

FOAM HOT STAMP
PRESS MACHINE

USER MANUAL



CE
CERTIFIED

**ABSOLUTELY
READ BEFORE**
USING THE MACHINE

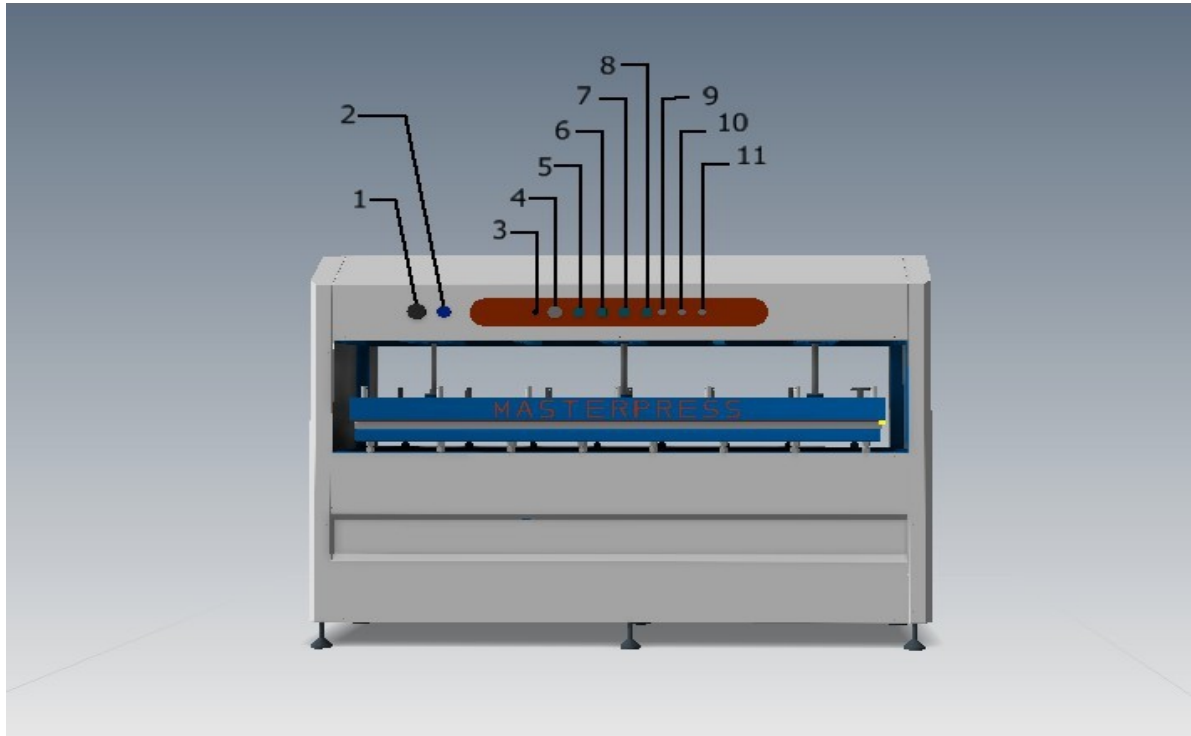


SAFETY INSTRUCTIONS

Before using the machine,
Operator should **read** the following precautions and recommendations

1. Read and understand the operation manual and all safety labels before operating this machine.
2. This product should only be used for the purpose and manner for which it was designed.
3. Protect the press machine from liquid contact to reduce the risk of electric shock.
4. When an electrical problem is accured, first power off the machine.
5. Avoid contact directly to hot surfaces.
This may cause severe burns and injuries.
6. Never use the machine for other materials than Eps and Xps foams.
7. Do not allow anyone to use the machine except as authorized user.
8. Use separate cable and fuse for Hot Press to reduce overload of the same electrical wiring.
9. Pressing of the product on the hot press machine for a long time may cause fire.
10. Before pressing, check that there are no extraneous matter on the surface to be pressed.
11. **ABSOLUTELY Never control the mold temperature by hand!!**
12. In case of malfunction of the machine, please contact the company authorities first.

