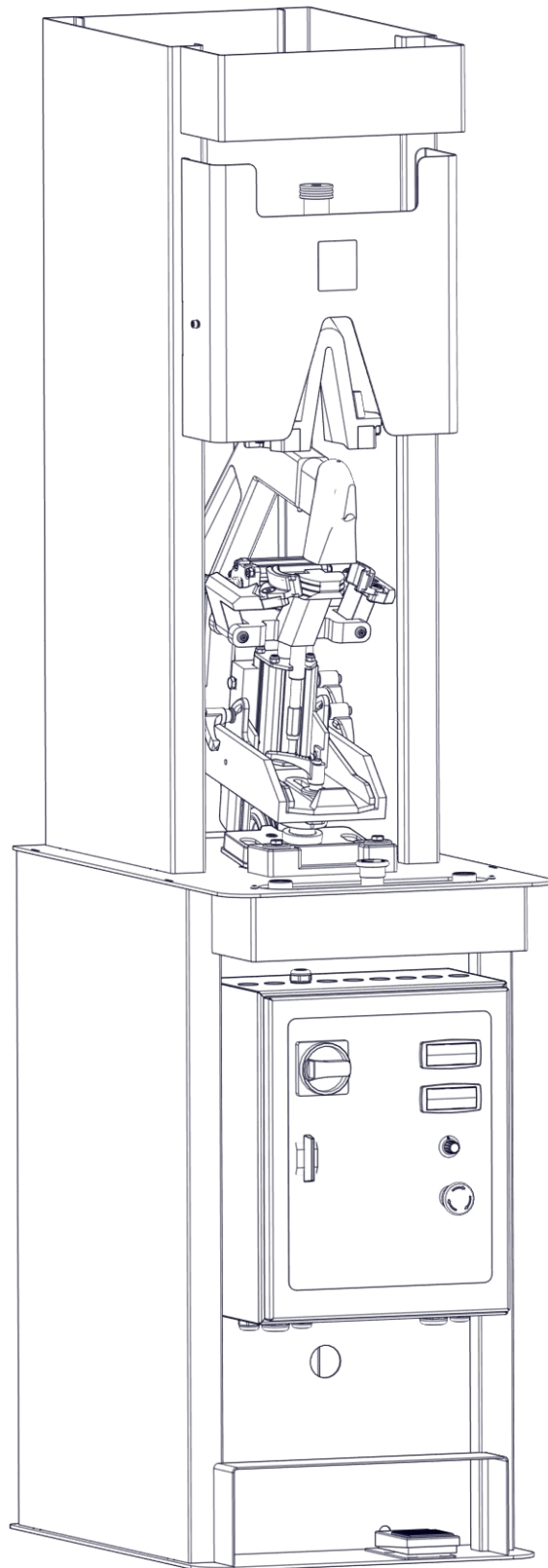


OPERATOR'S MANUAL



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INTRODUCTION

The purpose of this manual is to inform the owner of this machine of its operation, its maintenance and of all the safety regulations.

Please read carefully and follow all the instructions in order to use the machine properly and avoid any case of injury.

Our company is not responsible for any changes that occur to the machine by the owner or actions which are different from what this manual refers.

SAFETY REGULATIONS

This machine is intended for professional use only.



WARNING!

Only one operator may work on the machine at a time.



WARNING!

Read and follow carefully all the relative instructions to avoid serious injury.

The machine must be used only by qualified and authorized personnel.

- Operators are expressly forbidden to use the machine under the influence of alcohol or drugs capable of affecting physical and mental capacity.
- Keep unauthorized persons away from the work area.
- Make sure that the machine has been installed in compliance with the established legislation and standards.
- Never leave nuts, bolts, tools or other equipment on the machine to avoid the risk that they could become entrapped between moving parts during work.
- Do not touch power lines or other electrical equipment until the power has been disconnected.
- Always keep this user manual in a place where it can be readily consulted when working on the machine. Consult it whenever you are in need of information or explanation.
- Do not remove or deface the safety, danger, warning or instruction signs. Replace any missing or illegible Danger, Warning or instructions signs.
- Never use the machine if you notice any damaged electric wires.
- Never install the machine outdoors or in any place with a lot of moisture.



WARNING

The operator of this machine must never wear ties, loose fitting clothes, necklaces, wrist watches or any other articles that could become entrapped by moving parts.



WARNING

Use only original spare parts which can be supplied by the manufacturer or the local agent. Otherwise, your machine will not be a **CE** product.



WARNING

Never operate the machine without the aluminum lasts mounted.

ELECTRIC AND PNEUMATIC CONNECTIONS

Electric and pneumatic connections

1. Connect the machine (230V- 50Hz) single phase.
2. Before plugging in the machine check that the main voltage supply is the same as that indicated on the label situated on the back side of the machine.
3. Check if the plug and socket are the same technical type. If not, use a suitable adapter after having consulted with a qualified electrician.
4. For correct and safe operation of the machine it must be connected to an efficient grounding circuit.
5. To disconnect the machine turn the main switch off and then remove the plug from the outlet.
6. Connect the machine with a pneumatic supply of 6-8 bar.
7. Set the main pressure regulator, which is found, on the back part of the machine to 6 Bar.

