SCHULZE

Instruction manual

Version 11.01

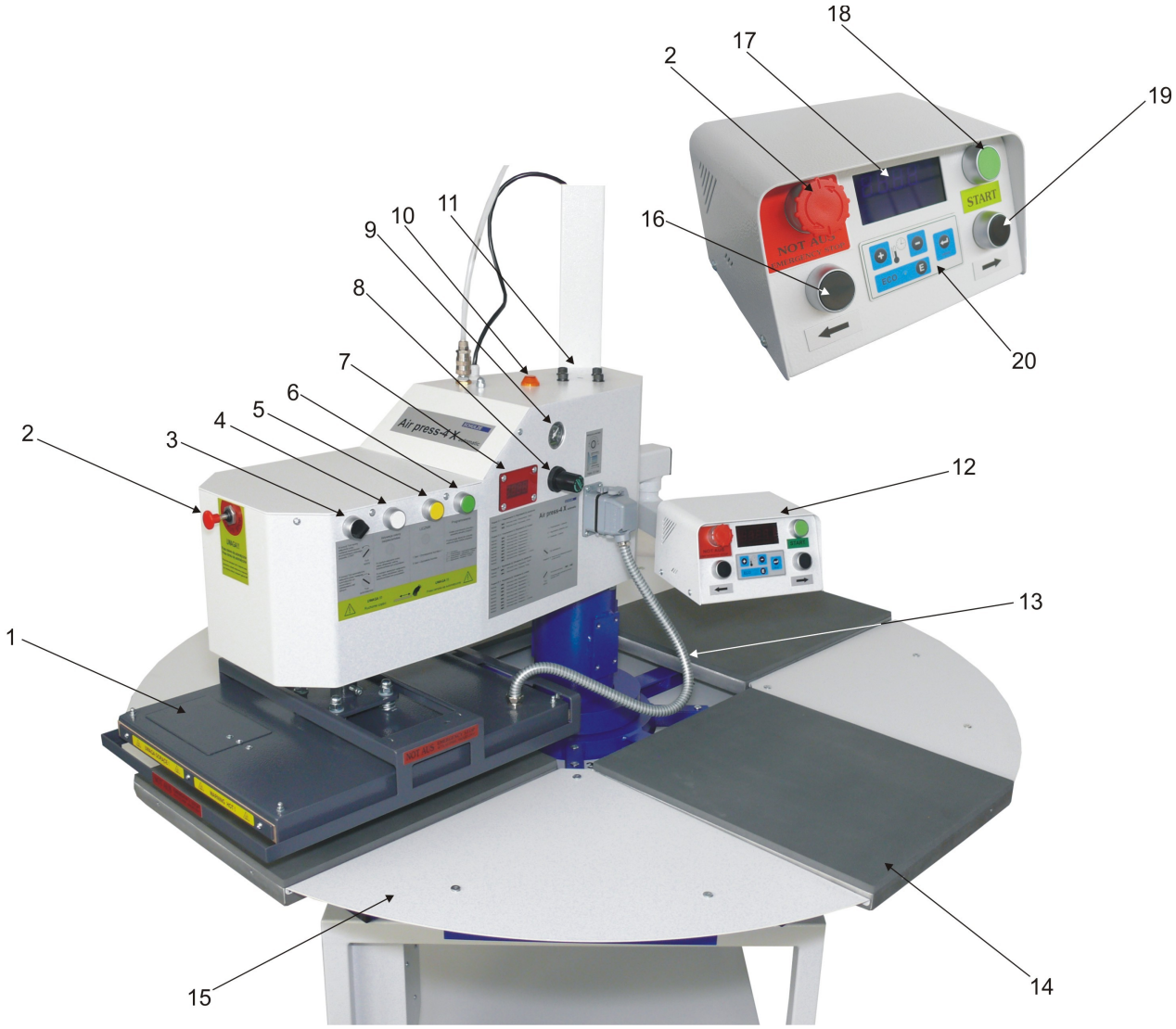
Pneumatic press

Air press-4 X
automatic

1. Introduction

1.1 Content

1.2 Illustration of the heat press



1. Heating plate with safety frame
2. Emergency button
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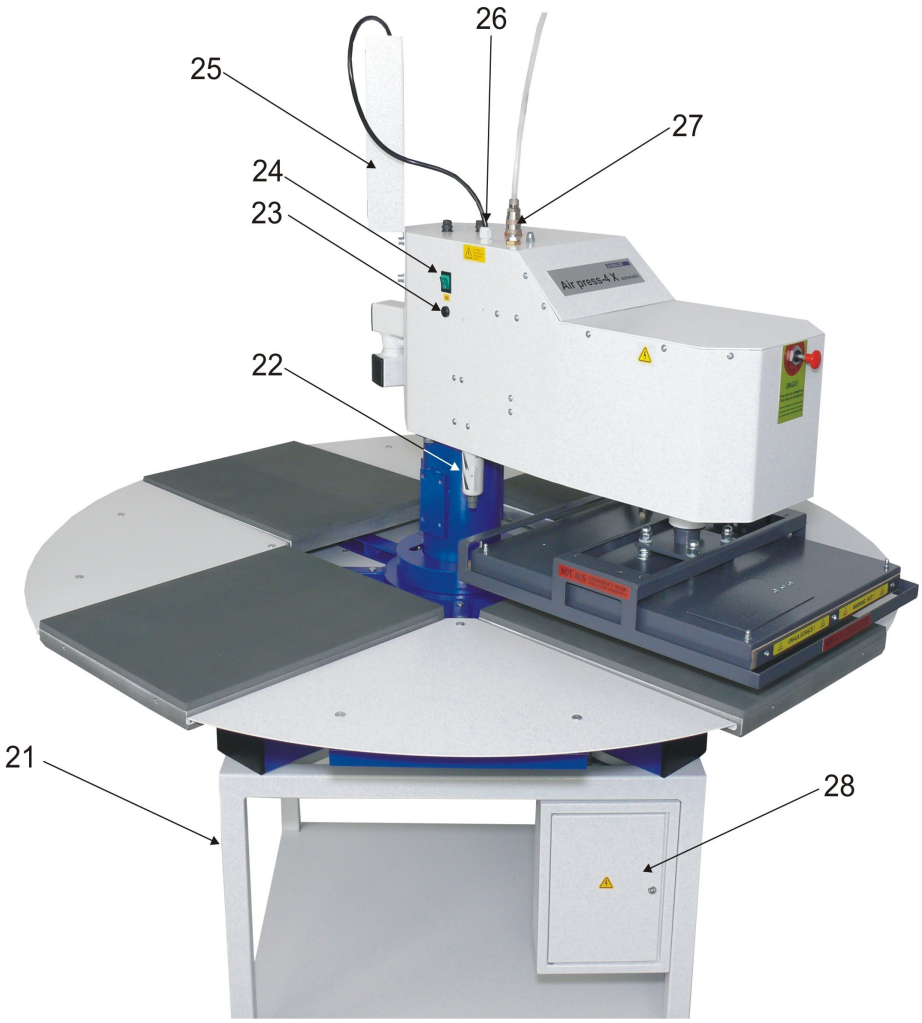

21. Metal case
22. Air filter with water separator
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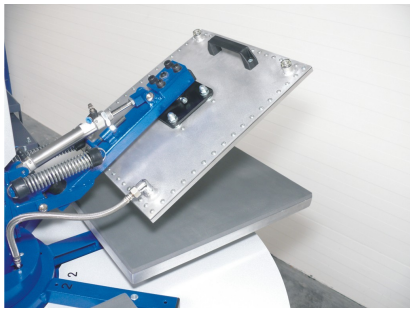
1.3 Technical data

Dimensions of the press with metal case:	182 x 146 x 146 cm
Working area:	40 x 50 cm / 38 x 50 cm
Weight:	210 kg
Operating voltage:	230 VAC
Rated power 40 x 50 cm:	2,3 kW
Rated power 38 x 45 cm:	2,0 kW
Air requirement per cycle:	7,2 l
Temperature range:	0 – 220° C
Time setting:	1 sec – 19:59 min
Max. pressure:	6 bar
Pressure output at 6 bar:	ca. 2490 kg
Main fuse:	12A

1.4 Accessory

The Air press-4 X can be equipped with complementary accessory.



