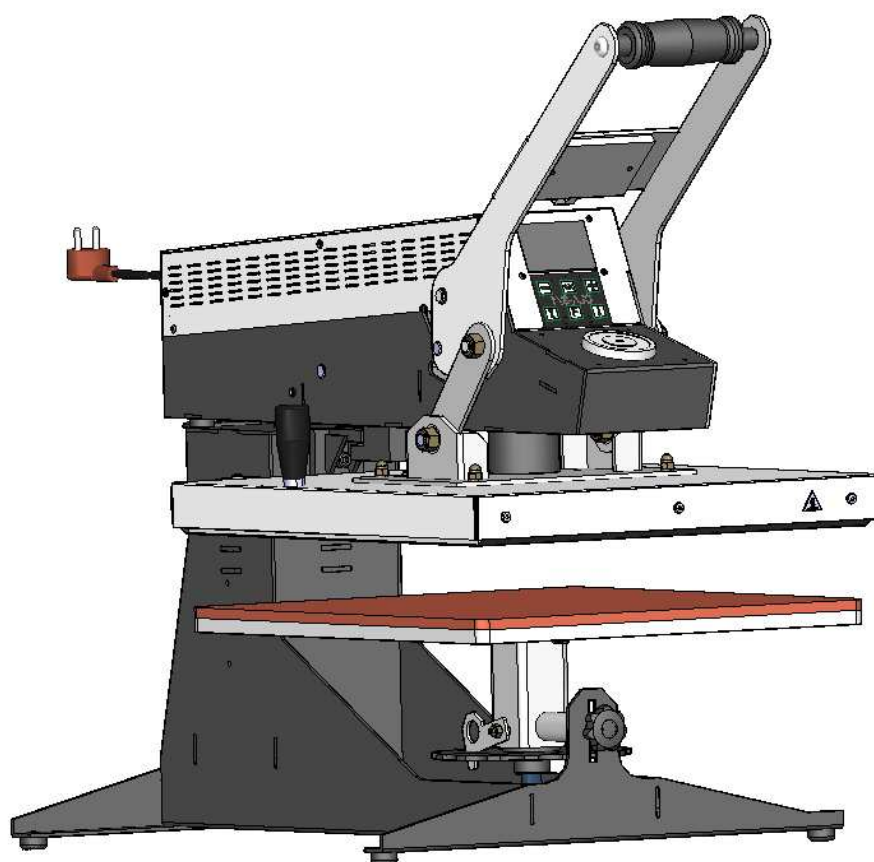


INSTRUCTION MANUAL MAGNET RV(X)(AUTO)



S.E.F.A®

Z.I PASTABRAC - B.P 44
11260 ESPERAZA
FRANCE

Tel :33 (0)4.68.74.05.89 - Fax : 33.(0)4.68.74.24.08

www.sefa.fr

E Mail : contact@sefa.fr

SUMMARY

I.	CONDITIONS OF GUARANTEE.....	2
II.	SPECIFICATIONS.....	3
III.	GENERAL INFORMATION	4
IV.	USE OF THE MACHINE.....	5
1.	SAFETY	5
2.	INSTALLATION	6
3.	DESCRIPTION OF THE RUNNING CYCLE	7
V.	SETTINGS OF THE PRESS	7
1.	TEMPERATURE / PRESSING TIME SETTINGS	7
a)	TEMPERATURE SETTING	7
b)	TIME SETTING.....	7
2.	BOARD PARAMETERS	8
3.	ADJUSTMENT HEIGHT OF COLD PLATE (PRESSING EFFORT)	9
4.	ADJUSTMENT OF AUTOMATIC ROTATION (OPTION).....	10
VI.	ELECTRIC DIAGRAM	11
VII.	SERVICE.....	12
1.	PARTS SUBJECTED TO WEAR AND TEAR	12
2.	REPLACEMENT OF USED PARTS	13
3.	MAINTENANCE	13
4.	ERROR CODE LISTING :	13
5.	REPAIR TABLE.....	14
6.	MAINTENANCE LOG	15