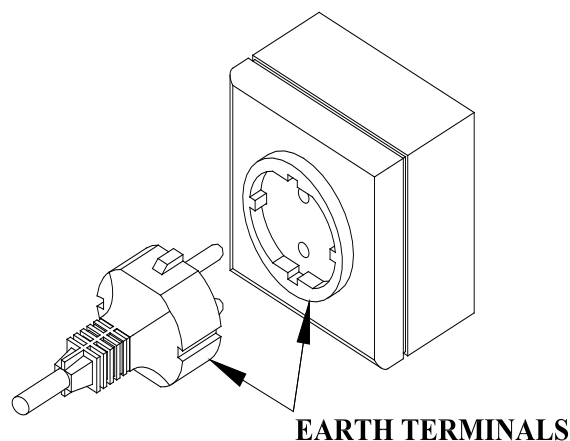


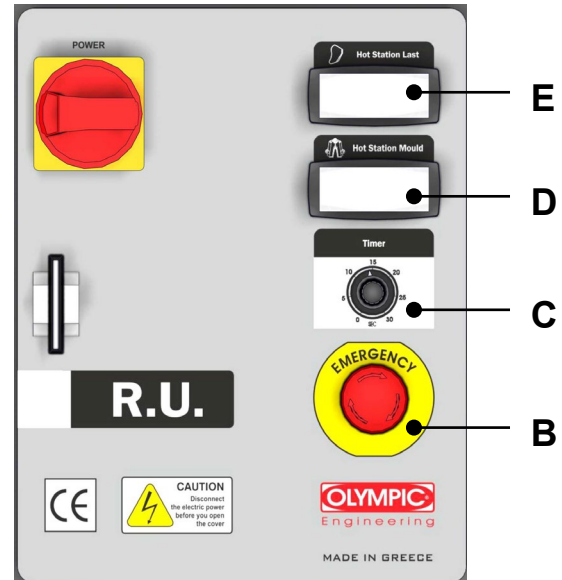
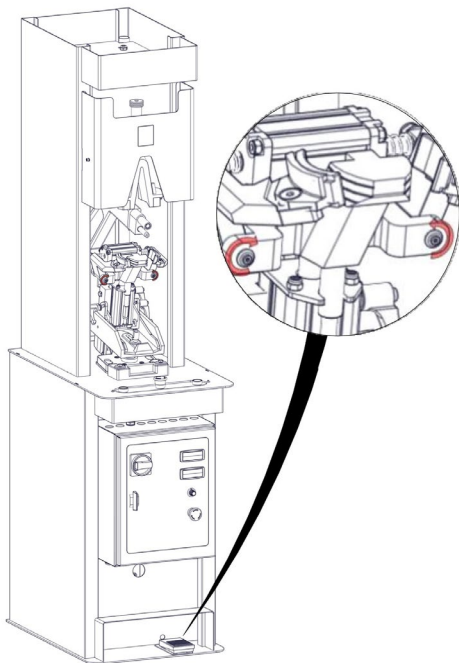
Fig. 1

TECHNICAL DATA

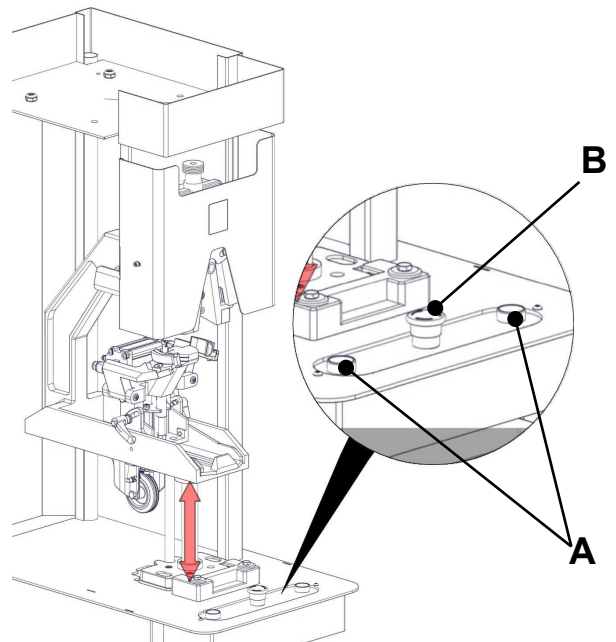
Operation	Pneumatic
Pressure	6 bar
Voltage	230V single phase 50Hz
Power	1000 W
Air consumption	1.8 scfm
Capacity	400 pairs per day
Dimensions (mm)	620 x 440 x 1520 h
Weight	90 kg
Year of Production	2014

GENERAL SETTINGS

- Set the main switch to the **ON** position
- The main filter regulator is located on the left side of the machine. Must always be set to 6 BAR.