1. Cooling system

2. Screen print frame mounting

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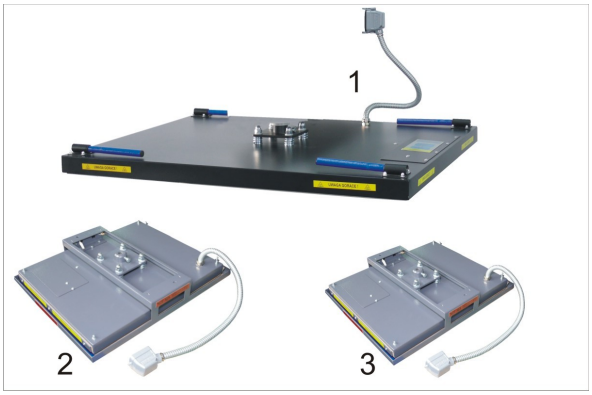
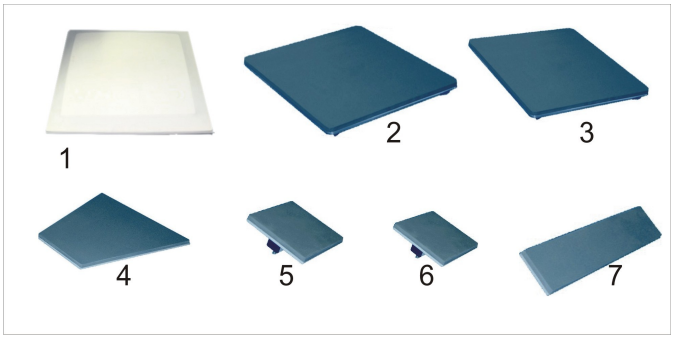
1.5 Exchangeable heating plates



For the press there are several heating plates available.
The instruction for the exchange you can find in chapter 3.7.

1.	Heating plate	70 x 90 cm
2.	Heating plate	40 x 50 cm
3.	Heating plate	38 x 45 cm

1.6 Exchangeable base plates



For the press there are several base plates available.
The instruction for the exchange you can find in chapter 3.8.

1.	Membrane plate	70 x 90 cm
2.	Base plate	40 x 50 cm
3.	Base plate	38 x 45 cm
4.	Trapezoid plate	
5.	Base plate	25 x 25 cm
6.	Base plate	20 x 20 cm
7.	Base plate	10 x 45 cm

1.7 Safety arrangements of the heat press

The Air press-4 X is equipped with different safety arrangements, to make a safe usage possible.

Main fuse 12A
The main fuse 12A is placed in the pivoting upper part of the heat press. In case of overcharge, the main fuse prevents the heat press from getting damaged.
Once the fuse was activated, it has to be replaced. The instruction for replacing the main fuse can be found in chapter 4.2.

Fuse 1,6A
This fuse is placed in the 12VAC power supply in the upper part of the heat press. It saves the 12VAC circuit of an overcharge. Once the fuse was activated, it has to be replaced. The instruction for the exchange you can see in chapter 4.4.

Thermal fuse
The thermal fuse is placed directly on the heating plate and it stops the power supply if the temperature exceeds 260°C. If this fuse is activated, the temperature sinks down to 90°C. After that the power supply gets activated again and the temperature of the heating plate rises and you can work with the press again. Certainly you need to install a new thermal fuse within the next days. The instruction for the replacement of the thermal fuse can be found in chapter 4.10.

Safety valve
The safety valve 6.0 bar is placed at the pressure pipe in the press. I the pressure should exceed 6.0 bar, the valve will be activated automatically.

Automatic switch-off
If the press doesn't get opened within 10 seconds after the pressing progress, the heating element switches off automatically, to avoid fire danger.

Safety frame
The safety frame is located at the heating plate. If it should be activated, the Pressing process will be suspended.

Emergency switch
In cases of emergency, press one of the two emergency switches situated at the front of the press and on the control desk.
After turning the emergency switch on, it should be turned off in order to continue pressing.

1.8 Safety arrangements at the workspace

Set-up and installation of the heat press
The set-up and installation of the press has to be done under supervision of an authorized person. The installation has to be done by 2 or more persons following the instructions of this manual.

Testing the heat press
After a correct installation of the press it is important to ensure that the press works properly, isn't damaged and has no safety defects. The testing can only be done by the employer or other authorized persons and is mandatory to guarantee correct installation and safe usage of the press. The testing should be protocoled.
If any irregularities regarding functionality or safety are found during the testing, these have to been noted and reported to Walter Schulze GmbH in written form within 7 days. Until clarification the press can not be used.

Information and Education
According to § 81 industrial relations law and § 14 employment protection law the employer has to make arrangements to give all information about the function and the range of application to the user.
In particular the user needs to be acquainted with the complete manual and be explicitly informed of the dangers of working with the press. The details have to be explained in a coherent form and language.

Safety distance and ventilation
The press has to be installed at a place which gives enough space on both sides to put the material on.
The space in front of the press has to be wide enough to let nothing disturb the user at work.
Using the press with certain materials may create a strong smell. That’s why the user should evaluate the need for a ventilation system at the workplace.

Safety instruction
- The press should only be used by trained personal after notice of this manual.
- Only one person is allowed to work on the press at a time.
- Beware of heating plate – risk of burns.
- Attention, the press opens automatically – keep the safety clearance.
- The plug has to be pulled out of the power outlet while maintenance.
- The safety frame has always to be connected.
- **Caution:** please do not connect this press to any other outlet (socket) than those equipped with *ground-fault protection* ELCB (**e**arth **l**eakage **c**ircuit breaker).

2. Initiation

2.1 Tips for transport

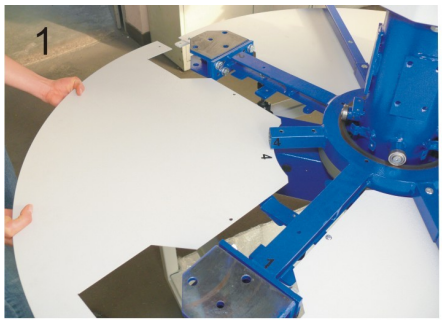
The SCHULZE Air press-4 X is covered in protective foil for transport and fixed onto the pallet. Right after the receiving you should check if the foil and the press are in good condition. Later on, if you have to send the press somewhere, we ask you to fix the press in the same way on the pallet. The press has to be cold for the transport.

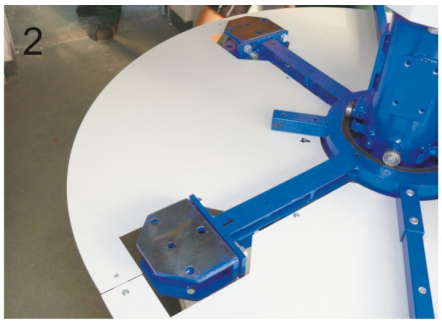
2.2 Installation of the heat press

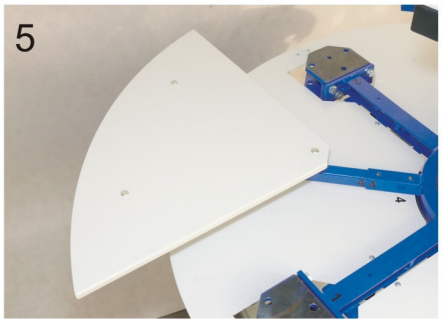
Remove the protective foil and release the pedestal of the pallet. The pedestal is equipped with 4 wheels with brakes. The brakes have to be tightened to avoid dislocation of the press. Lifting and moving of the press has to be done by at least 4 persons. The press with pedestal weighs 210 kg.
The base plates, heating plate and cover plates have to be mounted after the transport.