I. CONDITIONS OF GUARANTEE

- The guarantee period starts the day of putting the equipment into service at the user's place, for a duration of one year or 2000 hours.
- The guarantee is strictly limited to our equipments, against the defects of matter and execution, with the buyer's responsibility to prove the known defects.
- Our responsibility is limited to the obligation to rectify or replace free of charge the parts acknowledged as faulty by ourselves, and there will no claim for any indemnity whatever the reason given.
- Parts replaced under guarantee:
 - remain our property,
 - are the subject of an invoicing of deposit.
- A credit of cancellation is activated as soon as the faulty parts are returned. The return will have to occur ONE MONTH MAXIMUM after the intervention.
- **THE GUARANTEE DOES NOT COVER:**
 - the retail consumables such as : fuses, bulbs, transformers, joints, flexible devices, Teflon...
 - the supplies, which are not our own manufacturing, undergo the guarantee of their manufacturer.
- **THE GUARANTEE DOES NOT APPLY:**
 - to replacements, nor repairs which would result from normal wear and tear of apparatus and machines, of deteriorations and accidents coming from negligence, defect of monitoring and maintenance, defective use or modifications without our written agreement.
 - in case of vice coming from the material supplied by the buyer, or a design imposed by the latter.
 - to repairs which would result from deteriorations or accidents occurred during transport.
 - to operations of maintenance and adjustments inherent in the use of the machine, and indicated in the maintenance manual, such as: adjustments of intermediaries, screwing of piping, etc.



For the pneumatic machines, any trace of detergent oil in the pneumatic circuit inhibits the conditions of guarantee previously mentioned.

**For any technical information or spare parts orders,
please give the reference number of the machine as well as its serial number.**

II. SPECIFICATIONS

	Magnet RV	Magnet RVX
<i>Weight in running order</i>	54KG	55KG
<i>Height</i>	555 mm	
<i>Depth</i>	824 mm	
<i>Width</i>	480 mm	
<i>Dimension of the heating plate</i>	400 x 450 mm	400 x 500 mm
<i>Electric power supply</i>	230 V Single Phase + Earth 50/60 Hz	
<i>Power</i>	2500 W	
<i>Amperage</i>	11 A	
<i>Thermo-regulator</i>		
<i>Accurate to</i>	+/- 2%	
<i>Range of control</i>	0 to 250 °C	
<i>Timer</i>		
<i>Accurate to</i>	+/- 1%	
<i>Range of control</i>	0s to 30min	

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

Some of these specifications are mentioned on the company plaque that you will find on the machine.

S.E.F.A®

Z.I PASTABRAC

11 260 ESPERAZA - (France)

