

# INSTRUCTION MANUAL

## DUPLEX PRO DUPLEX AIR PRO DUPLEX LITE



**CE**

**S.E.F.A<sup>®</sup>**

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## **WARRANTY CONDITIONS**

The warranty period begins from the day the equipment is commissioning at the user's premises, as evidenced by the return of the guarantee form and the delivery note, for a period of two years for a current use of 8 hours a day, ie 3000 hours.

The warranty is strictly limited to our materials, against defects in material and workmanship. It is up to the buyer to prove the said defects.

Our liability is limited to the obligation to rectify or replace parts, free of charge, recognized defective by us, without being able to claim any compensation for any reason whatsoever.

Replaced parts under warranty:

Remain our property,

Deposit billed

A cancellation credit is triggered upon the return of defective parts.

The return will have to occur ONE MONTH MAXIMUM after the intervention.

### **THE WARRANTY DOES NOT COVER :**

Consumable supplies such as:

- Fuses, LED, gasket, hoses, nozzles, filters ...
- The supplies not being our pure manufacture, are under the guarantee of their manufacturer.

### **WARRANTY DOES NOT APPLY :**

Replacements or repairs that would result from normal wear and tear of the equipment and machinery, damage or accidents due to negligence, lack of supervision or maintenance, defective use or modifications without our written consent.

In the event of a defect originating from the material supplied by the purchaser, nor of a design imposed by this one.

To repairs that would result from damage or accidents occurring during transport.

To the maintenance operations and adjustments inherent to the use of the machine, and indicated in the maintenance manual, such as:

- intermediary settings
- tightening of piping, etc. ...



**For pneumatic machines, all traces of detergent oil in the pneumatic circuit inhibit the guarantee conditions mentioned above.**

**For technical information or ordering spare parts,  
give the machine reference and its serial number.**

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## **CHARACTERISTICS**

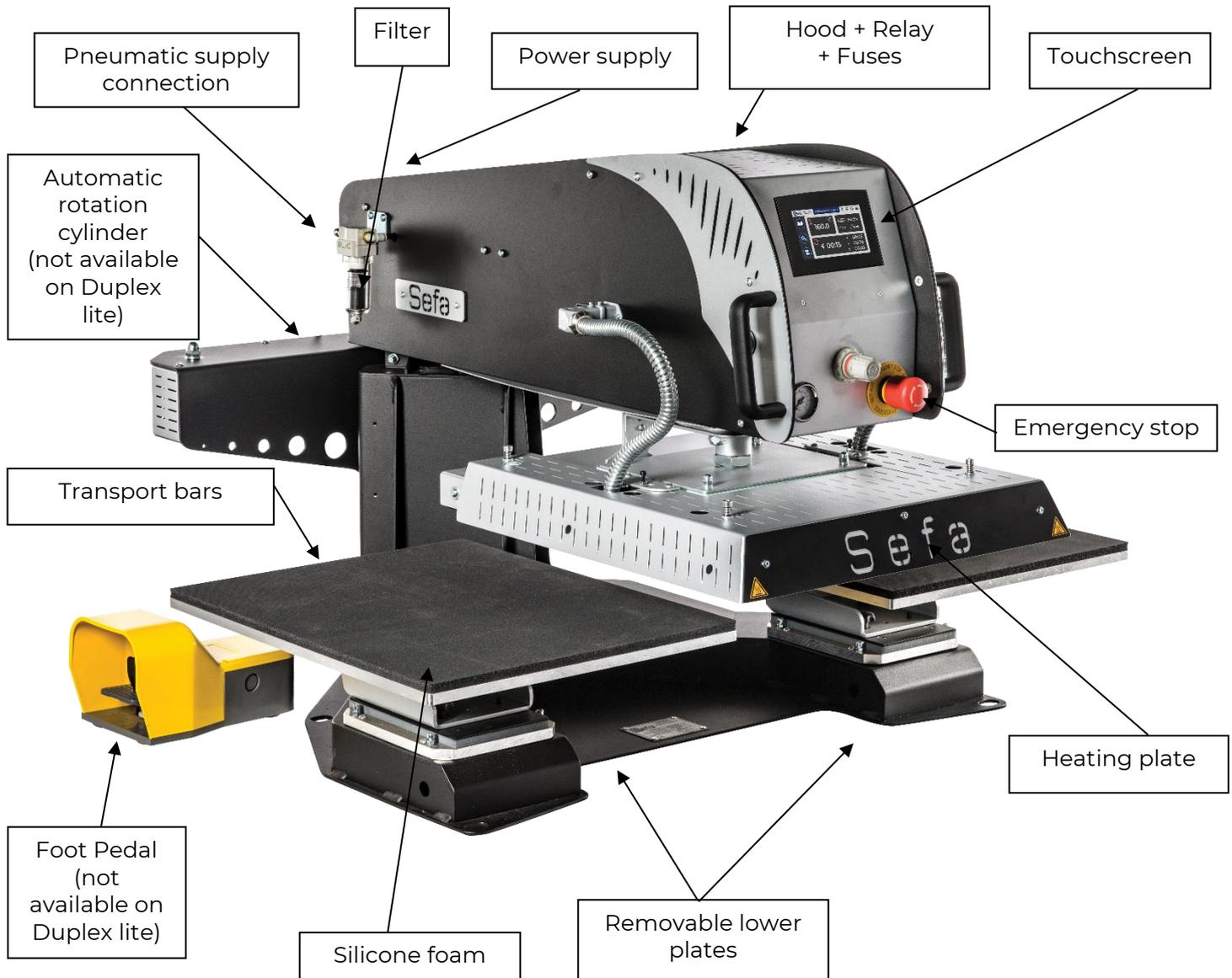
<b>Characteristics</b>	
Weight in working order	193 kg
Height	751 mm
Depth	1005 mm
Width	1071 mm
Dimensions of the plate	400 x 500 mm
<b>Power supply</b>	220/240 V Single phase + Ground 50/60 Hz
Power	3200 W
Amperage	14A
<b>Electronic temperature controller</b>	
Accurate to	+/- 1% of max temperature.
Adjustable from	0 to 220 °C
<b>Electronic timer</b>	
Accurate to	+/- 1%
Adjustable from	0s to 59min 59sec
<b>Terms of use</b>	
Noise	Less than 70 dB (A)
Ambient temperature of use	From 10°C to 35°C
Hygrometry	Less than 90%
Max pressing force	925 daN

Document non contractuel : en fonction des progrès techniques, nous nous réservons le droit de modifier les caractéristiques de nos produits.

## **GENERALITIES**

This hot-pressing machine has been designed to perform intensive production while respecting the article L 233-5 of the Labor Code, to ensure the safety of the user.

This press has been designed for an operator working in front of the machine.



## **USE**

It is recommended to read the "instructions for use" carefully before starting any pressing operation. The press must be used by an authorized person who has been informed of the risks that may be caused by misuse of the equipment.

The adjustments (pneumatic, electrical and mechanical) made by our technicians in the workshop as well as the safety devices installed on the machine must not be modified under any circumstances. Otherwise, the company SEFA will release all responsibilities on possible problems related to the said machine.

## **1. SECURITY**

**THIS DEVICE IS DESIGNED TO BE USED BY ONE USER**

**USE BY QUALIFIED PERSONNEL**

### **a) International symbols**



**OFF**

**ON**



**HOT SURFACE**



**DANGER, WARNING**



**RISK OF ELECTROCUTION**



### **b) Important points**

Obtain personal protective equipment E.P.I. (gloves and glasses for example)  
Do not touch the hot parts of the device during use.

Do not put hands between the trays once the device is turned on.

When handling, ensure that the operator does not risk anything in terms of burns, electrocution or other.

Perform a daily inspection of the machine before starting production.

In the area around the machine, make sure there is no one before starting.

If the machine does not work properly, switch off the power supply immediately and look for the cause (see chapter "Maintenance" in the manual).



### **c) Safety features on the machine**

Protections and safety devices must not be modified.

They must be reassembled in case of possible removal for maintenance.

They must be kept in place and in good condition during normal operation.

The DUPLEX PRO is equipped with safety systems that protect the operator from pinching.

The main security features are:

### **d) Emergency stop**

Located on the front of the machine: if the operator activates it, it turns off the machine.

### **e) Security guard**

Above the upper heating plate are two tab switches.

This system prevents the risk of pinching and crushing the operator.

If the system detects an obstacle, the heating plate rises, the rotation is deactivated immediately and the press goes into safety mode.

You must press the red zone on the "Alarm" page, position the stem above one of the lower plates and press the pedal so that the machine is functional again.



**f) Verification of the operation of the safety device**

Try the emergency stop and the safety cover daily.

**g) After an emergency stop**

In order to restart the nominal operation, check if there are any other problems on the machine. Unlock the emergency stop by turning the red part: the machine will reset automatically.

**h) Manual**

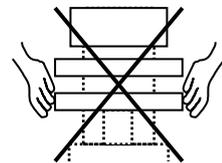
It is provided during the delivery of the machine, technical documentation on the components used. Please read it before handling the SEFA machine.

