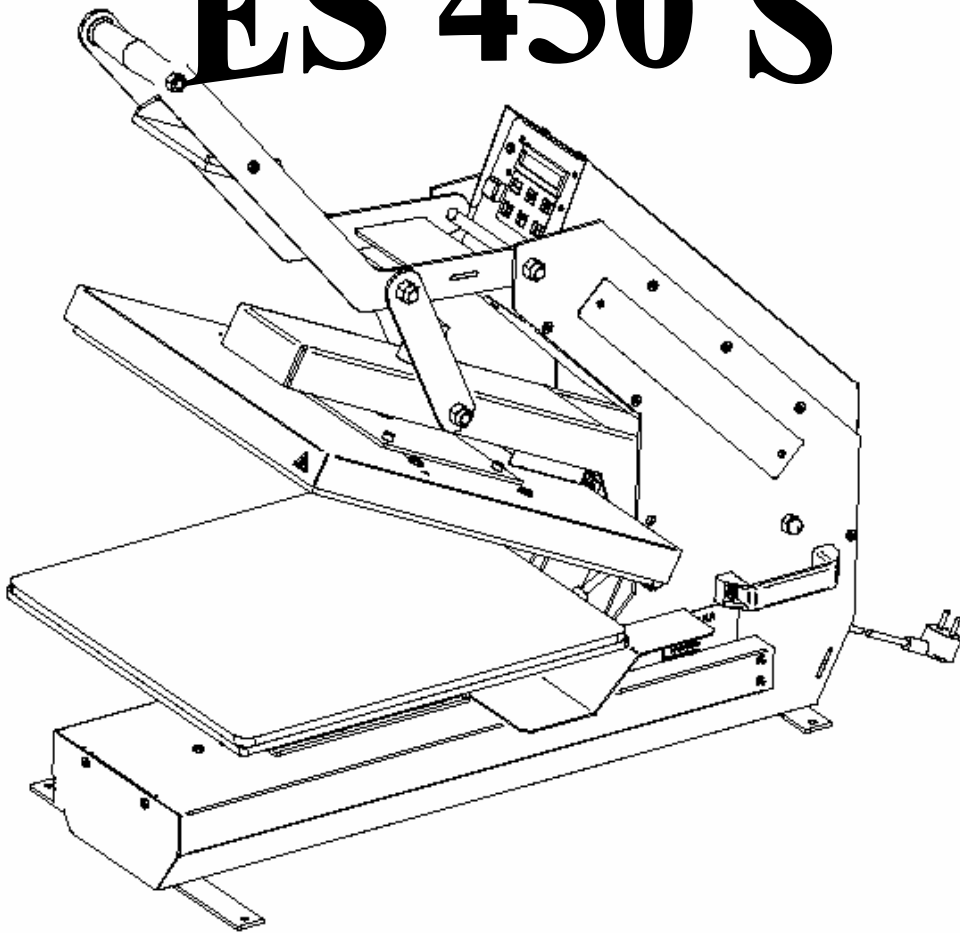


SEFA[®] France

INSTRUCTION MANUAL ES 450 S



CE

S.E.F.A[®]

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V01/05

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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 that is to say 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 the 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, joint, flexible devices, covers...
- 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 do not enter the clauses of guarantee.