Tel :+33.(0)4.68.74.05.89 Fax :+33(0)4.68.74.24.08

MODELE

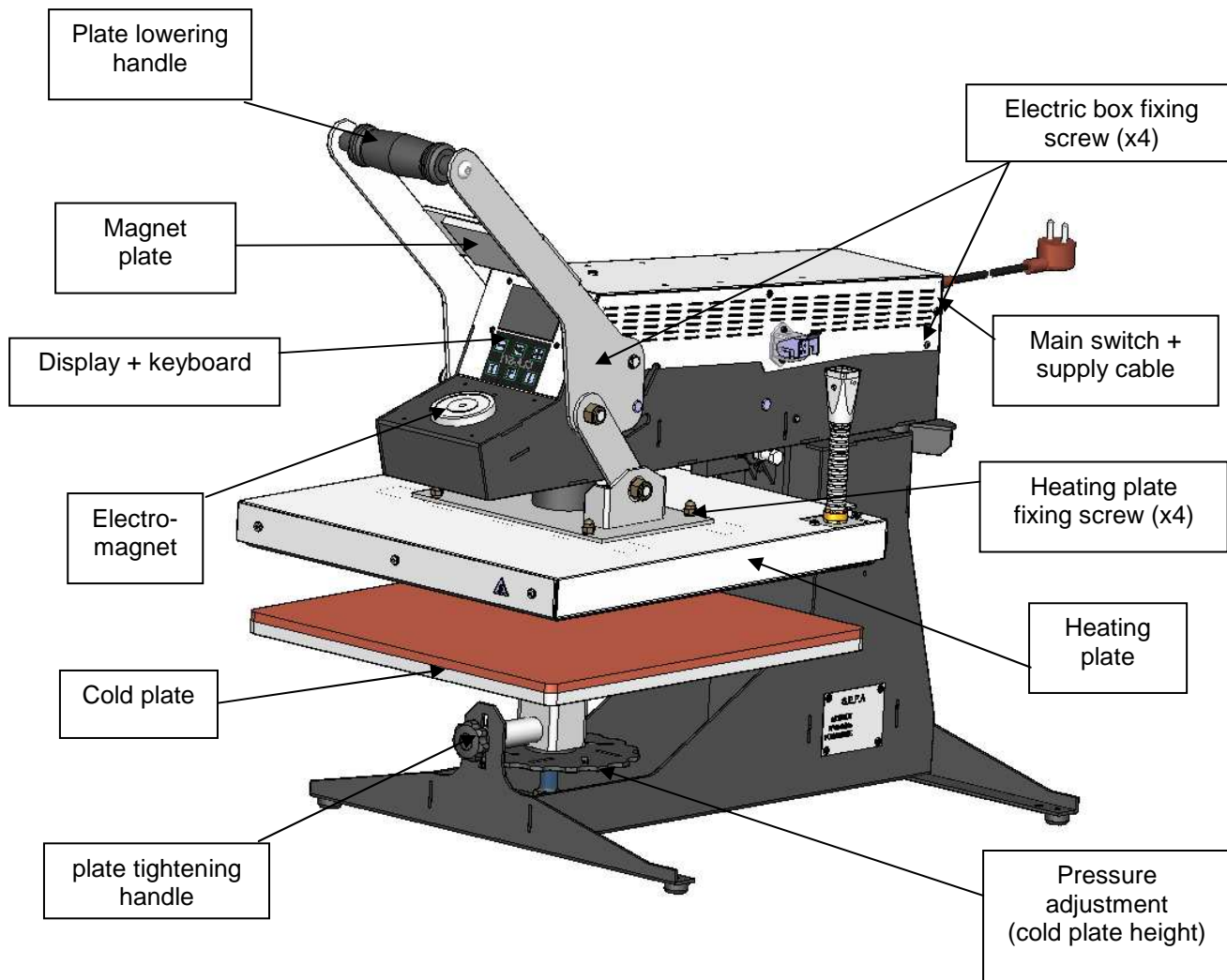
N° de Série

PUISSANCE

CE Année de Fab.

Made in France.by

III. GENERAL INFORMATION



This heat seal press is standard to the article L 233-5 of the labour laws, to ensure the safety of the user. Its design enables it to ensure an intensive production while keeping a total reliability.

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

IV. USE OF THE MACHINE

The MAGNET RV(F) press was designed for the application of all quality transfers in small and medium series. This equipment was tested in our workshops to obtain a one-year guarantee against any manufacturing vice.

The electric and mechanical adjustments realized by our technicians in the workshops as well as the safety measures set on the machine should not be modified in any case. Otherwise, the company **S.E.F.A[®]** will deny all responsibility on potential problems linked to the machine.

Before starting any operation of pressing, it is recommended to read carefully the safety instructions as well as the directions for use.

The press will have to be used by an authorized person having been informed of the risks which can be caused by wrong use of the equipment.

1. SAFETY

THIS EQUIPMENT IS DESIGNED FOR SINGLE USE ONLY

USE BY QUALIFIED STAFF ONLY

International symbols :



OFF



ON



DANGER, WARNING



HOT SURFACE



ELECTROCUTION RISK

You will find most of these symbols on the SEFA machines.

Some significant points for the staff safety:



Avoid touching the hot parts of the machine while in use.



When manipulating the machine, make sure that the operator does not risk anything in term of burn, electrocution or other.



Carry out a daily inspection of the machine before starting the production.



In the zone surrounding the machine, ensure that nobody is around before starting.



If the machine does not work properly, immediately cut the energy supply and look for the cause making use of the book's chapter "Service".

Safety device on the machine:



Protections and security devices should not be modified. They must be put together again in case of possible removal for maintenance. They must be kept in place and in good condition during normal operation.

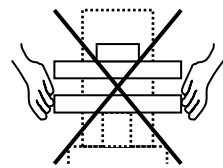
As the MAGNET RV(F) is a manual machine, the risks taken by the operator will only be the consequence of its acts.