**2. INSTALLATION OF THE MACHINE**

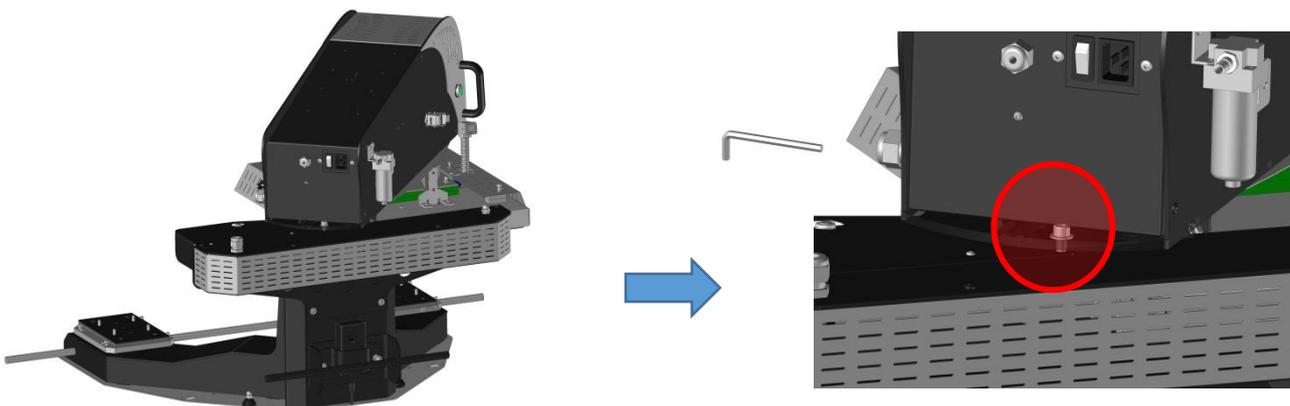
**USE BY QUALIFIED PERSONNEL**



***Do not handle the machine by the trays!***



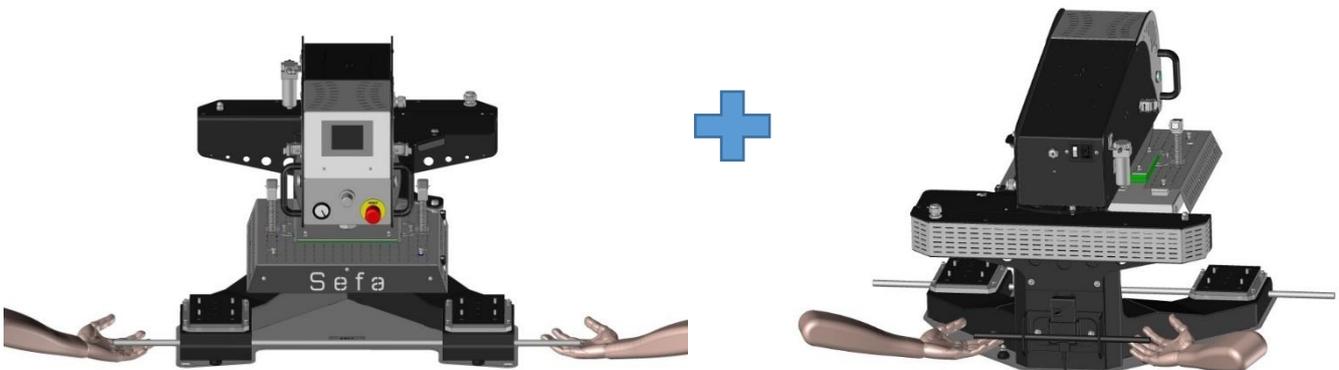
Cut the straps from the crate and unscrew the screws holding the cover and the bell. Remove the lid and the bell from the box.  
Remove the plastic bag protecting the machine.  
Remove the lag screws that secure the machine to its pallet.  
After removing the packaging, remove the security screw using the Allen key 4 provided.



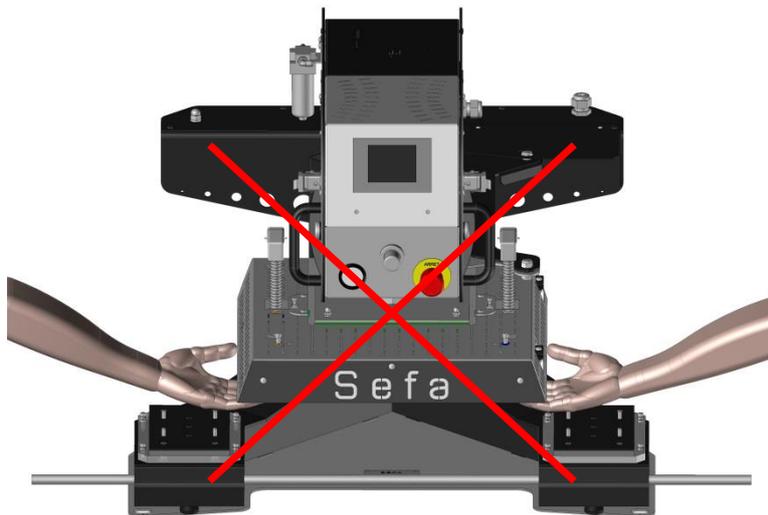
Center the machine between the two plates.



Position the transport bars and handle the machine only by them.



Warning ! Do not lift the machine by the trays.



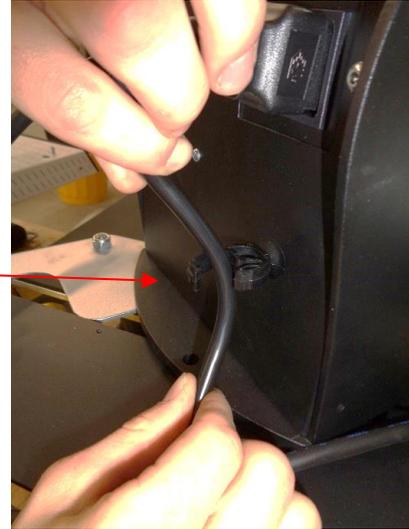
Fix the machine on a stable and level table by manipulating it with the transport bars.  
Position and secure the bottom plates if it is not done.  
Remove and store the transport bars with the machine box in case of future transport of the machine.

### **3. START-UP**

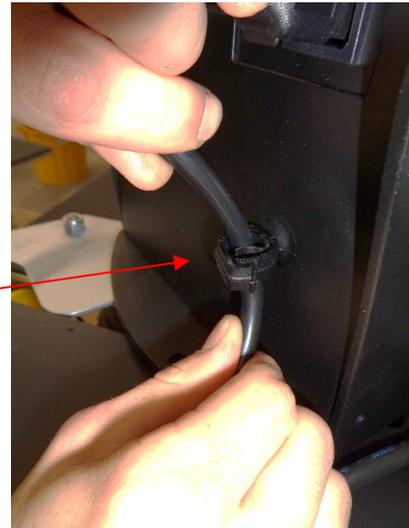
Supply compressed air to the machine. The compressor must provide at least 4 bars.  
Power the machine with the supplied power cord.

Position the button on the back of the stem to "1" and check that the emergency stop button on the front of the stem is unlocked. Clipper the cable as described below:

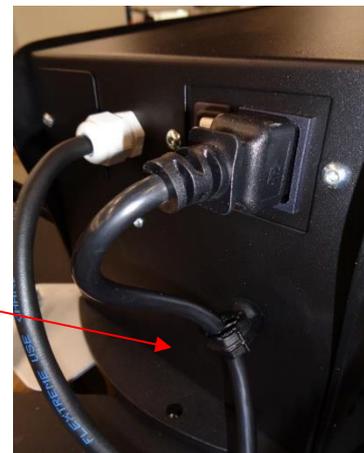
Place the power cable facing the notch



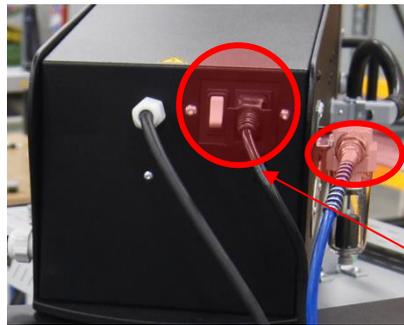
Push the cable until you hear a "clac"



Your cable is now fixed



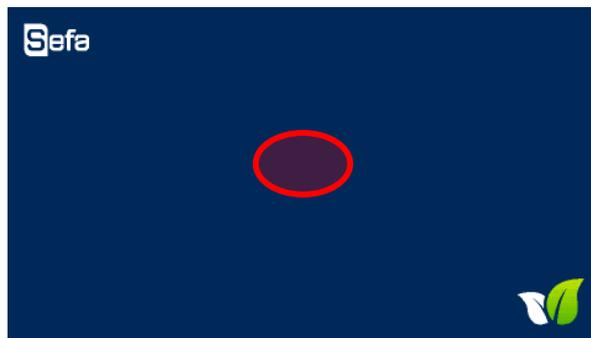
Turn on the machine by flipping the main switch on the back of the machine.



Pneumatic network connection

Electrical connection  
230VAC-20A

The touch screen will display the following start page:



Tap the screen to access the following pages.

This machine must be used by qualified personnel. When powering up, the temperature control, PLC and power supplies are energized.

#### 4. CONTROL PANEL



- 1) Measured temperature and temperature setting (0 to 220 ° C): The numbers are
  - a. Red when the temperature is above the set value
  - b. Blue when the temperature is below the set value
  - c. White when the temperature is at the set value
- 2) Time
- 3) Name of active recipe
- 4) Status bar (Heat – Cycle – ECO mode – Warning)
- 5) Daily counter / Working mode
- 6) Active timer
- 7) Next timers (4 possible timers)
- 8) Recipe button
- 9) Settings button
- 10) Exchange plate button – STOP during cycle 

The green start buttons and foot pedal allow the start of the pressing cycle. This action is only possible on this page.

For shutdown two modes exist:

- 1) STOP button : The heating plate goes up and the press stop moving.
- 2) Press the Foot Pedal or green button: the plate goes up, moves to the opposite position and stops.



## **5. SETTINGS**

### **a) Temperature**

Touch the area of the screen where the temperature is indicated.  
Press the temperature setting.  
A numeric keypad appears to enter the new value.  
This value is immediately entered in the current recipe.  
Press the arrow at the bottom right to return to the work screen.



### **b) Timers**

Touch the area of the screen where the timers are indicated.  
Then enter using the numeric keypad each value of the timers.  
Press the arrow at the bottom right to return to the work screen.  
These values are immediately entered in the current recipe.



### **c) Counters and Modes**

Press 3 seconds on  to reset the daily counter  
A totalizer is located below.

To change the operating mode press the following button:

- Mode single plate
- Mode Semi-Auto (pedal)
- Mode Auto



### **c) Rotation Speed**

Contact your official SEFA distributor to adjust this setting.

## **6. DESCRIPTION OF THE OPERATING CYCLE**

### **a) For Duplex LITE**

1. Place the item on the lower tray.
2. Adjust the transfer sheet.
3. Move the swing arm away the platen you want to work.
4. Push and maintain during 3 seconds the 2 bimanual buttons
5. Heat platen will lower and the press timer will start
6. Use this time to prepare the next work item and transfer sheet on the second workstation.
7. The heat platen will lift open when the timer has finished
8. Remove the work item from the first workstation and get the next one ready.
9. Repeat from step three above.
10. Pressing the stop button during a cycle will stop the cycle.

### **b) For Duplex PRO**

Place the hating plate on the opposite side to where you want to work.  
Test by pressing the pedal or the green push button to validate your choice.

1. Place the item on the lower tray.
2. Adjust the transfer sheet.
3. Press the start pedal cycle. The stem automatically moves to the tray, the warming plate automatically descends and activates the press timer.
4. Meanwhile, prepare the item and its transfer sheet on the second station.
5. At the end of the countdown of the timer, the heating plate will go up again.
6. If the machine is not in "FULL AUTO" mode, press the pedal. Otherwise the rotation will be done automatically after raising and counting the "timer after pressing" (see 5.c Counters and Modes)
7. Remove the item from the first item and prepare the next item.
8. Repeat the operation at the third point.

During the cycle, pressing the pedal or one of the green pushbuttons stops the cycle and releases the stem from the opposite side.



