BASIC INSTRUCTIONS FOR
30” X 40” AIR MAXI PRESS WITH TWIN TOP AND BOTTOM HEAT INDEXING STATIONS

UNPACKING:

The machine was shipped in (3) major sections. Left rail extensions with heated load vehicle, right rail extensions with heated load vehicle and the main pressing station. Each section has been lag bolted to it’s pallet. Start by un-wrapping the main pressing station. Remove all packing material from the machine. Using a fork lift, lift the pressing station from the front of the machine and position the forks carefully under the lower pressing structure. Great care is needed to insure that the forks will only lift on the actual metal tubular frame. Also, make sure that the forks will not damage the lower air inlet to the lifting air bag assembly**. SEE PHOTO:**

LIFT PRESSING STATION FROM UNDER FRAME WORK

Carefully lift pressing station vertically and then position the press at the final location the press will be set-up at. Make sure the machine is located on a solid, level flat surface. Ideally it is recommended that the machine be bolted or anchor bolted to the floor once it is in place and leveled.

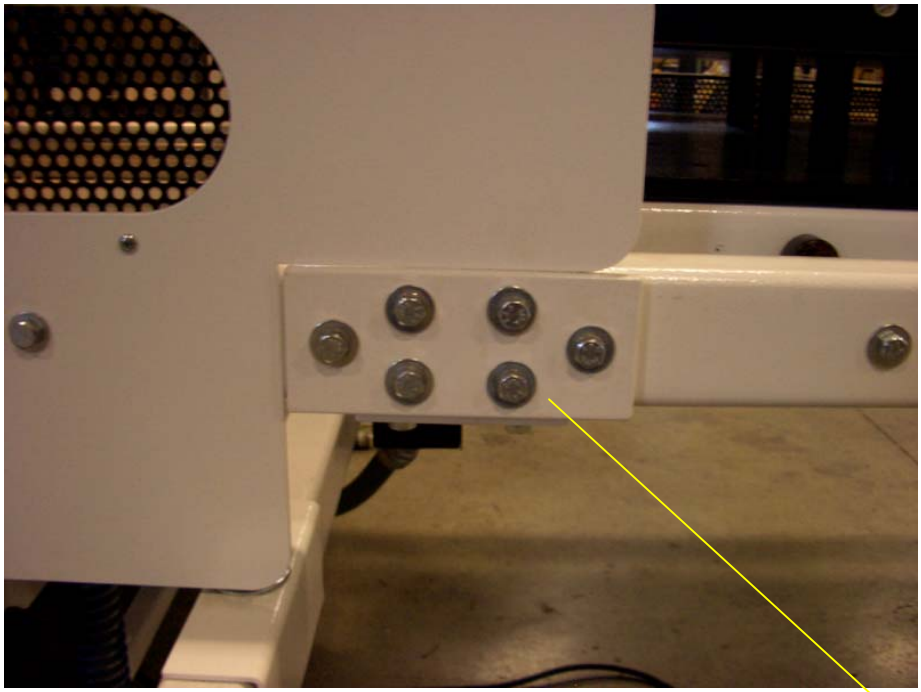
Next, unpack the left and right extension rail sections. Carefully remove wrapping material . It is recommended that the NYLON STRAPS and the BOARDS used for shipping not be removed until the section is in place. THIS WILL PREVENT THE LOAD VEHICLE FROM SHIFTING WHILE MOVING IN POSITION. You will noticed that BLACK PAINTED LEGS AND CROSS BRACES were attached to the sections. These were used for shipping only. DO NOT REMOVE THE BLACK LEGS UNTIL THE SECTION IS READY TO BE ATTACHED TO THE MACHINE.