2. INSTALLATION

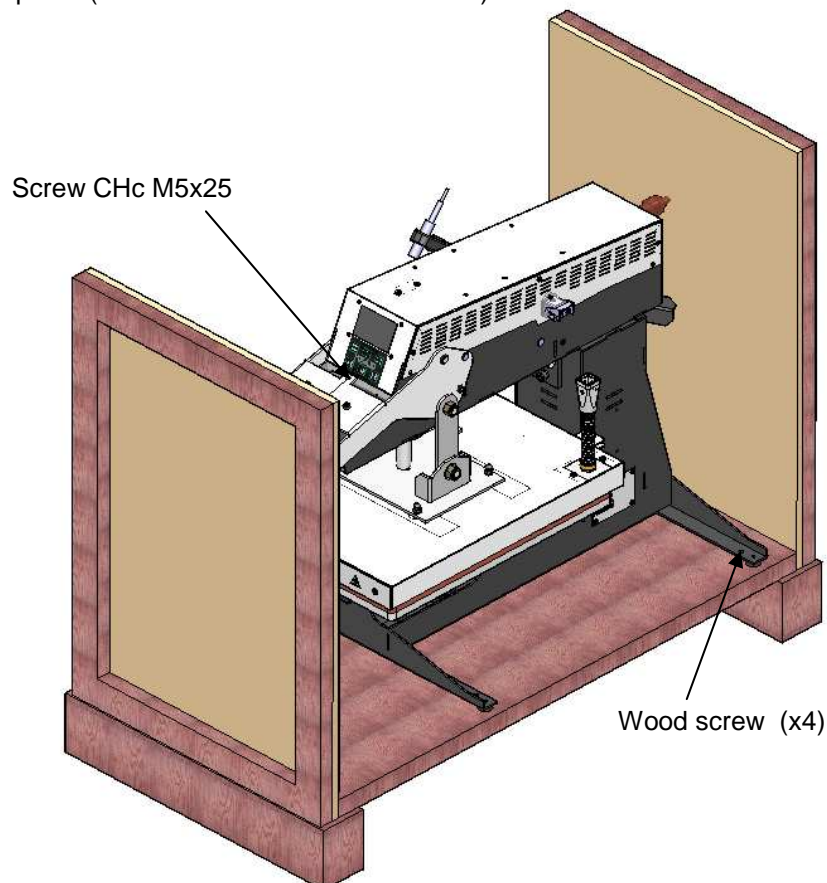
USE BY QUALIFIED STAFF ONLY



**Do not manipulate the machine by the plates!
Handles are provided for the handling of the machine.**



- Remove the cardboard of the packaging.
- With a 10 screw, remove the 4 screws which keep the machine on the packaging.
- Lift and position the press on a table handling it with the handles and/or the feet.
- Remove the screw CHc M5x25 which keeps the press in working position during transport.
- Then the press goes back to the resting position.
- Electrically plug the press (230 Volt + Earth / 50 or 60 Hertz).



3. DESCRIPTION OF THE RUNNING CYCLE

1. The operator will have to power up the machine in using the main switch which is at the back of the frame (the display lights up and after a welcome message, it indicates the values preset in the workshop),
2. Set the temperature with the keyboard (*to define according to the type of transfer*),
See SETTINGS § 1,
3. Set the pressing time with the keyboard (*to define according to the type of transfer*),
See SETTINGS § 1,
4. Adjust the pressure thanks to the wheel situated below the cold plate foot,
See SETTINGS § 2,
5. Position the item to mark on the inferior plate,
6. Adjust the transfer sheet,
7. Lower the heating plate in using the handle,
8. When the plate is in contact with the item, the timer starts its countdown,
9. At the end of the countdown, a buzzer indicates the imminent opening of the plate,
10. The heating plate goes back up automatically.
11. Start the operation again from no. 5 if the settings do not change (otherwise no. 2)

V. SETTINGS OF THE PRESS

USE BY QUALIFIED STAFF ONLY

1. TEMPERATURE / PRESSING TIME SETTINGS

These parameters must be programmed in the control electronic card with the keyboard situated at the front (the parameters will scroll down on the display positioned next to it).

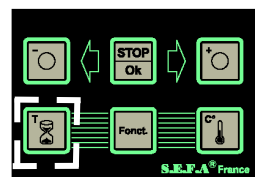
a) TEMPERATURE SETTING

- Press on "Temperature",
- Press on "-" to decrease the indicated value or on "+" to increase it,
- Press on "OK" to validate your choice.



b) TIME SETTING

- Press on "Time",
- Press on "-" to decrease the indicated value or on "+" to increase it,
- Press on "OK" to validate your choice.

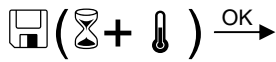


2. BOARD PARAMETERS


Press on "Fonct" key to enter parameters, "+" to scroll parameters, "OK" to enter in and validate, "Fonct" to exit.

"Fonct" > Bi-manuelle > program (T+s) > resetable counter > permanent counter > pre-heating > standby > code

PROGRAMS :



press + to scroll programs (P1 à P5)

press , + or - to modify preheating time, OK

press + or - to modify time pressure, OK

press  to modify temperature, OK

NOTA : the selected program at start will be the edited one in parameters. You need to enter in parameters to change and keep the new program.