During the cycle, pressing the stop button  on the screen stops the pressing cycle.

### **c) For Duplex AIR PRO**

Place the hating plate on the opposite side to where you want to work.  
Test by pressing the pedal or the green push button to validate your choice.

1. Place the item on the lower tray.
2. Adjust the transfer sheet.
3. Press the start pedal cycle. The stem automatically moves to the tray, membrane swells then the warming plate automatically descends and activates the press timer.
4. Meanwhile, prepare the item and its transfer sheet on the second station.
5. At the end of the countdown of the timer, membrane deflates and the heating plate will go up again.
6. If the machine is not in "FULL AUTO" mode, press the pedal. Otherwise the rotation will be done automatically after raising and counting the "timer after pressing" (see 5.c Counters and Modes)
7. Remove the item from the first item and prepare the next item.
8. Repeat the operation at the third point.

During the cycle, pressing the pedal or one of the green pushbuttons stops the cycle and releases the stem from the opposite side.

During the cycle, pressing the stop button  on the screen stops the pressing cycle.

## **7. PARAMETERS**

### **a) Status bar**

The status bar allows you to know the status of the machine on any activated page.



Heating status :		Blue flake = Stop
		Red flame = On. Blinks between the two states in regulation.
Cycle :		Machine ready to work.
		Cycle in progress (Rotating arrow).
Eco mode :		Eco mode OFF
		Eco mode ON
Warnings :		No warning
		Warning activated

No action is possible. It's just an information.  
Time is defined in the section [page 17](#).

**b) Digital keypad**

The numeric keypad allows you to enter values such as temperature or times. An alphanumeric keyboard allows you to enter the name you want to give to the recipe.



**c) Recipes**

The system is designed to receive up to 6 different recipes. Each recipe can be renamed with 16 characters. You can access the appointment page for recipes and choice of regulation as follows:



The recipe store :  
The name  
The type of regulation  
4 different timers



These values are summarized in the following page:

The following regulations are available for each type of product:

- Flex and flock, screen-printing transfers, laser transfers, flex in less than 5 seconds, pressing of digital printed textiles, sublimation textiles = TEXTILE
- Drying of pretreatment on textiles = DTG
- Sublimation of rigid materials = RIGID

To leave the page, you must first save the recipe even if there has been no change. The exit button at the bottom left of the screen, appears to leave the page.



**d) Setting menu and diagnosis**



Push the button  on the left of the screen to access the settings.  
Click on the desired menu to access it.  
Press the arrow on the bottom right to get out.

Settings (Buzzer, timers, etc.)



ECO Modes (2 pages)



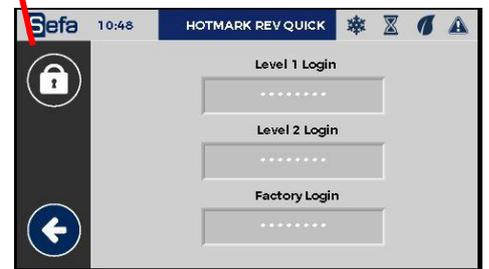
Firmware information



Time

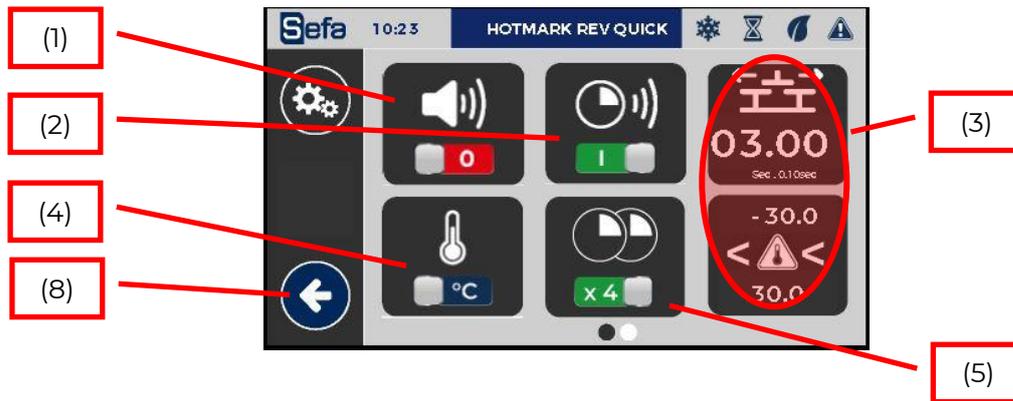


Diagnosis (I/O, warnings)



Protected access

**e) Ergonomics settings**



- (1) Buzzer ON/OFF = Disables or activates the buzzer when touching the screen and at the end of the cycle. The buzzer remains operational in the event of a fault (5 rings).
- (2) Buzzer « End of cycle » ON/OFF = ring 2 seconds before the end of the cycle.
- (3) Access to the page "Rotation - temperature range"
- (4) Unit change : allows to change temperature unit (° Celsius or ° Fahrenheit)
- (5) Choice of number of timer: 3 positions → single timer, 2 timers or 4 different timers and configurable.
- (6) Switching delay: In auto mode, wait for rotation of the stem before the next cycle (in seconds and tenth of a second).
- (7) Operating temperature range of the machine: allows the start of the cycle to be conditioned when the temperature has not yet been reached or exceeded.
  - a. Minimum : from -30 to 0°C or from -86 to 0°F.
  - b. Maximum : from 0 to 30°C or from 0 to 86°F.
- (8) Back to Menu



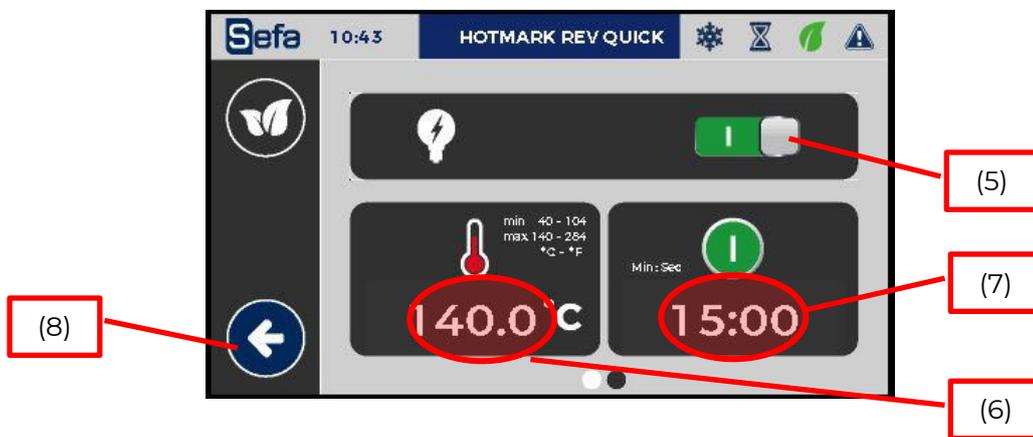
**f) Energy Mode**

The energy mode has two settings: a long standby setting and a short standby setting.

The long standby mode puts the machine into hibernation for the time defined by the two parameters. The temperature is then turned off, it will drop to room temperature. (No energy consumption). If the machine is in automatic mode, it stops at the set time. The program displays the idle page to indicate that it is paused. The brightness decreases and oscillates slightly. This mode also allows an early start of the heating, for example before taking post. For this, it is necessary to leave the machine under tension.



- (1) Extended standby mode ON / OFF.
- (2) Setting the sleep time.
- (3) Setting the heating time.
- (4) Next page: short sleep.
- (5) Short standby mode ON / OFF.
- (9) Short standby temperature.
  - a. Minimum: 40 ° C or 104 ° F.
  - b. Maximum: 140 ° C or 284 ° F.
- (6) Period after which the machine goes to standby when there has been no pressing of the green push buttons or the pedal, no press on the screen or an active output (press cycle).
- (7) Return to the previous screen.



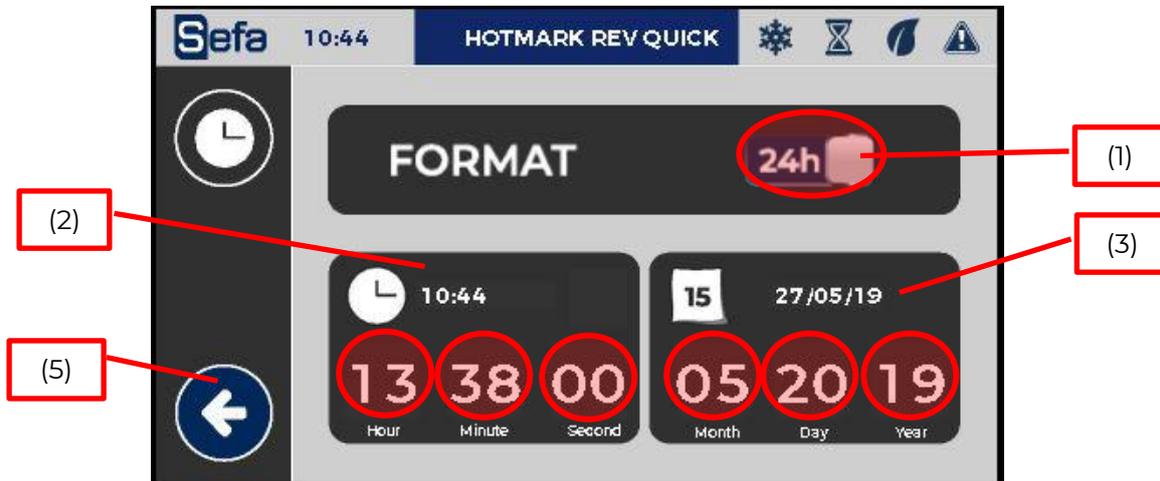
Short standby will lower the temperature after a time of inactivation (no cycle, no touch on the screen). The program displays the idle page to indicate that it is paused. The brightness decreases and oscillates slightly.

Regarding the temperature, in eco mode, it is impossible to ask for a lower temperature than the set point of the current recipe. In standby mode, it is impossible to ask for a temperature higher than the temperature of the eco mode.

To exit the energy saving modes in progress, a touch on the screen is sufficient and deactivates the mode (Button on "o").