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

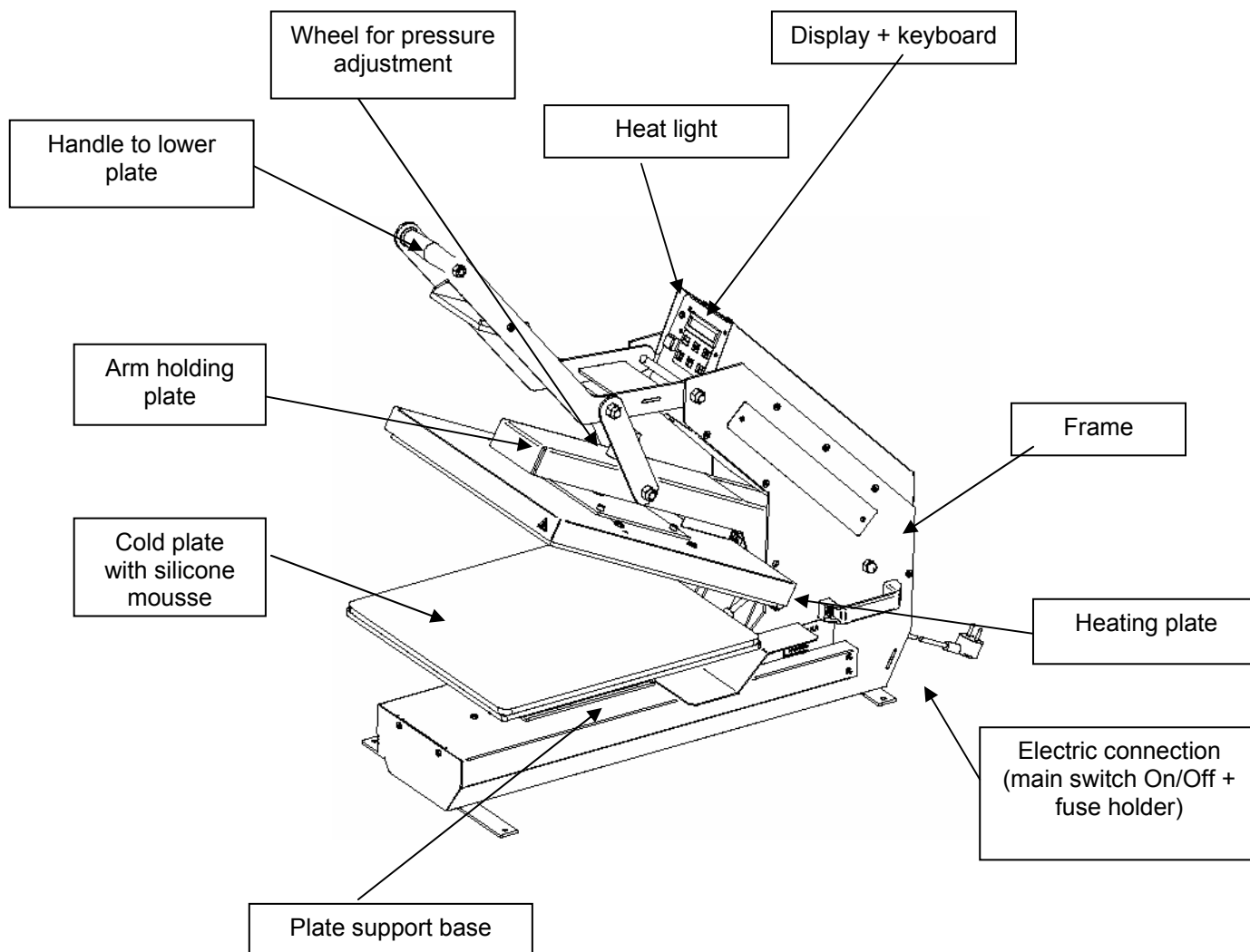
Poids en ordre de marche / Weight in running order	55 kg
Hauteur / Height	610 mm
Profondeur / Depth	750 mm
Largeur / Width	470 mm
Dimension du plateau / Dimension of the heating plate	400 x 450 mm
Alimentation électrique / Electric power supply	220 V Monophased + Earth 50/60 Hz
Puissance / Power	2 250 W
Ampérage / Amperage	10 A
Régulateur électronique de température à affichage digital / Thermoregulator	
Précis à / Accurate to	+/- 1%
Réglable de / Range of control	0 to 250 °C
Minuterie électronique / Timer	
Précis à / Accurate to	+/- 2%
Réglable de / Range of control	1 to 500 sec

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

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

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MODELE	<input type="text"/>
N° de Série	<input type="text"/>
PUISSANCE	<input type="text"/>
CE	Année de Fab. <input type="text"/>
Made in France.by 	

III. GENERAL POINTS



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 press ES450S was designed to apply transfers of all qualities in small and medium mass productions. This equipment was tested in our workshops to obtain a one-year guarantee against any manufacturing vice.