- **A. Start Buttons.**
Push the pedal to close the pincers and then push simultaneously the two buttons A
- **B. Emergency Stop.**
- **C. Timer.**
Operation Cycle Timer.
- **D. Temperature for aluminum (teflon coated) lasts.**
Range from 80°C to 150°C.
Recommended temperature : 130°C
- **E. Temperature for silicon rubber.**
Range from 130°C to 170°C.
Recommended temperature : 150°C

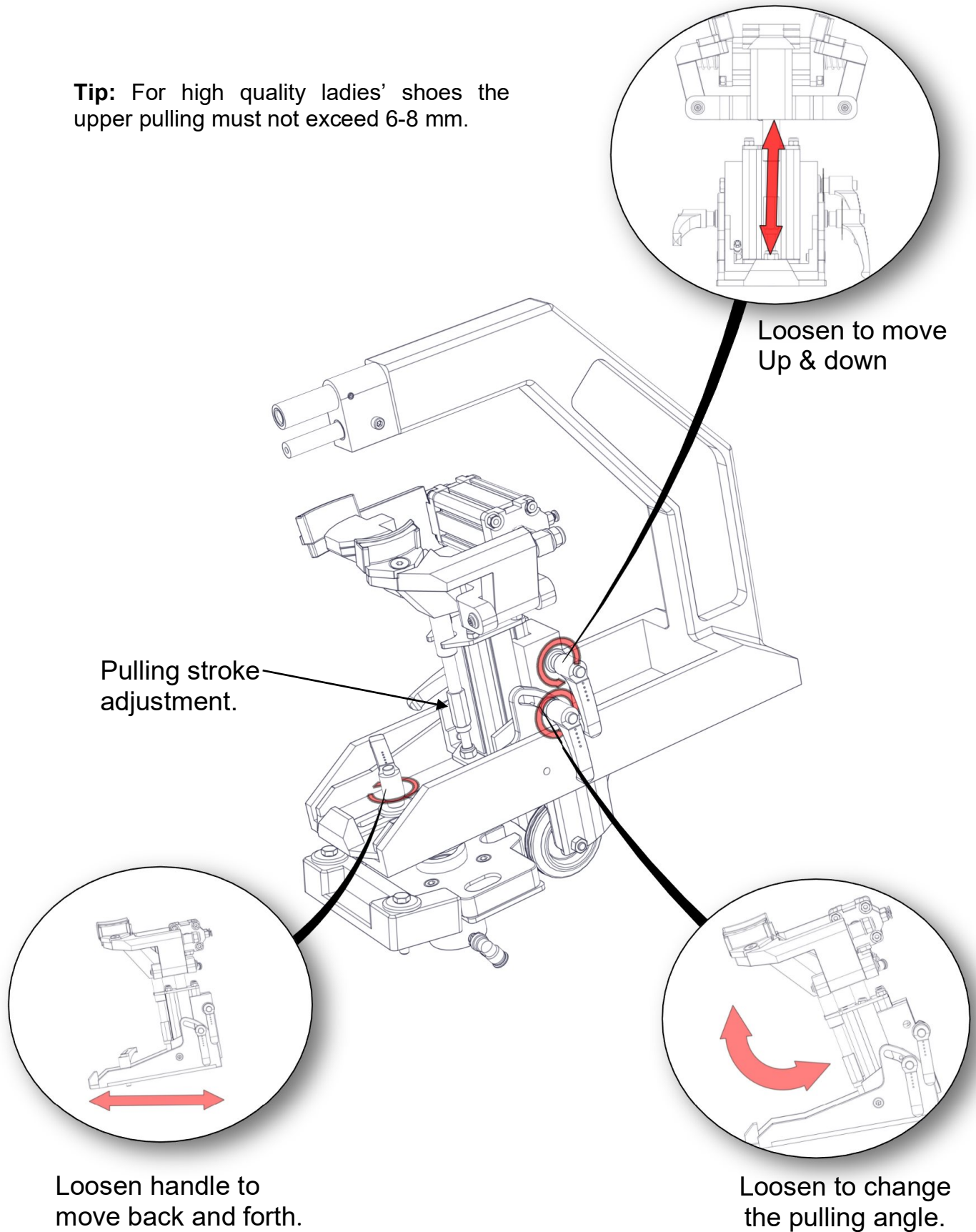


Note:

All of the above recommendations apply to the very first operation of the machine, in order for you to carry out your tests. The optimal adjustments will be set by you according to the material being used in production.