CONTENT SCHEME



1. Pressure indicator
2. Pressure Regulator
3. Emergency stop button
4. S1 (Start 1) Button
5. 1st Zone Heat Control Device
6. 2nd Zone Heat Control Device
7. 3rd Zone Heat Control Device
8. Press Time Timer
9. S2 (Start 2) Button
10. Manual / Automatic selector
11. Fan Manual Opening Selector

SWITCH ON and SWITCH OFF



Main switch , as seen above, switches on/off the main energy of the machine.

1 380 Volt 3 Phases 20 Amper 4*6 mm NYA - NYAF

2 4 - 8 Bar Air Inlet 8 Air Hose

OPERATION OF THE MACHINE

- 1 . Check air and electrical connection
2. Make sure that the mold is properly connected.
3. Adjust the back gauge to the ideal dimension in your pattern.
4. Set the temperature setting to the appropriate set point by the method described in the relevant section.
Appropriate heat may vary depending on weather conditions, material density and pattern pattern.
Average Heat Value: 160 C Celsius Degree.
5. Take the machine to automatic mode.
6. Set the pressing time.. The press time is 5 seconds on average. The time may vary depending on the set temperature and the model.
7. Align the styrofoam as keeping up the the surface that will be pressed.
8. Then press the S1 and S2 buttons simultaneously to start the machine.

The mold goes down and presses during the set time and the press mold will be automatically pulled up at the end of the period.

In general, the styrofoam may adhere to the surface in the first few usages.
When the press continues, the adhesion condition will disappear automatically.

In addition, silicone based mold release agents can be used to prevent styrofoam stick to the surface.

Mold release sprays ;

Best mould release KA-2000

Burtech BRT-250

LOCTITE LB 8021

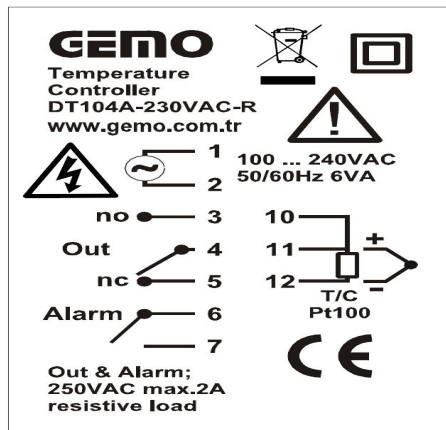


ADJUSTING THE HEAT



Three independent Gemo DT 104 A Series PID controlled heat control devices have been used in Masterpress Jams Pattern Machine.