The adjustments (pneumatic, electric and mechanical) realized by our technicians in the workshops as well as the safety measures established 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 so-called 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 a qualified person having been informed of the risks which can be incurred by wrong use of the equipment.

1. SAFETY

THIS EQUIPMENT IS DESIGNED FOR SINGLE USE ONLY

USE BY QUALIFIED STAFF ONLY

Symboles internationaux :



OFF



ON



DANGER, WARNING



HOT SURFACE



ELECTROCUTION RISK

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

Some important points for the staff safety:



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



When handling the machine, make sure that the operator does not risk anything in terms 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.

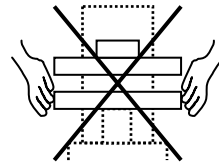
As the ES450S is a machine with manual action, the risks taken by the operator will only be the consequence of his acts.

2. INSTALLATION

USE BY QUALIFIED STAFF ONLY



Do not handle the machine by the plates !



Unpack the machine from its box.
Place it on a stable table handling it by its frame.

After having correctly positioned the equipment on its processing site:

- Electrically plug the press in (220 Volt + Earth / 50 or 60 Hertz)

3. DESCRIPTION OF THE RUNNING CYCLE

1. The operator will have to power the machine up using the main switch which is at the back of the frame (the screen will go on and will indicate the values preset in the workshop after a welcome message),
2. Set the temperature with the keyboard (*to define according to the type of transfer*),
See SETTING § 1,
3. Set the time of application with the keyboard (*to define according to the type of transfer*),
See SETTING § 1,
4. Adjust the pressure thanks to the wheel situated on the arm holding the plate,
See SETTING § 2,
5. Position the item to mark on the lower plate,
6. Adjust the transfer sheet,
7. Lower the heating plate using the lowering handle,
8. When the plate is in contact with the item, the timer will start its countdown,
9. At the end of the countdown, a bell will ring until the operator lifts the plate,
10. Lift the plate,
11. Start the operation again from n° 5 (if the settings do not change, otherwise start from n°2)

V. PRESS SETTINGS

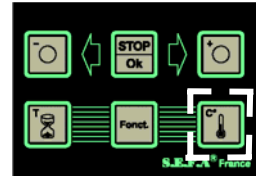
USE BY QUALIFIED STAFF ONLY

1. TEMPERATURE / PRESSING TIME SETTINGS

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

a) TEMPERATURE SETTING

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



b) TIME SETTING

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



2. PRESSURE ADJUSTMENT

The pressure exerted by the heating plate can be modified according to the need of the user.

- Bring down the heating plate against the silicone mousse,
- If they do not make contact (or on the opposite when we force too much on the lever), use the wheel situated on the arm holding the plate:
 - ↻ turning clockwise, you will increase the pressure,
 - ↻ turning anticlockwise, you will decrease the pressure.