RESETABLE COUNTER :



press - > reset counter > press OK (or Fonct to cancel)

PERMANENT COUNTER :



: not modifiable

PRE-HEATING:




press OK, then + to modify ON/OFF


Nota : pre-heating time will be able only if pre-heating parameter is ON.




STANDBY :




: press  to modify > + activate (ON) > OK > + to modify standby temperature, OK > + to modify start standby time > OK > + to modify wake-up time

CODE : press OK to enter a code, + for next digit, ok to confirm and swap to next

100 : time setting :  to enter in, + to modify, OK to confirm

300 :   > ok to enter in **offset** temperature setting >  to modify offset > +/- to change value.



> ok to enter in ALARM parameters at end cycle >  to modify > +/- to change value.



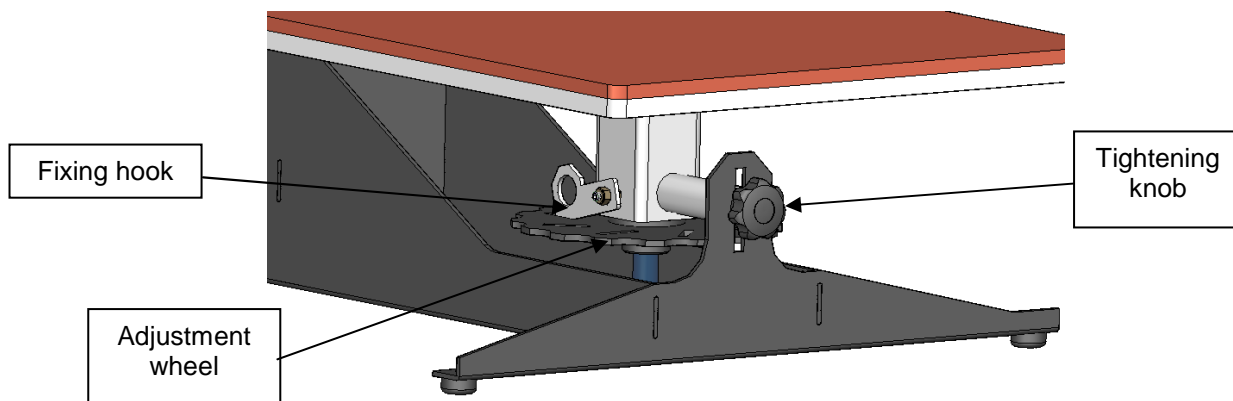
°C/°F

> ok to modify temperature UNIT > + to modify > ok to confirm > Fonct > Fonct to exit.

Adr. MODBUS : > ok to see communication port (switch on board)

3. ADJUSTMENT HEIGHT OF COLD PLATE (PRESSING EFFORT)

The pressure exerted by the heating plate can be modified according to the user's needs. It is also possible to leave a space between the two plates completely lowering the cold plate (maximum space in working position: 25mm).



