency stop
i6	Left rear outlet emergency stop
i11	Photocell detection speed
Q2	Contact breaker fan motor
R1	Thermic probe PT100



32006966

POWER CIRCUIT
(ironer with rear outlet)
32006966

A1	Variable speed drive
A3	Programmer
Citel	Accommodating connection
D1	Primary breaker 4 A
D2	Secondary breaker motion motor 4 A
D3	Secondary breaker control circuit PH + N 2 A
KM1	Motion motor contactor
KM2	Fan motor contactor
Q1	Mainswitch
Q2	Three-pole motor breaker 2.4 A star - 6 A triangle
L1	Coil
M1	Motion motor
M2	Fan motor
T1	Control circuit transformer 750 VA

INPUTS / OUPUTS CARD (ironer with rear outlet)

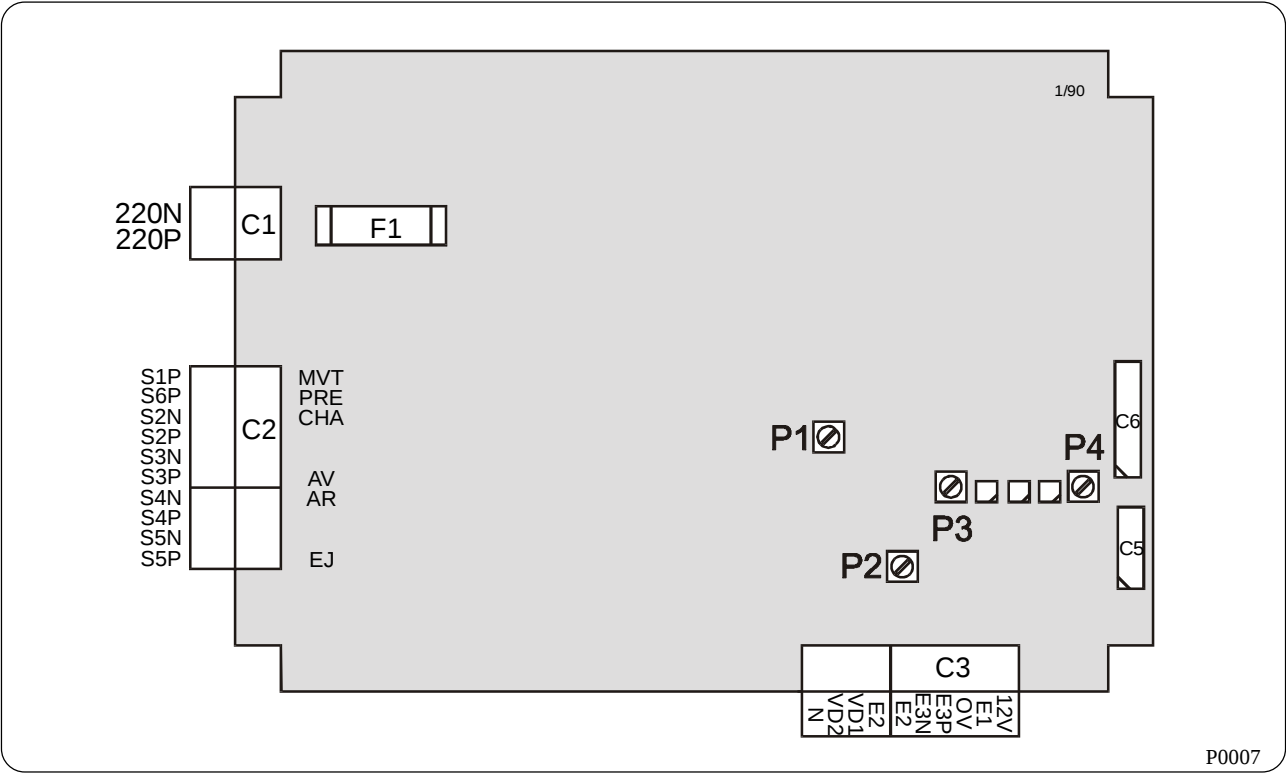
- F1 General fuse 2 A

- C1 Feeding connector 230 V
- C2 Outputs connector 230 V
- C3 Inputs connector
- C5 Connector for converter flat cable
- C6 Connector for extension connection

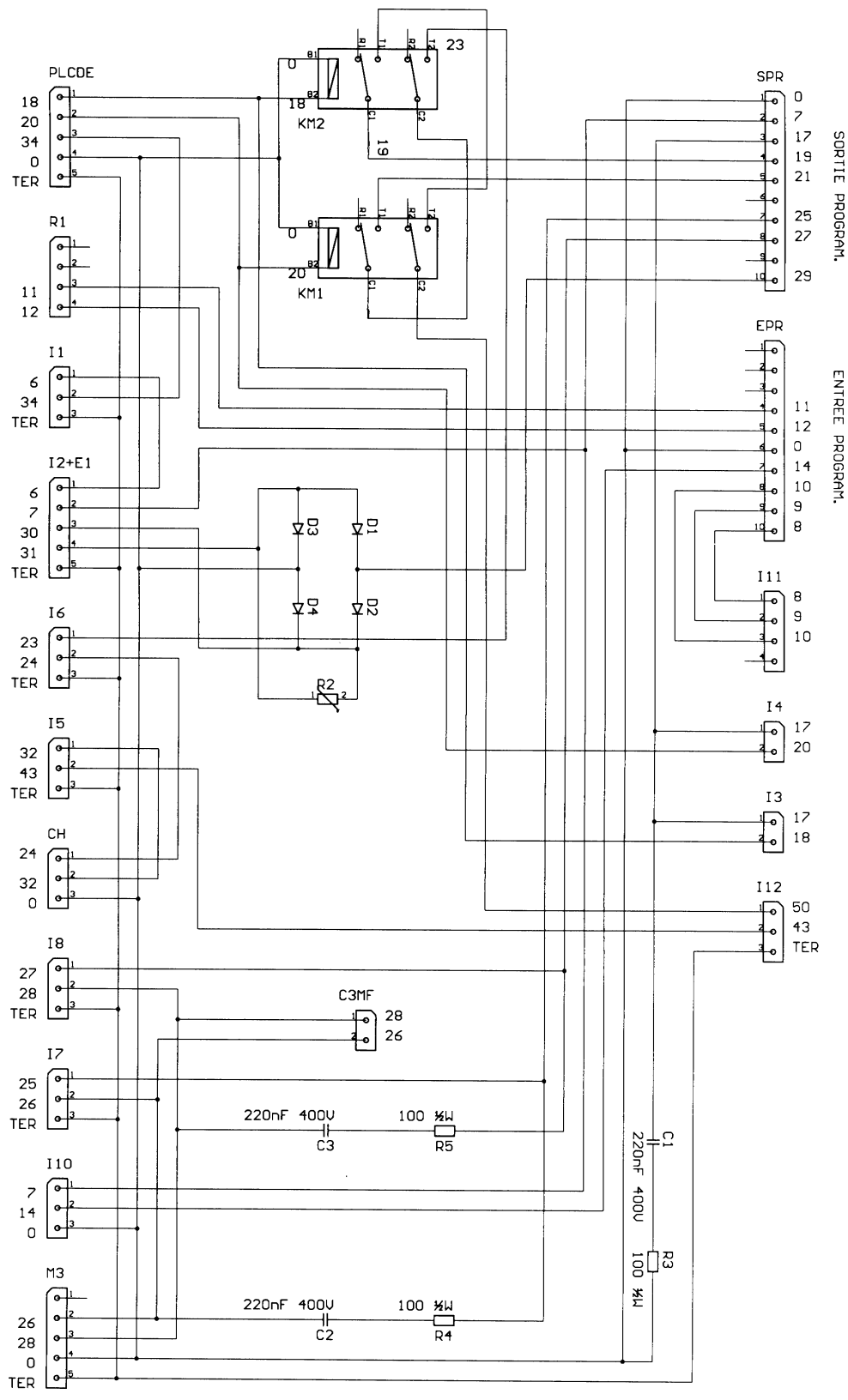
Adjustment potentiometers

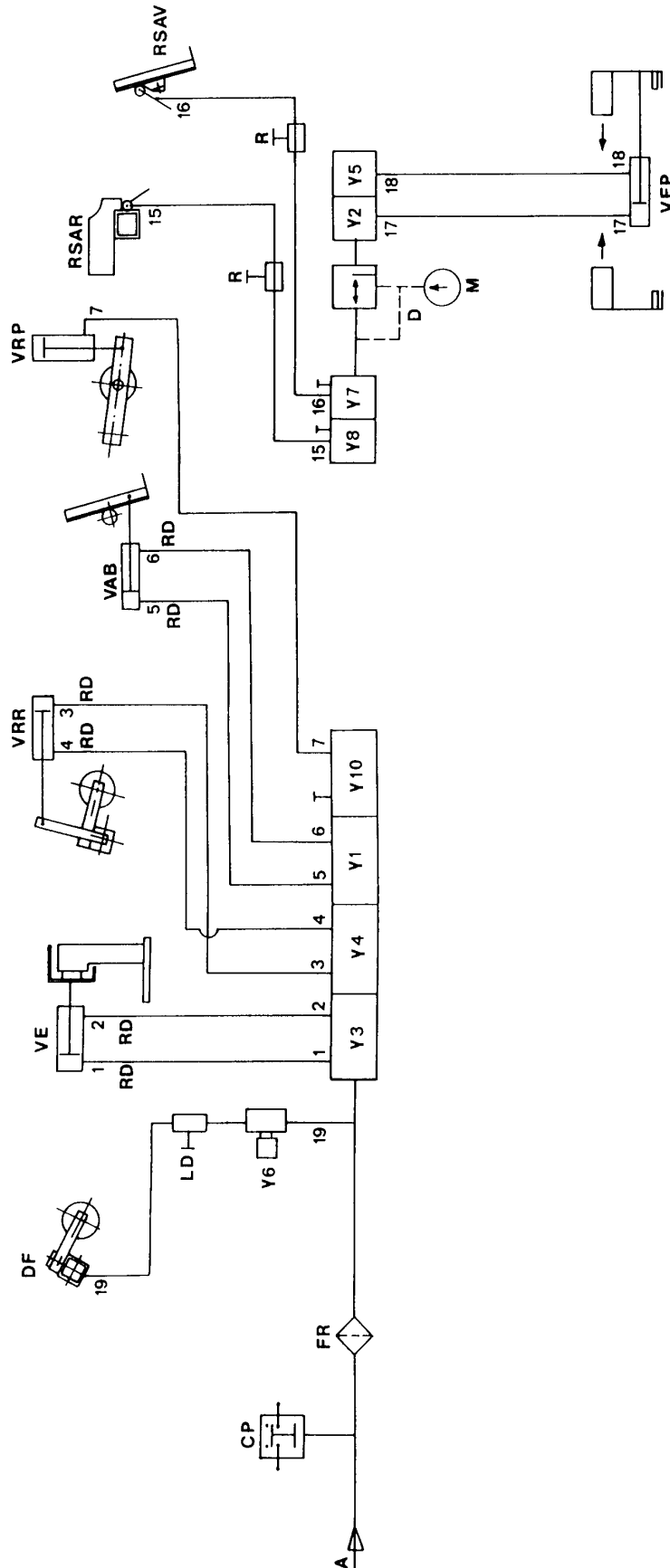
- P1 Adjustments of gain in temperature
- P2 Adjustments of temperature zero
- P3 Adjustments of minimum ironing speed
- P4 Adjustments of maximum ironing speed

These adjustments should only be carried out by a technician.



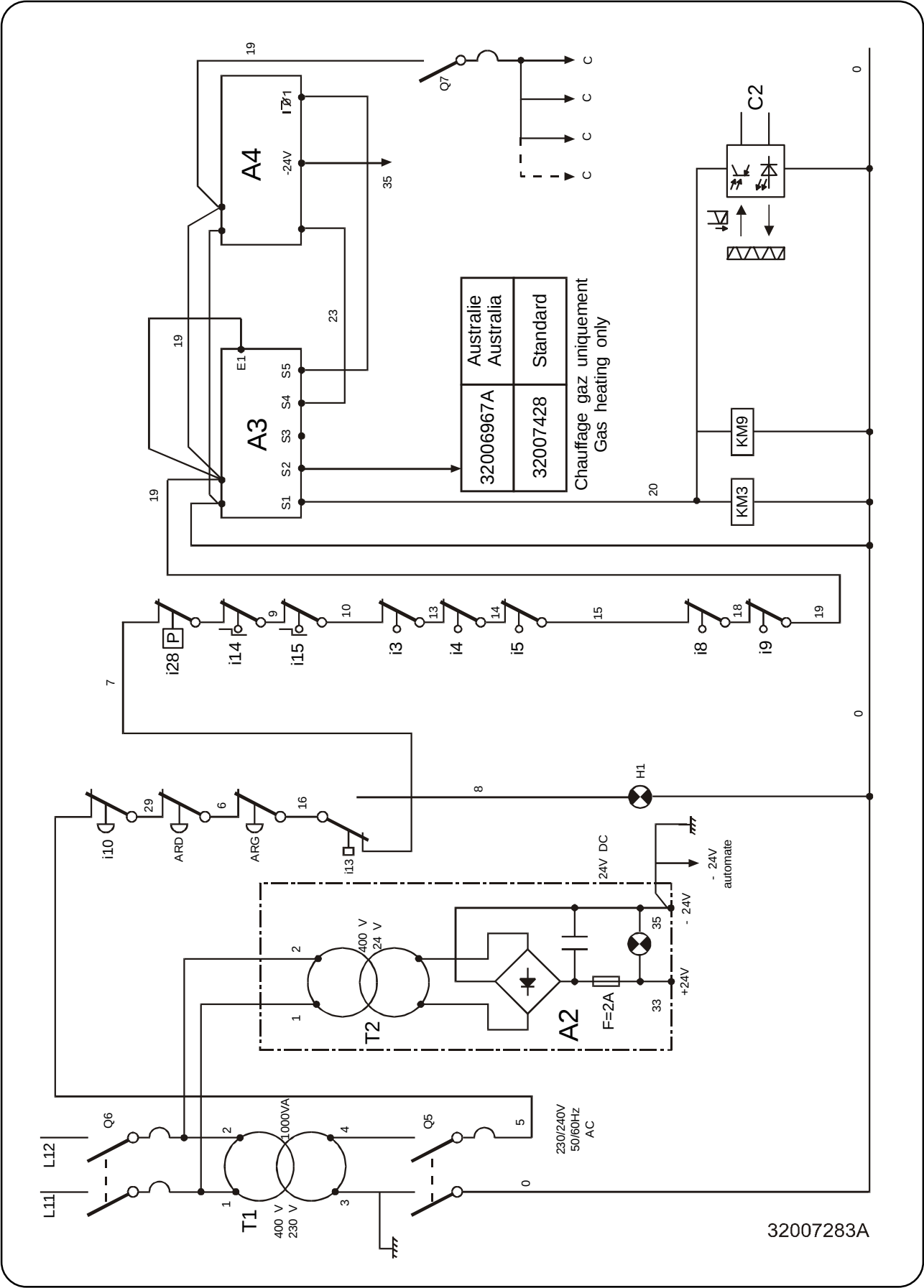
INTERCONNECTION CIRCUIT (ironer with rear outlet)