With the extensions unwrapped and pallet lag bolts removed, you can now lift the section off the pallet using a fork lift. The forks need to lift up on the underside of the main horizontal rail tubes yet not make contact with the black wire support track. Lift the section from the front edge of the assembly. **SEE PHOTO**

With the extension section lifted off the shipping pallet, now carefully bring the section over to the machine. **MAKE SURE THE NYLON TIES AND THE SHIPPING WOOD IS STILL IN PLACE BEFORE MOVING SECTION.**

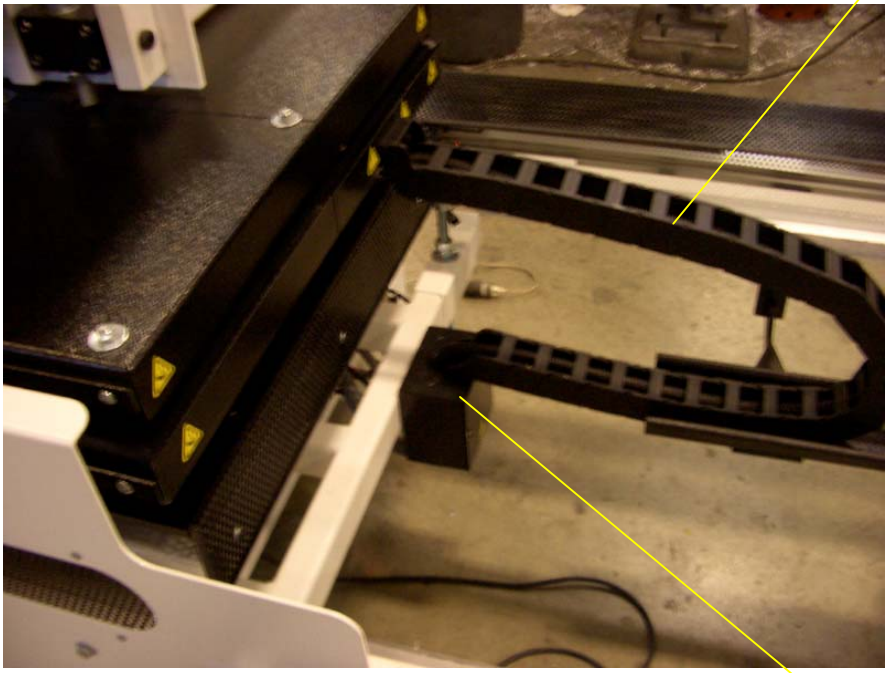
Position the section near to it's proper side-right or left of the pressing station. While the section is lifted off the floor, remove the shipping black legs and cross member from the assembly. Carefully bring the section into place using the RAIL UNION PLATES as guides. Each section is connected to the main pressing station by front and rear union plates as well as supported by lower union plates on each rail.

Loosely attach union hardware to allow the unit to be supported yet be able to level to the pressing station. Using a level on the top surface of the rails, adjust the adjustable feet so the extension section is level with the rails on the pressing station. **SEE PHOTO**



Once the extension section is in place and level with the pressing station. The following connections and attachments can be made.

1. Remove the shipping timbers and hardware from assembly
2. Remove the shipping NYLON TIES
3. The INDEXING BAND CYLINDER base mounting tube has (1) bracket on the pressing station that needs to be re-attached to the mounting tube. Hardware used is in the tapped hole. Refer to the other black angle iron brackets for reference
4. Attach the AIR HOOKS lines for the indexing cylinder to lower indexing control box. These air lines are color coded to match their proper connection.
5. Attach the electrical signal wire harness. Make sure that once the connector is inserted, that the locking outer ring is turned.
6. Connect the bottom heat main electrical feed wires and thermocouple to the connector box on the pressing station. The bottom heater block has attached to it a FLEXIBLE PLASTIC WIRE DUCT that contains the supply voltage wires for the heater block as well as the thermocouple sensor wires. These wires get connected inside the bottom heat connection box located on the right and left lower side of the pressing station. **SEE PHOTO**



REMEMBER THAT YOU CAN FREELY MOVE THE HEATED BOTTOM TABLE

The FLEXIBLE WIRE DUCT has a mounting end cap that gets attached to the top of the connection box using (2) flat head allen screws. The screws were shipped in their proper location on the box. Snake the plastic covering the wires into the top hole of the connection box and then fasten the end cap to the box. Inside the box, you need to connect the main feed wires to the heater wires using the metal butt connectors attached to the wires. You will notice that each wire is marked either L1-L2-L3. Make sure you connect the wires so L1 is with L1 and L2 is with L2 and so on. We have supplied shrink tubing and high temperature glass tubing to be used to cover the butt connections made. **MAKE SURE YOU SLIDE THE SHRINK TUBING ON TO THE WIRES BEFORE CONNECTING.** After connecting, apply heat to the shrink tubing to insulate the metal butt connector from shorting out on the box. Then slide the glass tubing over the connection point for added protection. Add additional electrical tape as needed.