**g) Time / Language**

- (1) Set the time format
- (2) Set the time value
- (3) Set the date value
- (4) Set AM or PM
- (5) Back to MENU



***Procedure to set the date:***

- a. Choose format
- b. Set time
- c. Set date
- d. Check values
- e. Back

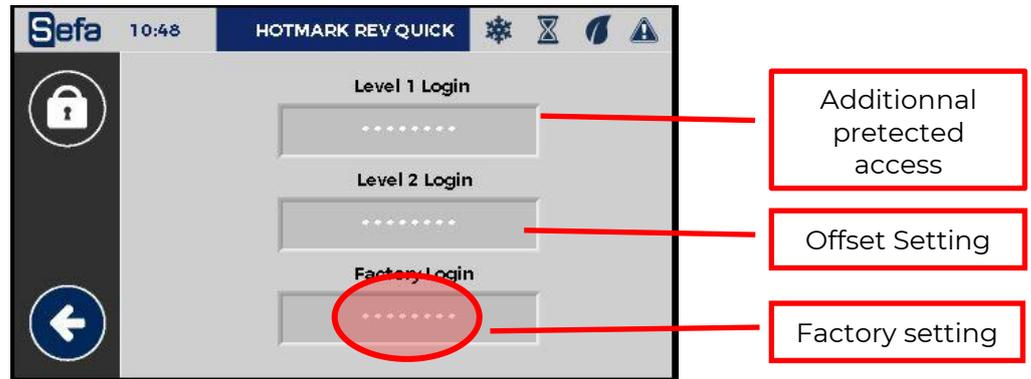
**h) Information**

Manufacturer – Firmware version.



***i) Factory settings***

Change the factory settings, vital settings for the machine. Changing them voids the warranty. Enter the password in the field dedicated :



**8. DIAGNOSIS**

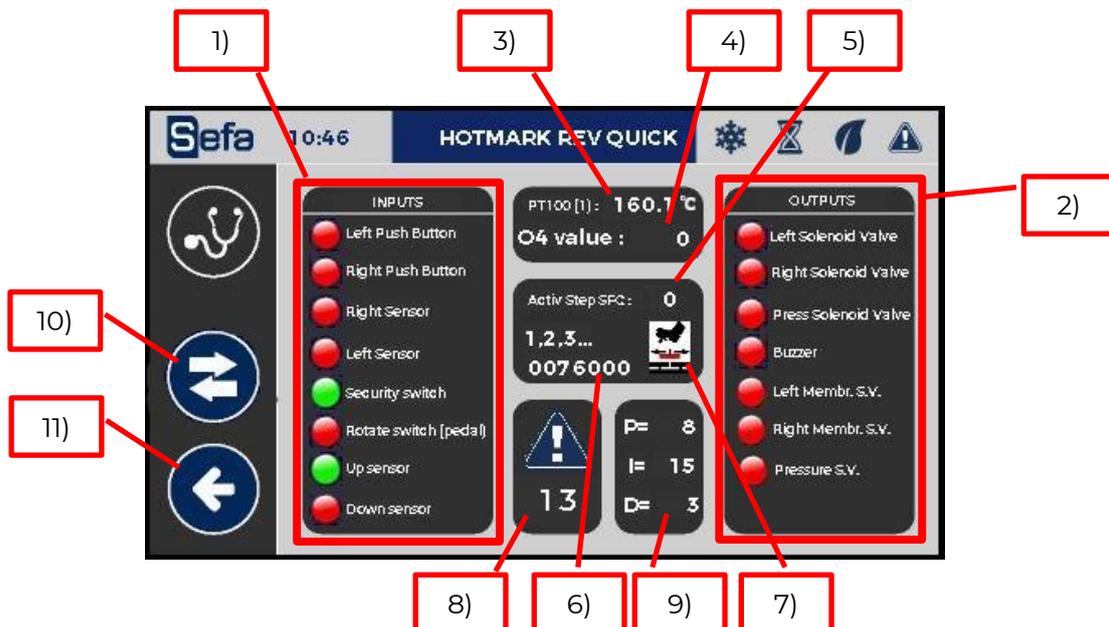
To know the status of the inputs / outputs of the PLC.

On this page all operating cycles are possible by pressing the pedal and the green buttons.

Arrêt possible par l'appui du bouton 

No action possible. This screen is used for troubleshooting and evaluating sensor and actuator states. The support service can ask the operator to display it during a telephone intervention for example.

- 1) Inputs
- 2) Outputs
- 3) Temperature in ° Celsius or ° Fahrenheit
- 4) Analogue value of the static relay (resistance control) (0 to 1000 pts)
- 5) Active SFC Step: number of the active step during the cycle (0 to 10)
- 6) Totalizer counter (no reset)
- 7) Active mode: FULL AUTO, SEMI AUTO, 1 POST
- 8) Alarm in progress: access summary page alarms
- 9) PID control type (based on PID values)
- 10) Change plate and stop cycle button
- 11) Back to previous page



**a) Alarms and warnings**

If a fault is detected, the machine is in STOP mode   
Following screen is displayed :



Press the red area to acknowledge the fault and the job page is displayed.

If an event is detected, the machine is Waiting   
Following screen is displayed :



Press the orange area to acknowledge the fault and the job page is displayed.

If the event is not acknowledgeable, the above page remains displayed. To exit, press the back button to see which one is still present in the list of activated alarms. (press on the flashing triangle).

- (1) Blinking indicator active fault
- (2) Access to the Default page (flashing LED)
- (3) Back to MENU



**b) Summary Alarms-Events**



If the problem that caused the fault (faulty sensor, lack of air, temperature problem) is solved, the fault light goes out automatically.



: Removes unpaid defects that are no longer in progress (repair done).  
If this support is not enough, stop and restart the machine (press the emergency stop).

**List of alarms / events :**



Active fault



Inactive fault

Alarm 00 : PT100 sensor		Loss of signal from the sensor (sensor or cable). The heating control is instantly deactivated.
Alarm 01 : Overheat Temperature over 220°C		Temperature is over 230°C. The heating regulation is instantly deactivated.
Alarm 02: Plate security activated		The detection is immediate. Heating control and pressing are instantly deactivated.
Alarm 03 : Temperature regulation trouble (Static relay or other)		Indicates the abnormal difference between the activation of the analog output and the delta of the corresponding temperature. (Cable, resistance or static relay problem).
Alarm 05 : Pressing upper sensor not reached		Signal not detected after 5 seconds. Result of sensor failure, lack of compressed air supply, mechanical lock, ...).
Alarm 06 : Pressing lower sensor not reached		Signal not detected after 5 seconds. Result of sensor failure, lack of compressed air supply, mechanical lock, ...).

Alarm 8 : Right sensor rotation not achieved		Signal not detected after 5 seconds. Result of sensor failure, lack of compressed air supply, mechanical lock, ...)
Alarm 08: Left sensor rotation not achieved		Signal not detected after 5 seconds. Result of sensor failure, lack of compressed air supply, mechanical lock, ...)
Alarm 10: Temperature setpoint not reached.		Temperature during rise or fall trips before + or - 30 ° C around the set point. Extra push on green Button and / or pedal in the minute starts pressing
Alarm 11: Change of temperature unit (Celsius or Fahrenheit)		Occurs when you change the unit of temperature. Prevents the operator in case of unwanted selection.
Alarm 12 : Maintenance required (not activated on 27/05/2019)		unavailable
Alarm 13 : Sensors left or right not reached. Movement impossible.		It activates when the operator presses the pedal or the green buttons while the press is not above a plate.
Alarm 14 : PLC battery		End of life (shelf life: 7 years at 20 ° C)

## **9. OPERATING CYCLE**

### **a) Operating mode**

The DUPLEX PRO can operate according to 3 cycle variants:



Semi-automatic pedal mode: after pressing the pedal, the stem changes its position and presses.

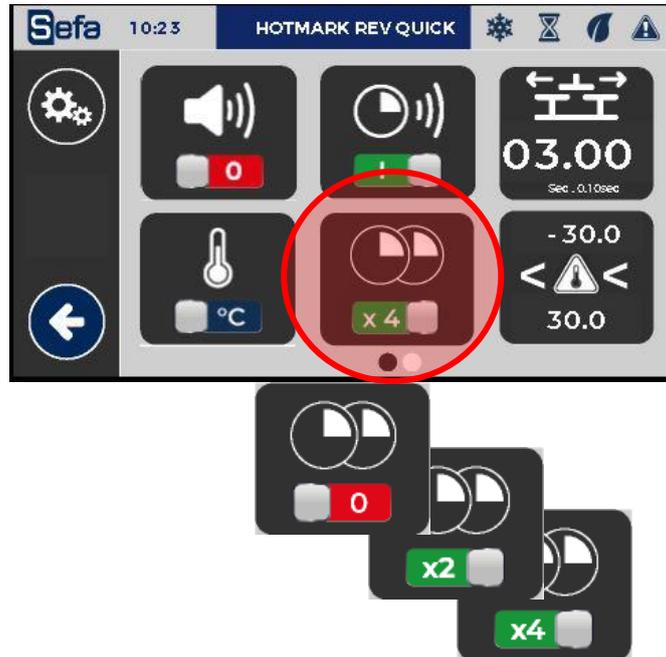


Single post mode: After pressing the pedal, the stem changes its position, presses, and returns to the starting plate.



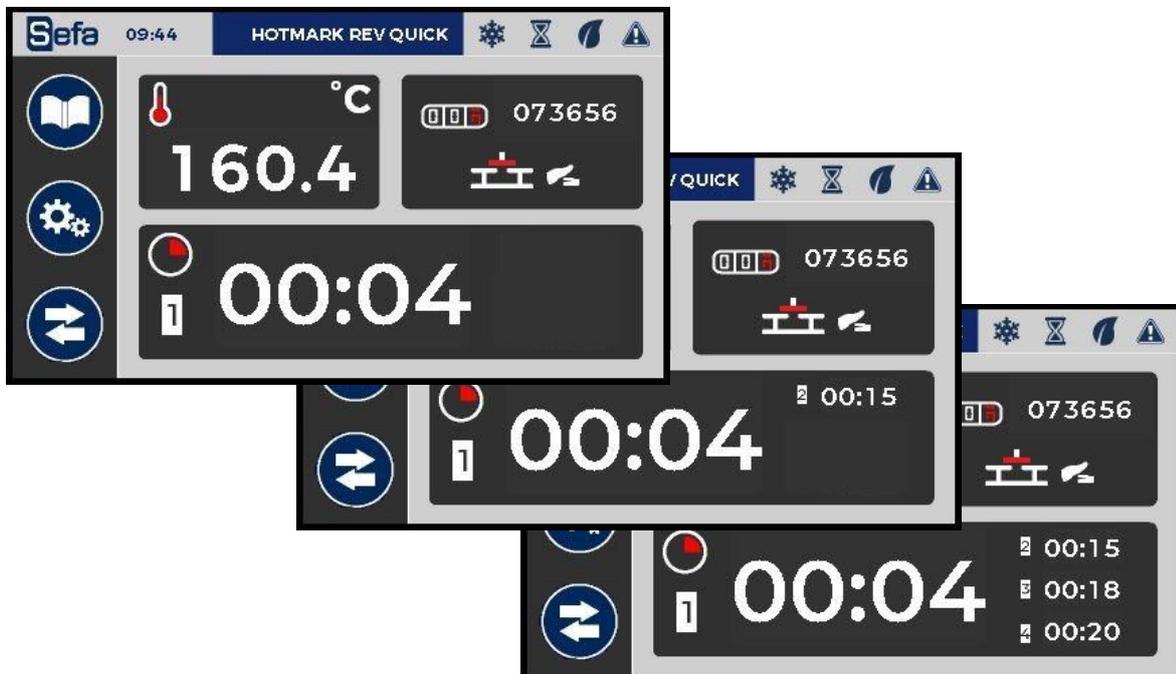
Automatic mode: after pressing the pedal, the stem changes its position and presses. At the end of the countdown of the "timer after pressing", it automatically changes position and presses again. So on until you press the STOP icon or the foot pedal or the green button to stop the automatic cycle.