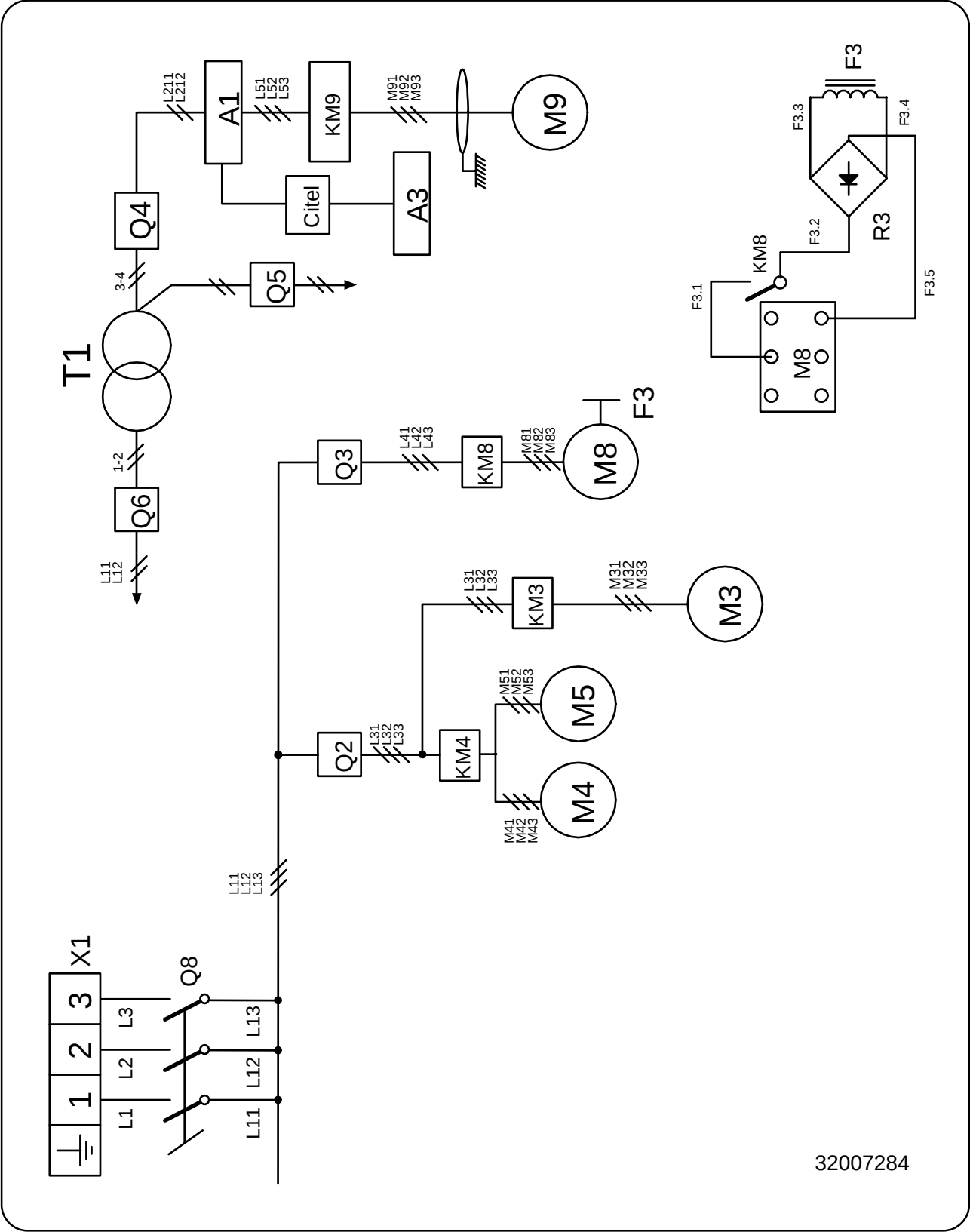
PNEUMATIC DIAGRAM
(feeder, ironer, folder with rear outlet)
32007279

A	Compressed air supply 8 bar maxi
CP	Air shortage pressostat
FR	Regulating filter 5 microns (adjustment 5 bar)
DF	Feeding blowing supply
VE	Feeding jack
VRR	Small wheels lift jack
VAB	Vat joint jack
VRP	Pressure roller lift jack
RSAR	Rear blowing burner supply
RSAV	Front blowing burner supply
LD	Flow limiter
RD	Flow reducer
R	Adjusting valve
Y1-Y3-Y4-Y10	Distributor
D	Pressure reducing valve 2/3 bar
M	Manometer
Y2-Y5-Y6	NF electrovalve
VEP	Feeding clamps spreading jack



CONTROL CIRCUIT
(feeder, ironer, folder with rear outlet)
32007283A

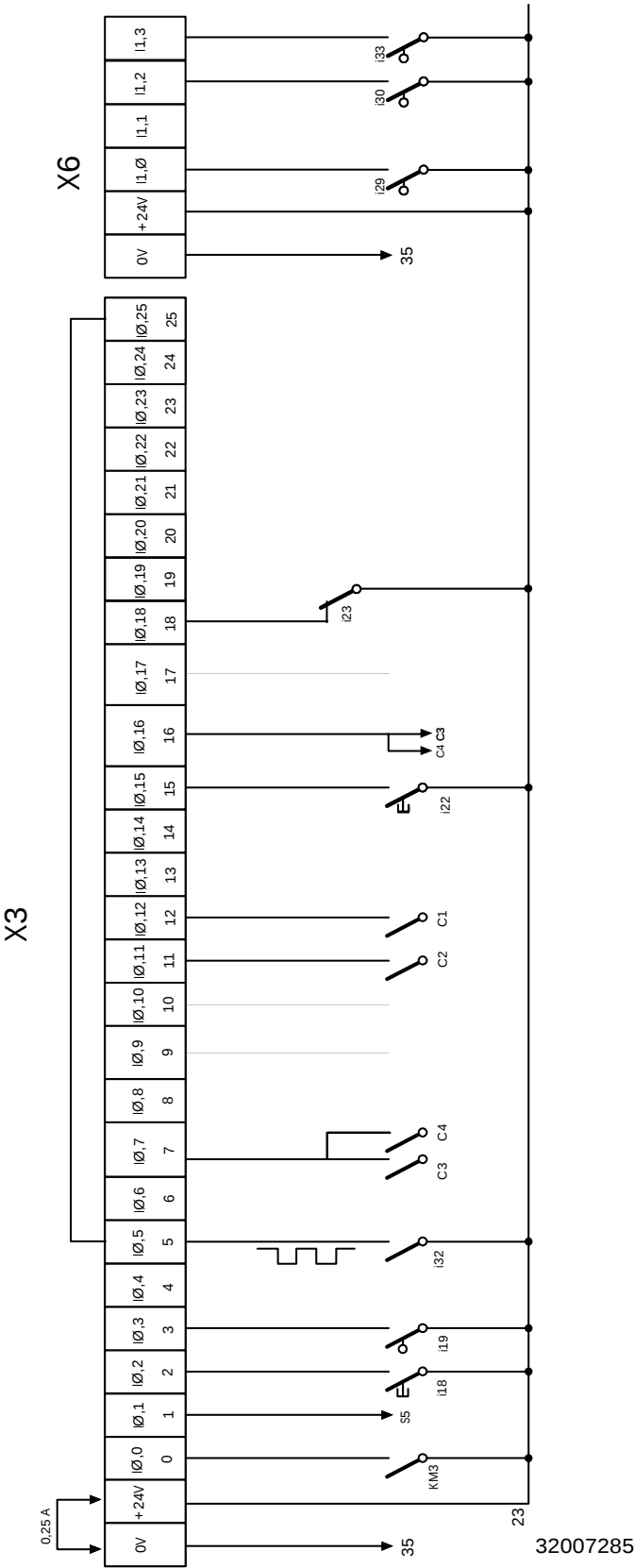
T1	Isolating transformer 1000 VA
T2	Distribution circuit transformer 24 V
A2	Distribution circuit rectifier 24 V DC
A3	Programmer / block diagram
A4	Programmable automate
ARD	Rear right emergency stop
ARG	Rear left emergency stop
C2	Longitudinal folding photocell
H1	Air shortage indicator
Q5	Two-pole breaker ph + N 2 A secondary
Q6	Two-pole breaker 2 A primary
Q7	Two-pole breaker 2 A (common outputs)
i3	Thermal contact fan motor
i4	Thermal contact smoothing motor
i5	Thermal contact smoothing motor
i8	Thermal contact rear evacuation motor
i9	Thermal contact motion motor
i10	Ironer emergency stop
i13	Air shortage pressostat
i14	Finger protection right flap position switch
i15	Finger protection left flap position switch
i28	Gas pressure switch (optional or Australia machine) (for gas heating machine only)
KM3	Fan contactor
KM9	Motion contactor



POWER CIRCUIT
(feeder, ironer, folder with rear outlet)

32007284

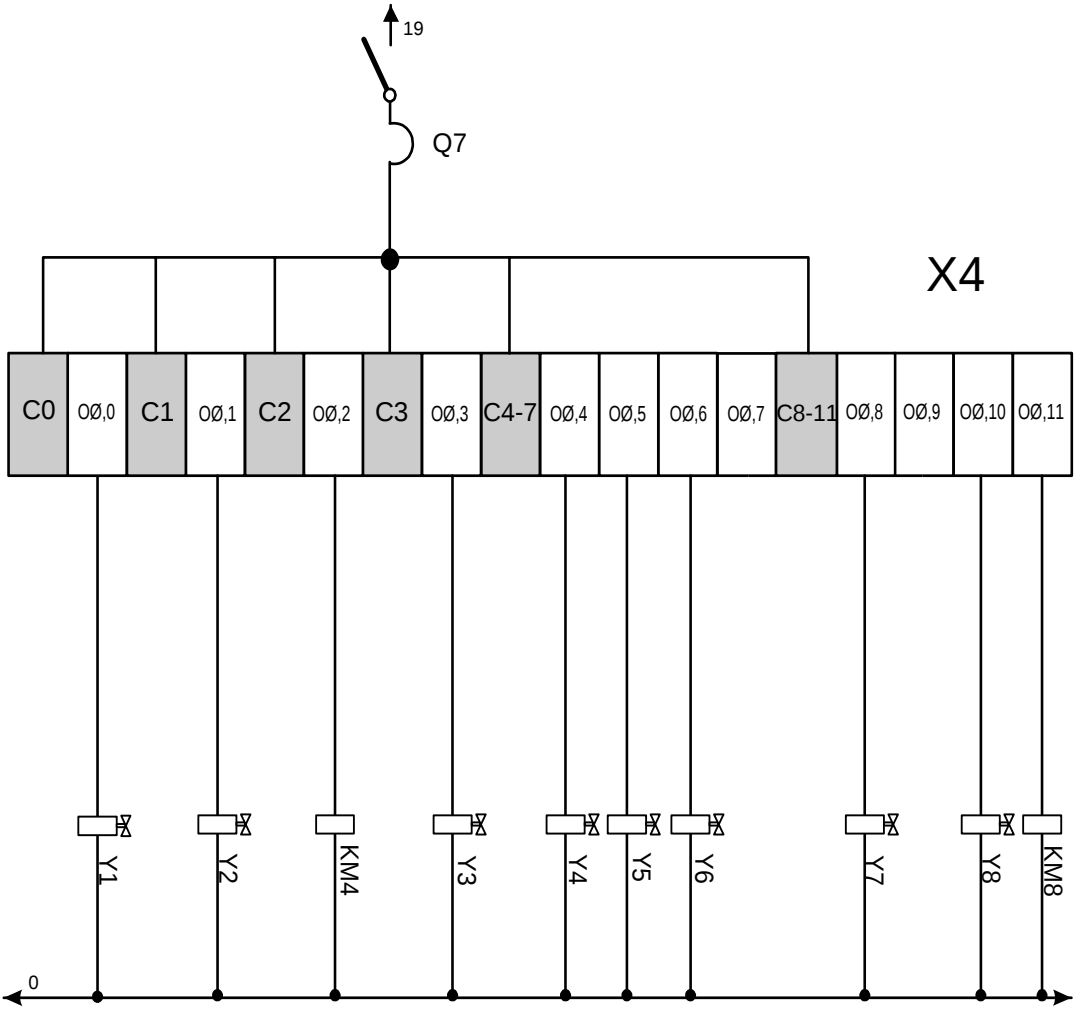
X1	General supply terminal
Q2	Three-pole motor breaker
Q3	Three-pole motor breaker
Q4	Two-pole breaker 4 A
Q5	Two-pole breaker ph + N 2 A
Q6	Two-pole breaker 6 A
Q8	General switch
T1	Isolating transformer 1000 VA
A1	Motion frequency converter (ATV16)
A3	Programmer
Citel	Accommodating connection
F3	Rear evacuation brake
M3	Fan motor
M4	Smoothing right motor
M5	Smoothing left motor
M8	Rear evacuation motor
M9	Motion motor
KM3	Fan motor contactor
KM4	Smoothing motor contactor
KM8	Rear evacuation motor contactor
KM9	Motion motor contactor
R3	Rectifier for brake F3



32007285

AUTOMATE INPUTS
(feeder, ironer, folder with rear outlet)
32007285

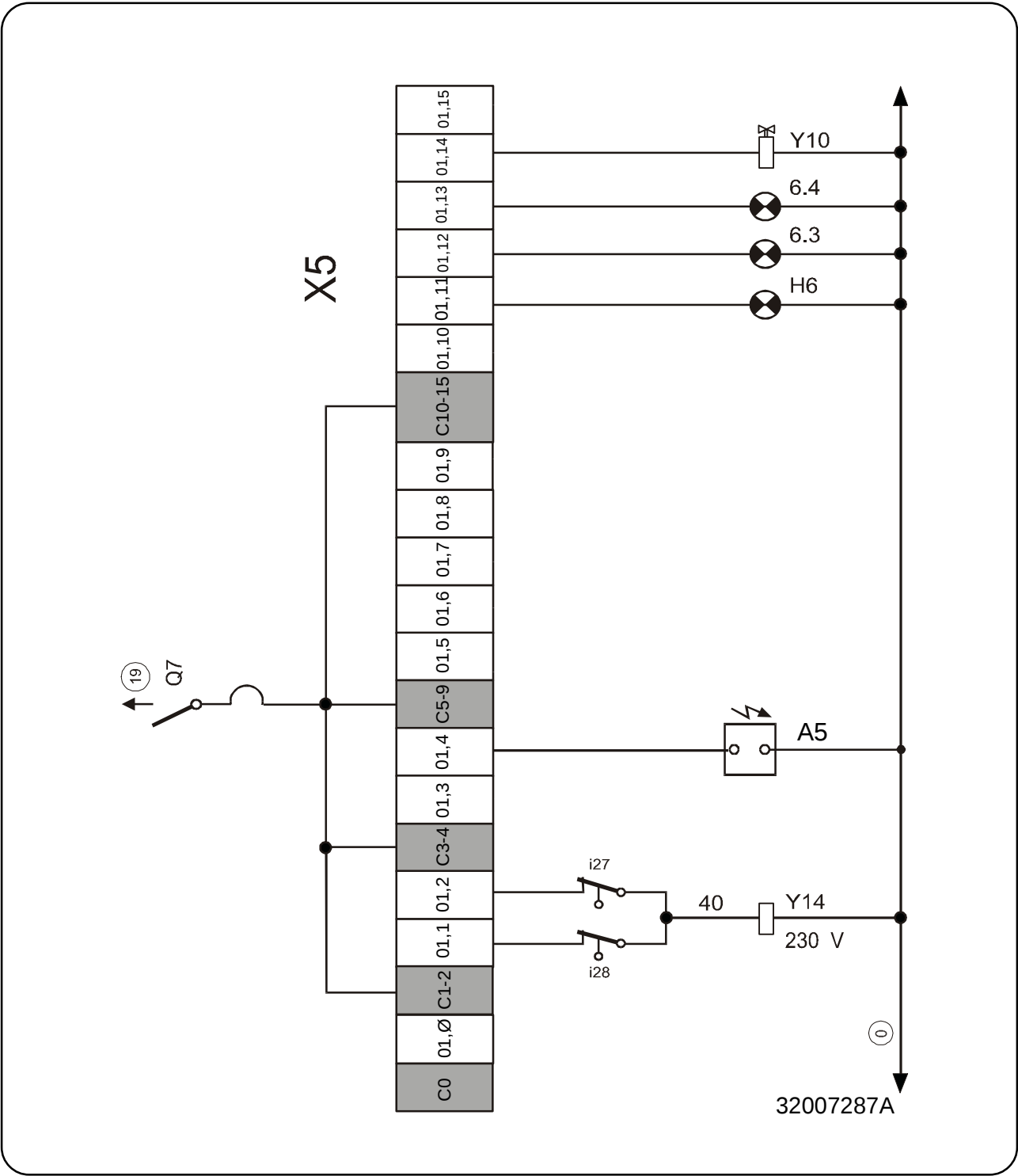
X3	Inputs connection terminal on automate A4
X6	Extension inputs connection terminal
IØ,0	Run / stop
IØ,1	With/without folding
IØ,2	Feeding push button
IØ,3	Jack sensor feed motion
IØ,5	Longitudinal sheet measurement
IØ,7	Longitudinal folding safety device (C3-C4)
IØ,11	Longitudinal folding (C2)
IØ,12	Sheet at feeding (C1)
IØ,15	Reclosing/initialization push-button
IØ,16	Dirty cell detection (C3-C4)
IØ,18	Feeding switch without folding
IØ,21	Dirty cell detection (C7-C8-C9-C10)
IØ,25	Longitudinal folding shunted at IØ,5 quick metering input
I1,Ø	Feeding return jack sensor
I1,2	Rear longitudinal arm
I1,3	Small wheels lowering jack sensor
C1	Feeding sheet photocell
C2	Longitudinal folding photocell
C3	Longitudinal folding safety device photocell
C4	Longitudinal folding safety device photocell
KM3	Fan contactor
i18	Feeding push-button
i19	Feeding position switch
i22	Reclosing initialization push-button
i23	Switch without folding / without third fold] 3 positions
i29	Return feeding position switch
i30	Rear longitudinal arm position switch
i32	Longitudinal folding measurement inductive detector
i33	Small wheels lowering jack position switch