Assembly instruction of the handles and safety plates:

1. Put the cover plates (Every bar has a number, please mind that) **(photo 1-2)**
2. Screw the cover plates together **(photo 3)**
3. Put the cover plates in the corresponding slot (Every bar has a number, please mind that) **(photo 4-5)**
4. Screw the cover plates together **(photo 6)**

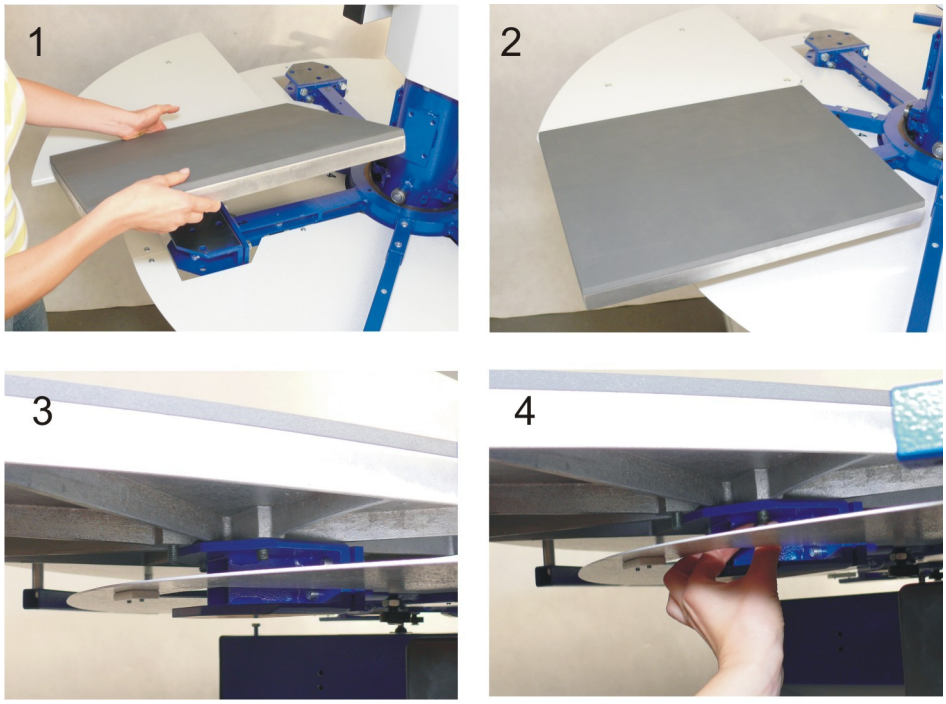






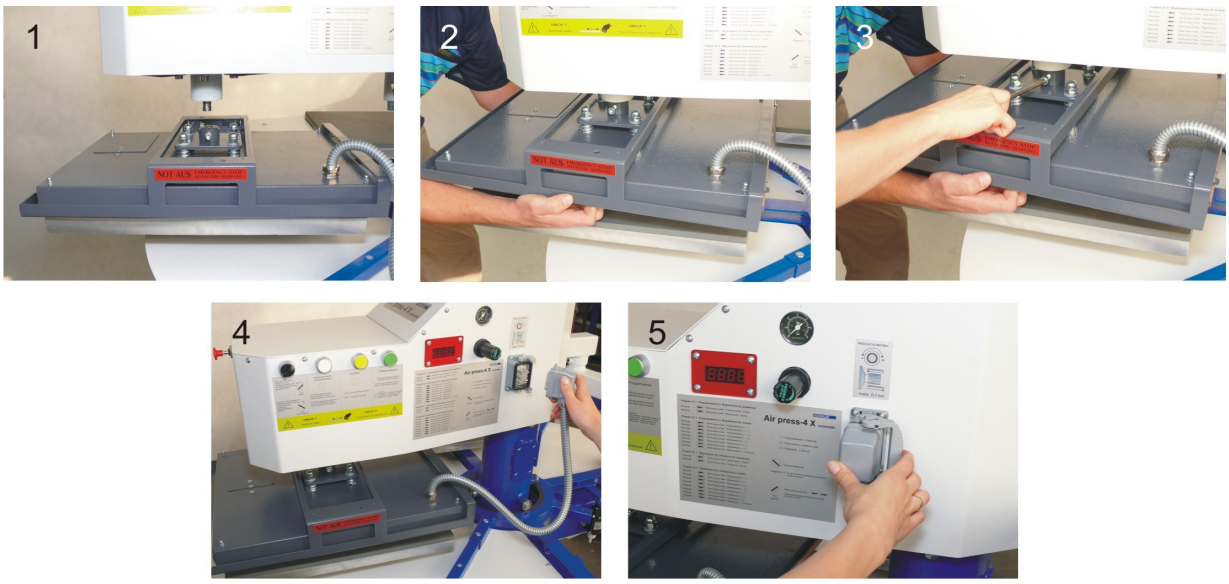
Assembly instruction of the base plates:

1. Put the base plates in place **(photo 1-2)**
2. Tighten the base plates **(photo 3-4)**



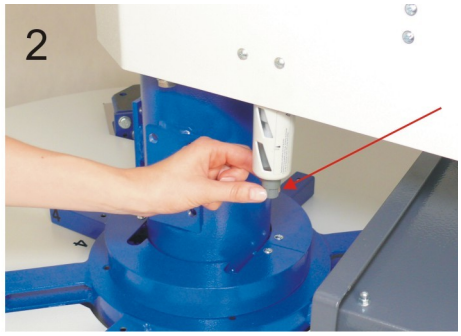
Assembly instruction of the heating plate:

1. Put the heating plate on the base plate **(photo 1)**
2. Pick up the heating plate and then put into the pin **(photo 2)**
3. Screw the heating plate **(photo 3)**
4. Connect the heating plate with the press **(photo 4-5)**



2.3 Connection of the press to compressed air

The Air press-4 X is a pneumatic press, which has to be connected to compressed air. The maximum pressure inside the press must not exceed 6 bar. The air has to be dry and clear of oil. If required you may employ additional filter and drier. The port for the compressed air at the press is equipped with a quick connect **(photo 1)**.
After working with the press disconnect the compressed air. So the container with the condensed water will empty automatically. If you compressed air system isn't equipped with an air drier, you need to check the container every 4 hour and empty it. Therefore press the knob **(photo 2)** upwards.
To remove the container, disconnect the compressed air first. Push the container up and turn it to the left, now you may remove it. If there is oil in the container you need to switch off the press at once and repair the compressor. Oil in the system may be damage the press.



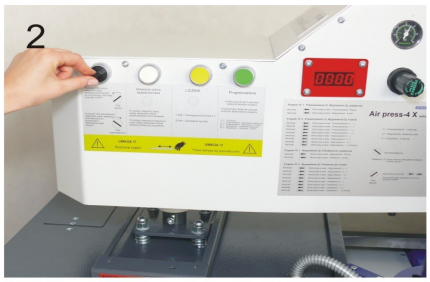
2.4 Power supply

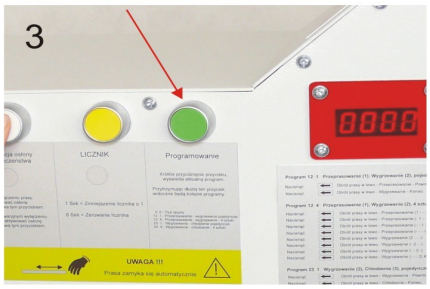
Die Air press-4 X has to be connected to a voltage of 230VAC/ 50Hz. The press is equipped with a plug. Make sure that the power outlet is in the right condition and that the grounding is connected to the power outlet. Turn and fasten the the retainer **(photo 1-2).** An extension cable 230VAC must be fasten in the retainer above the press **(photo 3-4).** The laying and connection the power cable and the compressed air pipe has to be done above the press.