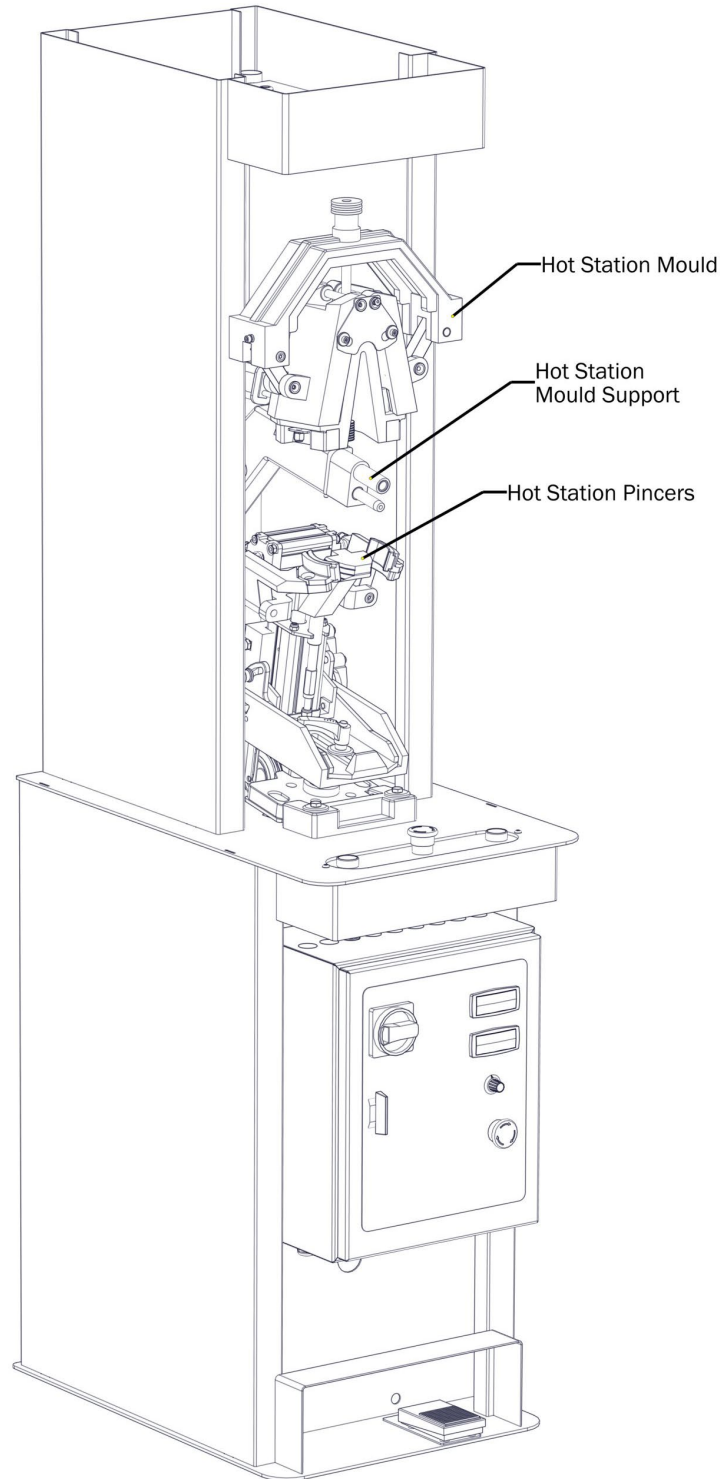
HOTPINCER'S ADJUSTMENTS

Tip: For high quality ladies' shoes the upper pulling must not exceed 6-8 mm.



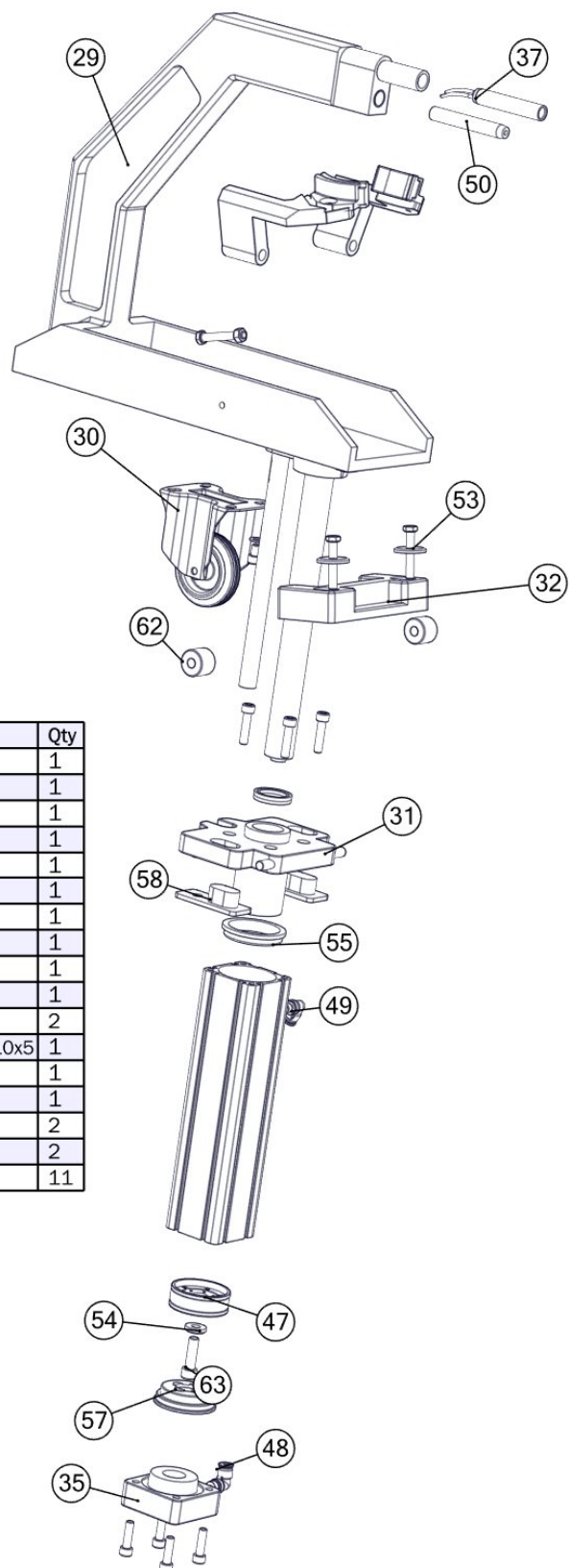
ASSEMBLING R.U

- Hot Station Support (page 10)
- Hot Station Pincers (page 11, 12)
- Hot Station Mould (page 13)