AUTOMATE OUTPUTS (feeder, ironer, folder with rear outlet)

32007286

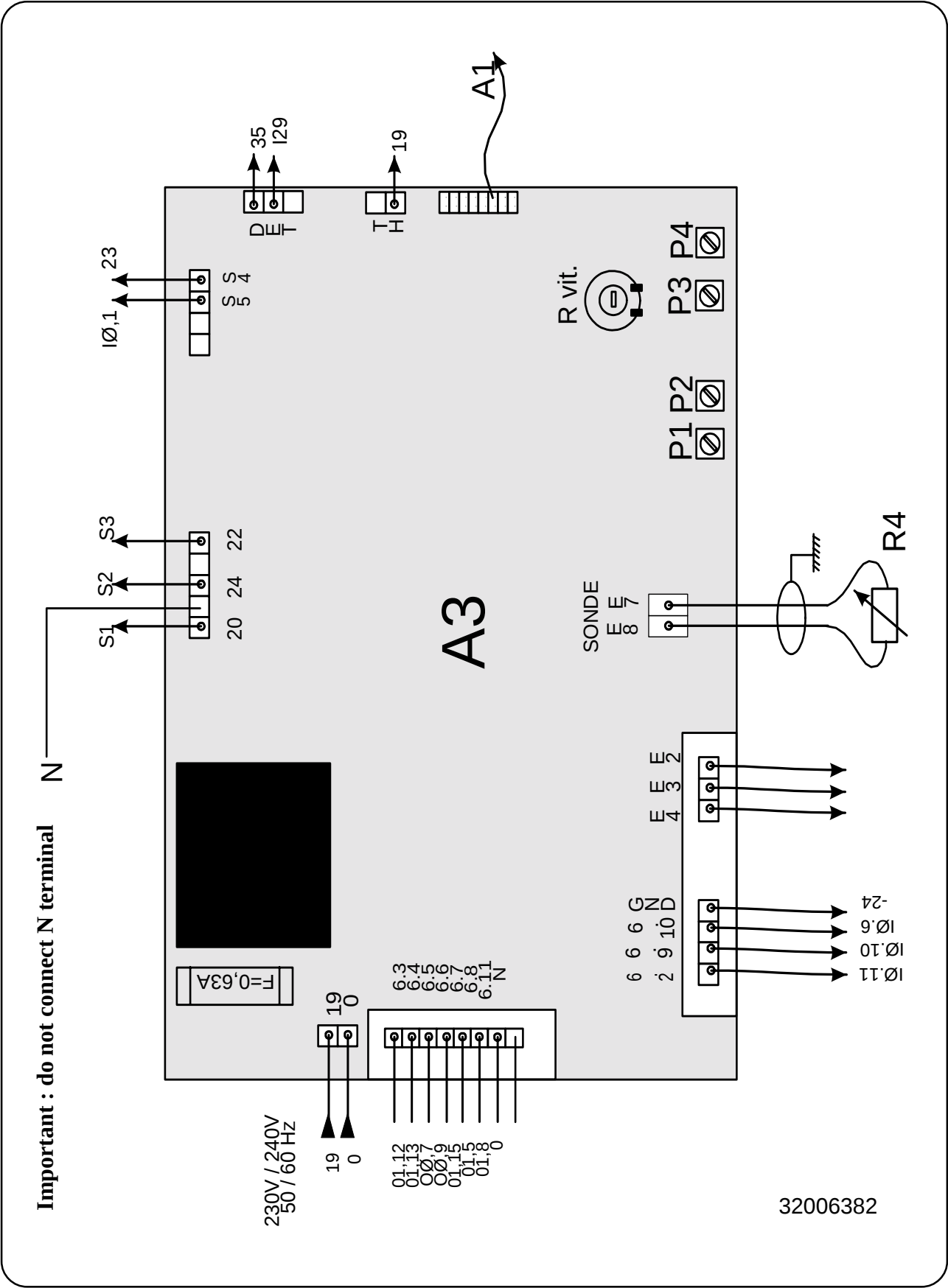
X4	Outputs on automate A4 connection terminal
Q7	Two-pole breaker 2 A (common outputs)
OØ,0	Vat without folding
Y1	Vat without folding pneumatic distributor
OØ,1	Clamps spreading
Y2	Clamps spreading pneumatic distributor
OØ,2	Smoothing
KM4	Smoothing motor contactor
OØ,3	Clamps movement
Y3	Clamps movement pneumatic distributor
OØ,4	Clamps unblocking (small wheels)
Y4	Clamps unblocking pneumatic distributor
OØ,5	Clamps drawing nearer
Y5	Clamps drawing nearer pneumatic distributor
OØ,6	Feeding blow
Y6	Feeding blow pneumatic distributor
OØ,8	Front blow
Y7	Front blow pneumatic distributor
OØ,10	Rear blow
Y8	Rear blow pneumatic distributor
OØ,11	Sheet evacuation
KM8	Rear evacuation motor contactor



AUTOMATE OUTPUTS (continued) (feeder, ironer, folder with rear outlet)

32007287A

X5	Connection terminal on outputs extension
Q7	Two-pole breaker 2 A (common outputs)
A5	Control box for antistatic bar
A 7	Fan frequency converter
O1,Ø	Maximum speed fan control
O1,1	Front longitudinal folding arm
i 28	Rear folding position switch
O1,2	Rear longitudinal folding arm
i 27	Front folding position switch
Y14	Longitudinal folding arm clutch (clutch/brake, 2 stops/turn).
O1,11	Dirty cell
H6	Dirty cell indicator
01,12	Front longitudinal folding led (6-3)
01,13	Rear longitudinal folding led (6-4)
01,14	Pressure roller lifting
Y10	Pressure roller lifting pneumatic distributor



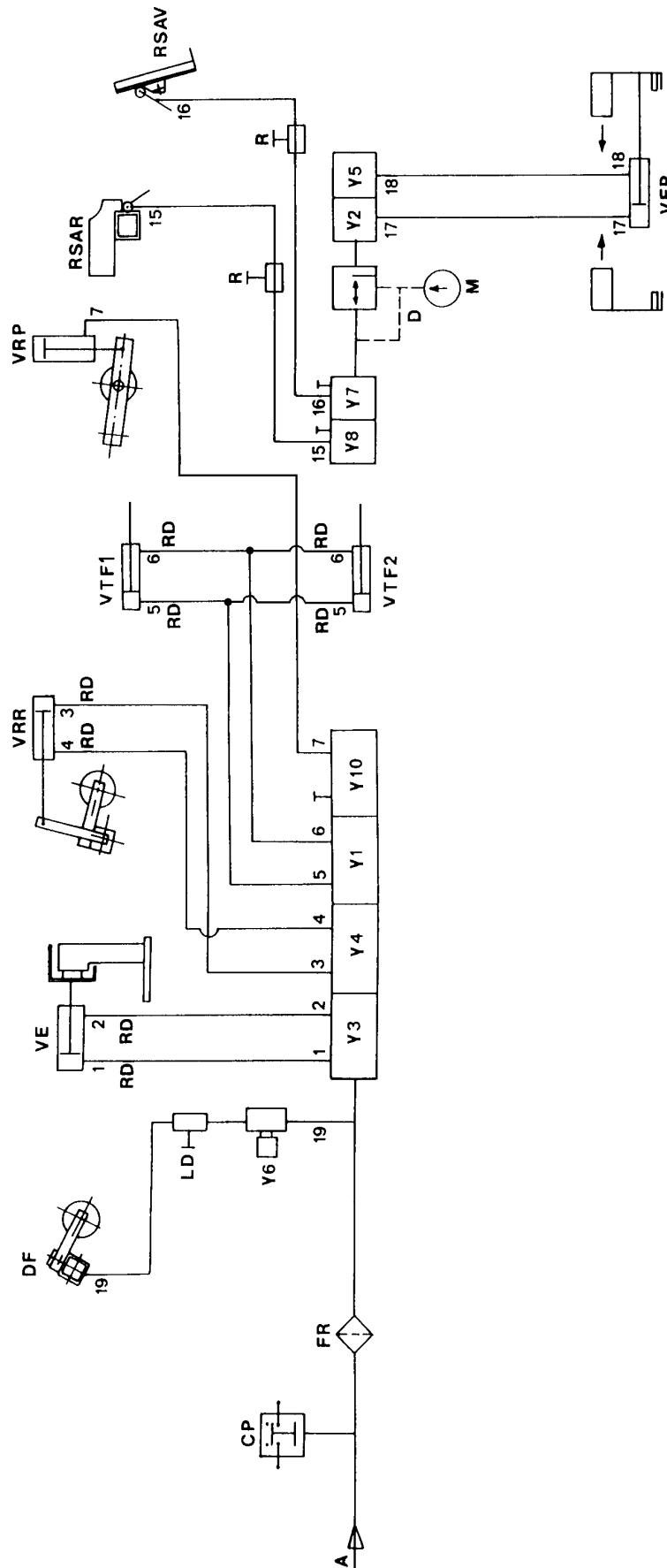
INPUTS / OUTPUTS CARD (feeder, ironer, folder with rear outlet)

32006382

A1	Frequency converter
A3	Programmer / synoptic
P1	Temperature adjustment potentiometer (do not touch)
P2	Temperature adjustment potentiometer (do not touch)
P3	Maximum speed adjustment potentiometer
P4	Minimum speed adjustment potentiometer
R4	Temperature adjustment PT100 probe
i29	Speed display detector
KM3	Fan motor contactor
KM9	Motion motor contactor
S1	Fan control output
S2	Adjusted heating control output
S3	Direct heating control output
S4 and S5	Outputs for automate control with or without folding
E2	Ignitor indicator input
E3	Ignitor indicator input
E4	Ignitor indicator input
E7	Temperature probe input
E8	Temperature probe input

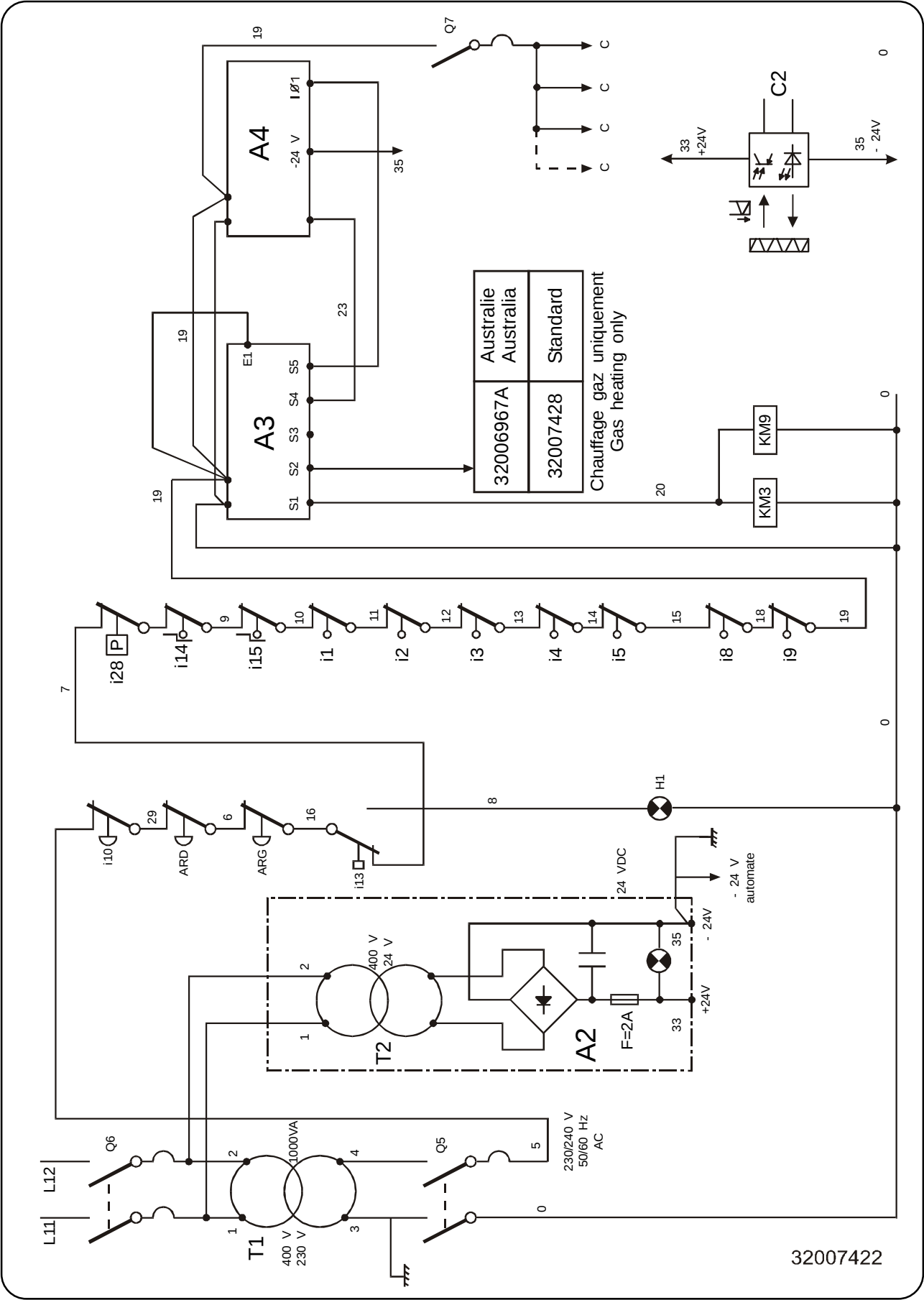
Synoptic led assignment

led 6.2	Ironing output
led 6.3	Front folding
led 6.4	Rear folding
led 6.5	Rear evacuation
led 6.6	First fold
led 6.7	Second fold
led 6.8	Third fold
led 6.9	Folding output
led 6.10	Stacker
led 6.11	Completed pile