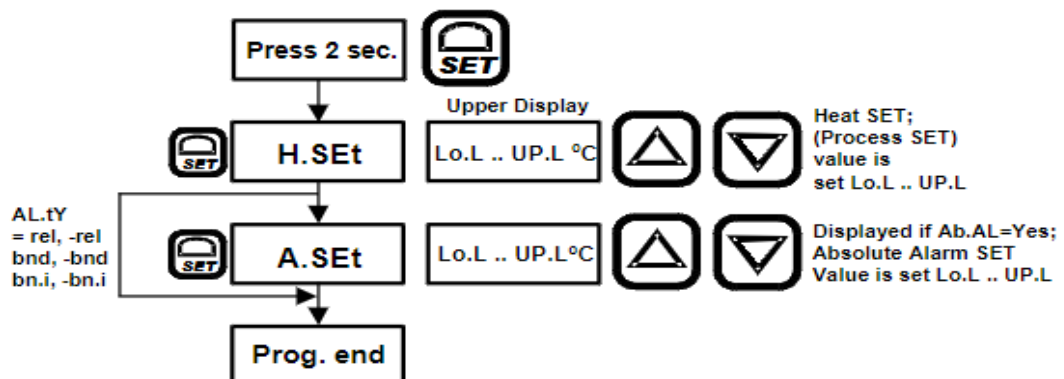
Dimensions	: DT109:96x96, DT107:72x72, DT105/DT106:48x96, DT104:48x48mm
Panel Cut-out	: DT109:91x91, DT107:68x68, DT105/DT106:93,5x45,5, DT104:45,5x45,5mm
Display	: 4 Digits 7 Segment (PV), 4 digits 7 Segment (SV)
Sensor Type	: J,K,T,S,R type T/C, Pt100 selectable
Measuring Scale	: -100 .. 600 °C, J type T/C, (Inpt=J), -100 .. 1300 °C, K type T/C, (Inpt=k) -100 .. 400 °C, T type T/C, (Inpt=t), 0 .. 1750 °C, S type T/C, (Inpt=S) 0 .. 1750 °C, R type T/C, (Inpt=r), -100 .. 600 °C, Pt100, (Inpt=Pt) -99.9 .. 600.0 °C, Pt100, (Inpt=Pt.0)
Resolution	: ± 1 °C or ± 0.1 °C
Accuracy	: ± 0.3 % (Over full scale)
Control Form	: ON-OFF or P, PI, PD, PID - selectable
Out Output	: Relay (NO + NC), 250VAC, 2A, Resistive load, (optional SSR)
Alarm Output	: Relay (NO + NC), 250VAC, 2A, Resistive load, (only NO for DT104)
Heat SET	: Lower Limit .. Upper Limit °C (H.Set)
Alarm SET	: AL.tY = Abs,-Abs; Lo.L .. UP.L °C (A.Set) AL.tY = rel, -rel, bnd, -bnd, bn.i, -bn.i; -100 .. +100 / -10.0 .. +10.0 (Pt.0)



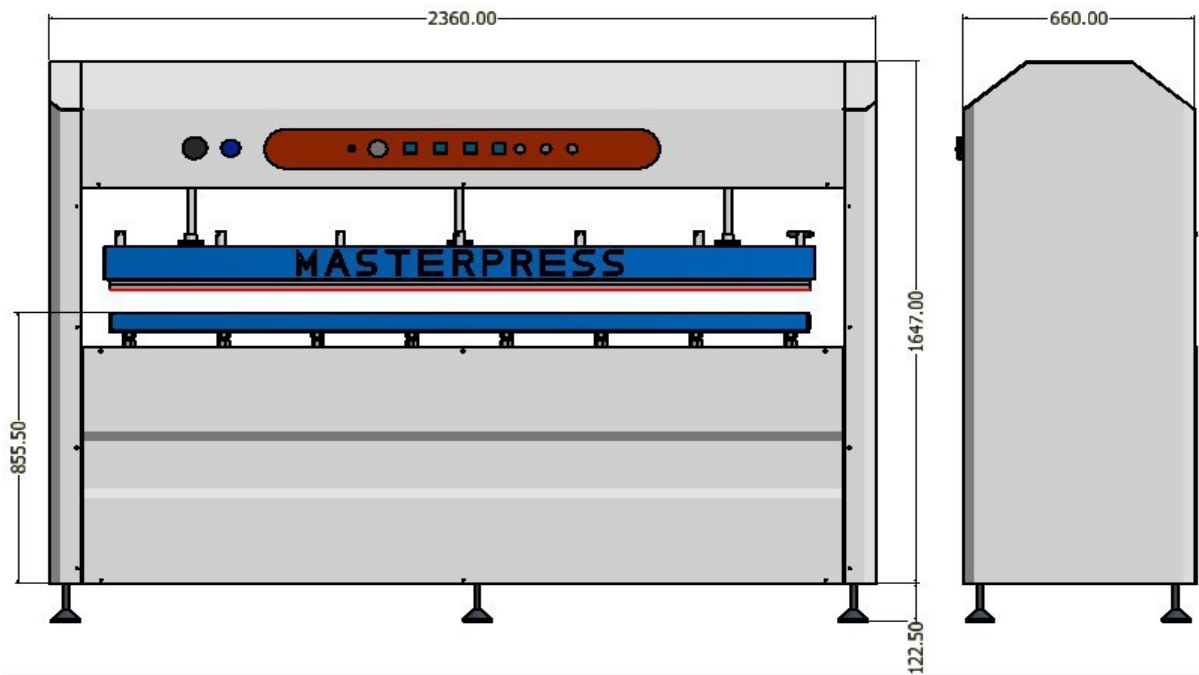
Hold the SET button for 3 seconds to adjust the temperature. At the end of the time, the red PV value in the top row starts to flash. Set the desired value by the up and down key. Then press the SET button again to set the the desired value.