**b) Number of timers**

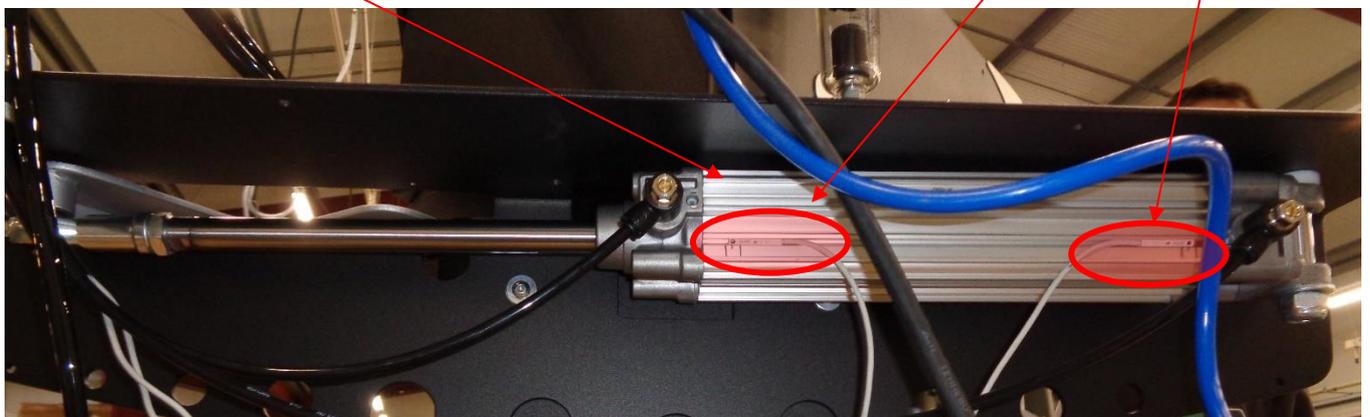
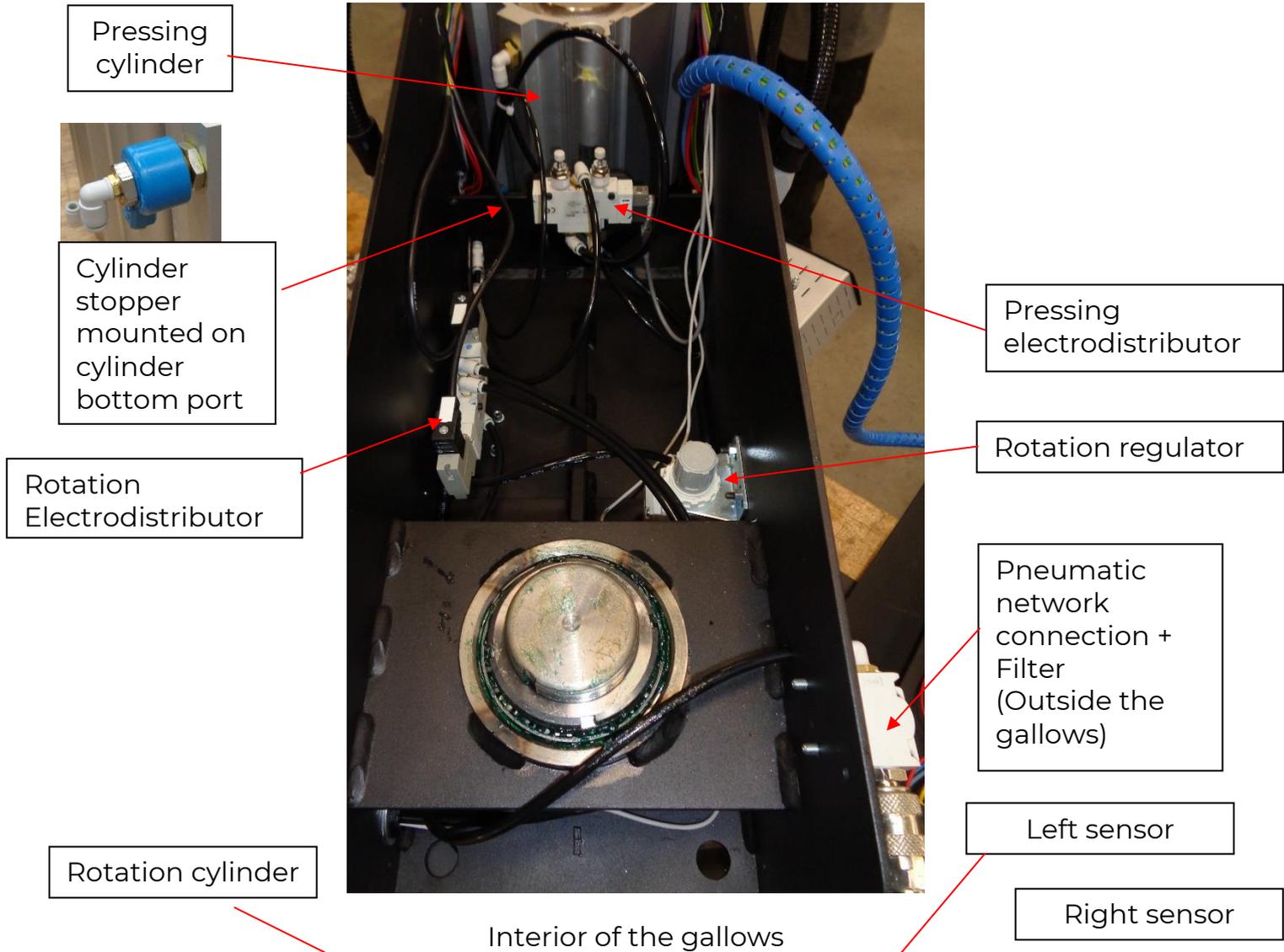


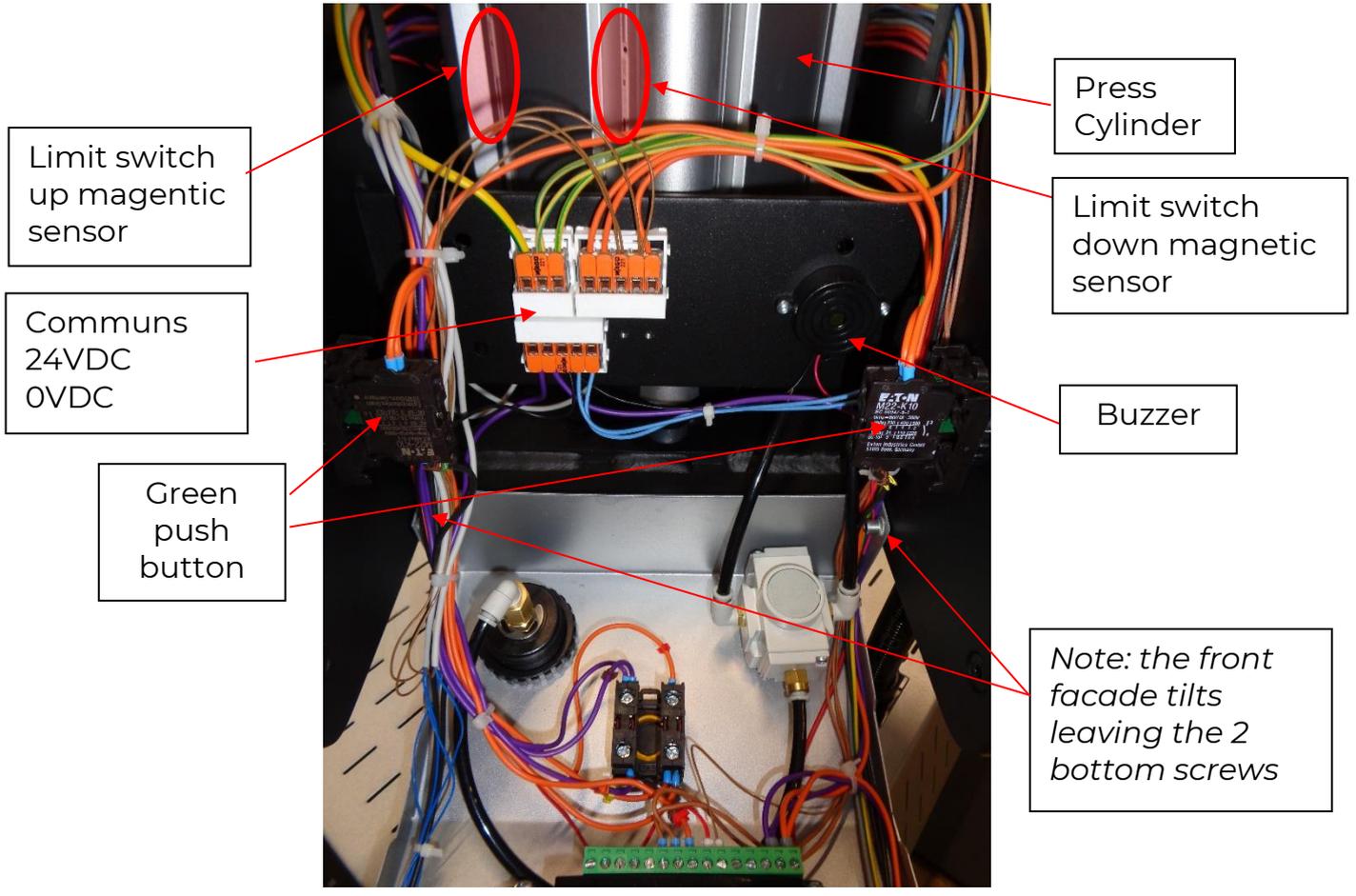
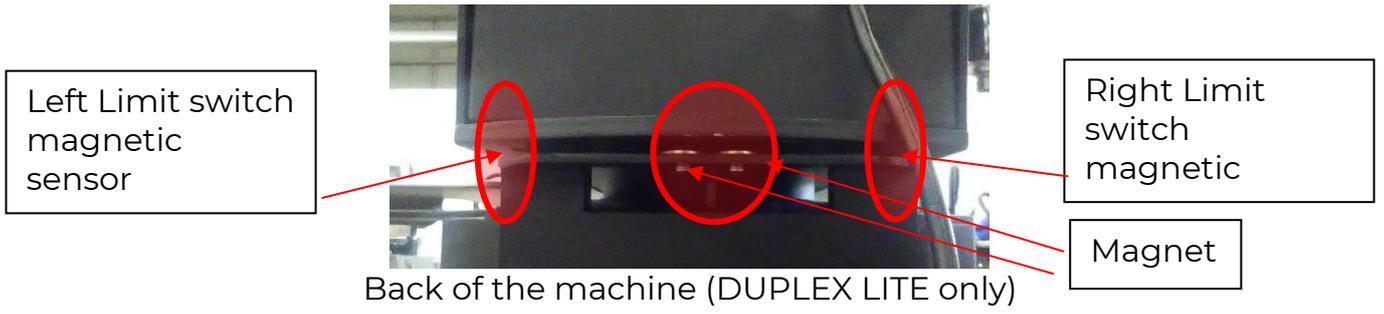
It is possible to choose a single timer, 2 timers or 4 different timers and configurable.