VI. SETTING UP OF THE ACCESSORIES

USE BY QUALIFIED STAFF ONLY



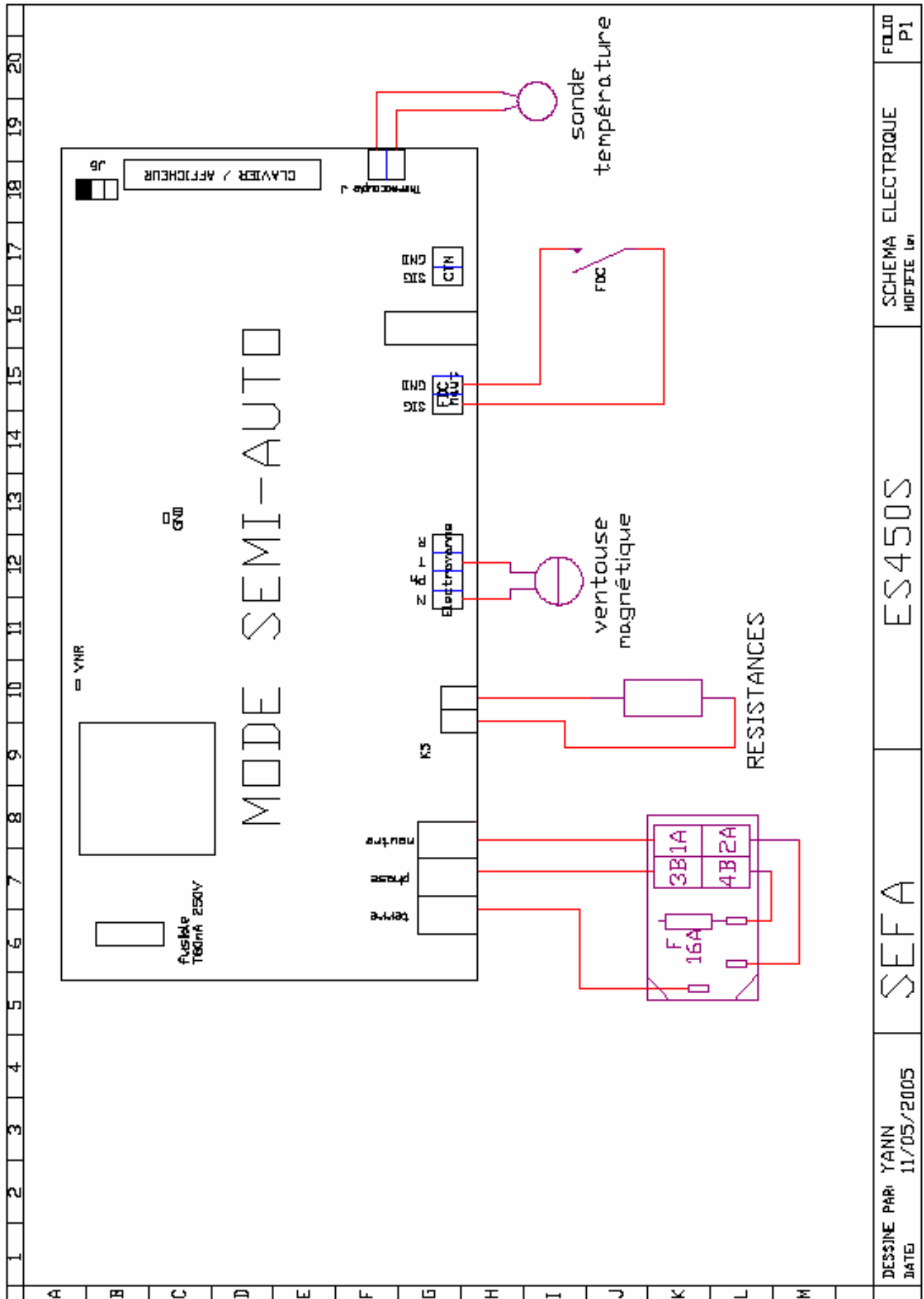
CAUTION: make this operation on cold plate

This machine offers the advantage to be possibly fitted with various accessories:

1. LOWER PLATES OF VARIOUS FORMATS

In this case, it will only be necessary to remove the lower plate unscrewing the bakelite nut (1) which fixes the lower plate to the support and to replace it by the plate required.

VII. ELECTRIC DIAGRAM



FOLIO
P1

SCHEMA ELECTRIQUE
MODIFIEE Lm

ES450S

SEFA

DESSINE PAR: YANN
DATE: 11/05/2005

VIII. SERVICE

USE BY QUALIFIED STAFF ONLY

ANY MAINTENANCE INTERVENTION MUST BE ONE WHEN THE MACHINE IS OFF AND LOCKED (ELECTRIC ENERGY UNPLUGGED)

It is recommended to have the following tools within reach:

- Screwdriver
- Cruciform screwdriver
- A set of box spanners and end wrenches
- 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 below 25°C.