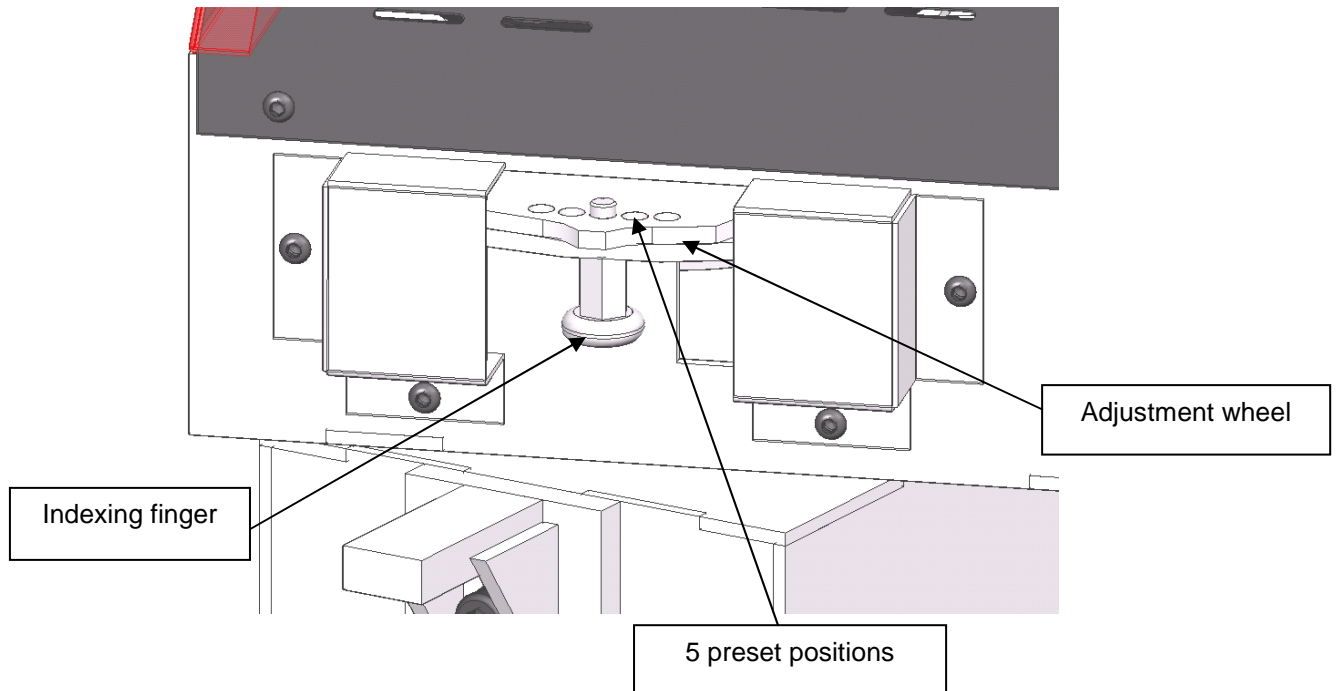
- a) Lift the hook. Loosen the tightening knob (in turning it anticlockwise) until the foot of the cold plate is free. This manipulation enables also to remove the foot + plate set to set up an accessory.
- b) For the cold plate to go up (and increase the pressing effort), turn the adjustment wheel anticlockwise.
- c) To decrease the pressure, turn the other way.
- d) Lower the hook.
- e) Tighten the knob to place the cold plate properly and to fix the pressure adjustment.

4. ADJUSTMENT OF AUTOMATIC ROTATION (OPTION)

At the end of the timer countdown , the heating element goes up and the swing away system opens the machine on the right to free more space above the lower plate.

You can tweak the speed of this rotation.
You can also turn this functionality off.

In order to access this setting : make sure the machine is in open position.
The adjustment wheel is located on the left side in the back of the machine.