The green values Sv at the bottom show the current temperature value.

PROGRAMMING HEAT SET and ABSOLUTE ALARM SET

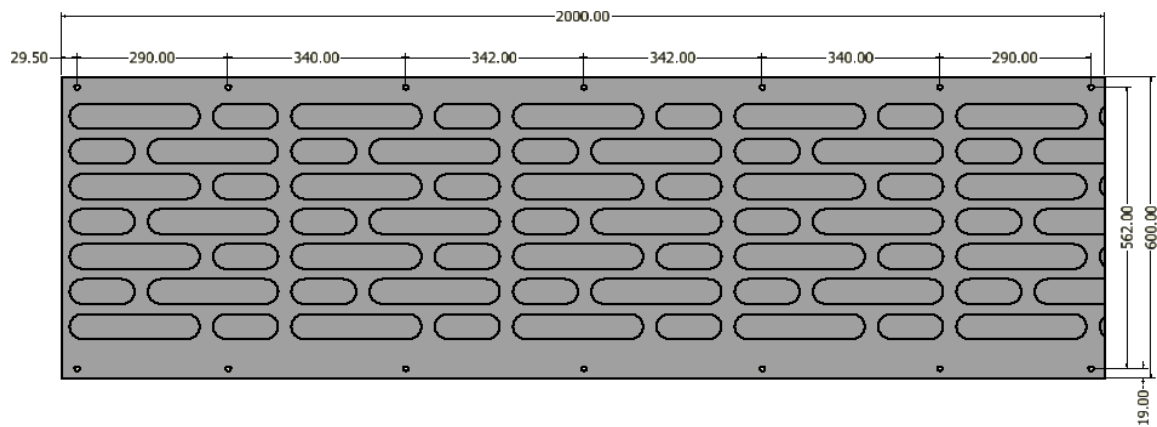


Physical Dimensions and Features

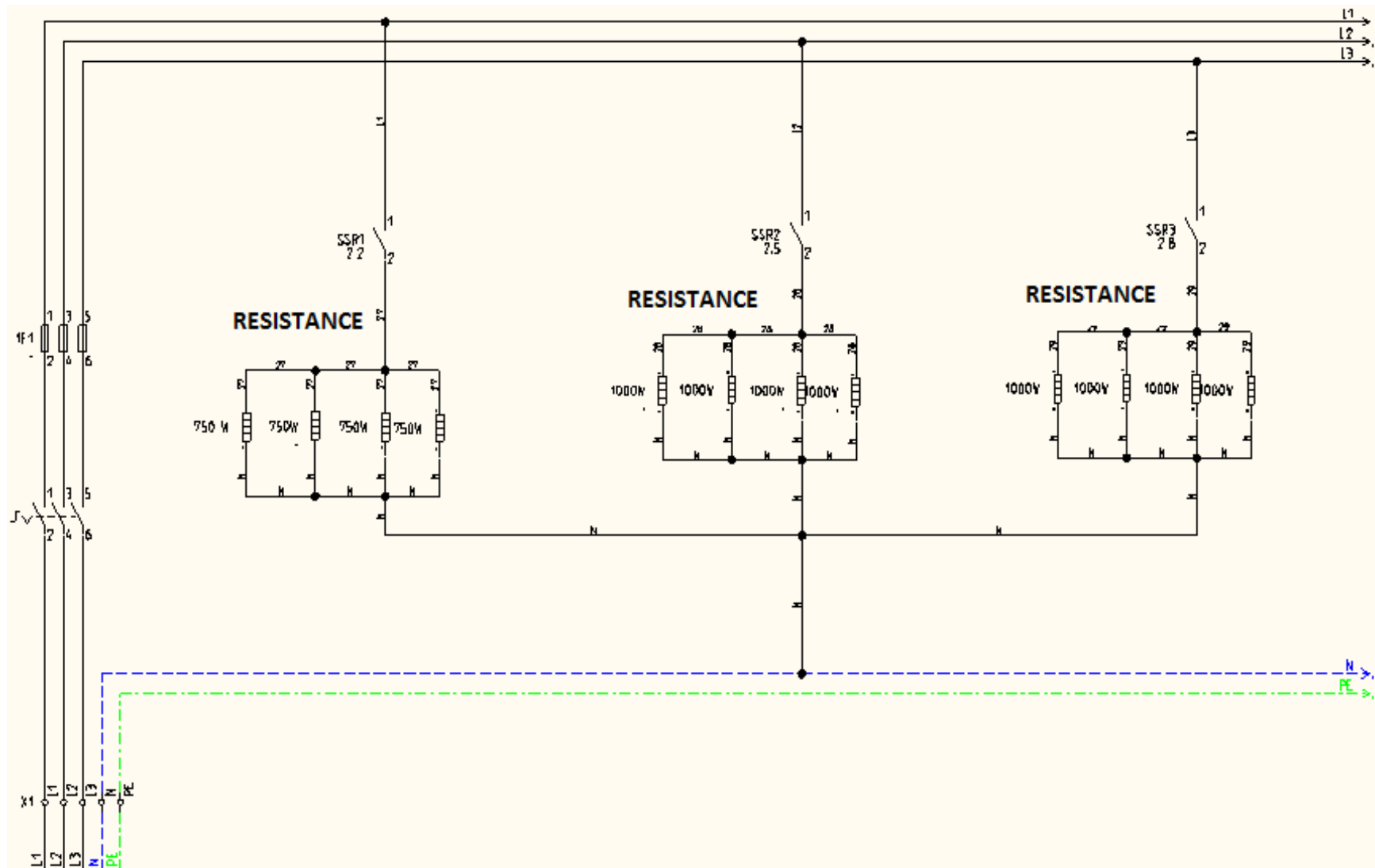


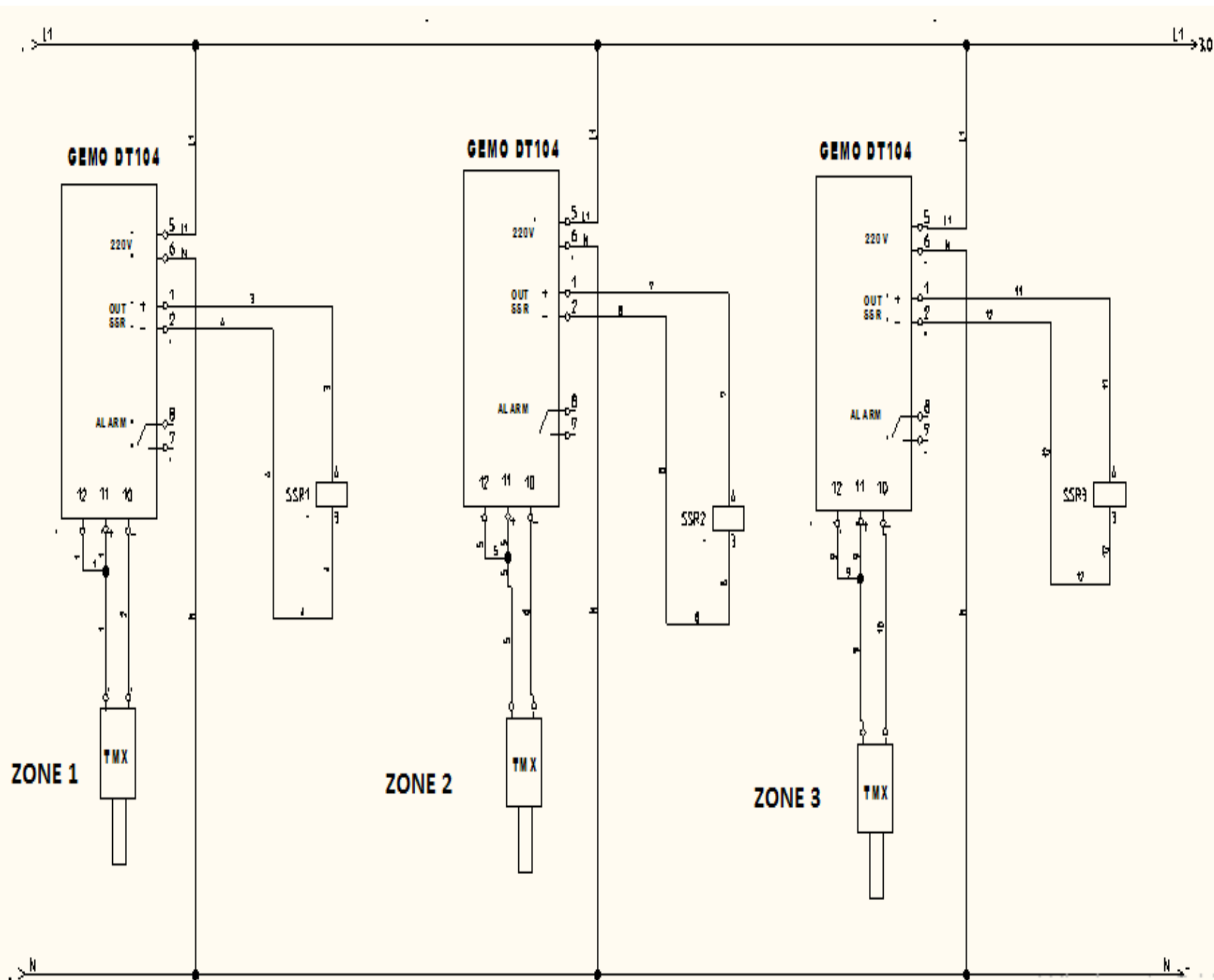
Machine Weight : 650 KG (No Mold)

Mold Dimensions