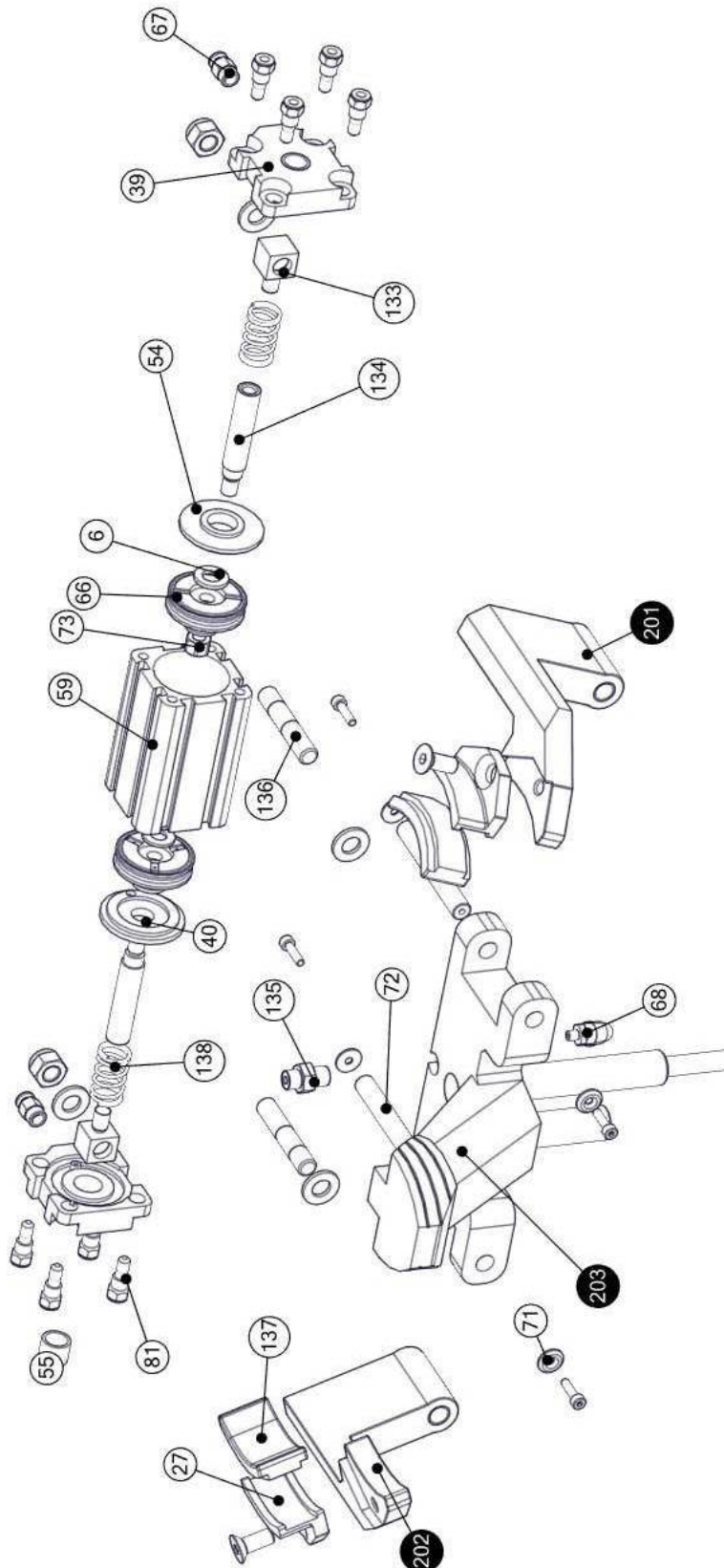


R.U HOT STATION SUPPORT

BOM ID	PartNo	Description	Qty
29	ASM-00317	HOT STATION MOULD	1
30	ASM-00325	WHEEL Ø80	1
31	ASM-00322	END CAP	1
32	CAS-00081	ARTICULATION	1
35	CAS-00099	END CAP, Ø63	1
37	ELE-00217	RESISTANCE 48V 450W	1
47	GEN-00294	DKN Ø63, NORMAL	1
48	PNE-00043	FITTING, ELBOW, 1/4 - Ø6	1
49	PNE-00044	FITTING, ELBOW, 1/8 - Ø6	1
50	REV-00056	THERMISTOR BRACKET	1
53	REV-00113	WASHER, CUSTOM	2
54	REV-00193	WASHER, CUSTOM, TAPER, Ø23xØ10x5	1
55	RUB-00005	PISTON RUBBER Ø63	1
57	RUB-00019	STOPPER	1
58	RUB-00060	SHOCK ABSORBING RUBBER	2
62	REV-00054	BEARING Ø28L23	2
63	FAS-00399	SCREW DIN 912 M8 x 30	11