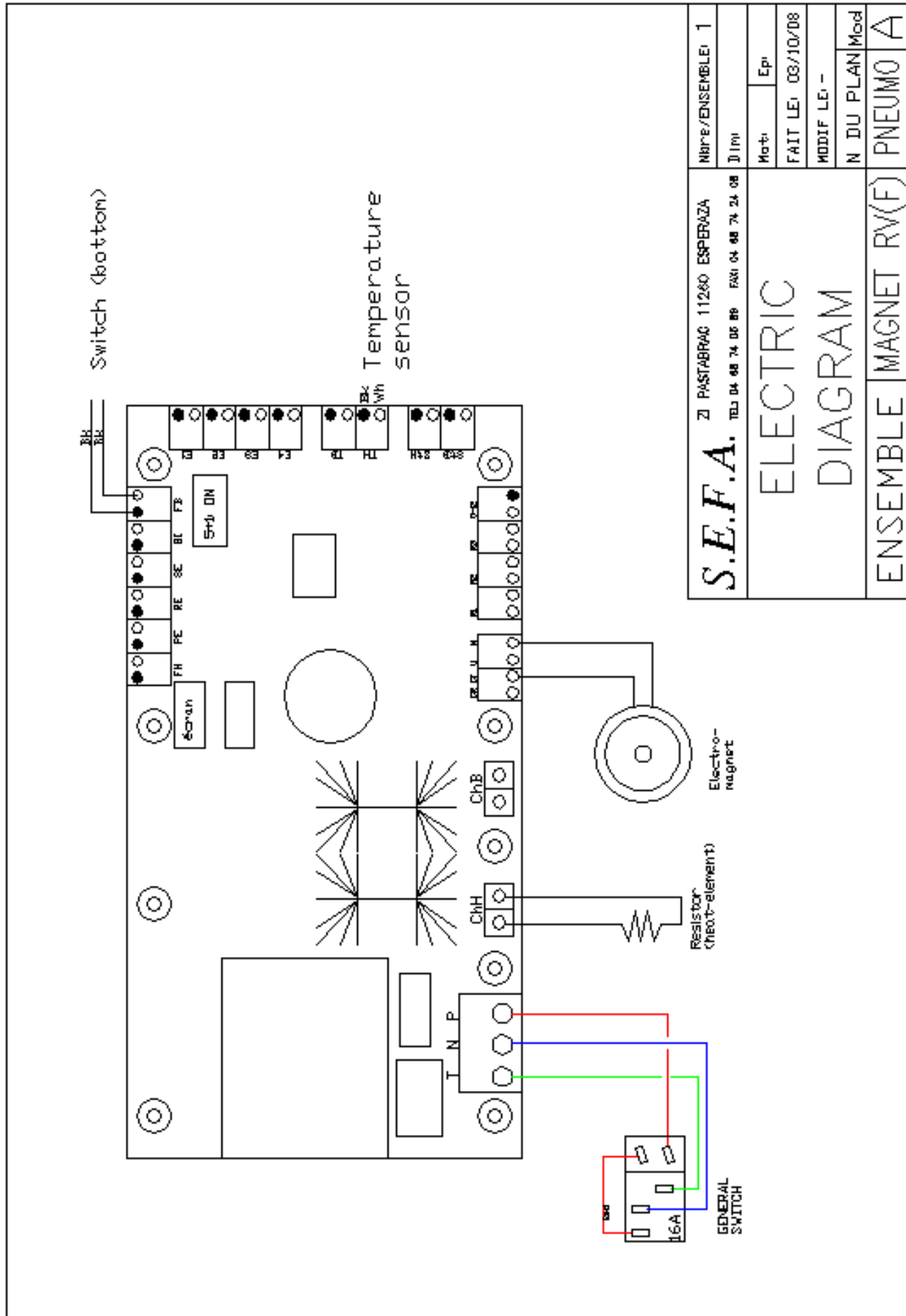


- a) Pull down the indexing finger until the adjustment wheel is free from the locking part.
- b) Spin the adjustment wheel on one of the 5 positions of your choice : to the right to speed up the rotation, to the left to slow it down.
- c) Release the indexing finger and make sure it's locking properly the wheel position you want.

How to turn off the Auto Swing-Away system :

*Pull down the indexing finger completely and while you maintain it in low position, spin it a quarter turn.
Do the reversed process to engage the swing-away system again.*

VI. ELECTRIC DIAGRAM



<p>S.E.F.A. ZI PASTABRAC 11260 ESPERAZA TEL: 04 68 74 06 86 FAX: 04 68 74 24 08</p>	N° RE/ENSEMBLE: 1 J: 1/01
<p>ELECTRIC DIAGRAM</p>	Mat: Epi FAIT LE: 03/10/08 MODIF LE: - N DU PLAN: Mod PNEUMO: A
<p>ENSEMBLE MAGNET RV(F)</p>	

VII. SERVICE

USE BY QUALIFIED STAFF ONLY

**ANY SERVICE INTERVENTION MUST BE DONE WHEN THE MACHINE IS OFF AND LOCKED
(ELECTRIC ENERGY UNPLUGGED)**

It is recommended to have the following tools within reach:

- Bit screwdriver
- Cross blade screwdriver
- A set of end wrenches and box spanners
- Small adjustable pliers
- Circlip pliers
- Long and fine pliers with insulating handle
- A set of Allen keys



Before any handling, check that the temperature of the heating plate is lower than 25°C.

1. PARTS SUBJECTED TO WEAR AND TEAR

On any order: specify the reference, the specification and the quantity

<u>Reference</u>	<u>Specification</u>	<u>Quantity</u>
<u>ELECTRICAL EQUIPMENT</u>		
CAR-RS1	ELECTRONIC CARD	1
ECR-RS1	DISPLAY	1
CLA-371	6-KEY KEYBOARD	1
RES-546	MAGNET RV HEAT ELEMENT MICA 430x380 2250W	1
RES-682	MAGNET RVX HEAT ELEMENT MICA 480x380 2250W	1
VEN-300	ELECTROMAGNET 230V 10W	1
FIN-231	MICROSWITCH 16A 250V	1
FUS-153	FUSE 5x20mmT 16 A 250V	2
	CARD FUSE 1A 250V	1
<u>VARIOUS EQUIPMENT</u>		
RES-DI1	GAS SPRING 200N	2
<u>PRESS COVERING</u>		
MOU-001	SILICONE RUBBER 9 MM	1