Caution: please do not connect this press to any other outlet (socket) than those equipped with *ground-fault protection* ELCB (**e**arth **l**eakage **c**ircuit breaker).

2.5 Initiation of the heat press

The press should only be used by trained personal after notice of this manual. Before the first start up make sure that the power outlet is in the right condition and that the grounding is connected to the power outlet. Assemble the press before you work with it (chapter 2.2).
The press can be turned on with the green dip-switch **(photo 1)**. If the green switch glows the press heats up to the adjusted temperature. The press heats up to the preset temperature. The press must be open while heating up. The device can operate in two modes – automatic and manual. The mode must be set before the press starts the pressing process **(picture 2).** One of the operating programmes is to be selected next **(picture 3).** In order to initiate the process of pressing, push the green START button on the control desk **(picture 4).** The heat platen lowers itself down and presses against the lower platen. After the pressing process finishes, the press opens automatically. When the press is not used, switch it off and unplug it.



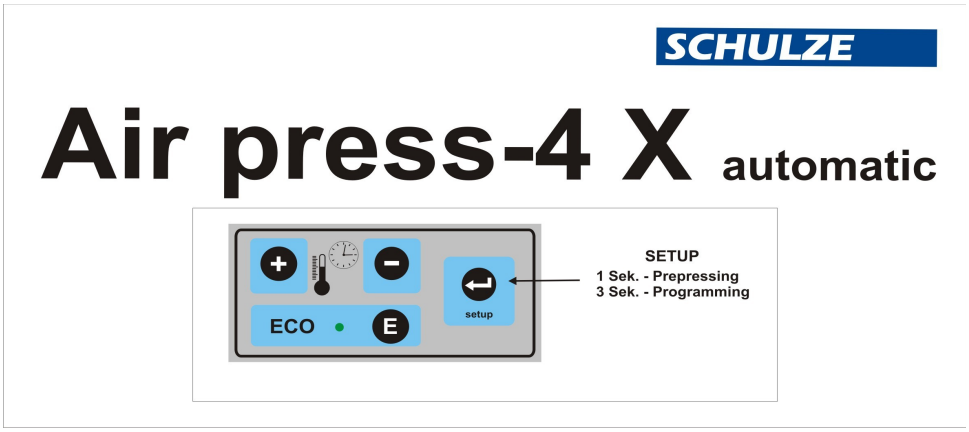


2.6 Automatic / Manual

The switch on the right side of the press allows for the change of the operating mode.
In the manual mode the START button must be pushed every time the heat platen movement is to be initiated **(picture 1)**.
In the automatic mode the buttons for the 90º left or right turn of the lower platens must be pushed in order to initiate the heat platen movement **(pictures 4-5).**
The yellow warning light on the press is on when the lower platens are turning **(picture 6).**
In both the automatic and the manual mode, the process of pressing may be stopped by pushing the START button again **(picture 1)** or by pressing one of the two emergency switches **(picture 2-3).**
The number of lower platen turns depends on the number of times the lower platen left/right turn button is pushed.
If the 0..0 program in the automatic mode is selected, the process of pressing will start automatically. If other programs are used, the lower platen will stop and the pressing process will begin after pushing the START button.

3. Working with the heat press

3.1 Programming the electronic devices



After switching on the press, the current temperature is shown is shown on the display and the press heats up.

Change settings:

1. The programming mode shows up when you press **Setup** for about 5 seconds, until the LED1 blinks up.
2. LED1 blinks and the programmed temperature shows on the display The programming mode is activated.
3. The temperature gets programmed with button **"+" and "-".**
4. Press **Setup** shortly.
   On the display you now can see the programmed time. You can adjust the time by pushing Button **"+" and "-"**.
5. Press **Setup** shortly to save the changes and leave the programming mode.
   All settings are saved.

Control of adjusted temperature

If you want to control which temperature is adjusted at the moment, press button "+". The temperature shows up on the display.

Control of adjusted time

If you want to control which time is adjusted at the moment, press button "-". The time shows up on the display.

3.2 Automatic mode types

Air Press-4X operates using five different programs. Push the green "PROGRAM" button to select a program. One of the following programs may be chosen:

0 0 - automatic mode: each movement of the press must be preceded by pushing the START button or the lower platen turn button

12 1 - pre-pressing – single pressing: once the lower platen turn button is pushed, the work platen will position itself under the heat platen and pre-pressing will start. When the press is opened, the lower platen turns right. Pushing the lower platen turn button again makes the work platen return under the heat platen which lowers itself down and the transfer is pressed;

12 4 – pre-pressing – pressing – 4 items: once the START button is pushed, there begins the process of pre-pressing on the work platen located under the heat platen. The pre-pressing on other platens takes place after every push of the platen turn button. The pressing process begins right after the whole cycle of pre-pressing. Each instance of pressing must be initiated by pushing the lower platen turn button.

23 1 - pressing – single repressing: once the lower platen turn button is pushed, the work platen will position itself under the heat platen and pressing will start. When the press is opened, the lower platen turns right. Pushing the lower platen turn button again makes the work platen return under the heat platen which lowers itself down and the transfer is repressed;

23 4 - pressing – repressing – 4 items: once the START button is pushed, there begins the process of pressing on the work platen located under the heat platen. The pressing on other platens takes place after every push of the platen turn button. The process of repressing begins right after the whole cycle of pressing. Each instance of repressing must be initiated by pushing the lower platen turn button.

3.3 Counter

Air Press-4 X is equipped with a transfer counter. The number of transfers is displayed on the screen. Use the yellow button **(picture 1)** to reset the counter or deduct one unit from the counter's record. Additionally, the screen **(picture 2)** displays the number of the selected program. The transfer counter operates only in 0..0 mode.

The display shows the stage in the cycle of a given program or, when operating in 0..0 mode, the number of transfers made. The screen also displays the following alarm codes:
7777 – one of the two emergency switches is turned on during the start of the machine or a safety frame has been activated
9999 – one of the two emergency switches is turned on

3.4 Error reports

The electronic devices of the Airpress4 control the main functions of the press.

Here is a list of possible messages:

ERR.1 – No connection of the electronic devices to the temperature sensor. (**Temperature sensor defect/** cable not connected)
ERR.2 – Connection of electronic devices and temperature sensor bypassed. (**Temperature sensor defect/**)
ERR.3 – Resistor of temperature sensor too low. The temperature range of the electronic devices is deceeded.
ERR.4 – Resistor of temperature sensor too high. The temperature range of the electronic devices exceeded.
ERR.5 – No temperature rise within 3 minutes even if heating element is switched on. (**Temperature fuse is defect**)
ERR.6 – No reduction of the temperature within 3 minutes even if heating element is turned off. **(Power relay CRYDOM is defect)**
ERR.7 – Temperature too high, over 230°C **(Power relay CRYDOM is defect)**

ERR.3 and ERR.4 can occur if the electronic devices are not programmed properly.