PNEUMATIC DIAGRAM
(feeder, ironer, folder with transfer table)
32007421

A	Compressed air supply 8 bar maxi
CP	Air shortage pressostat
FR	Regulating filter 5 microns (adjustment 5 bar)
DF	Feeding blowing supply
VE	Feeding jack
VRR	Small wheels lift jack
VTF1	1st jack positionning table
VTF2	2nd jack positionning table
VRP	Pressure roller lift jack
RSAR	Rear blowing burner supply
RSAY	Front blowing burner supply
LD	Flow limiter
RD	Flow reducer
R	Adjusting valve
Y1 to Y10	Distributor
D	Pressure reducing valve 2/3 bar
M	Manometer
Y2-Y5-Y6	NF electrovalve
VEP	Feeding clamps spreading jack

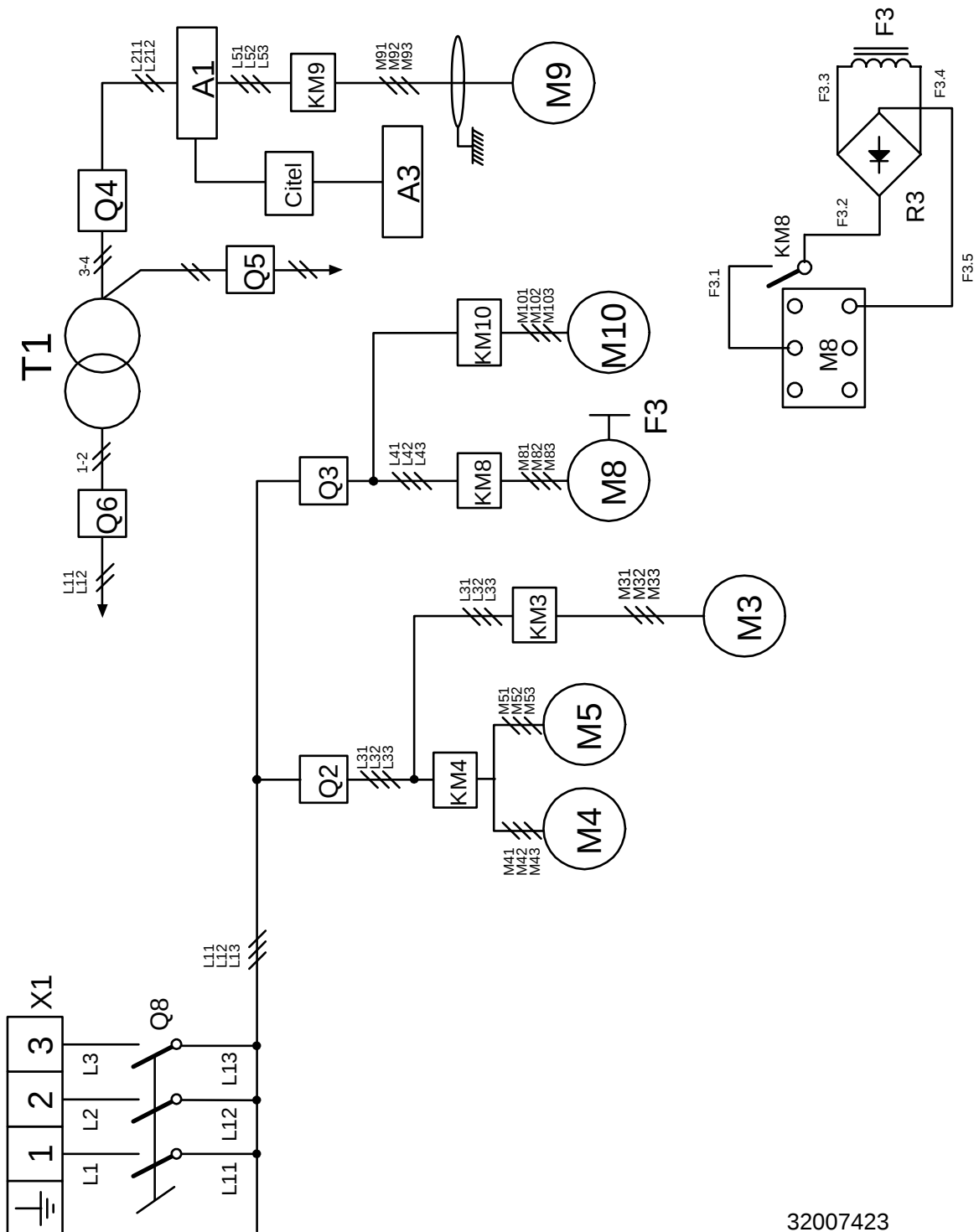


CONTROL CIRCUIT

(feeder, ironer, folder with transfer table)

32007422

T1	Isolating transformer 1000 VA	
T2	Distribution circuit transformer 24 V	] same part
A2	Distribution circuit rectifier 24 V DC	
A3	Programmer/block diagram	
A4	Programmable automate	
ARD	Rear right emergency stop	
ARG	Rear left emergency stop	
C2	Longitudinal folding photocell	
H1	Air shortage indicator	
Q5	Two-pole breaker ph + N 2 A secondary	
Q6	Two-pole breaker 2 A primary	
Q7	Two-pole breaker 2 A (common outputs)	
i1	Left protection casing contact	
i2	Right protection casing contact	
i3	Thermal contact fan motor	
i4	Thermal contact smoothing motor	
i5	Thermal contact smoothing motor	
i8	Thermal contact rear evacuation motor	
i9	Thermal contact motion motor	
i10	Ironer emergency stop	
i13	Air shortage pressostat	
i14	Finger protection right flap position switch	
i15	Finger protection left flap position switch	
i28	Gas pressure switch (optional or Australia machine) (for gas heating machine only)	
KM3	Fan contactor	
KM9	Motion contactor	

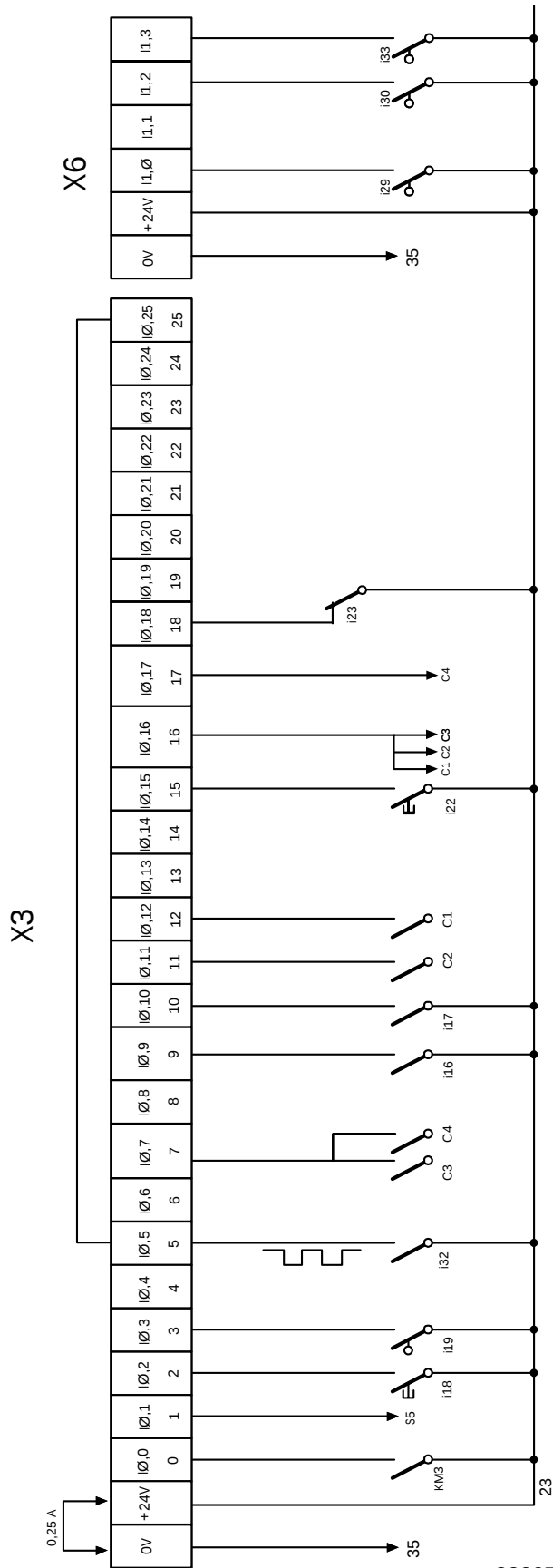


32007423

POWER CIRCUIT
(feeder, ironer, folder with transfer table)

32007423

X1	General supply terminal
Q2	Three-pole motor breaker
Q3	Three-pole motor breaker
Q4	Two-pole breaker 4 A
Q5	Two-pole breaker ph + N 2A
Q6	Two-pole breaker 6 A
Q8	General switch
T1	Isolating transformer 1000 VA
A1	Motion frequency converter (ATV16)
A3	Programmer
Citel	Accommodating connection
F3	Rear evacuation brake
M3	Fan motor
M4	Smoothing right motor
M5	Smoothing left motor
M8	Rear evacuation motor
M9	Motion motor
M10	Transfer table motor
KM3	Fan motor contactor
KM4	Smoothing motor contactor
KM8	Rear evacuation motor contactor
KM9	Motion motor contactor
KM10	Transfer table motor contactor
R3	Rectifier for brake F3



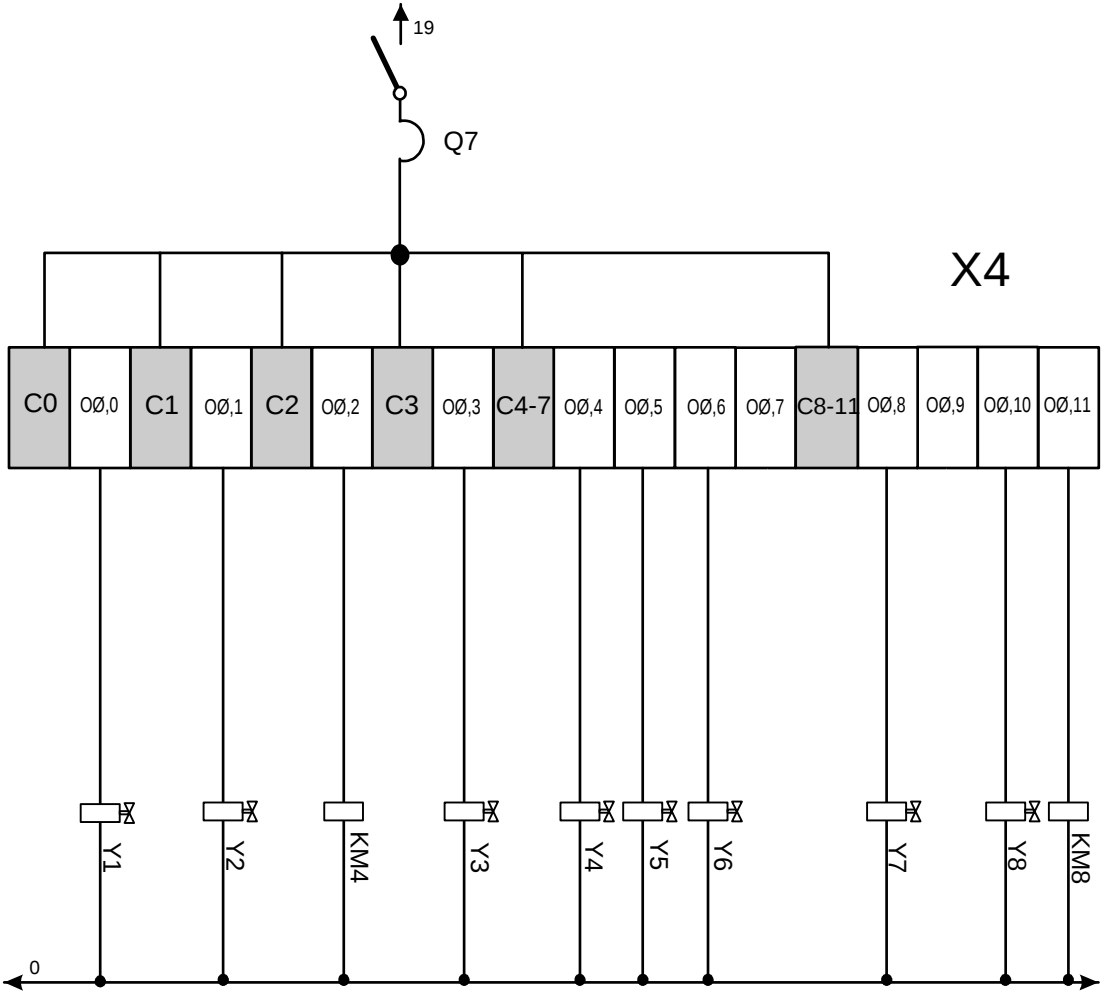
32007424

AUTOMATE INPUTS

(feeder, ironer, folder with transfer table)