Carefully now connect the thermocouple connectors together. Once connected, it is recommended that they be taped together to prevent them from separating. Once connected, move freely the bottom heated table back and forth to insure the flexible wire duct is moving properly and that the wires are not binding. NOTE: CHECK THE CONNECTION BOX END AND THE HEATER BLOCK END of the wire bundle, make sure the black plastic tubular covering preventing exposure to the heater wires.

7. Proceed to attach the opposite side extension section and bottom heated table as above.
8. Once both bottom heated table extensions have been attached to the machine and is electrically connected, position both Left and Right bottom heated tables in the “OUT” position.
9. Attach the protective screen panel to the INDEX CYLINDER mounting tube. Use the 10-32 screws shipped in the proper holes for attachment. Make sure you position the panel so the

INDEX CYLINDER can move freely back and forth without making contact with the panel.
SEE PHOTO:

ELECTRICAL AND AIR HOOK-UPS

ELECTRICAL SPECS:
VOLTAGE:208-240VAC
AMPERAGE: 72 AMPS @ 3-PHASE
PHASE: THREE PHASE

AIR HOOK-UP:
½"NPT CONNECTION
MAXIMUM OPERATING PRESSURE 100PSI

Have a licensed electrician connect the main power supply to the MAIN DISCONNECT located on the rear of the machine. Position the machine and the connections made for ease of

turning the machine main on and off without hindrance. It is recommended that the air line be ½" and that the connection at the machine be a quick disconnect with ball shut-off for emergency response.

INITIAL START-UP PROCEDURES

1. **Make sure all shipping and packaging material has been removed.**
2. **Confirm that all electrical connections have been checked and have been done in a means to meet local electrical code and safety.**
3. **Physically move the heated Right and Left stations to the "OUT" positions. REMOVE ANY ITEMS THAT ARE ON TOP OF THE BOTTOM HEATED TABLES.**
4. **Carefully connect the air line**
5. **Turn machine on by switching the rear main disconnect to the on position.**
6. **Turn the front panel control on/off switch to the on position so the front panel digital control is powered up.**
7. **At this point, turn both the LEFT and RIGHT bottom heat controls OFF.**
8. **Turn the front panel AIRBAG pressure regulator to 40PSI. This can be increased in the future if needed.**
9. **Confirm that the REAR INDEX pressure regulators for the LEFT and the RIGHT stations is set for 50PSI. SEE PHOTO:**

INDEXING PRESSURE REGULATOR-SET FOR 50PSI

10. **Confirm that all RED E-STOP push buttons are “pulled” fully out.**
11. **Set the pressing time on the front panel control to 10 secs.**
12. **Confirm that all items have been removed from the bottom tables and that no one is in the indexing area.**
13. **Press either the left index foot-pedal or the right index foot pedal to activate the machine cycle.**

COMPLETE MACHINE CYCLE

1. **Operator depresses the “RIGHT” or “A” foot-pedal.**
2. **“A” bottom table indexes into the pressing station.**
3. **Machine “pauses” to insure the table is fully indexed for 1-2secs.**
4. **The bottom AIRBAG then starts to inflate and raises the bottom heat for pressing.**
5. **Material is pressed for the time programmed in the front control.**
6. **When time has expired, the AIRBAG deflates lowering the table.**
7. **Machine pauses for 3-5 secs. to confirm that the lift table is in the full down position and to allow time for valves to shift.**
8. **Then the lower bottom station indexes out of the press.**

9. **If during the operation cycle, the operator depresses "B" foot pedal. "B" will stay at home until "A" has completely finished it's cycle. Then "B" will automatically index into the pressing station.**

E-STOP ACTIVATION AND RE-SET

The machine is equipped with (3) E-STOP push buttons on the top control box. If one of these E-STOP push buttons is pressed, the following result will be in place:

- **MACHINE WILL NOT INDEX**
- **MACHINE WILL NOT PRESS**
- **MACHINE WILL STOP INDEXING**
- **MACHINE WILL RELEASE IF PRESSING**