3.5 Application range and sample adjustments of the press

This press is used to put transfers and transfer films on textiles. To get good achievements, get in contact with the producer of the textiles. Here are some settings:

Film Flex	150°C – 160°C	Time 15 Seconds
Film Flex S	155°C – 160°C	Time 15 Seconds
Film A-Flex	155°C – 160°C	Time 15 Seconds
Film Flock	160°C – 180°C	Time 15 Seconds
Sublimation Film	190°C – 205°C	Time 50 Seconds

All information is supplied without liability, please run your own testing before production.

3.6 Pressure settings

Wit this press you can change the pressure setting .

After every change of the pressure settings, close the heat press to check the new settings.
Damages, which arise from to much pressure, are excluded from the guarantee.

To adjust the pressure do the following:
1. Take the pressure reading. **(photo 3)**
2. To alter the pressure pull the knob to you. **(photo 1)**
   - Rotating the knob to the right will increase the pressure
   - Rotating the knob to the left will decrease the pressure
3. To retain the setting push the knob to the press again.
4. Test the pressure **(photo 2)**

The pressure reading you may take at the top on the right.

Plate 38 x 45 cm ~ 2,0 bar (max. 4,0 bar)
Plate 40 x 50 cm ~ 2,5 bar (max. 4,5 bar)

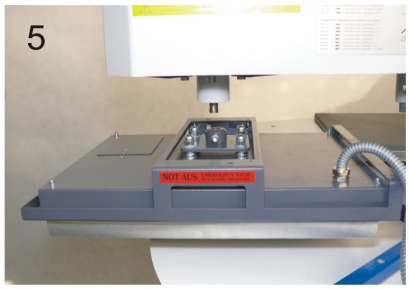
The pressure reading you may take at the top on the right.

1,0 bar - ca. 415 kg
2,0 bar - ca. 830 kg
3.0 bar - ca. 1245 kg
4.0 bar - ca. 1660 kg
5,0 bar - ca. 2075 kg
6.0 bar - ca. 2490 kg

If you alter the pressure to a setting higher than 6 bar, a safety valve will be activated. In this case you have to reduce the pressure.

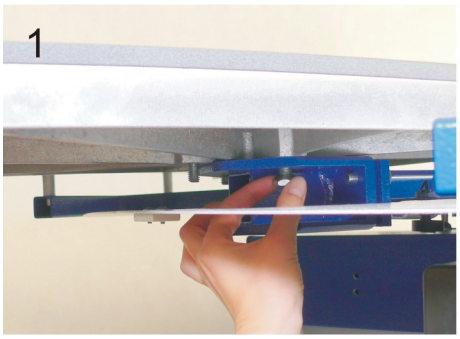
3.7 Exchanging the heating plate

To exchange the heating plate, the press **must be disconnected from electricity and cold.**
Now disconnect the spiral tube plug of the heating plate. **(photo 1-2)**. Loosen fixation screw with a wrench **(photo 3)**. Take hold of the plate and put it down carefully on the base plate **(photo 4-5)**. Take the heating plate carefully and put it on a soft underground, because the Teflon cover should not be damaged. Then take the new heating plate and tighten it with the wrench. Connect the heating plate and the safety frame with the press again.
The heating plate can not be turned.



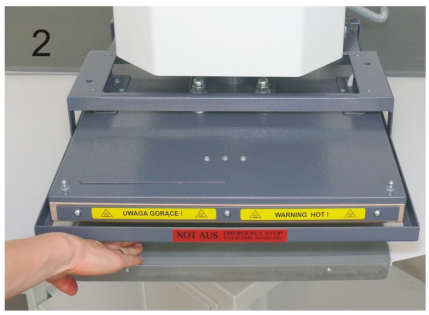
3.8 Exchanging the base plate

If you want to exchange the base plate you have to loosen the fixation screw s **(photo 1)**. Then you can take of the base plate **(photo 2).**
After exchanging the base plate, tighten the fixation screw again **(photo 1).**
The base plate can not be turned 90 degrees.



3.9 Safety frame

The Air press-4 X is equipped with an safety frame **(photo 1)**. The safety frame guards against burnings. If you should touch the safety frame while it's going down **(photo 2)**, the process will be interrupted at once. In that case you have to press the activation button again **(photo 3)**. Thereby you also confirm, that it is still safe to work with the press.



3.10 Cooling System (optional)

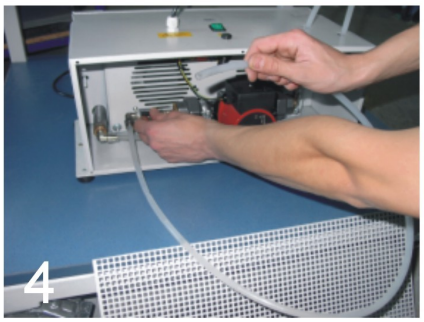
The cooling system is run with water. To fill the cooling system with water, do the following:

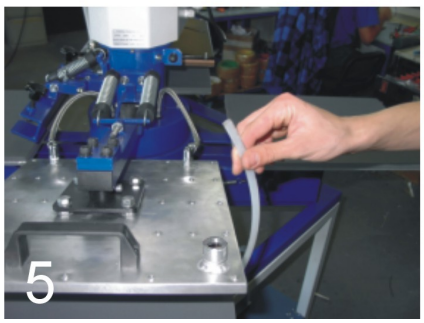
1. Turn off the press and pull the disconnect the power.
2. Unscrew both air bleed valves and tilt the cooling plate slightly up **(photo 1).**
3. Pull the plug of the cooling system and remove the cover of the pump **(photo 2).**
4. Take out the connecting tube **(photo 3).**
5. Open the valve for filling the system **(photo 4).**

Geschlossen

Geöffnet

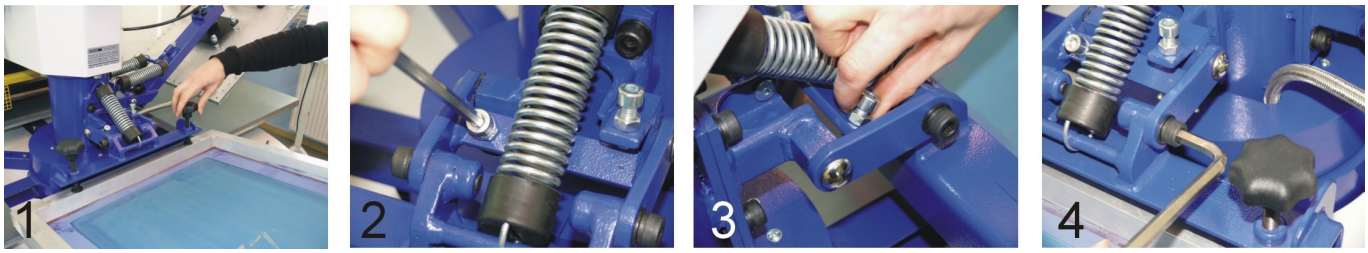
6. Fill the system with tap water by means of a funnel or a tube, until the water comes out the air bleed valves **(photo 5).**
7. Close the valve below and let the water out of the tube.
8. Screw the air bleed valves with caution manually in place.
9. Place carefully the tube into the housing below.
10. Screw the cover in place.