32007424

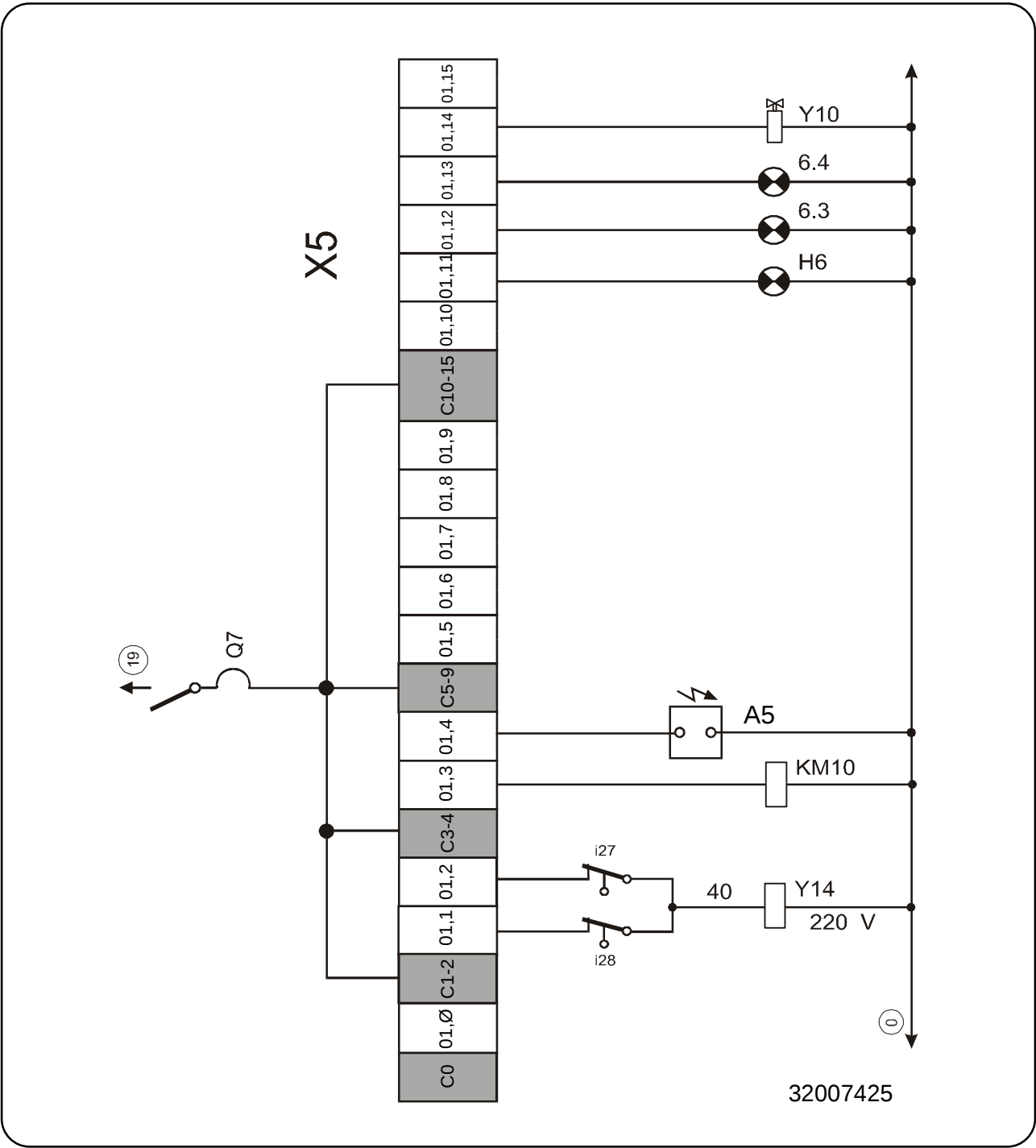
X3	Inputs connection terminal on automate A4
X6	Extension inputs connection terminal
IØ,0	Run / stop
IØ,1	With/without folding
IØ,2	Feeding push button
IØ,3	Jack sensor feed motion
IØ,5	Longitudinal sheet measurement
IØ,7	Longitudinal folding safety device (C3-C4)
IØ,9	Table in upper position sensor
IØ,10	Table in working position sensor
IØ,11	Longitudinal folding (C2)
IØ,12	Sheet at feeding (C1)
IØ,15	Reclosing/initialization push-button
IØ,16	Dirty cell detection (C1-C2-C3)
IØ,17	Dirty cell detection (C4-C5-C6)
IØ,18	Feeding switch without folding
IØ,21	Dirty cell detection (C7-C8-C9-C10)
IØ,25	Longitudinal folding shunted at IØ,5 quick metering input
I1,Ø	Feeding return jack sensor
I1,2	Rear longitudinal arm
I1,3	Small wheels lowering jack sensor
C1	Feeding sheet photocell
C2	Longitudinal folding photocell
C3	Longitudinal folding safety device photocell
C4	Longitudinal folding safety device photocell
KM3	Fan contactor
i16	Table in upper position sensor
i17	Table in working position sensor
i18	Feeding push-button
i19	Feeding position switch
i22	Reclosing initialization push-button
i23	Switch without folding / without third fold] 3 positions
i29	Return feeding position switch
i30	Rear longitudinal arm position switch
i32	Longitudinal folding measurement inductive detector
i33	Small wheels lowering jack position switch



AUTOMATE OUTPUTS (feeder, ironer, folder with transfer table)

32007286

X4	Outputs on automate A4 connection terminal
Q7	Two-pole breaker 2 A (common outputs)
OØ,0	Vat without folding
Y1	Vat without folding pneumatic distributor
OØ,1	Clamps spreading
Y2	Clamps spreading pneumatic distributor
OØ,2	Smoothing
KM4	Smoothing motor contactor
OØ,3	Clamps movement
Y3	Clamps movement pneumatic distributor
OØ,4	Clamps unblocking (small wheels)
Y4	Clamps unblocking pneumatic distributor
OØ,5	Clamps drawing nearer
Y5	Clamps drawing nearer pneumatic distributor
OØ,6	Feeding blow
Y6	Feeding blow pneumatic distributor
H3	Sheet evacuation indicator
OØ,8	Front blow
Y7	Front blow pneumatic distributor
OØ,10	Rear blow
Y8	Rear blow pneumatic distributor
OØ,11	Sheet evacuation
KM8	Rear evacuation motor contactor



AUTOMATE OUTPUTS (continued)
(feeder, ironer, folder with transfer table)

32007425

A5	Control box for antistatic bar
X5	Connection terminal on outputs extension
Q7	Two-pole breaker 2 A (common outputs)
A 7	Fan frequency converter
O1,Ø	Maximum speed fan control
O1,1	Front longitudinal folding arm
i 28	Front folding position switch
O1,2	Rear longitudinal folding arm
i 27	Rear folding position switch
Y14	Longitudinal folding arm clutch (clutch/brake, 2 stops/turn).
O1,4	Transfer table motor contact control
KM10	Transfer table motor contactor
O1,11	Dirty cell
H6	Dirty cell indicator
01,12	Front longitudinal folding led (6-3)
01,13	Rear longitudinal folding led (6-4)
01,14	Pressure roller lifting
Y10	Pressure roller lifting pneumatic distributor

(feeder, ironer, folder and stacker)

32006381

Ⓐ Plug on stacker (front view) connection side

1 to 16 and 17 to 32 tags on plug
M11 to IØ,17 and 23 to 29 tags of threads

Ⓑ Socket on ironer (front view) connection side

1 to 16 and 17 to 32 tags on socket
M11 to IØ,17 and 23 to 29 tags of threads

Ⓒ Plug shunt (front view) connection side

Shunt between 9 and 11 and shunt between 23 and 24

Ⓓ Cells connection example

XUJ, XUM and OMR 1 PA 400 W 3 types.

INPUTS / OUTPUTS CARD
(feeder, ironer, folder with transfer table)

32006382

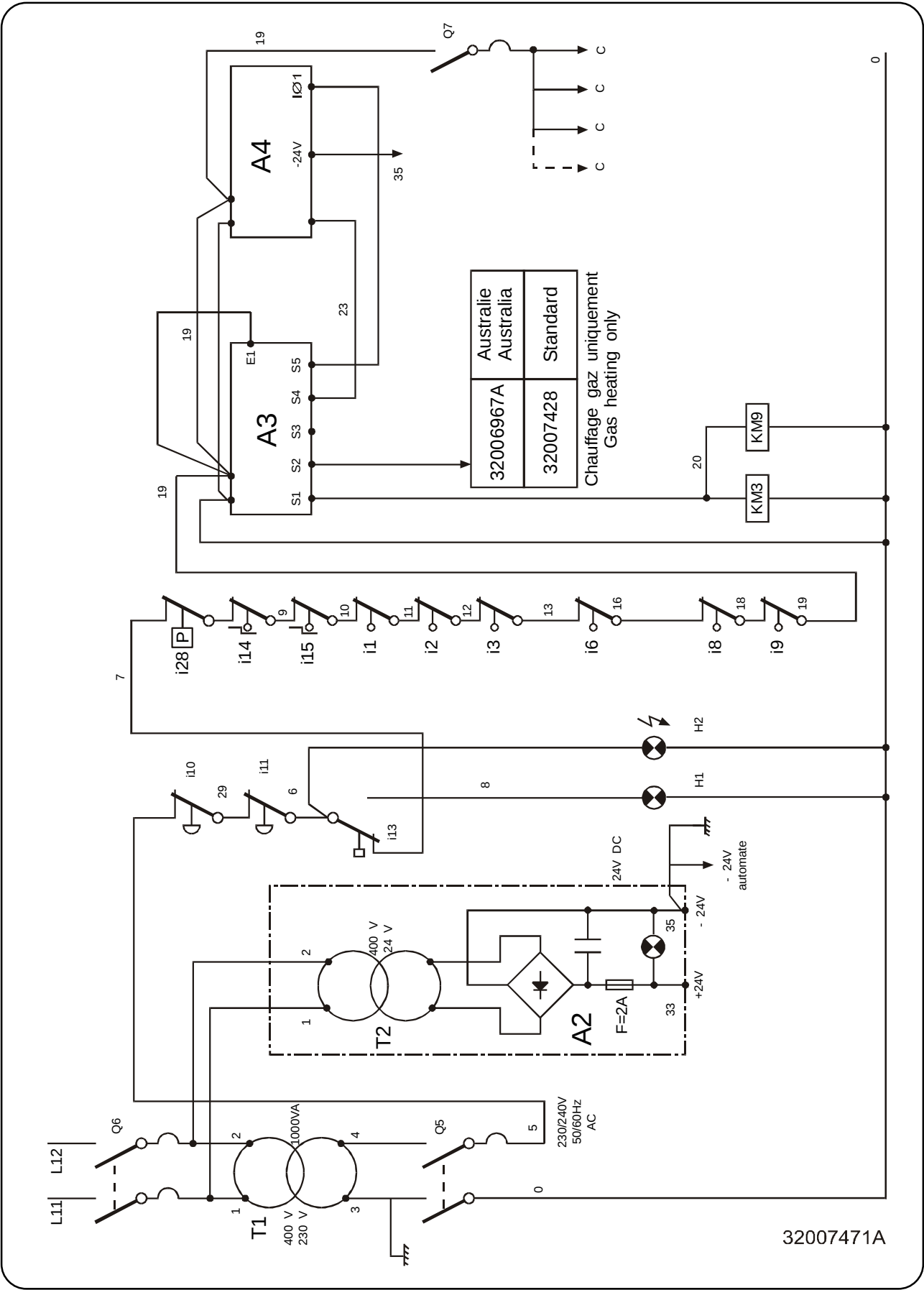
A1	Frequency converter
A3	Programmer / synoptic
P1	Temperature adjustment potentiometer (do not touch)
P2	Temperature adjustment potentiometer (do not touch)
P3	Maximum speed adjustment potentiometer
P4	Minimum speed adjustment potentiometer
R4	Temperature adjustment PT100 probe
i29	Speed display detector
KM3	Fan motor contactor
KM9	Motion motor contactor
S1	Fan control output
S2	Adjusted heating control output
S3	Direct heating control output
S4 and S5	Outputs for automate control with or without folding
E2	Ignitor indicator input
E3	Ignitor indicator input
E4	Ignitor indicator input
E7	Temperature probe input
E8	Temperature probe input

Synoptic led assignment

led 6.2	Ironing output
led 6.3	Front folding
led 6.4	Rear folding
led 6.5	Rear evacuation
led 6.6	First fold
led 6.7	Second fold
led 6.8	Third fold
led 6.9	Folding output
led 6.10	Stacker
led 6.11	Completed pile

PNEUMATIC DIAGRAM
(ironer, folder and stacker)
32007459

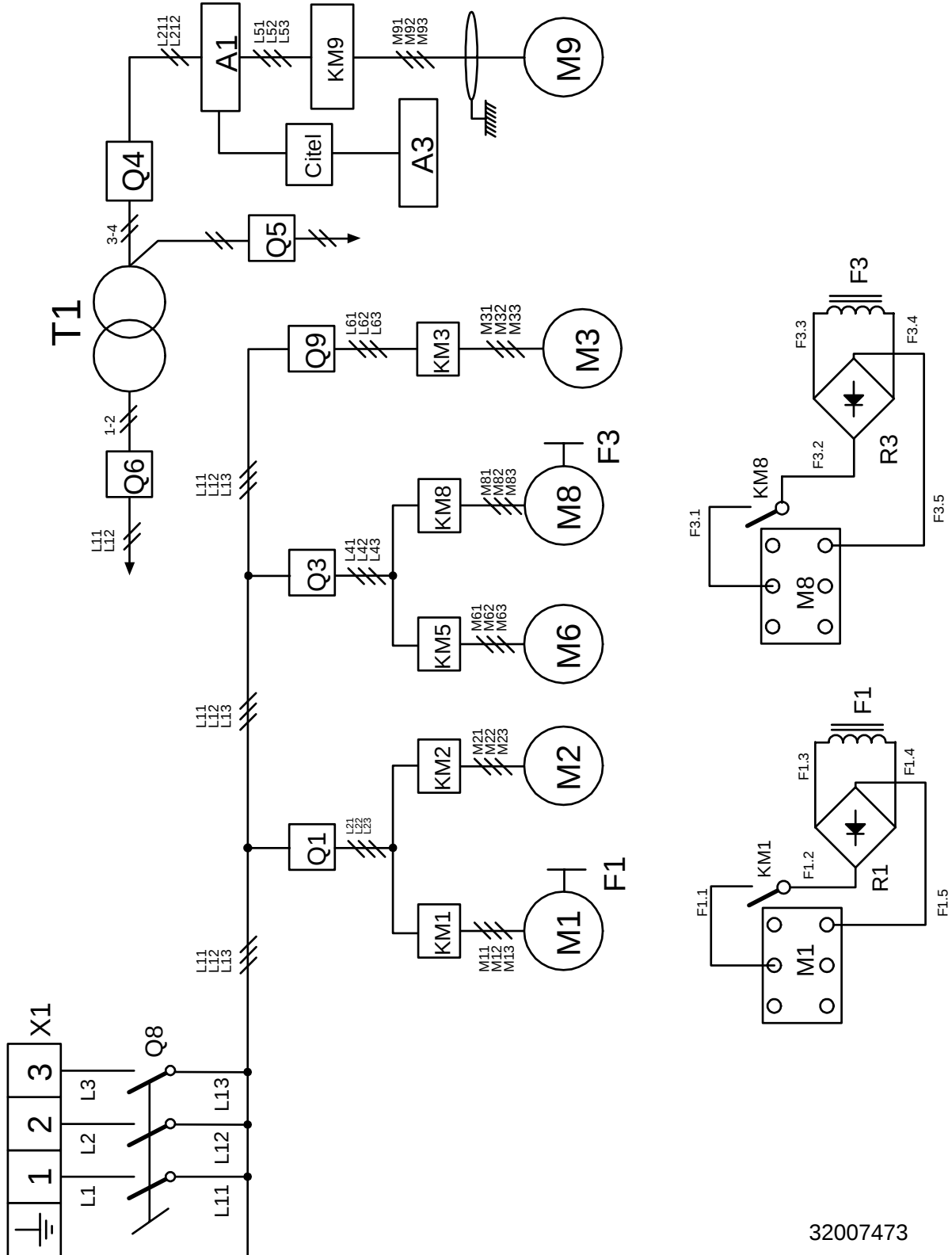
A	Compressed air supply 8 bar maxi
CP	Air shortage pressostat
FR	Regulating filter 5 microns (adjustment 5 bar)
VAB	Vat joint jack
VRP	Pressure roller lift jack
RSAR	Rear blowing burner supply
RSAB	Front blowing burner supply
RD	Flow reducer
R	Adjusting valve
Y1 to Y13	Distributor
D	Pressure reducing valve 2/3 bar
M	Manometer
VPT1	First fold cross-folding jack
VPT2	Second fold cross-folding jack
VPT3	Third fold cross-folding jack
EMP	Stacker
VEE	Sheet stacking jack



CONTROL CIRCUIT (ironer, folder and stacker)

