

TECHNICAL MACHINE PRODUCTS

5500 Walworth Ave., Cleveland, OH USA 44102

CUSTOMER:

S.O. 21282

O W N E R ' S M A N U A L

OPERATING INSTRUCTIONS

**READ THE "EXPLANATION OF CONTROLS"
AND THIS INSTRUCTION BEFORE
OPERATING THE PRESS.**

Always keep the platens clean.

Always check to make certain there are no foreign objects
between the platens.

Always watch for pinch points.

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AUTOMATIC MODE

Locate the Main Power Handle on the front of the Control Panel. Make certain it is in the ON (or UP) position.

Press Power On to activate the press.

Set the Hot Press required pressing pressure as follows:

- Set Manual/Auto to MANUAL.
- Select Low or High Pressure range.
- Set Low Pressure Off/On to On.
- Hold in both Press Close buttons - at the same time - until the press is fully closed.
- Set the low pressing force by turning the Digital Knob until the desired reading is shown on the pressure monitor. (Clockwise to increase, counter clockwise to decrease.)
- Set Low Pressure Off/On to Off.
- Set the high pressing force by turning the Digital Knob until the desired reading is shown on the pressure monitor. (Clockwise to increase, counter clockwise to decrease.)
- Push the Press Open button.

Set the following switches:

- Manual/Auto to AUTO
- Heat Off/On to ON
- Cooling Off/On to ON
- Vacuum Off/On to ON
- Nitrogen Off/On to ON
- Cool Open Off/On to ON
- Time/Temp. to TEMP.
- Push the Heat Reset Button

Setting each digital Temperature Controller (TC1-4):

- Press and release the Index Button. The previous set point will be displayed.
- Press the UP or DOWN arrows, with a firm pressure, to set the new temperature setpoint.
- Press and release Enter. Wait a few seconds, the display will return to the actual temperature of the platen. Note that each heat zone is clearly labeled.

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- Zone #1 is the top platen edge zone.
- Zone #2 is the top platen center zone.
- Zone #3 is the bottom platen edge zone.
- Zone #4 is the bottom platen center zone.

To program the Cool Open and Time/Temp. Temperature Setpoint Values (TC5):

- Press the Index button once.
- Setpoint 1 (Time/Temperature function) will appear.
- Press Up or Down arrows with firm pressure to change value.
- Press Enter.
- Press the Index button once.
- Setpoint 2 (Cool Open function) will appear.
- Press Up or Down arrows with firm pressure to change value.
- Press Enter.
- Press Index once to exit.

Enter the cycle parameters into the DTAM.

- Push the "F()" Button on the DTAM keypad.
- Enter the desired address from the list below:
 - F(1) Low Pressure Time - XXXX.X MINUTES
 - F(2) High Pressure Time - XXXX.X MINUTES
 - F(3) Air Cool Time - XXXX.X MINUTES
 - F(4) Mist Cool Time - XXXX.X MINUTES
 - F(5) Water Cool Time - XXXX.X MINUTES
 - F(6) Spare - XXXX.X MINUTES
 - F(7) Vacuum Time - XXXX.X MINUTES
 - F(8) Nitrogen Time - XXXX.X MINUTES
- To change that value, enter the new value and press the "ENTER" Button on the DTAM keypad.
- All Cycle times can be set in this manner.

Regarding the Cool Open Selector: If selector is in the Time (Off) position, the press will cool per the cycle times set in the DTAM.

If selector is in the Temperature (On) position, the press will terminate the cycle when the product reaches the setpoint (SP2) entered on the temperature controller (TC5).

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Regarding the Time/Temp. selector: If selector is in the Time (Off) position, the press will go from low to high pressure per the cycle times set in the DTAM.

If the selector is in the Temp. (On) position, the press will go from Low Pressure to High Pressure when the product reaches the setpoint (SP1) entered on the Temperature Controller (TC5).

Load the product.

Plug the product thermocouple into TCJ1. Verify that TC5 reads the proper temperature of the product.

Close the press by pressing both PRESS CLOSE pushbuttons simultaneously. Once the press is fully closed, the buttons can be released and the press will run automatically.

When the Hot Press cycle is completed, the platens will open and the alarm will sound. Push the Alarm Reset button to turn off the alarm.

Push Emergency Stop in an emergency, if a problem arises during operation, or at the end of the work day. Pull or twist to reset.

W A R N I N G W A R N I N G

Always remember to avoid PINCH POINTS.

MANUAL MODE

Read the instructions for the Automatic Mode.

Follow the instructions with the following exceptions:

- Turn the Auto/Manual selector to the Manual position.
- All timing is controlled by the operator.
- After closing the platens, the press will hold set pressure until the Open button is pushed.

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- All functions such as Vacuum, Nitrogen, Heating, and cooling, are operated by the switches and pushbuttons.
- After cooling is completed, the blue Air Cool button is pressed to remove residual coolant from the platens.