3.11 Screen printing mounting adjustment (optional)

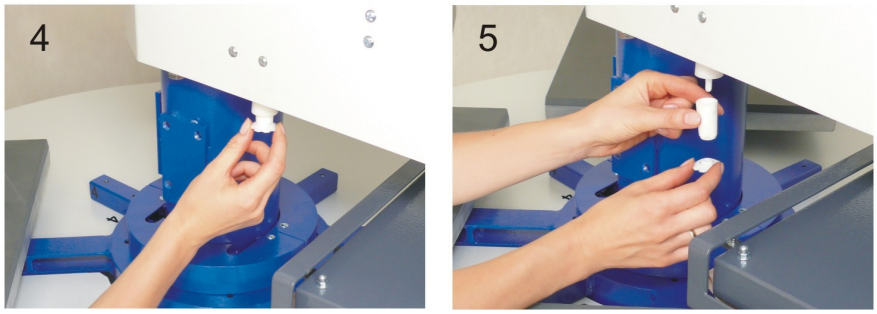
At the Airpress4 you can mount a screen print frame directly over one of the base plates. In this way you can print one colour directly on the press. To work comfortably with the frame you can adjust the screen lift-off **(photo 2 + 3)** and the inclination of the screen **(photo 4)** with the depicted screws



4. Maintenance

4.1 Daily Maintenance

The working surface of the heating plate and the base plate have to be clean. The heating plate can be cleaned with a clean, dry cloth. Avoid contact with the heating plate – **risk of burns.**
The silicon gum can be cleaned with a soft cloth. You can use mild household detergent. Avoid scrub sponges, solvents or fuel.
Should the press be used continuously over several days, you have to **repeatedly in one day push the black button** right under the air connection to release the water, which accumulated there **(photo 1)**. You also can remove the container and empty it. Therefor push the container up and turn it left **(photo 2-3)**. If needed you can disassemble the filter and clean it **(photo 4-5).**
If there is oil in the container you need to switch off the press at once and repair the compressor. Oil in the system may be damage the press.



4.2 Replacing the main fuse

If the heat press does not work after switching on (the main switch is glowing, but the display is not), check the main fuse of the press. The main fuse 12A is placed in the upper part of the press **(photo 1)**. To exchange the fuse, **switch off the heat press first and pull the plug**. Screw the fuse bracket loose **(photo 1).** Then remove the fuse bracket **(photo 2)**. Exchange the fuse **(photo3)** and tighten the fuse bracket again.

4.3 Replacing the power supply

To exchange the power supply, **turn the press off and disconnect it from power first.** Open the electric case **(photo 1)**. Remove the stopper of the power supply **(photo 2).** Remove the power supply **(photo 3).** Pull the green plug **(photo 4)** and replace the power supply**.** Connect the green plug and fasten the power supply in the upper part of the press again. Then reassemble the press.

4.4 Replacing the fuse in the power supply

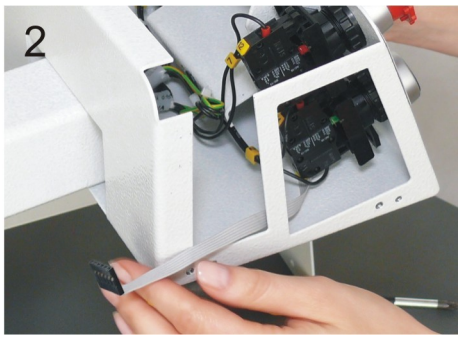
The heat press is equipped with a main fuse 1,6A/12Volt, which is placed in the upper part of the press. In the electric case is a LED.
When the LED **(photo 1)** glows, the power supply works.
If the LED doesn't glows, the fuse 1,6A in the power supply has to be exchanged.
To exchange the fuse in the power supply, **first turn off the press and pull the plug.**
Take out the power supply, as in chapter 4.3. Screw loose the fuse bracket **(photo 2)** and exchange the fuse **(photo 3-4).** Then reassemble the press again.

4.5 Replacing the electronic devices

Inside the control desk of the press there are electronic devices, which control the temperature and time of the press.
To exchange the electronic devices, **turn off the press and pull the plug.**
Loosen the screws in the upper part of the press and remove the cover **(photo 1-2)**. Pull out the green plug **(photo 3)** Loosen the stopper of the electronic devices **(photo 4).** Remove the electronic devices **(photo 5).** Pull out the Temperature and time adjustment **(photo 6).** Connect the new electronic devices and fix them into the press . Then reassemble the press again.

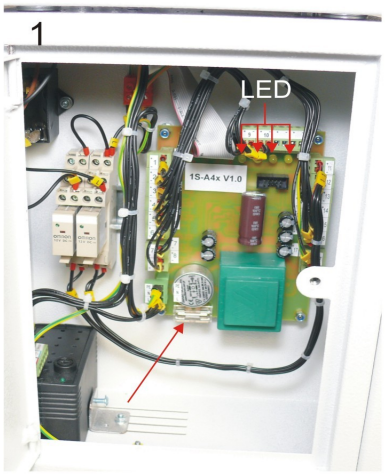
4.6 Electronics keyboard replacement

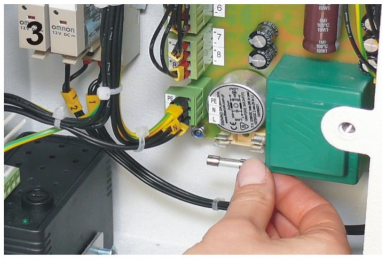
To change the electronics keyboard the press must be switched off and unplugged. Remove the electronics from the control panel as instructed in chapter 4.5. Disconnect the keyboard plug from the electronics **(picture 1)** and remove the keyboard from the press **(picture 2).** Install a new keyboard and plug it into the electronics. Reassemble the press.



4.7 Control system replacement

If the display does not show any readings, check if the heat platen is directly over the lower platen. If the setting is correct, check if the diodes on the control panel **(picture 1)** are on during the turn of the lower platens. If the diodes are not on, replace the fuse on the panel (**picture 1-3)** or the whole panel **(picture 4-5).**





4.8 Transmitter replacement

If the lower platens do not change position after pushing the right/left platen turn button, check if the diodes on the transmitter are on (turn of the platens left – the left transmitter; turn of the platens right – the right transmitter) **(picture 1)**. If the diodes are not on, a given transmitter is broken and needs to be replaced **(picture 2-3)**.

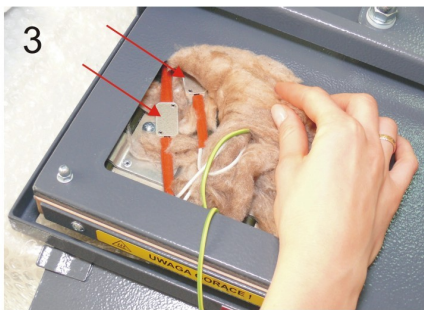
4.9 Replacing the silicon mat

To exchange the silicon mat the press must be disconnected from the electricity and cold. For the exchange you need a new silicon mat, silicon glue, acetone and a notched trowel.

1. Remove the silicon mat with a knife restless.
2. Put an equal film of silicon glue on the plate using the notched trowel.
3. Put on the new silicon mat.
4. Close the pressure lever to press the silicon mat and the plate together.
5. Open the pressure lever and make sure that the plate and the mat lays exactly over each other.
6. Let the glue dry for 24hours.
7. Take of the heating plate and cut off the overlaying edge of the silicon mat.

4.10 Replacing the thermal fuse

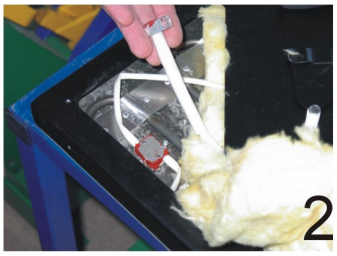
The replacing may only be done by an authorized person.
For the replacement of the thermal fuse, the heat press **must be disconnected from the electricity and cold**. Remove the cap from the heating plate and remove the heat isolation **(photo 1-2)**. Then remove the thermal fuse **(photo 3)** and connect a new one. Tighten it on the heating plate, put in the heat isolation and tighten the cap again. If you have the heating plate 400 x 500 mm the same should be done with the second thermal fuse.