32007471A

T1	Isolating transformer 1000 VA	
T2	Distribution circuit transformer 24 V	] same part
A2	Distribution circuit rectifier 24 V DC	
A3	Programmer/block diagram	
A4	Programmable automate	
H1	Air shortage indicator	
H2	Stacker indicator	
Q5	Two-pole breaker ph + N 2A secondary	
Q6	Two-pole breaker 2 A primary	
Q7	Two-pole breaker 2 A (common outputs)	
i1	Thermal contact stacker table motor	
i2	Thermal contact pile evacuation motor	
i3	Thermal contact fan motor	
i6	Thermal contact cross-folding motor	
i8	Thermal contact rear evacuation motor	
i9	Thermal contact motion motor	
i10	Ironer emergency stop	
i11	Stacker emergency stop	
i13	Air shortage pressostat	
i14	Finger protection right flap position switch	
i15	Finger protection left flap position switch	
i28	Gas pressure switch (optional or Australia machine) (for gas heating machine only)	
KM3	Fan contactor	
KM9	Motion contactor	

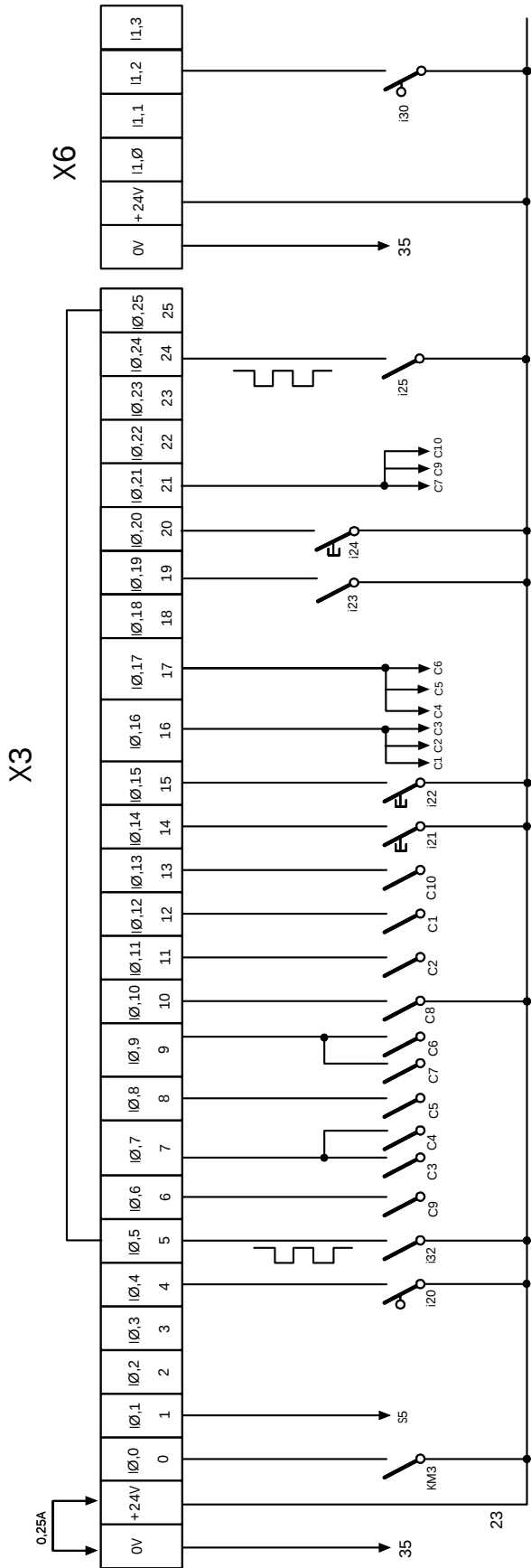


32007473

POWER CIRCUIT (ironer, folder and stacker)

32006378

X1	General supply terminal
Q1	Three-pole motor breaker
Q3	Three-pole motor breaker
Q4	Two-pole breaker 4 A
Q5	Two-pole breaker ph + N 2A
Q6	Two-pole breaker 6 A
Q8	General switch
Q9	Three-pole breaker 6.3 A
T1	Isolating transformer 1000 VA
A1	Motion frequency converter (ATV16)
A3	Programmer
Citel	Accommodating connection
F1	Stacker table brake
F3	Rear evacuation brake
M1	Stacker table motor
M2	Pile evacuation motor
M3	Fan motor
M6	Cross-folding motor
M8	Rear evacuation motor
M9	Motion motor
KM1	Stacker table motor contactor
KM2	Pile evacuation motor contactor
KM3	Fan motor contactor
KM5	Cross-folding motor contactor
KM8	Rear evacuation motor contactor
KM9	Motion motor contactor
R1	Rectifier for brake F1
R3	Rectifier for brake F3

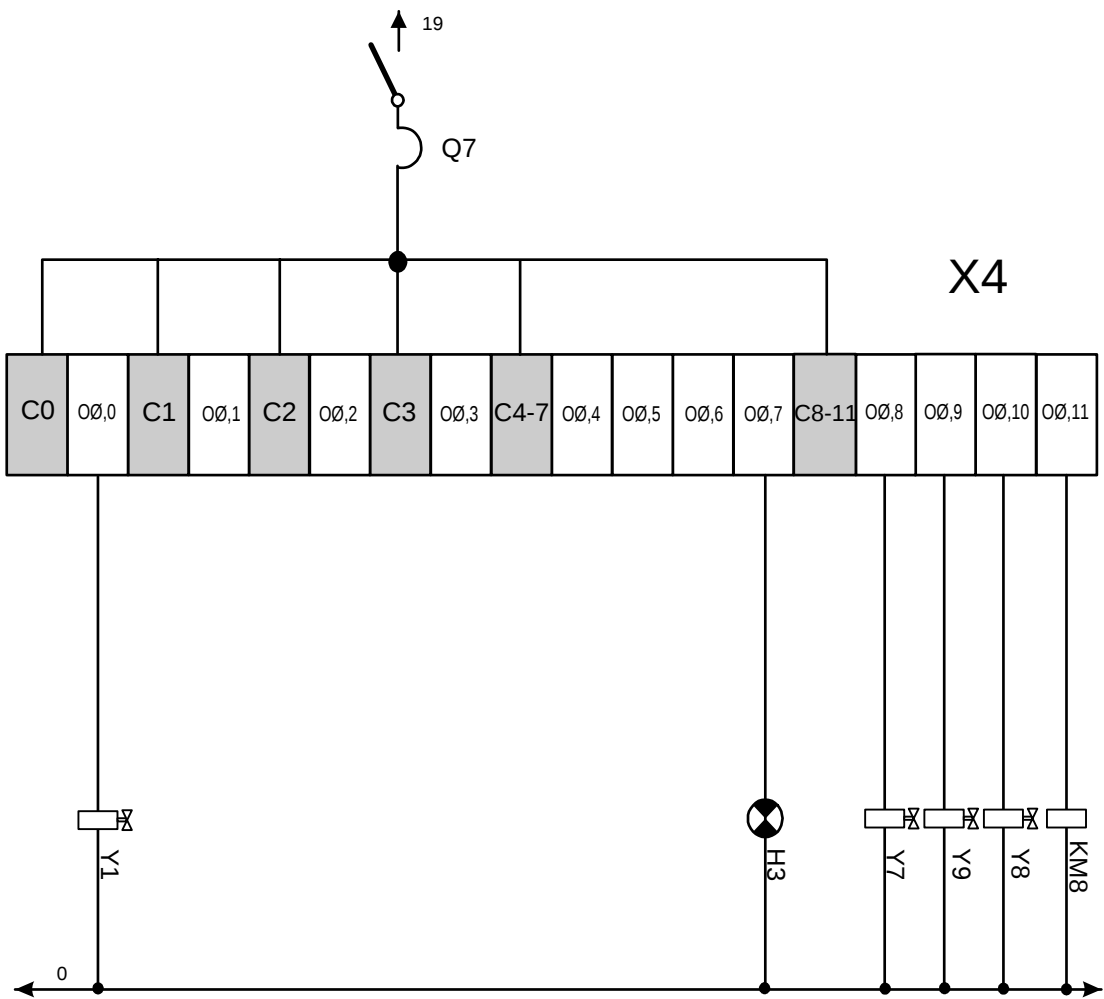


32007470

AUTOMATE INPUTS (ironer, folder and stacker)

32007470

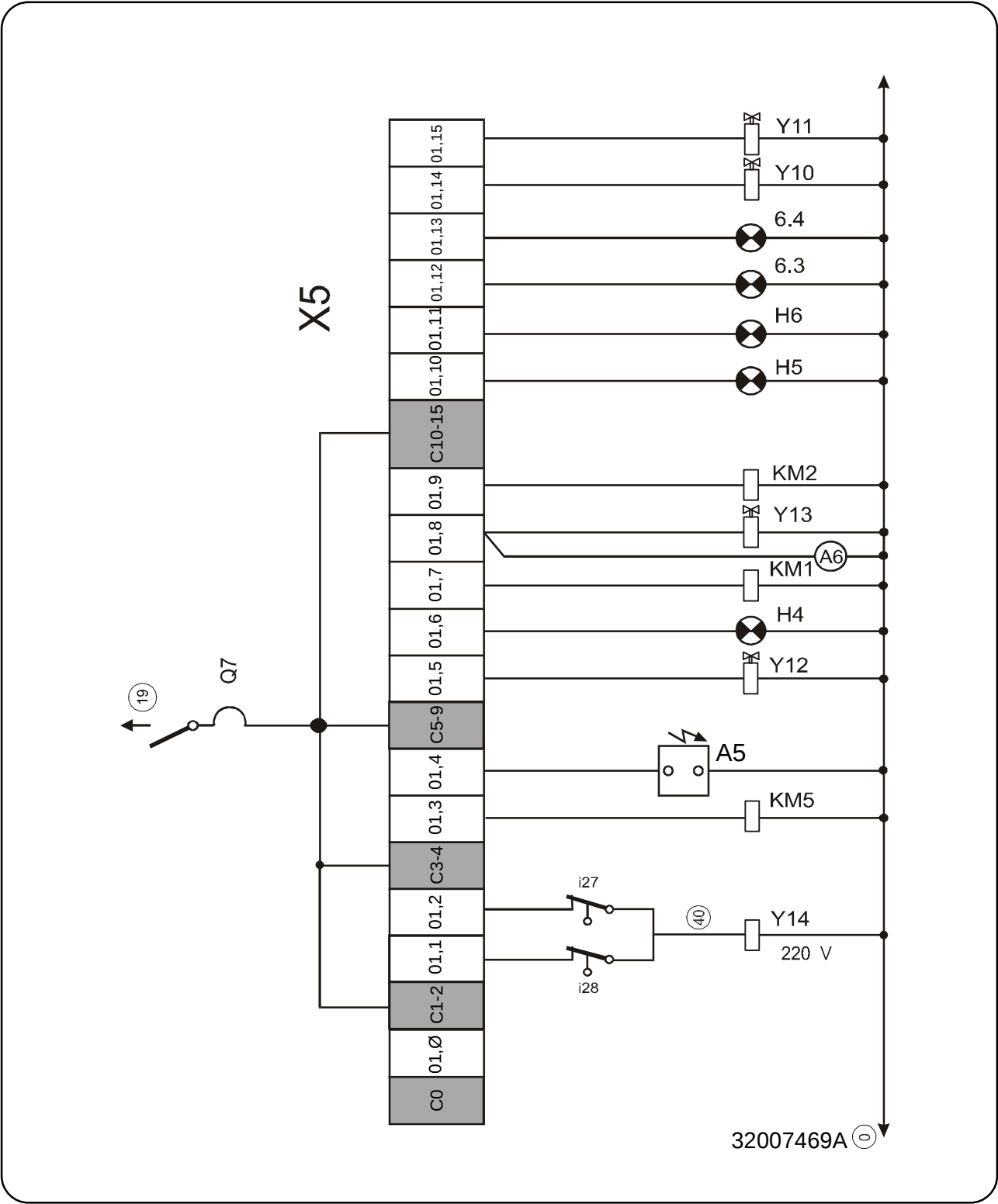
X3	Inputs connection terminal on automate A4
X6	Extension inputs connection terminal
IØ,0	Run / stop
IØ,1	With/without folding
IØ,4	Stacker jack closed flaps sensor
IØ,5	Longitudinal sheet measurement
IØ,6	Sheet at stacker (C9)
IØ,7	Longitudinal folding safety device (C3-C4)
IØ,9	Detector for transversal measurement (C6-C7)
IØ,10	Sheet detection at ironer delivery (C8)
IØ,11	Longitudinal folding (C2)
IØ,12	Sheet at feeding (C1)
IØ,13	Pile completed on stacker (C10)
IØ,14	Pile evacuation push-button
IØ,15	Reclosing/initialization push-button
IØ,16	Dirty cell detection (C1-C2-C3)
IØ,17	Dirty cell detection (C4-C5-C6)
IØ,19	Third fold suppression switch
IØ,20	Rear ejection push-button
IØ,21	Dirty cell detection (C7-C8-C9-C10)
IØ,24	Cross-folding measurement / stacker centering
IØ,25	Longitudinal folding shunted at IØ,5 quick metering input
I1,2	Rear longitudinal arm
C1	Feeding sheet photocell
C2	Longitudinal folding photocell
C3	Longitudinal folding safety device photocell
C4	Longitudinal folding safety device photocell
C5	Cross-folding photocell
C6	Detection for transversal measurement photocell
C7	Detection for transversal measurement photocell
C8	Ironer delivery detection photocell
C9	Sheet detection on stacker photocell
C10	Pile completed on stacker photocell
KM3	Fan contactor
i20	Stacker jack position switch
i21	Pile evacuation push-button
i22	Reclosing initialization push-button
i23	Switch without folding / without third fold] 3 positions
i24	Rear ejection push-button
i25	Cross-folding measurement inductive detector
i30	Rear longitudinal arm position switch
i32	Longitudinal folding measurement inductive detector



AUTOMATE OUTPUTS
(ironer, folder and stacker)

32007472

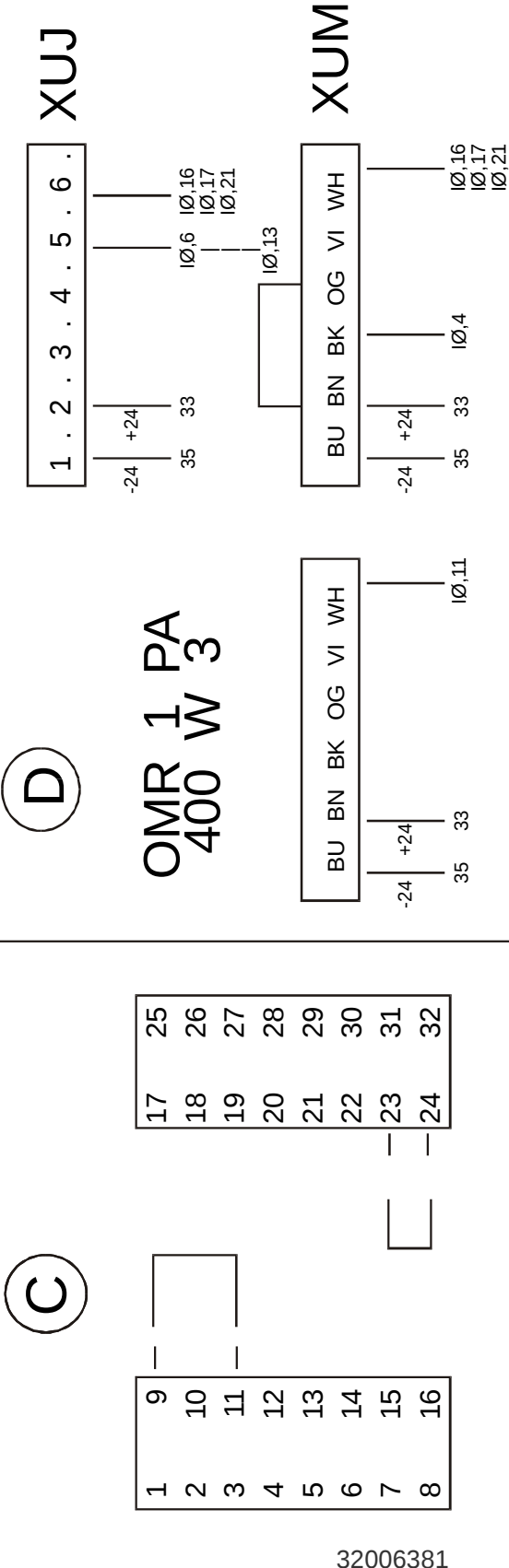
X4	Outputs on automate A4 connection terminal
Q7	Two-pole breaker 2 A (common outputs)
OØ,0	Vat without folding
Y1	Vat without folding pneumatic distributor
OØ,7	Rear evacuation indicator (led 6-3)
H3	Sheet evacuation indicator
OØ,8	Front blow
Y7	Front blow pneumatic distributor
OØ,9	1st fold blade lowering (led 6-6)
Y9	First fold blade lowering pneumatic distributor
OØ,10	Rear blow
Y8	Rear blow pneumatic distributor
OØ,11	Sheet evacuation
KM8	Rear evacuation motor contactor