1. PARTS SUBJECTED TO WEAR AND TEAR

On any order: precise the reference, the description and the quantity

<u>Reference</u>	<u>Description</u>	<u>Quantity</u>
<u>ELECTRIC EQUIPMENT</u>		
CAR-XS2	CONTROL CARD	1
ECR-361	FRONT SCREEN VERS.50°C BACKLIT	1
CLA-371	6-KEY KEYBOARD	1
RES-456	MICA RESISTOR 380X430 2250W	1
VEN-300	ELECTROMAGNETIC SUCTION CUP 230V 10W	1
FIN-231	MICROSWITCH WITH TONGUE 16A 250V	1
FUS-153	FUSE 5x20mmT 16 A 250V	2
	CARD FUSE 80mAT 250V	1
<u>VARIOUS EQUIPMENT</u>		
RES-006	GAS SPRING 600N	2
<u>PRESS COVER</u>		
MOU-001	SILICONE MOUSSE 9 MM	400 X 450 mm

2. REPLACEMENT OF USED PARTS

- **Silicone mousse mat**

- a) Check that the plate is cold.
- b) Make sure that the plate surface is properly clean. Possibly use a soft solvent such as White Spirit.
(NB: As this product is flammable, use it with care and keep it away from heat sources)
- c) Use a RTV-1 tube of glue to stick the mousse to the aluminium plate (NB: read the instructions on the tube packaging).
- d) The mat and the plate must be clean and dry before starting gluing.
- e) Spread a fine and homogeneous layer of glue on the plate and apply immediately 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 heat 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 the Teflon plate when cold with a dry cloth or impregnated with spot remover.

MONTHLY: Check the axles and lubricate them.

ACCORDING TO THE USE: Change the silicone mousse every 6 month.

4. REPAIR TABLE

USE BY QUALIFIED STAFF ONLY

SYMPTOMS	POSSIBLE BREAKDOWNS	REPAIR
The machine will not switch on	<ul style="list-style-type: none"> ➤ The plug is not in ➤ The switch is not engaged ➤ The main fuse is out of order ➤ The card fuse is out of order ➤ The display is faulty 	<ul style="list-style-type: none"> ➤ Check your network and if the machine is linked to it. ➤ Put the main On/Off switch on 1. ➤ It is situated in a casing next to the socket of the power cable. To access it, remove the power cable. With the tip of a screwdriver, lift the casing of the fuse. In a square tube, you will find a replacement tube to put instead of the one in the clip. ➤ It is situated on the bottom left of the card (80mA) ➤ Check if the cable is properly connected otherwise it means that the display is out of order
The heating plate will not heat up	<ul style="list-style-type: none"> ➤ The resistors are faulty ➤ Card problem ➤ Temperature value too low 	<ul style="list-style-type: none"> ➤ Check the connections and the state of the electric cables. To remove the heating plate, contact your reseller. ➤ Check the messages displayed on the screen and refer to the card manual. ➤ 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 the LCD screen and refer to the card manual. Get in contact with your reseller.
The timer will not count down	<ul style="list-style-type: none"> ➤ The bracket microswitch 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 in lowered (a small "clic" must be heard). Check its connections. ➤ See the messages displayed on the screen and refer to the card manual.
The plate will not go down	<ul style="list-style-type: none"> ➤ The axles are jammed or too tight ➤ The gas spring is blocked 	<ul style="list-style-type: none"> ➤ Grease them or loosen them slightly ➤ Check it but do not try to open it: danger, high pressure. Get in touch with your reseller to possibly change it.
The plate stays in low position after pressing	<ul style="list-style-type: none"> ➤ The gas spring is blocked ➤ The timer will not count down 	<ul style="list-style-type: none"> ➤ There is a leak on the spring, there is not enough pressure to allow the heating plate to go up. Check it but do not try to open it: danger, high pressure. Get in touch with your reseller to change it. ➤ See above
The plate will not stay in low position	<ul style="list-style-type: none"> ➤ The gas spring(s) is(are) faulty 	<ul style="list-style-type: none"> ➤ Check them, change them if necessary.

5. MAINTENANCE LOG BOOK

The maintenance and check operations indicated in this table must be regularly carried out in order to check the reliability and operating condition of the press.

Date	Number of hours	Axles control	Control of material state	Silicone mousse state	Electric cables control	Observations

In order to facilitate the filling of the table, it can prove to be useful to use the following code:
C : Control CL : Cleaning R : Replacement