When you set 2 or 4 timers, the first timer can operate over the left or right tray. It will keep this position as long as one does not stop voluntarily or by the appearance of an alarm-event. At the next cycle start, the next timer will be the first. Each timer is not linked to the working position.



## IMPLANTATION OF EQUIPMENT





Front

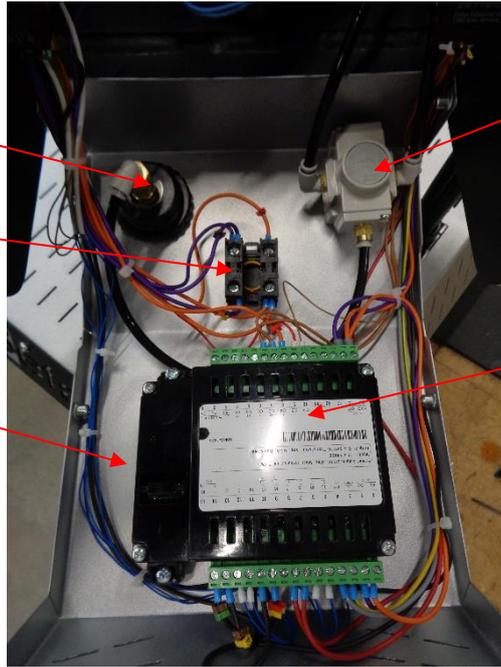
Manometer

Emergency stop

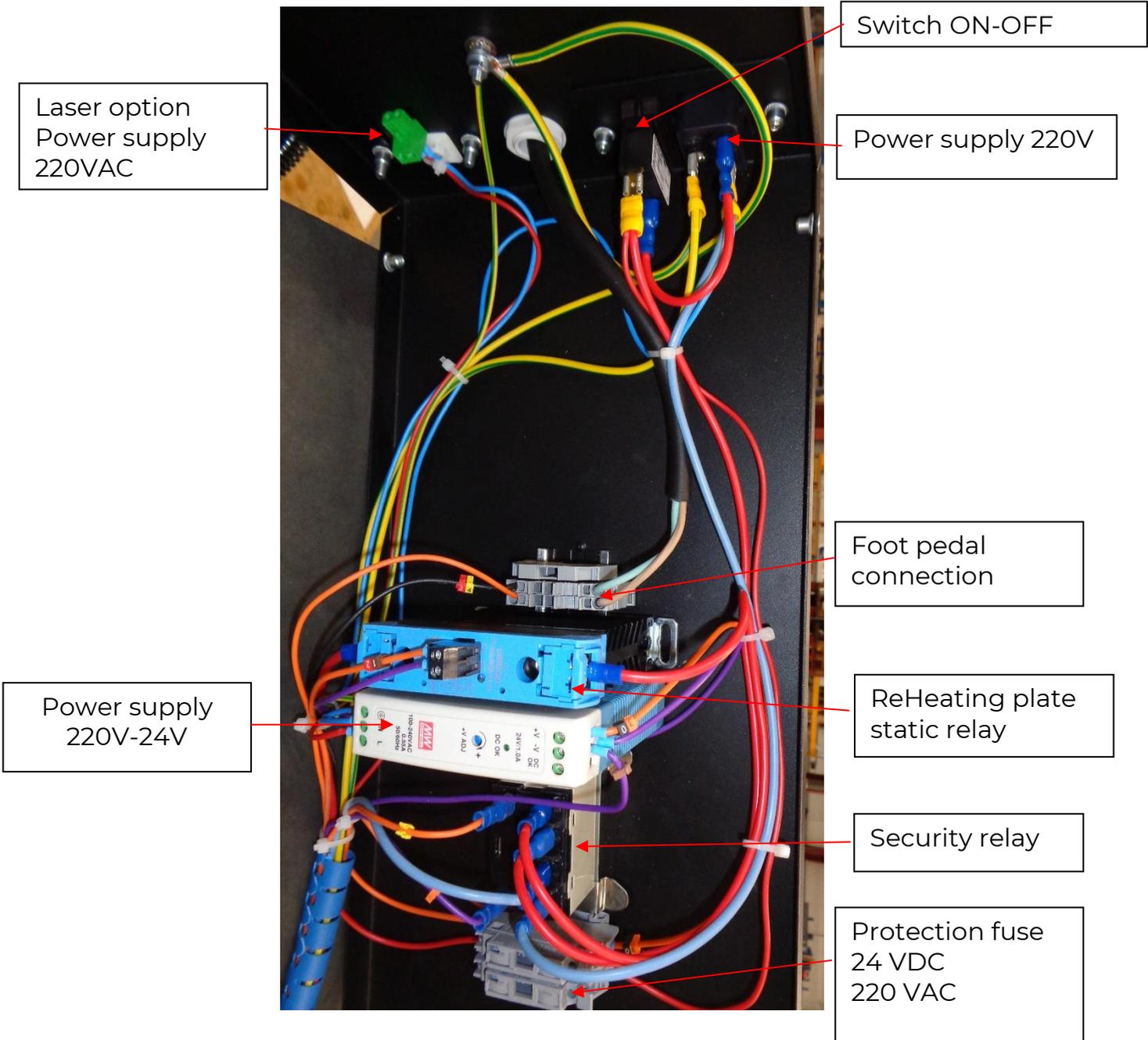
USB cable connector (not included)