AUTOMATE OUTPUTS (continued) (ironer, folder and stacker)

32007469A

X5	Connection terminal on outputs extension
Q7	Two-pole breaker 2 A (common outputs)
O1,1	Front longitudinal folding arm
i 28	Rear folding position switch
O1,2	Rear longitudinal folding arm
i 27	Front folding position switch
Y14	Longitudinal folding arm clutch (clutch/brake, 2 stops/turn).
O1,3	Drive of transversal bands
KM5	Cross-folding motor contactor
A5	Control box for antistatic bar
O1,5	Third cross-folding blade folding (led 6-8)
Y12	Third fold blade folding pneumatic distributor
O1,6	Safety positive device indicator
H4	Safety positive device indicator
O1,7	Stacker table bands "ON"
KM1	Table motor contactor
O1,8	Stacker table opening (led 6-11)
A6	Stacker meter
Y13	Stacker table opening pneumatic distributor
O1,9	Pile evacuation
KM2	Pile evacuation motor contactor
O1,10	Completed pile indicator
H5	Completed pile indicator
O1,11	Dirty cell
H6	Dirty cell indicator
O1,12	Front longitudinal folding led (6-3)
O1,13	Rear longitudinal folding led (6-4)
O1,14	Roller lifting
Y10	Roller lifting pneumatic distributor
O1,15	Second cross-folding blade folding (led 6-7)
Y11	Second fold blade folding pneumatic distributor



(ironer, folder and stacker)

32006381

Ⓐ Plug on stacker (front view) connection side

1 to 16 and 17 to 32 tags on plug
M11 to IØ,17 and 23 to 29 tags of threads

Ⓑ Socket on ironer (front view) connection side

1 to 16 and 17 to 32 tags on socket
M11 to IØ,17 and 23 to 29 tags of threads

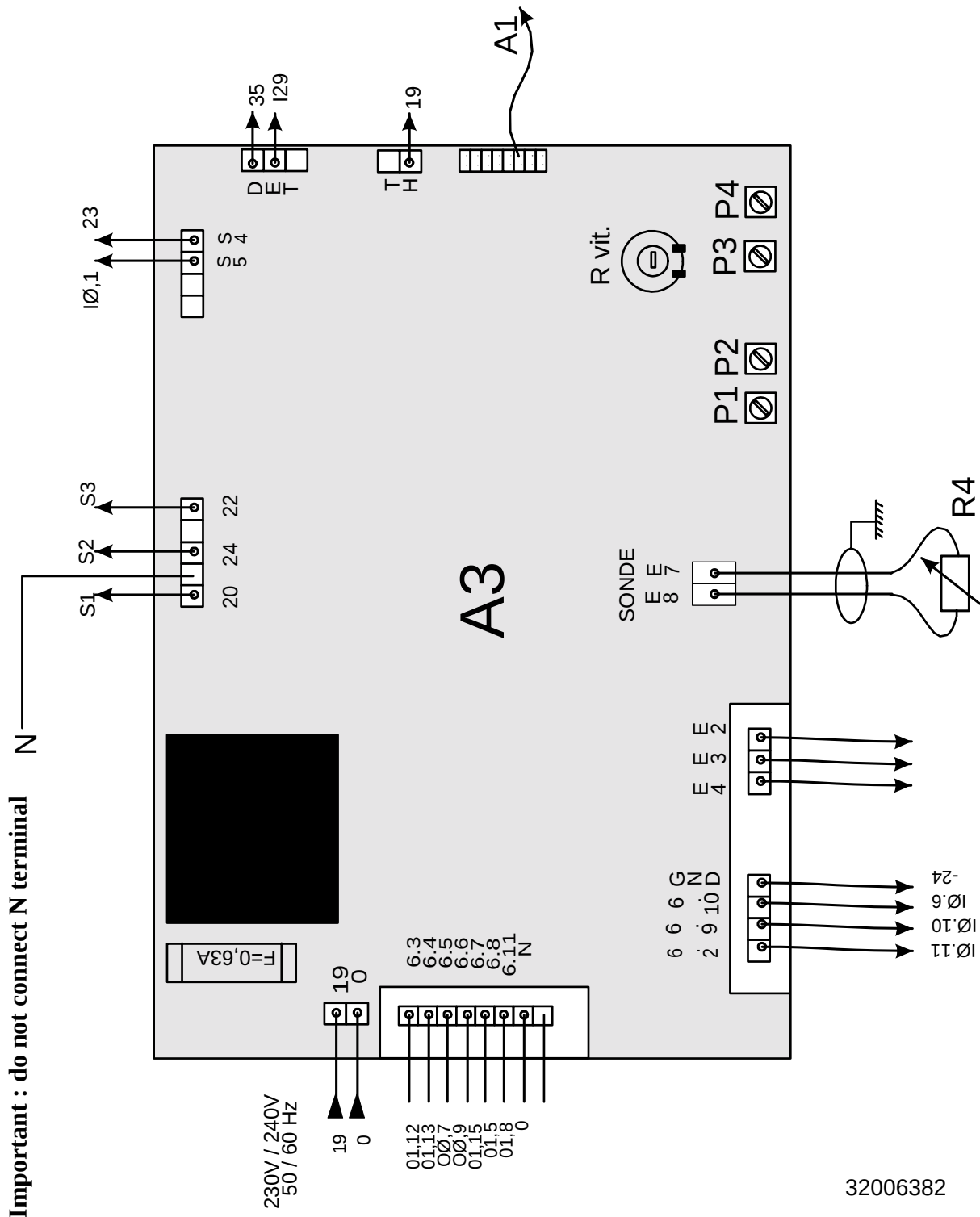
Ⓒ Plug shunt (front view) connection side

Shunt between 9 and 11 and shunt between 23 and 24

Ⓓ Cells connection example

XUJ, XUM and OMR 1 PA 400 W 3 types.

Important : do not connect N terminal



32006382

INPUTS / OUTPUTS CARD (ironer, folder and stacker)

32006382

A1	Frequency converter
A3	Programmer / synoptic
P1	Temperature adjustment potentiometer (do not touch)
P2	Temperature adjustment potentiometer (do not touch)
P3	Maximum speed adjustment potentiometer
P4	Minimum speed adjustment potentiometer
R4	Temperature adjustment PT100 probe
i29	Speed display detector
KM3	Fan motor contactor
KM9	Motion motor contactor
S1	Fan control output
S2	Adjusted heating control output
S3	Direct heating control output
S4 and S5	Outputs for automate control with or without folding
E2	Ignitor indicator input
E3	Ignitor indicator input
E4	Ignitor indicator input
E7	Temperature probe input
E8	Temperature probe input

Synoptic led assignment

led 6.2	Ironing output
led 6.3	Front folding
led 6.4	Rear folding
led 6.5	Rear evacuation
led 6.6	First fold
led 6.7	Second fold
led 6.8	Third fold
led 6.9	Folding output
led 6.10	Stacker
led 6.11	Completed pile

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MOTORS INTENSITY

M1 **Stacker** table motor : 0.37 kW

M2 **Stacker** piles evacuation motor : 0.37 kW

Nominal intensity : triangle 4.5 A
 star 2.6 A

M3 Fan motor **ironer** : 0.30 kW

M4 Smoothing right motor **ironer** : 0.18 kW

M5 Smoothing left motor **ironer** : 0.18 kW

Nominal intensity : triangle 4.4 A
 star 2.5 A

M6 Cross-folding motor **ironer** : 0.37 kW

M7 Longitudinal folding motor **ironer** : 0.37 kW

M8 Rear evacuation motor **ironer** : 0.25 kW

Nominal intensity : triangle 6.6 A
 star 3.9 A

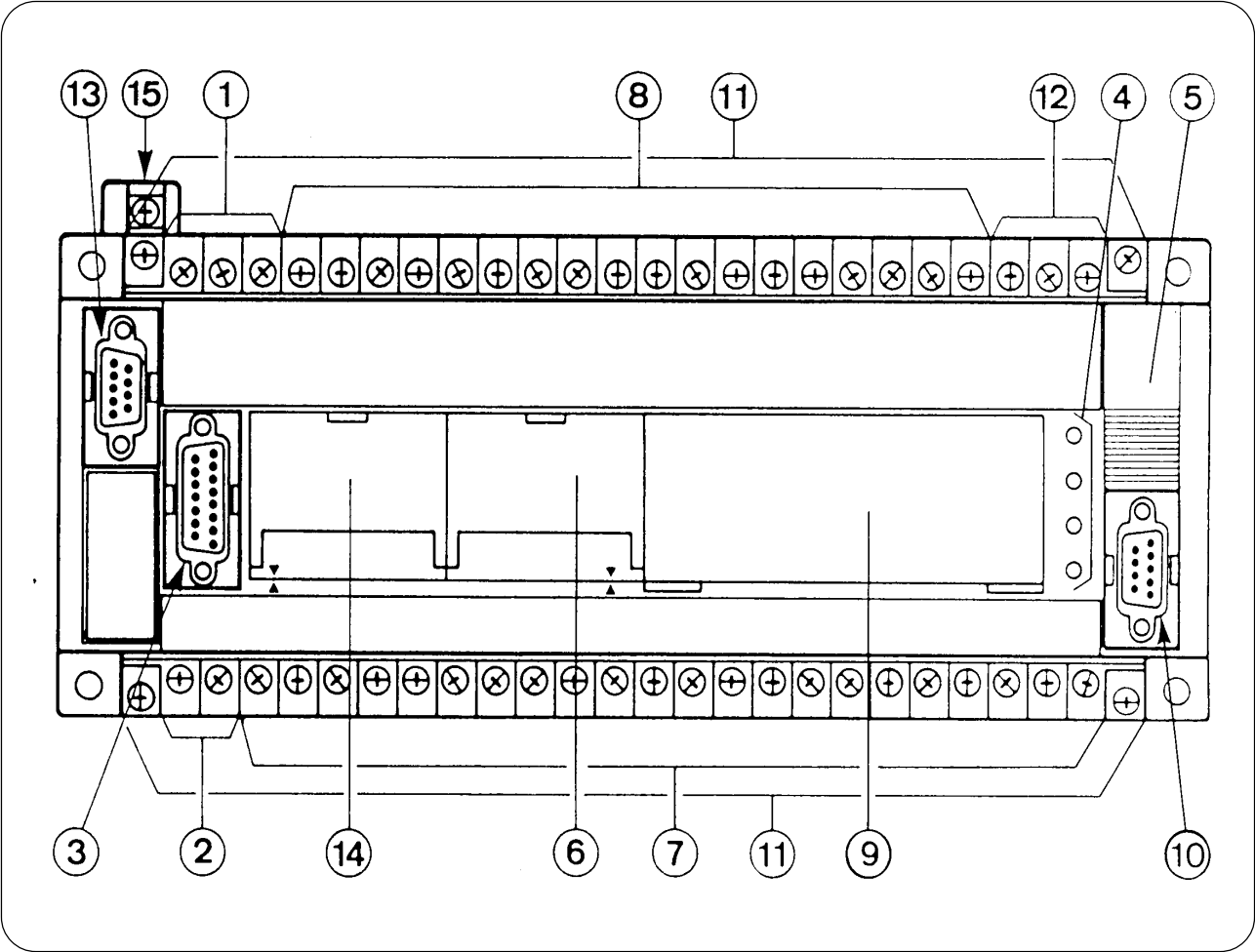
M9 Ironer motion motor : 0.37 kW

Nominal intensity : 3 A (with 132 V)

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D0079



MICRO AUTOMATE TSX 17

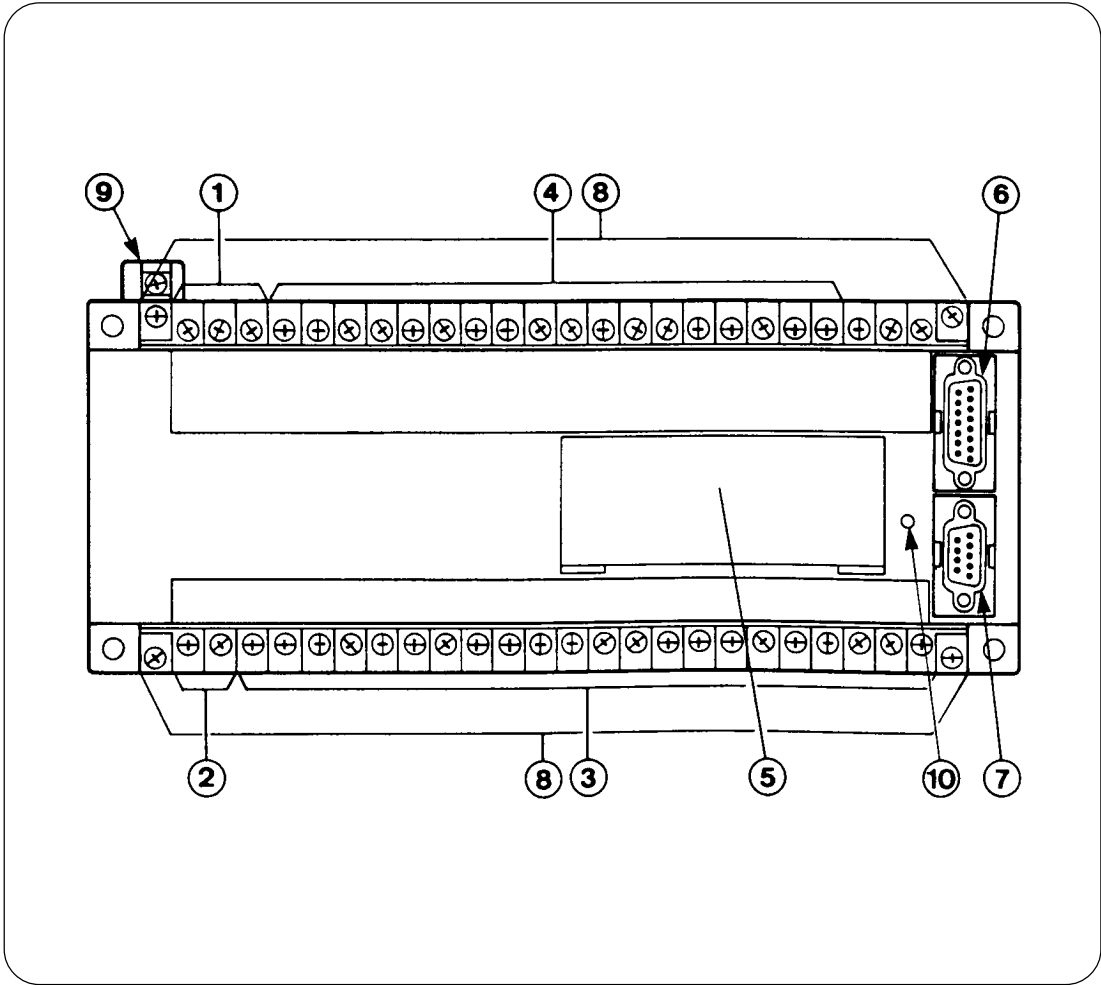
Description of micro automate TSX 17

TSX 172 3428 type.