R.U HOT STATION PINCERS (top)

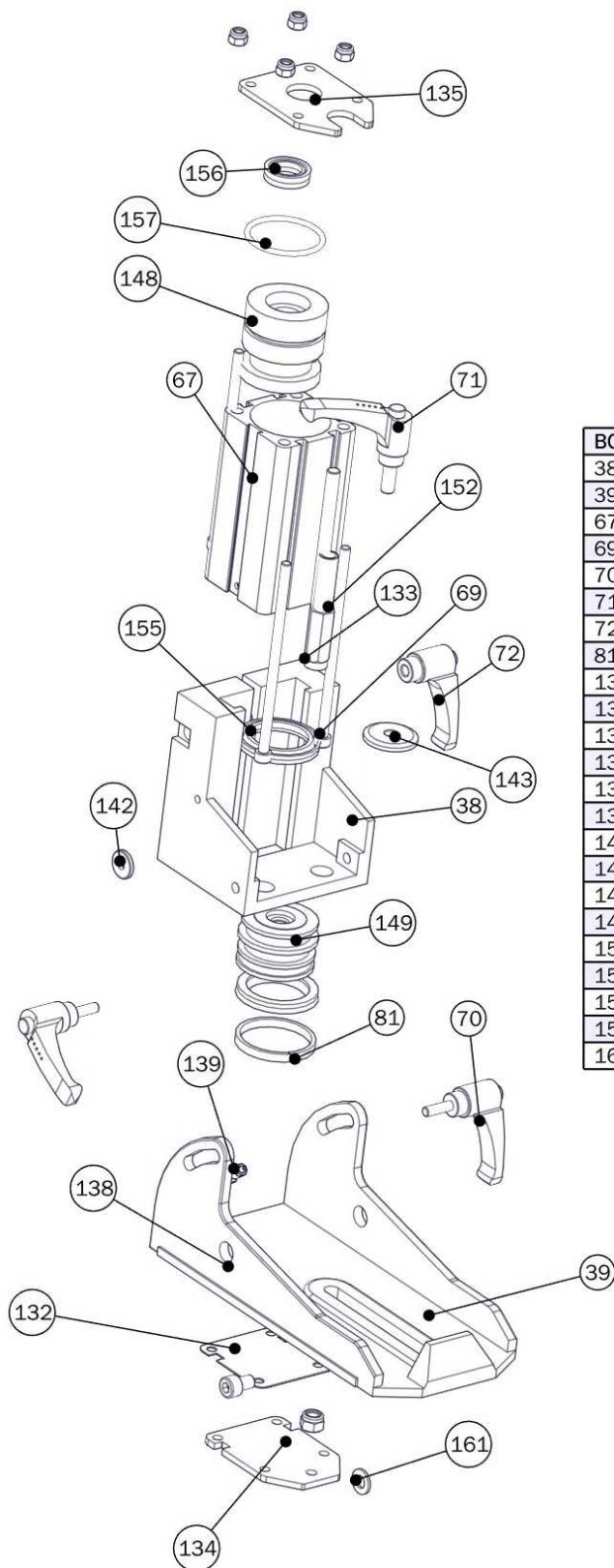


BOM ID	PartNo	Description	Qty
135	REV-00295	FITTING, CUSTOM	1
136	REV-00296	M10 THREADED PIN	2
137	RUB-00092	PINER RUBBER (v.2014)	2
138	SPR-00018	SPRING	2
201	ASM-00357	PINER ARM (RIGHT)	1
202	ASM-00356	PINER ARM (LEFT)	1
203	ASM-00316	CASTED PINER SUPPORT	1

BOM ID	PartNo	Description	Qty
67	PNE-00028	FITTING, PARALLEL, 1/8 - Ø4	2
68	PNE-00030	FITTING, ANGLE, M5 - Ø4	1
71	REV-00133	WASHER, CUSTOM, Ø14X2.5	4
72	REV-00028	MF88-99 BRACKET PINS	2
73	REV-00136	NUT, CUSTOM, M8, CUT EDGES	2
81	REV-00138	CBS SCREW, M6	8
133	REV-00201	SPACER	2
134	REV-00202	ROD	2