Rotation regulator

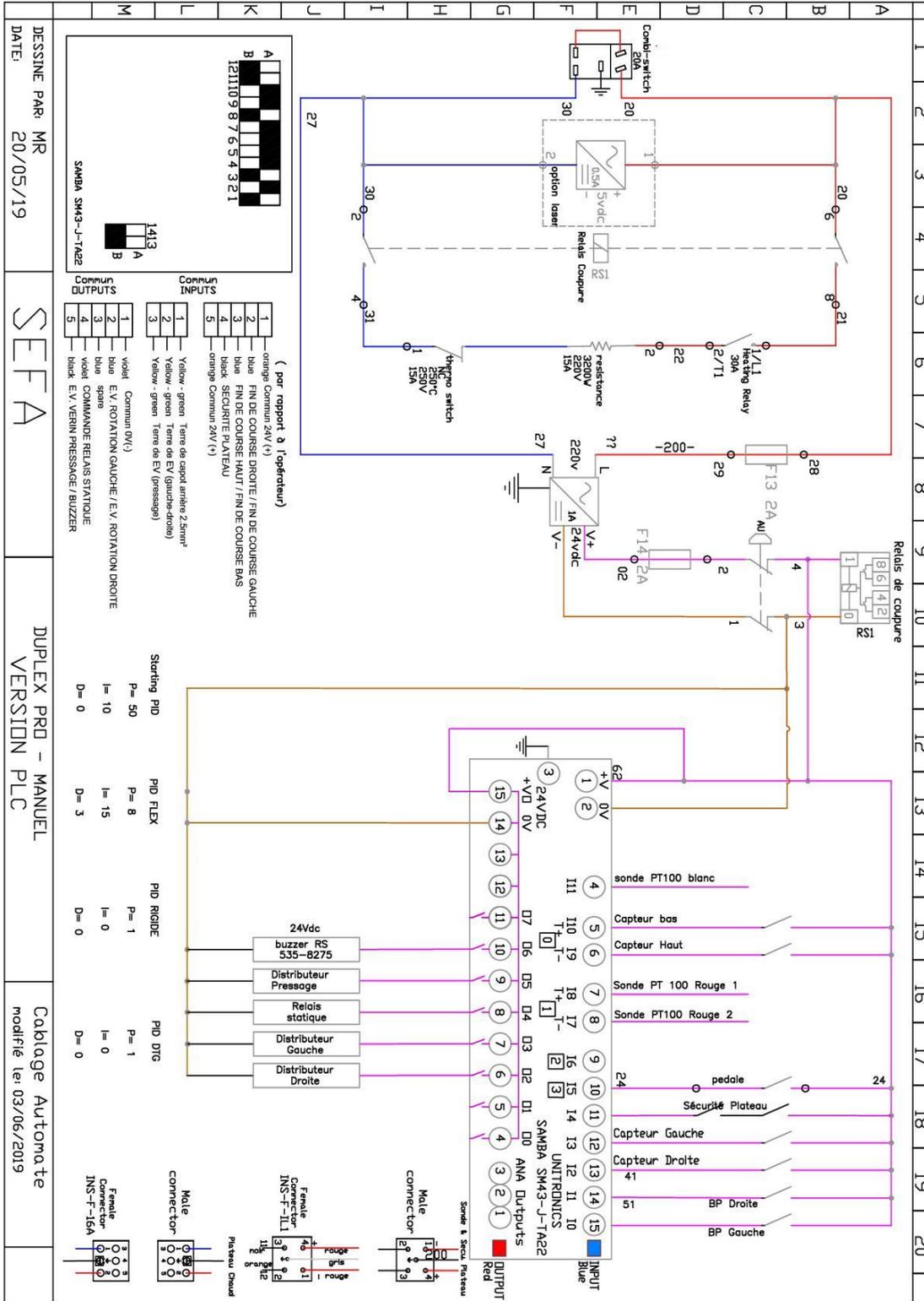
PLC-HMI



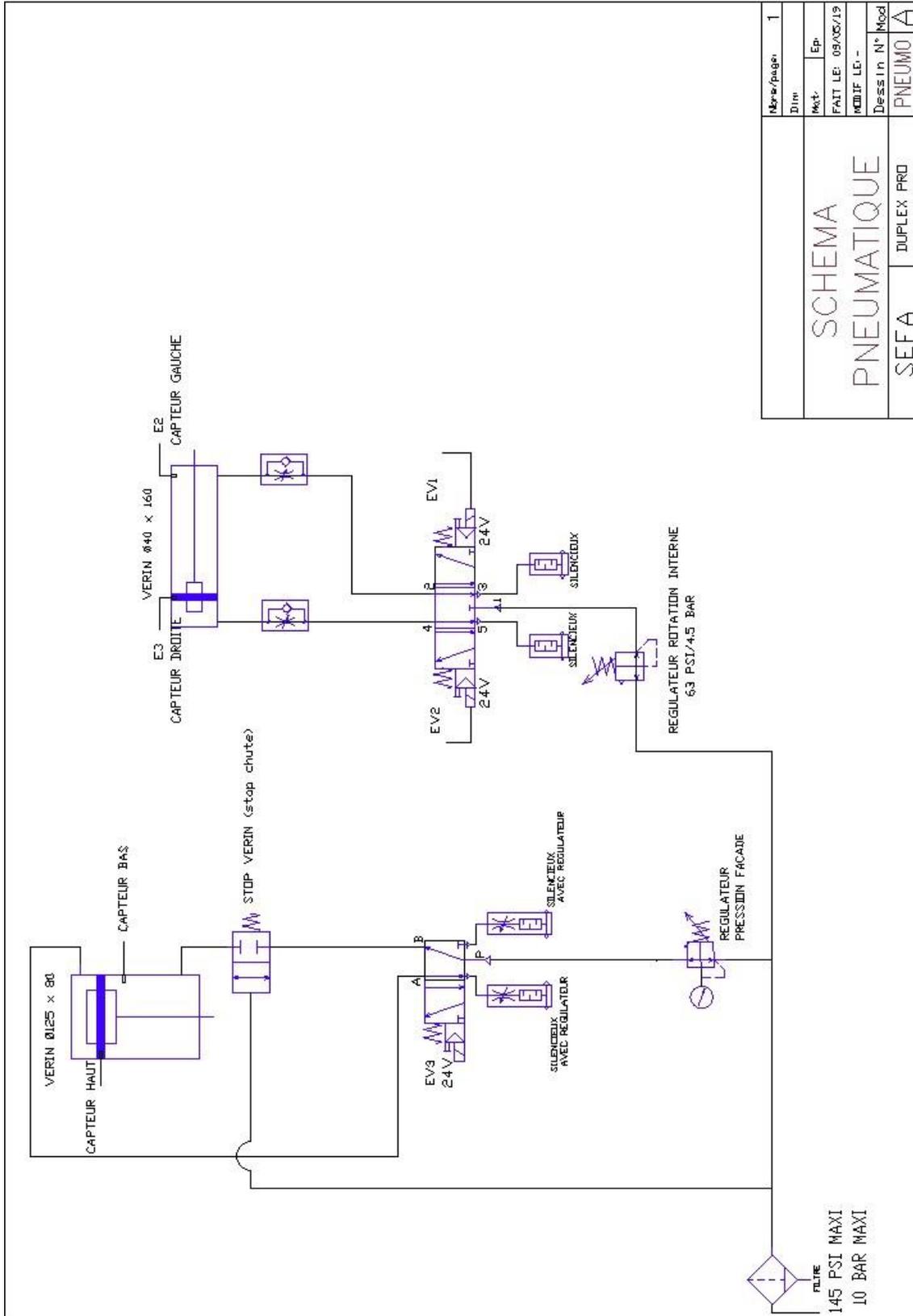
Inside the top cover



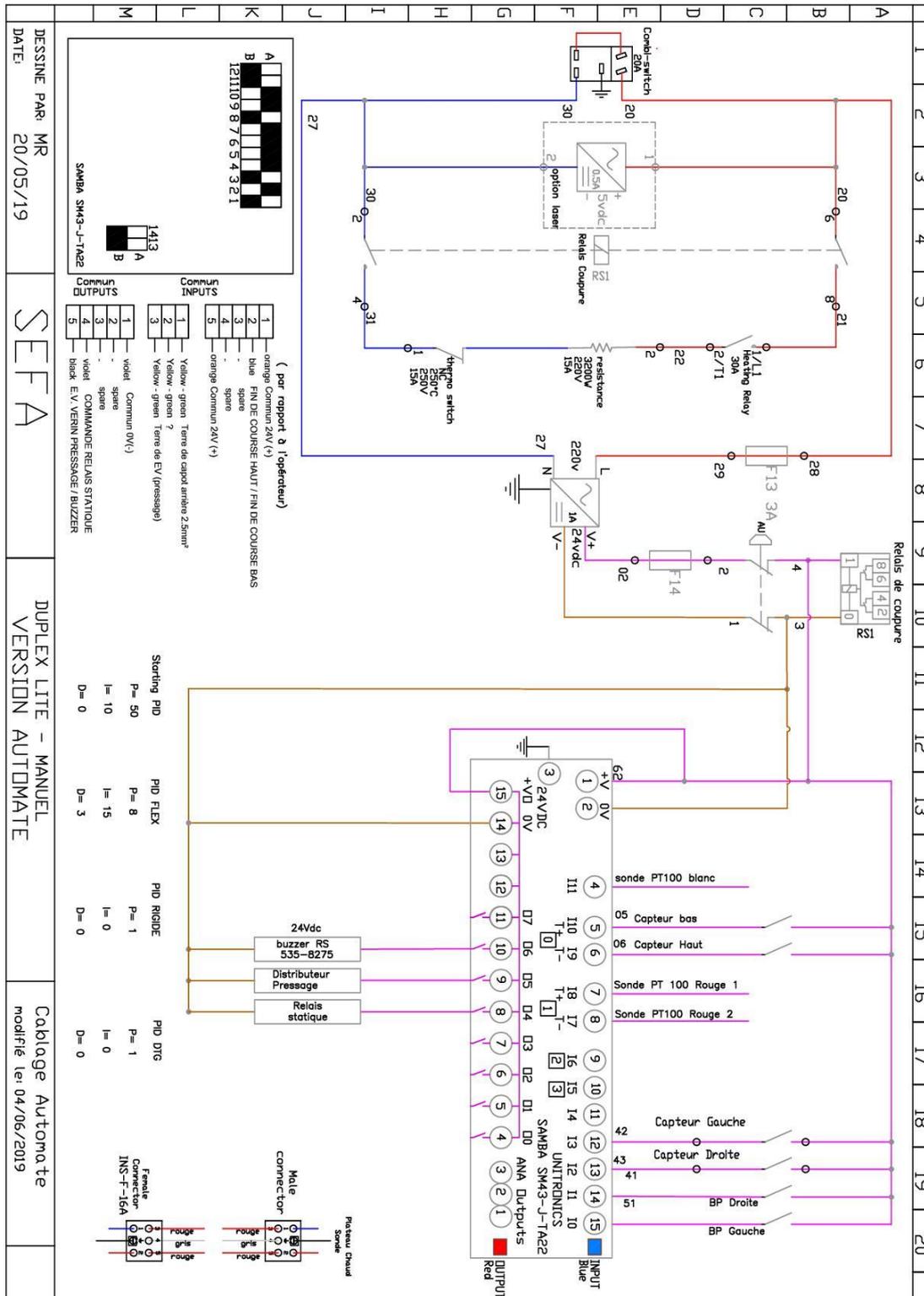
# DUPLEX PRO ELECTRICAL DIAGRAM



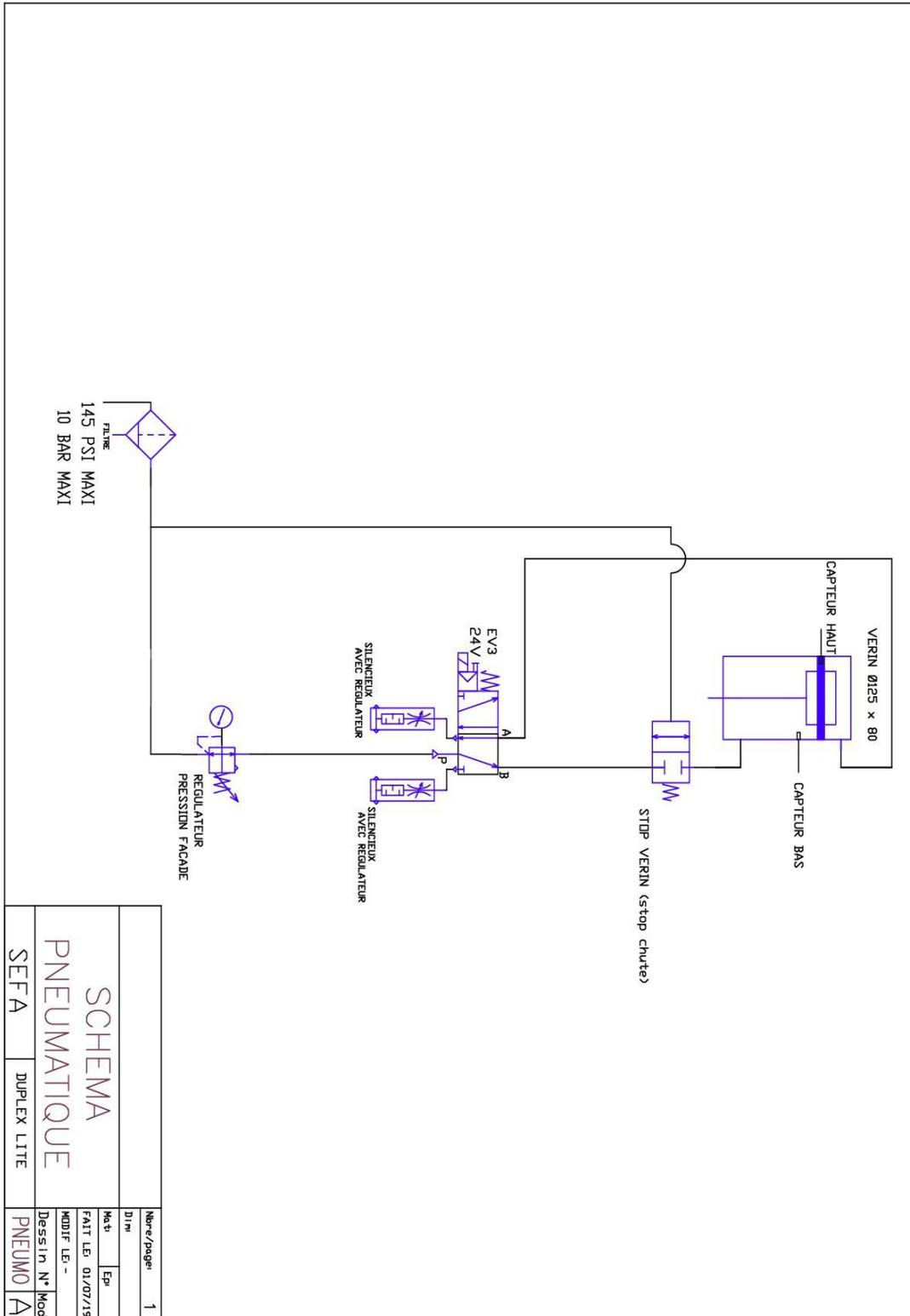
# DUPLEX PRO PNEUMATIC DIAGRAM



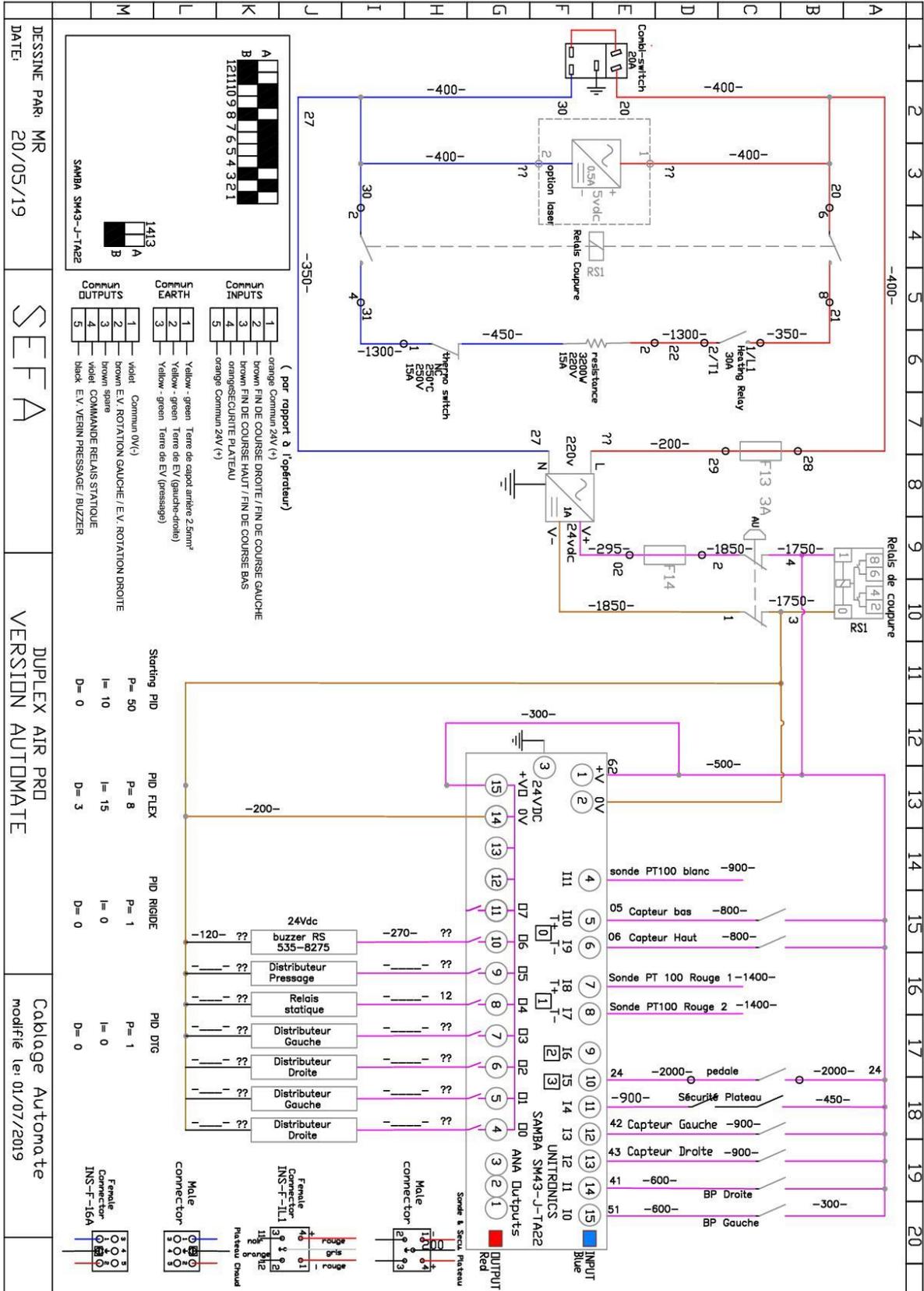
# DUPLEX LITE ELECTRICAL DIAGRAM



# DUPLEX LITE PNEUMATIC DIAGRAM



# DUPLEX AIR PRO ELECTRICAL DIAGRAM





## **MAINTENANCE**

**USE BY QUALIFIED PERSONNEL**

**ALL MAINTENANCE OPERATIONS MUST BE STOPPED AND MACHINE SATISFIED (ELECTRICAL AND PNEUMATIC ENERGIES DISCONNECTED)**

It is recommended to have at hand the following tools:

Phillips and flat screwdrivers  
A set of flat and pipe keys  
Allen key set  
A multimeter

### **1. REPLACEMENT OF WASTE PARTS**

#### **a) Silicone foam mat**

Check that the tray is cold

Make sure the surface of the tray is clean.

Optionally use a mild solvent such as isopropyl alcohol with adequate personal protection.

Use an RTV-1 glue tube to glue the foam to the aluminum plate (NB: read the instructions on the tube package).

The foam and the plate must be clean and dry before starting the bonding.

Spread a thin layer of glue evenly on the tray and immediately apply the foam ensuring that there is no air bubble (Example: a spatula serrated tiler).

Let stand overnight at room temperature with low pressure and without heating.

#### **b) Other parts**

Contact your dealer to evaluate their change or repair.

### **2. MAINTENANCE**

SEFA heat presses are virtually maintenance-free. To ensure proper operation, follow the precautions listed below:

Do not heat objects that could damage or cut the silicone mat or damage the teflon coating of the heating plate.

Periodically and when the plate is cold, clean the machine with a clean cloth and isopropyl alcohol (NB: this product is flammable, use it carefully and keep it away from heat sources). provided with adequate personal protections.

When the warming plate is hot and not used, keep it in the up position.

DAILY:

Clean the foam and the heating plate liner (cold) with a dry cloth or impregnated with degreaser.

Check the air inlet filter on the left side of the stem, purge it if there is too much condensate.

MONTHLY:

Check the lubrication of the joints.

According to the use:

Change the foam every 6 months.

## **PIECES SUBJECT TO WEAR**

**When ordering: specify the description, the reference and the quantity. In development**

<b><u>Reference</u></b>	<b><u>Description</u></b>	<b><u>Quantity</u></b>
<b><i>ELECTRICAL PARTS</i></b>		
AUT-SM43	PLC IHM	1
SON-PT100 3V	TEMPERATURE SENSOR	1
RES-500x400-3200W	MICA RESISTANCE 400x500 3200W	1
<b><i>PNEUMATIC PARTS</i></b>		
VER-SM25	AIR CYLINDER Ø125 C80	1
VER-SM23	AIR CYLINDER Ø40 C200	1
FIL-013	AIR FILTER	1
ELE-SM8	ELECTRODISTRIBUTOR 24V	1