Electrical Diagram and Features





MAN/AUTO
1-0-2

MAN/AUTO
1-0-2

START E-

START E-

EMERGENCY
STOP

VALP

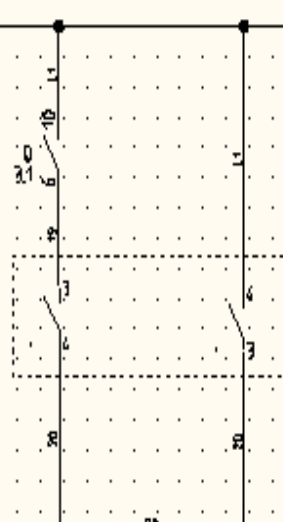
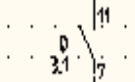
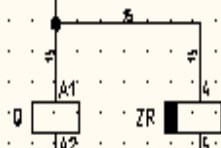
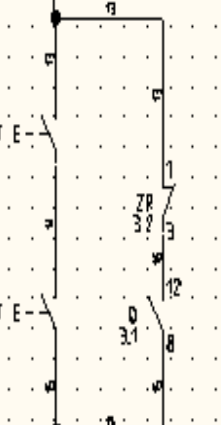
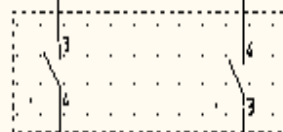
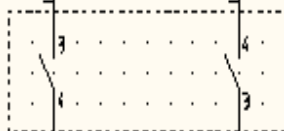
FAN
MAN/AUTO
1-0-2

FAN

2,9 N

L1 → 1,0

→ 1,0





ATTENTION

It is Dangerous to Intervene other than Authorized Persons



ATTENTION

Electrical Voltage causes sudden deaths and serious injuries.

Pac Makina Otomasyon Ltd. Şti.
3. Cadde No:1/N Estim Kısıköy Menderes İZMİR
+90 232 257 64 66
www.pac-cnc.com pacmakina@gmail.com