2. REPLACEMENT OF USED PARTS

- The silicone rubber mat

- a) check that the plate is cold.
- b) make sure that the surface of the plate is quite clean. If required use a soft solvent such as White Spirit. (NB: As it is a flammable product, use it with caution and keep it away from any heat source)
- c) use a tube of adhesive RTV-1 to stick the rubber to the aluminium plate (NB : read the instructions on the tube packaging).
- d) The mat and the plate must be clean and dry before gluing.
- e) spread out a fine layer of glue in a homogeneous way over the plate and immediately apply the mat making sure that there is no air lock (NB: an indented spatula similar to the one used to lay tiles would suit perfectly).
- f) leave to settle overnight at room temperature with slight pressure and without heat.

- Other parts

Contact your retailer to evaluate their change or their repair.

3. MAINTENANCE

USE BY QUALIFIED STAFF ONLY

The SEFA transfer presses hardly require any maintenance. To ensure a good functioning, follow the preventive notice indicated below:

- Do not heat up objects which could deteriorate or even cut the silicone rubber or damage the teflon surface of the heating plate
- Every so often and when the plate is cold, clean the machine with a clean cloth and white spirit
- When the heating plate is hot and unused, keep it in open position.

DAILY : Clean when cold, clean the heating plate with a dry cloth or impregnated with spot remover.

MONTHLY : Check the axles and lubricate them.

ACCORDING TO THE USE : Change the silicone rubber every 6 months.

4. ERROR CODE LISTING :

SSH/B : HEAT SENSOR DEFECT High/Bottom

RRH/S : RESISTOR out of service High/Bottom

DDD : overshoot 30°C of order

CCC : fall out of 30°C of order

FDC : Sensor still activated at end cycle

TRIAC : TRIAC defect

5. REPAIR TABLE

USE BY QUALIFIED STAFF ONLY

SYMPTOMS	POSSIBLE BREAKDOWNS	REPAIR
The machine will not start	<ul style="list-style-type: none"> ➤ The plug is not in ➤ The switch is not on ➤ The main fuse is out of order ➤ The card fuse is out of order ➤ The display is faulty 	<ul style="list-style-type: none"> ➤ Control your network and if the machine is connected there. ➤ Put main switch M/A on 1. ➤ It is situated in a casing next to the power cable plug. To access it, pull the power cable out, with the tip of a screwdriver lift the fuse casing. You will find in the square tube a replacement fuse to put instead of the one in the clip. ➤ It is located at the bottom left of the card (1A) ➤ Check if the cable is correctly connected otherwise the display unit is out of order.
The plate will not heat anymore	<ul style="list-style-type: none"> ➤ The heat element is faulty ➤ Card problem ➤ Temperature value too low 	<ul style="list-style-type: none"> ➤ Control the connections and the state of the electric wires. To dismantle the heating plate, contact your retailer. ➤ See the messages displayed on the screen and refer to the 4§ chapter VII. ➤ To modify this value, see chapter V
The plate overheats	<ul style="list-style-type: none"> ➤ Sensor or card problem 	<ul style="list-style-type: none"> ➤ See the messages displayed on screen LCD and refer to the card manual. Contact your retailer.
The timer will not countdown	<ul style="list-style-type: none"> ➤ The microswitch of the bracket is not activated or is faulty ➤ Card problem 	<ul style="list-style-type: none"> ➤ Check if this component is properly in contact when the lever is down (a little "click" must be heard). Check its connections. ➤ See the messages displayed on the screen and refer to the 4§ chapter VII.
The plate will not go down	<ul style="list-style-type: none"> ➤ The axles are jammed or too tight ➤ The gas springs are stuck 	<ul style="list-style-type: none"> ➤ Lubricate them or loosen them slightly ➤ Check them but do not try and open them: danger high pressure. Get in contact with your reseller to possibly change them.
The plate stays in low position after pressing	<ul style="list-style-type: none"> ➤ The gas springs are stuck ➤ The timer will not countdown 	<ul style="list-style-type: none"> ➤ There is a leak on the springs. There is not enough pressure for them to ensure the lifting of the plate. Check them but do not try and open them: danger high pressure. Get in contact with your reseller to possibly change them. ➤ See above

6. MAINTENANCE LOG

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

Date	Number of hours	Pressure control	Air filter control	Jacks control	Rubber state	Resistors control	Changed parts	Observations

In order to make the filling out of the table easy, it can be useful to use the following codes :
C : Control CI : Cleaning R : Replacement