<b><i>PRESS ACCESORIES</i></b>		
MOU-455	SILICON PAD 9,53mm 400X500	2
TOI-4050	TEFLON COVER 400X500	1
HOU-50	NOMEX COVER FOR BOTTOM PLATES	2

## **QUICK RESPONSE TIPS**



All maintenance repairs must be done at standstill and machine recorded (electrical and pneumatic energy stopped).  
The heating plate can cause burns. The operator must ensure that the temperature of the plate is below 25 ° C on the display, before any manipulation.

<b><i>SYMPTOMS</i></b>	<b><i>POSSIBLE TROUBLES</i></b>	<b><i>TROUBLESHOOTING</i></b>
Machine does not turn on	<p>The plug is not connected</p> <p>The switch is not connected</p> <p>The emergency stop is activated</p> <p>The display is faulty</p>	<p>Check your network and if the machine is connected to it.</p> <p>Set the main ON / OFF switch to 1.</p> <p>Turn the red knob to trigger the emergency stop</p> <p>Check that the cables are not damaged (possible short circuit)</p>
Machine does not heat up	<p>Resistance is defective</p> <p>Problem due to the automaton</p> <p>Temperature value too low</p>	<p>Check the connections and condition of the electrical wires.</p> <p>To disassemble the heating plate, contact your dealer.</p> <p>See the messages on the screen and contact your dealer.</p> <p>To change this value, see Chapter 5</p>
Machine over-heat	<p>Problem due to the sensor or temperature regulation</p>	<p>Check message box on the touch screen and contact your dealer.</p>
Timer does not work	<p>The sensor placed on a cylinder is not activated or defective</p> <p>PLC problem</p>	<p>Check his position. Check its connections. Change it if necessary</p> <p>See the messages displayed on the screen and refer to the manual or contact your dealer.</p>
The plate does not go down	<p>Leak on the cylinder</p> <p>Electro-distributor or proportional controller fail</p> <p>Compressed air pressure is not enough</p>	<p>Check the seals and all connections. Cut the end of the pipes. Contact your dealer.</p> <p>Check its connections. Contact your dealer to change it.</p> <p>Check if the pressure of your network is operational.</p>
The plate does not go up	<p>The electro distributor is faulty</p> <p>Leak on the cylinder</p>	<p>Check its connections. Contact your dealer to change it.</p> <p>Check the seals and all connections. Contact your dealer.</p>
The plate stays down after pressing	<p>Lack of compressed air</p>	<p>Check the compressed air network.</p>

## **SERVICE BOOK**

**THE CONTROL AND MAINTENANCE OPERATIONS INDICATED IN THIS TABLE MUST BE PERFORMED REGULARLY TO VERIFY THE OPERATING AND RELIABILITY OF THE PRESS.**

Date	Working hours	Pressure control	Air filter control	Cylinder control	State of the pad	Resistance control	Exchanged parts	Details

To make it easier to fill the table, it may be useful to use the following code:  
C: Control N: Cleaning R: Replacement