E-STOP WHILE MACHINE IS PRESSING:

- **AIRBAG WILL DEFLATE**
- **UNIT WILL NOT INDEX**

RESET E-STOP

1. **REMOVE AIR PRESSURE FROM THE MACHINE**
2. **PULL-E-STOP BUTTON TO RESET**
3. **SLOWLY APPLY AIR PRESSURE TO THE MACHINE- The table that was pressing when the E-STOP was activated, may index to the out position. If the table is in the full indexed position, the table will not index until approx 3-5 secs has expired. Then the unit will index outward.**

E-STOP WHILE INDEXING IN OR OUT:

- **TABLE WILL STOP INDEXING AND COME TO A STOP**

RESET E-STOP

1. **REMOVE AIR PRESSURE FROM MACHINE**
2. **PULL E-STOP BUTTON TO RESET**
3. **SLOWLY APPLY AIR PRESSURE TO THE MACHINE-The table that was indexing will return to the out position.**

BASIC INDEX OPERATION INSTRUCTION

1. **Load material to be pressed to the bottom table.**
2. **Make sure area and ready for indexing.**
3. **Depress the foot-pedal to index the machine.**
4. **Once the pressing cycle is completed, the table will index back out.**
5. **Unload and re-load table for next operation.**

REPLACEMENT COMPONENT PARTS LIST

ELECTRICAL
HEAT AND TEMPERATURE CONTROL COMPONENTS:

(6)PCS-ELN-MX1540	MICA HEAT ELEMENTS-(2)/HEATER BLOCK
(3)PCS-ELN-K120TC	THERMOCOUPLE SENSOR-(1)/HEATER BLOCK
(6)PCS-ELN-HA4890	SOLID STATE HEATER RELAY-(2)/CONTROL
(3)PCS-DKA-CTRLP	220V POWER BOARD
(3)PCS-DKA-CTRLC	PROCESSOR BOARD
(3)PCS-ELN-KM0227A1	MEMBRANE KEYPAD
(2)PCS-ELN-7402K4	TOGGLE SWITCH

INDEXING CONTROL:

(2)PCS-ELN-ONE3MTIME	SINGLE SHOT 180 DPDT TIMER RELAY
(2)PCS-ELN-5B404	10SEC TIME DELAY RELAY
(2)PCS-ELN-SQD8501K	120V 3PDT OCTAL RELAY
(2)PCS-ELN-5YP82	120V DPDT OCTAL RELAY
(2)PCS-ELN-5X361	SPDT MOMENTARY FOOT PEDAL SWITCH
(1)PCS-ELN-3A095	SPDT LEVER MICRO SWITCH
(2)PCS-ELN-MSM5	5 SEC. MINI TIMER CAN
(4)PCS-ELN-TOLOMAG	TOLOMATIC AC MAGNO W/LED

PNEUMATIC
AIR BAG PRESSING COMPONENTS:

(1)PCS-ARN-1B14365	LARGE AIRBAG
(1)PCS-ARN-4ZJ86	EXHAUST FLOW CONTROL
(1)PCS-ARN-NAQ3KN03	QUICK EXHAUST VALVE
(1)PCS-ARN-F1804SK00	½”FILTER
(1)PCS-ARN-55B120	120V 3/8” PORT MAC VALVE
(1)PCS-ARN-R18	PANEL REGULATOR

AIR INDEX SYSTEM COMPONENTS:

(2)PCS-ARN-471AB12	120V-4-WAY DUAL SOLENOID MAC VALVE
(2)PCS-ARN-MXP48	48” AIR BAND CYLINDER
(4)PCS-ARN-EV½	3/8” EXHAUST FLOW CONTROLS
(2)PCS-ARN-NAW20N02CZ	¼”REG-FILT-GAUGE ASSEMBLY

ASSORTED MATERIALS AND COMPONENTS:

(2)PCS-HCR-183040	1/8” X 30” X 40” HEAT CONDUCTIVE RUBBER
(*)YRD-TRM-1005BLK	BLACK GLASS TEFLON FABRIC MATERIAL
(8)PCS-MEN-YR1¼	1¼”OD YOKE CAM FOLLOWER