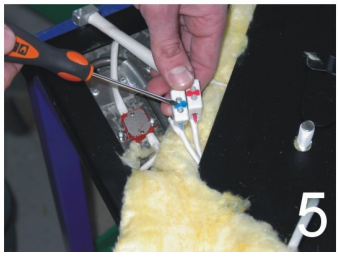


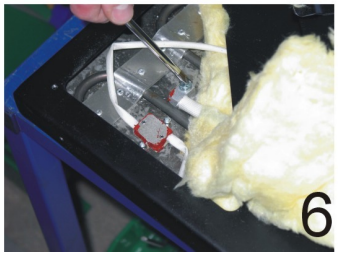
4.11 Replacing the thermo couple

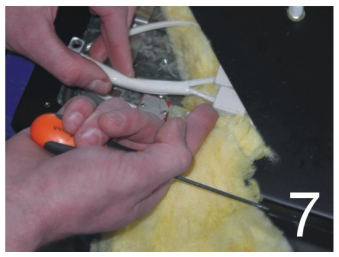
The replacing may only be done by an authorized person.
For the replacement of the thermo couple the press **must be disconnected from the electricity and cold**.

1. Remove the cap and take out isolation.. **(photo 1)**
2. Remove the thermo couple. **(photo 2)**
3. Remove the cable with a nipper. **(photo 3)**
4. Pull off the cable isolation. **(photo 4)**
5. Connect the cables to the new thermo couple. **(photo 5)**
   Mind the polarity (blue to blue and red to red).
6. Tighten the thermo couple (photo 6), lay the cables on the heat isolation (photo 7) and tighten the cap.