This micro automate includes :

- A power supply (1) of 10 to 240 VCA delivering a supply (2) of 24 VCC, 250 mA, meant to the sensors 24 VCC connected to TSX 17.
- A central unit with terminal plug (3) and display of its condition (4).
- A place (5) for a cell in order to save the programmes stored. TSX 17 is not equipped with a cell because the memory used on your machine cannot be deleted but with UV rays.
- A place (6) for the EPROM type cartridge.
- 22 inputs (7) deliver a supply in 24 isolate VCC.
- 12 inputs (8) to feed the relays of the machine.
- An indicator (9) displays the inputs/outputs with leds.
- A 9 points connector (10) for the inputs/outputs bus extensions.
- 2 disconnectable terminals (11) with protected screws.
- 2 fast inputs (12) (24 VCC).
- A connector (13) for the connection of the inputs of counting and resetting operations of the counter/quick sucker.
- A place (14) for the PL7-2 micro software cartridge. This cartridge is compulsory to access to the language of the PL7-2 software when a technician connects a console table to TSX 17.
- An earth terminal (15) for the earthing of the micro automate.

D0266



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TSX DMF 242A OUTPUT MODULE

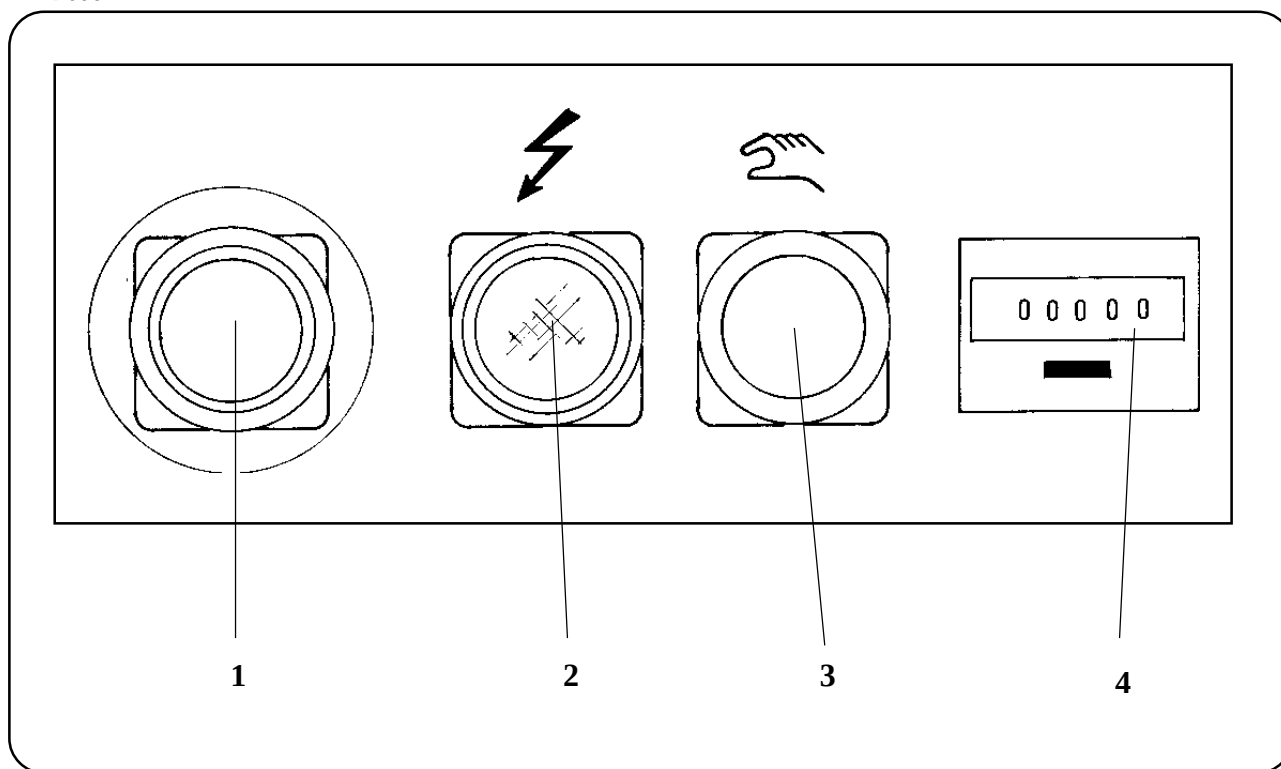
It includes :

- a power supply (1) of 110 to 240 VCA delivering a sensors supply (2) VCC, 250 mA.
- 24 inputs/outputs all or nothing displayed in the front (5)
 - 8 inputs (3) 24 VCC isolated,
 - 16 outputs (4) with relays,
- a display (10) of bus faulty linkage or extention block,
- a 15 points connector (6) for inputs/outputs bus extension admission,
- a 9 points connector (7) for inputs/outputs bus extension outgoing,
- 2 disconnectable terminals (8) with protected screws,
- a terminal (9) for the earthing.

STACKER CONTROL PANEL

- 1 Emergency stop push-button
- 2 Voltage indicator
- 3 Pile evacuation push-button
- 4 Sheet counter with resetting device

D0067



UTILIZATION

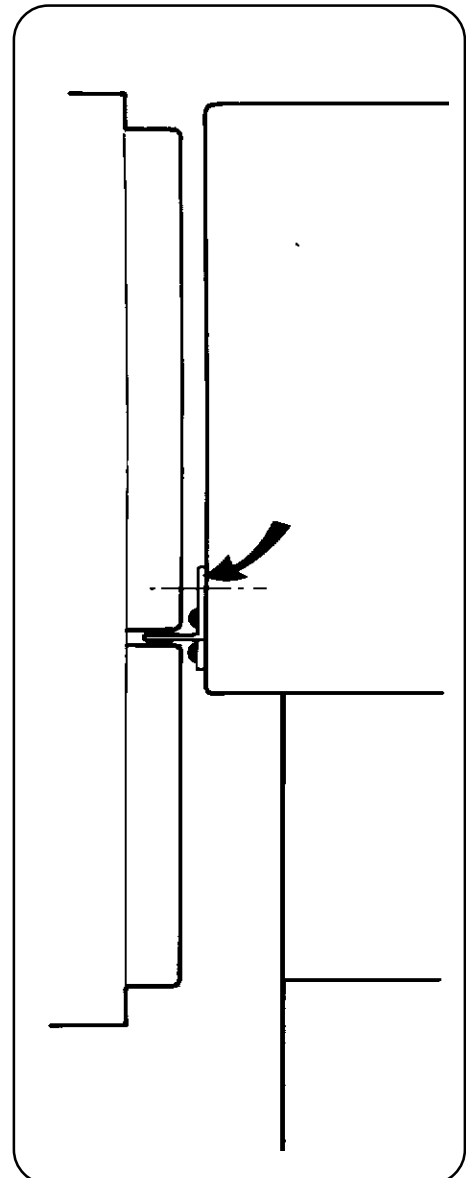
Present the stacker on the right side of the ironer and centre it with the centering finger on the opening of the machine (diagram D0071).

Set the stacker in position with the blocking bolsters.

Connect the compressed air supply pipe.

Connect the supply and control plug of the stacker.

D0071

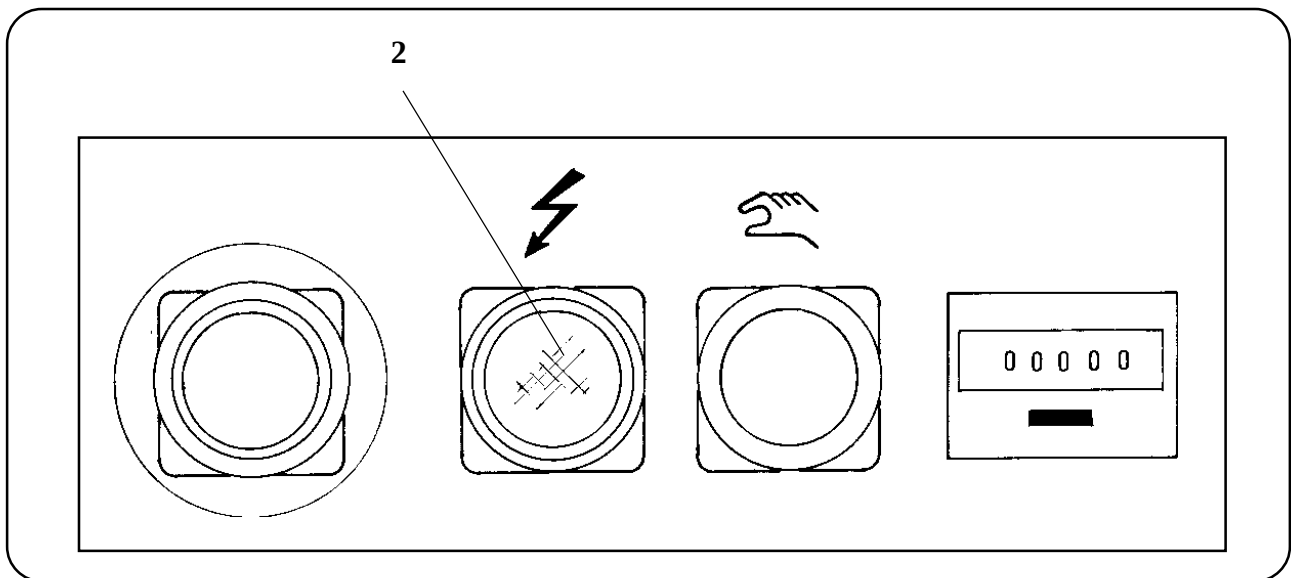


NB : the ironer will not work if the supply plug of the stacker is not connected.

If the ironer is used without the stacker, it is absolutely necessary to connect the special plug (without threads) provided with the machine.

When the ironer is being charged, the indicator (2) "UNDER VOLTAGE" of the stacker is lit.

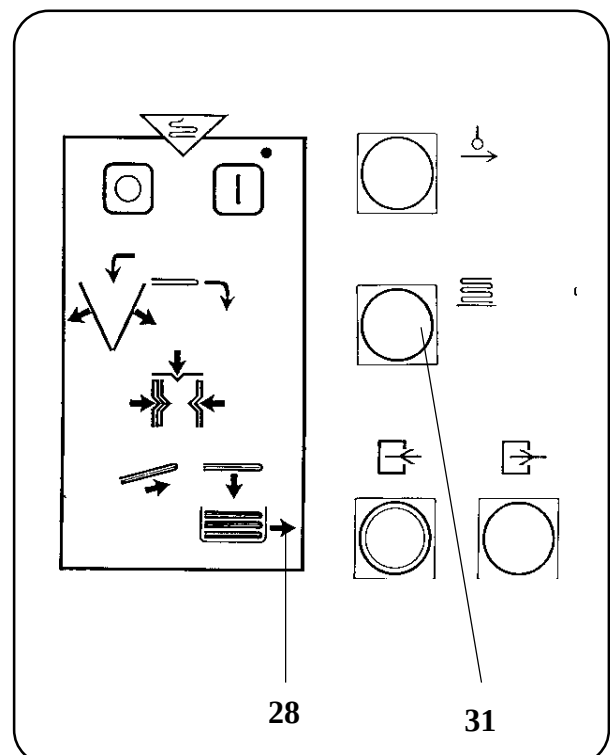
D0067



D0070

When a pile of linen is completed (height 210 mm approximately) on the stacker plate, it is then evacuated on the evacuation table.

The indicators (28-31) on the control panel of the ironer signal during 30 seconds to warn that a pile is completed.



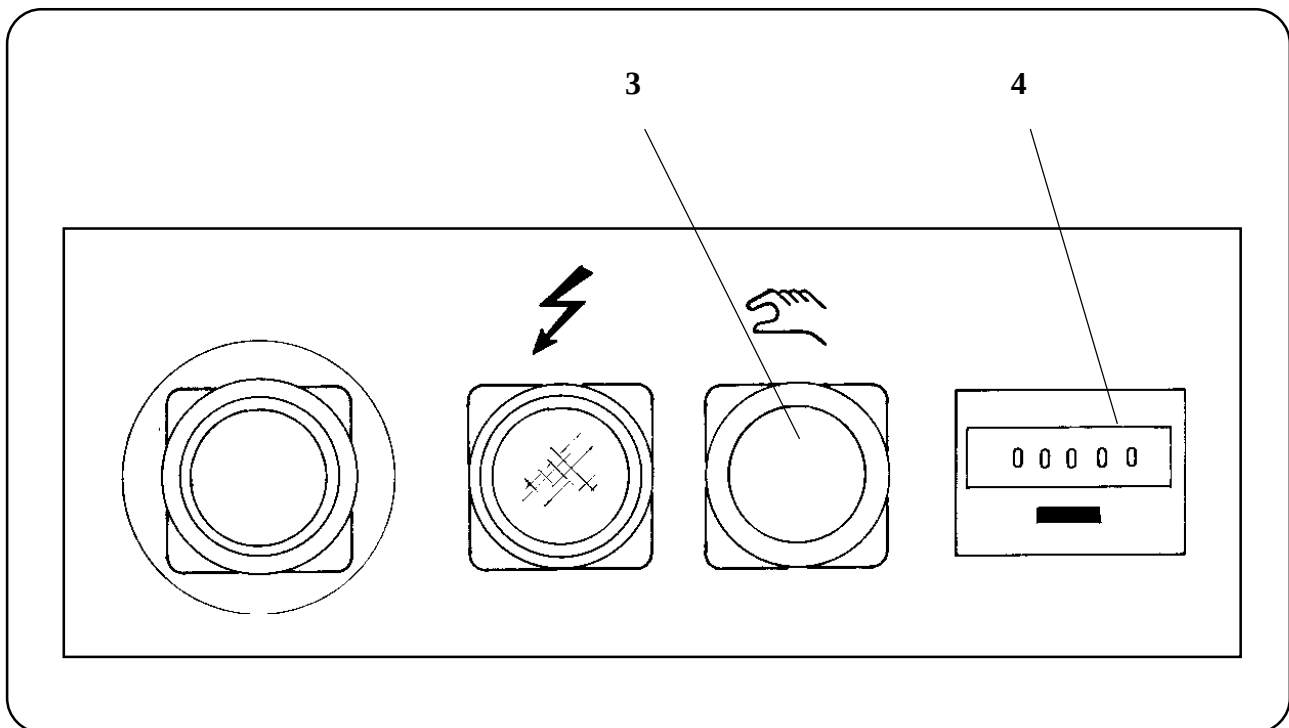
NB : the evacuation table of the stacker can contain 2 completed piles and another one being completed on the plate of the stacker.

It is necessary to evacuate the piles as soon as they arrive on the evacuation ramp.

A push-button (3) makes it possible to evacuate the pile(s) of linen manually.

A sheet counter (4) with resetting device makes it possible to count the ironed items during a given time.

D0067



MAINTENANCE

Clean the detection cells daily.

SAFETY

The sheets the folded length of which is above 55 cm are evacuated on the right side of the stacker to avoid obstruction.



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