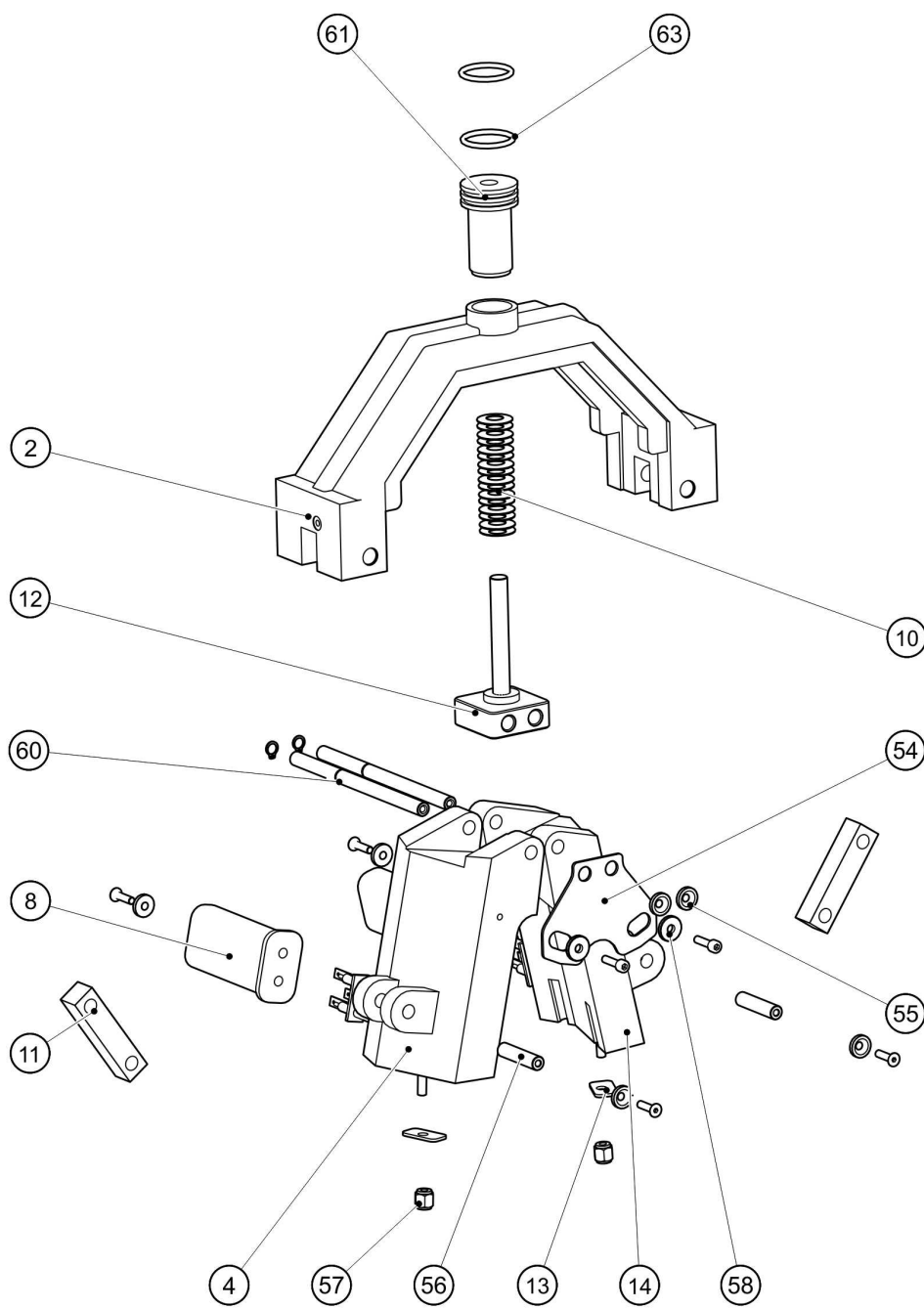
BOM ID	PartNo	Description	Qty
6	GEN-00177	CBS WASHER, 8.5x17x1.5	2
27	CAS-00017	PINER	2
39	CAS-00069	CBS PISTON CAP, FRONT, Ø40	2
40	RUB-00072	BRAKE RUBBER, FRONT, Ø40	1
54	RUB-00068	BRAKE RUBBER, BACK, Ø40	1
55	GEN-00125	BRASS RING FOR Ø32 CAP	2
59	CYL-00029	CYLINDER Ø40 FOR PINCERS	1
66	GEN-00072	DKN Ø40	2

R.U HOT STATION PINCERS (bottom)



BOM ID	PartNo	Description	Qty
38	CAS-00082	CYLINDER SLIDING BASE	1
39	CAS-00083	SLIDING PINCER'S BASE	1
67	CYL-00027	CYLINDER Ø50X115	1
69	FAS-00030	SCREW DIN 912 M6 x 130	4
70	GEN-00067	CL. LEVER, MALE, ELES, M6X20	2
71	GEN-00068	CL. LEVER, MALE, ELES, M8X20	1
72	GEN-00070	CL. LEVER, FEMALE, ELES, M8	1
81	GEN-00175	PISTON SEAL RING 44.5x49.5x5.4	1
132	GEN-00226	OAK PISTON INTERNAL SEAL (MF)	1
133	GEN-00250	THREAD ROD M8	1
134	LAS-00159	Ø50 PISTON CAP	1
135	LAS-00160	Ø50 PISTON CAP	1
138	PNE-00971	M5 BANJO STEM SINGLE LIGHT	1
139	PNE-00972	SINGLE BANJO BODY	1
142	REV-00078	WASHER, CUSTOM, FLAT, Ø6	2
143	REV-00113	WASHER, CUSTOM	1
148	REV-00197	BRASS BEARING Ø50	1
149	REV-00198	PISTON	1
152	REV-00234	PULLING REGULATOR	1
155	RUB-00012	PISTON SEAL Ø50	2
156	RUB-00015	ROD WIPER	1
157	RUB-00062	ORING, NBR, 44X3	1
161	FAS-01025	WASHER DIN 125 - A 8.4	1