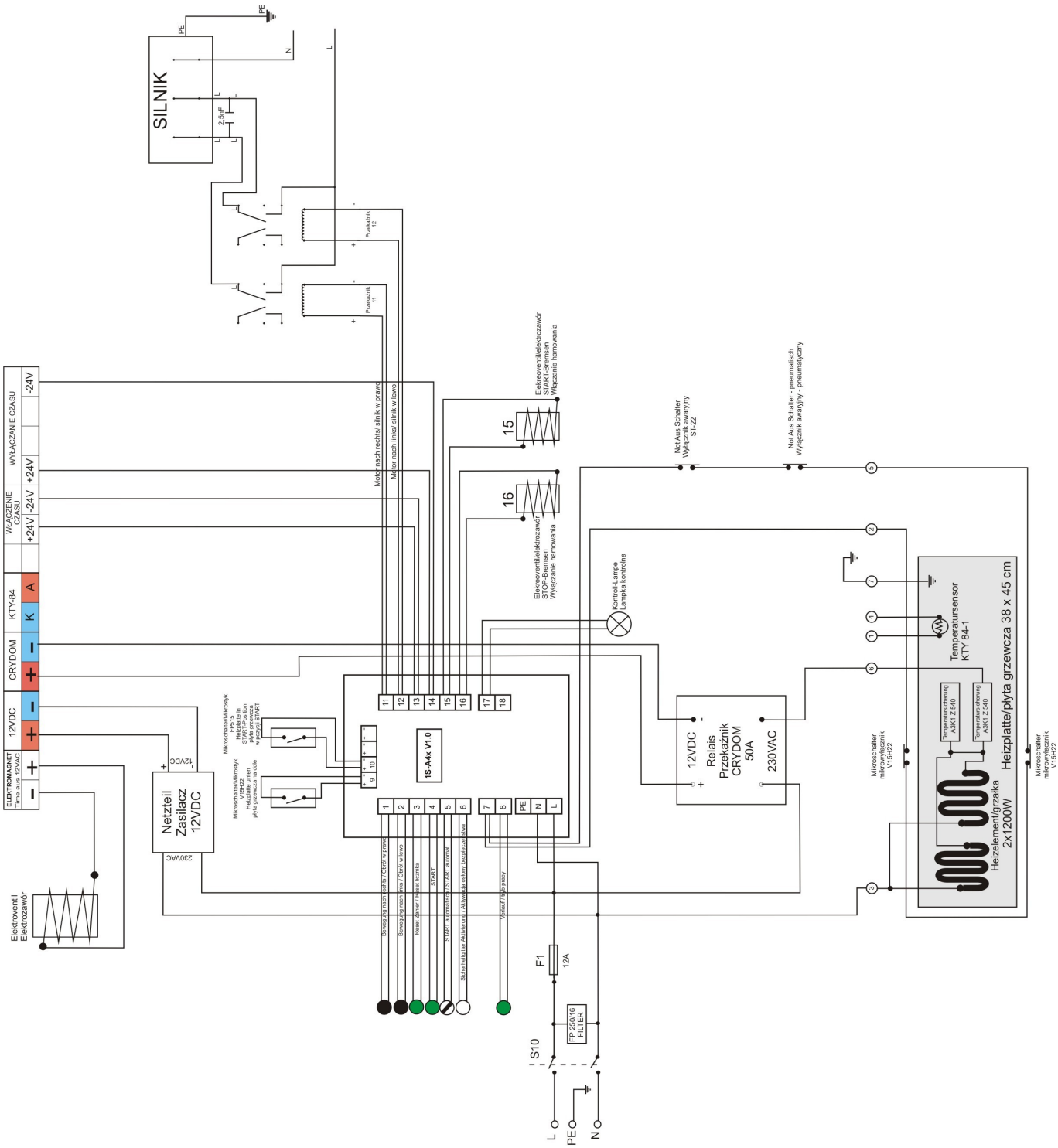




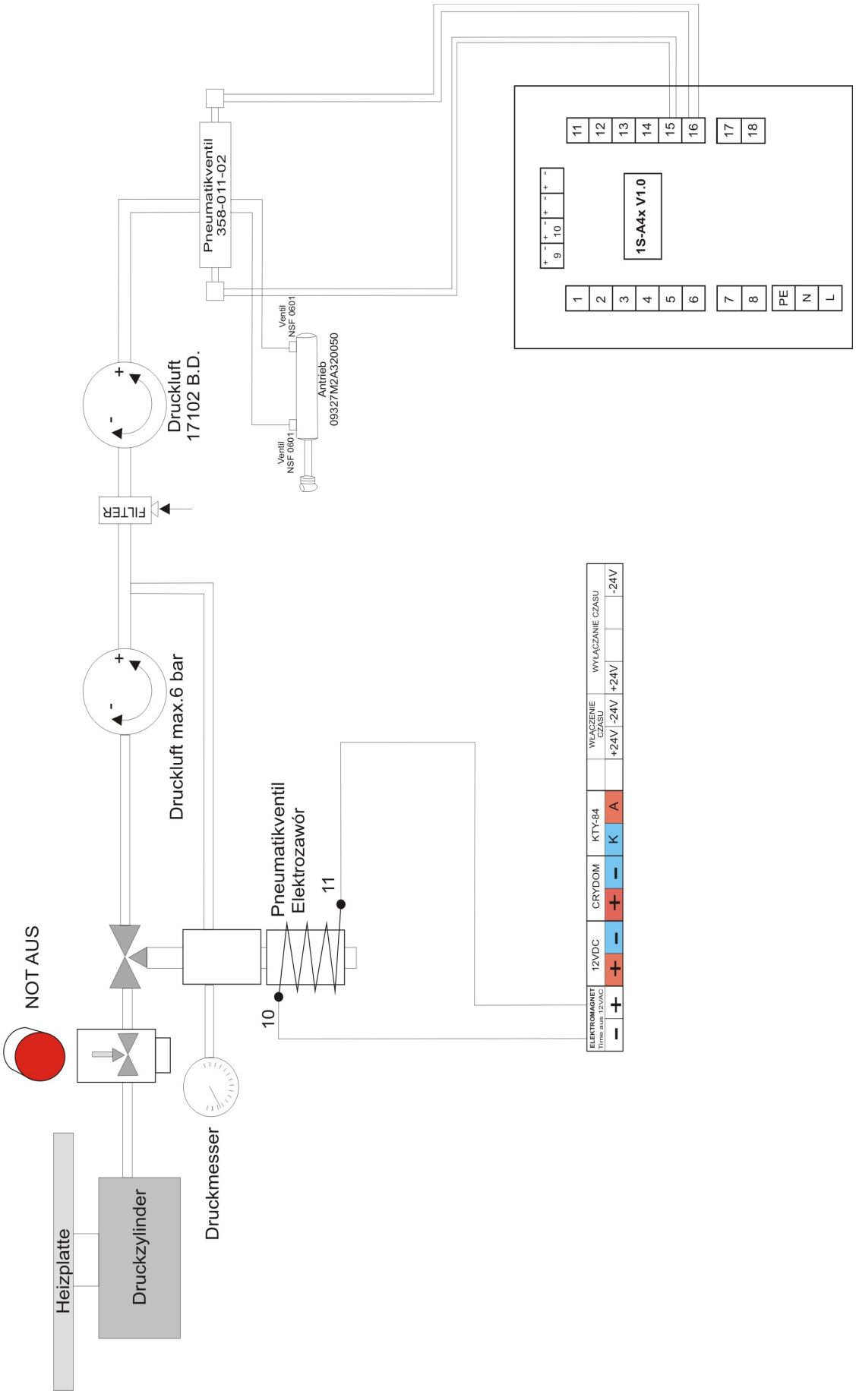
4.12 Troubleshooting

Problem	Cause	Debugging
The main switchs glows, but the display isn't the heating plate isn't heating up	Main fuse 12 A is defect	Replace main fuse 12 a
	If the main fuse is okey, check if the diode in the power supply is glowing. If not the fuse or the power supply is defect	Replace fuse 1,6A in the power supply or replace the power supply
	If the diode is glowing the electronic devices are defect	Replace the electronic devices
The display shows "Err.5"	Thermal fuse on the heating plate is defect	Replace the thermal fuse If you use the heating plate 400x500mm replace both thermal fuses
The display shows "Err.1"	Thermo couple is defect or the cables to the thermo couple are defect	Check the cables to the thermo couple or exchange the thermo couple
	No connection to the heating plate	Put the plug of the heating plat into the socket
The display shows "Err.2"	The thermo couple is defect	Exchange the thermo couple
The display shows "Err.3"	Resistance of the thermo couple is too low	Exchange the thermo couple
The display shows "Err.4"	Resistance of the thermo couple is too high	
The display shows "Err.6" The display shows "Err.7"	Power relay CRYDOM is defect	Replace power relay CRYDOM
Adjustment buttons aren't working No time or temperature adjustments are possible	Adjustment buttuns are defect	Replace adjusment buttons
Temperature of the heating plate doesn't correspond to the Temperature on the display – Temperature too high/low	Malfunction of the electronic devices	Reset the electronic devices, but first contact Walter Schulze GmbH
The press heats up very slowly – over 30 minutes one half of the plate doesn't reach the adjusted temperature	One of the tow heating elements is defect	Replace the heating plate and/or send it in for repairs
The press will not stay down The time is not activated	Micro switch is defect The Material is to thick and so the micro switch isn't activated	Mikroschalter einstellen oder Mikroschalter austauschen
The press will not close	Emergency button is pressed down Compressed air is not connected Micro switch is defect	Pull the emergency button out Connect the compressed air Exchange the micro switch
The press will not open The press will only open with the emergency button	Pneumatic valve is defect	Replace the pneumatic valve
The display shows ERR 7777	Turn on the heating press with: 1. the emergency button is enabled 2.disconnected the heating plate 3. safety frame is enabled	unlock the kind of failure
The display shows ERR 9999	When you turn the heating press is one of the two emergency buttons	Unlock the safety button
The main switchs glows, but display works the heating plate heats the heating press doesn't work	1. the heating plate isn't on the base plate 2. fuse of the electronics counter is defect 3. Electronics counter is defect	1.Press the button of the Rotation of base plate to the left or right 2. Exchange the fuse 3. Exchange the electronics counter

4.13 Connection diagram



4.14 Controlling of the pneumatics



4.15 Certificate of manufacturer

Załącznik Nr. 1
Certificate No.
Zertifikat Nr.

POŚWIADCZENIE ZGODNOŚCI
CERTIFICATE OF MANUFACTURE CONFORMITY
HERSTELLERZERTIFIKAT

Wystawia zakład wytwarzający
issued by manufacturer
ausgestellt vom Hersteller

Oświadcza się że urządzenie (peina nazwa i typ)
We hereby certify that the technical device (full name and type)
Hiermit bestätigen wir, dass die Armatur (Name und Typ)

Safety Valve, brass, type tested
Art.No. 06205.0200.0000

Nr fabr. Fabr. No. Herst. – Nr.	.TÜV-SV.05-651.7.D/G.0.60 6,0 bar Ventil-Nr.: 117365 - 117414	Rok budowny Date of production Herstelldatum	10.06

wyprodukowane przez:
manufactured by:
Hersteller:

HEROSE GMBH
ARMATUREN UND METALLE
Elly-Heuss-Knapp-Straße 12
D – 23843 Bad Oldesloe

HEROSE – Auftrags-Nr.: 449262 / 10 (Arko)

odpowiada przebadanemu wzorcowi typu zgodnie ze ŚWIADECTWEM BADANIA TYPU
correspond to tested type standard according to CERTIFICATE OF TYPE EXAMINATION
in Einklang steht mit der Bauteilprüfung gemäß Zertifikat

Nr. No. Nr.	103-C-03/imp.	z dnia Date Datum	2003.10.29

wydanym przez laboratorium badawcze
issued by accreditated testing laboratory
erteilt durch das anerkannte Prüflabor

URZĄD DOZORU TECHNICZNEGO
Centralne Laboratorium Dozoru Technicznego
OFFICE OF TECHNICAL INSPECTION
CENTRAL LABORATORY OF TECHNICAL INSPECTION
60-706 Poznań, ul. Małeckiego 29

HEROSE GMBH
ARMATUREN UND METALLE
Elly-Heuss-Knapp-Straße 12
23843 Bad Oldesloe

.....
pieczęć zakładu wytwarzającego
manufacturer stamp
Herstellerstempel

24.10.06 .....
Data I podbis osoby upoważnionej
Date and signature authorized person
Datum und Unterschrift des Sachverständigen

4.16 Testing Report

final check of the heat press:

- o - base, paint
- o - greasing of the waves
- o - heating plate and base plate, silicon, Teflon
- o - electronic connection, safety wire, power cable
- o - electronic, max. temperature 220°C
- o - check of all functions
- o - working time at 180°C . . . . . hours
- o - temperature tolerance at 180°C . . . . . -/ . . . . . +°C
- o - working time at 220°C . . . . . .hours
- o - test with a transfer film
- o - caution labels

Serial number . . . . . Date . . . . . Signature . . . . . .

4.17 EC-Conformance-Declaration **after EC- guideline for machines 2006/46 EC**

The Walter Schulze GmbH
Schmalenbachstraße 15
12057 Berlin

as European representative of the manufacturer company ROMANIK hereby declares that the following machine:

Heat press . . . . . Serial number . . . . . .

is compliant with the specifications of the following EC directives:

Machinery (2006/46)
Low Voltage (2006/95)
EMC (2004/108)

used norms and technical specifications:

EN ISO 12100-1 EN ISO 12100-2 safety of machines
EN 60204-1 electrical equipment of machines

Berlin , ...

_____
Peter Meidinger
President

All SCHULZE heat presses are exempt from the waste disposal law under reg. no. DE 231060054.