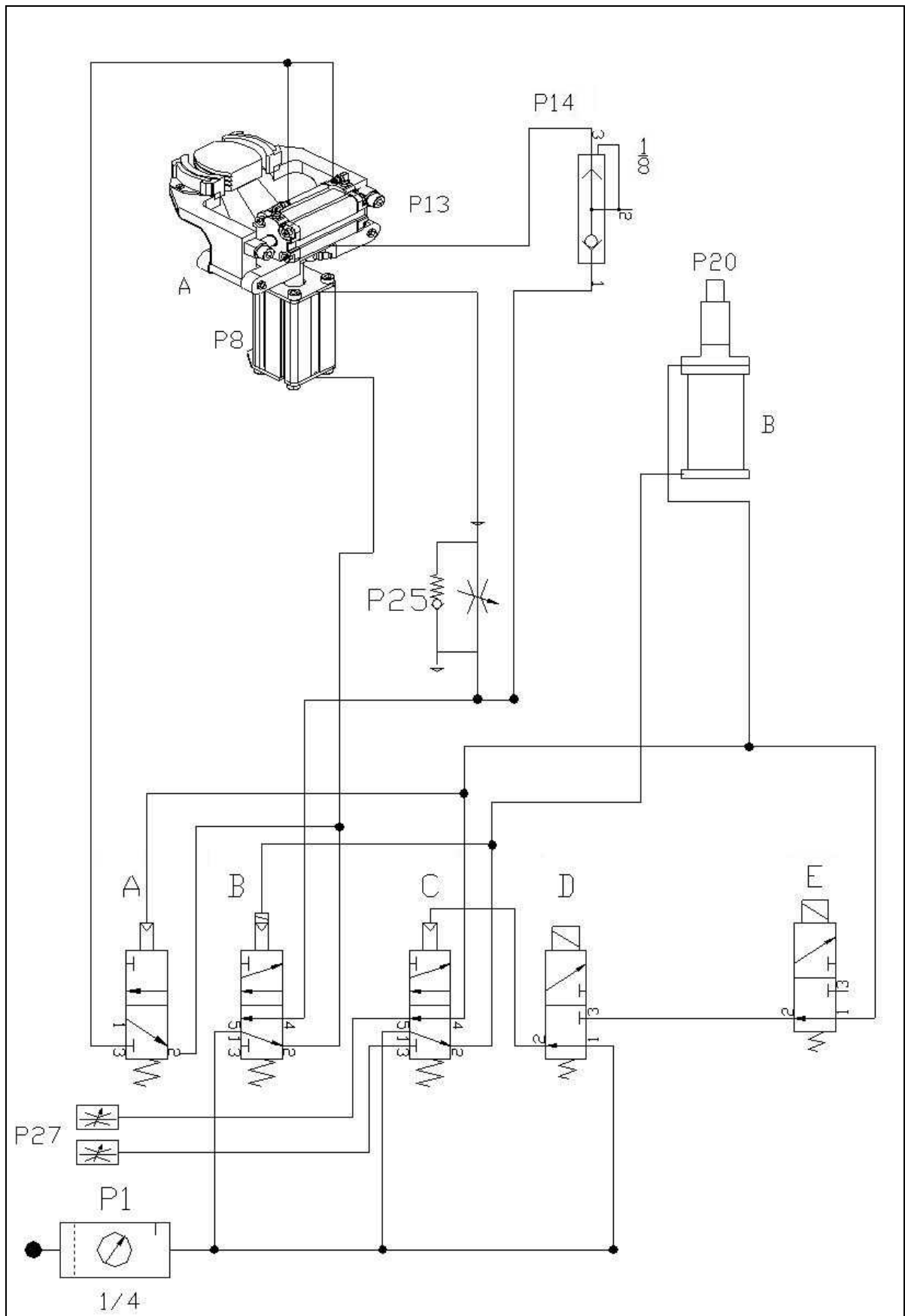
R.U HOT STATION CUSHION MOULD



BOM ID	PartNo	Description	Qty
2	CAS-00102	CUSHION SUPPORT	1
4	ASM-00476	HEATED CUSHION (LEFT), MF-3 & MF-4	1
8	ELE-00016	ELECTRIC ELEMENT ISOLATOR	2
10	FAS-00003	WASHER, SPRING, DIN9023, 28X12.2X1	16
11	GEN-00245	BRACKET	2
12	ASM-00434	GUIDE	1
13	LAS-00051	WASHER RECTANGULAR $\Phi 7 \times 16$	2
14	ASM-00475	HEATED CUSHION (RIGHT), MF-3 & MF-4	1
54	LAS-00453	HOT CUSHION COVER	1

BOM ID	PartNo	Description	Qty
55	REV-00029	$\Phi 5$ WASHER FOR CUSHION PINS	6
56	REV-00067	PIN	2
57	REV-00074	NUT, CUSTOM, M6	2
58	REV-00078	WASHER, CUSTOM, FLAT, $\Phi 6$	2
60	REV-00245	AXLE	2
61	REV-00255	STROKE ADJUSTER	1
63	RUB-00089	ORING, NBR, 35x3.5	2

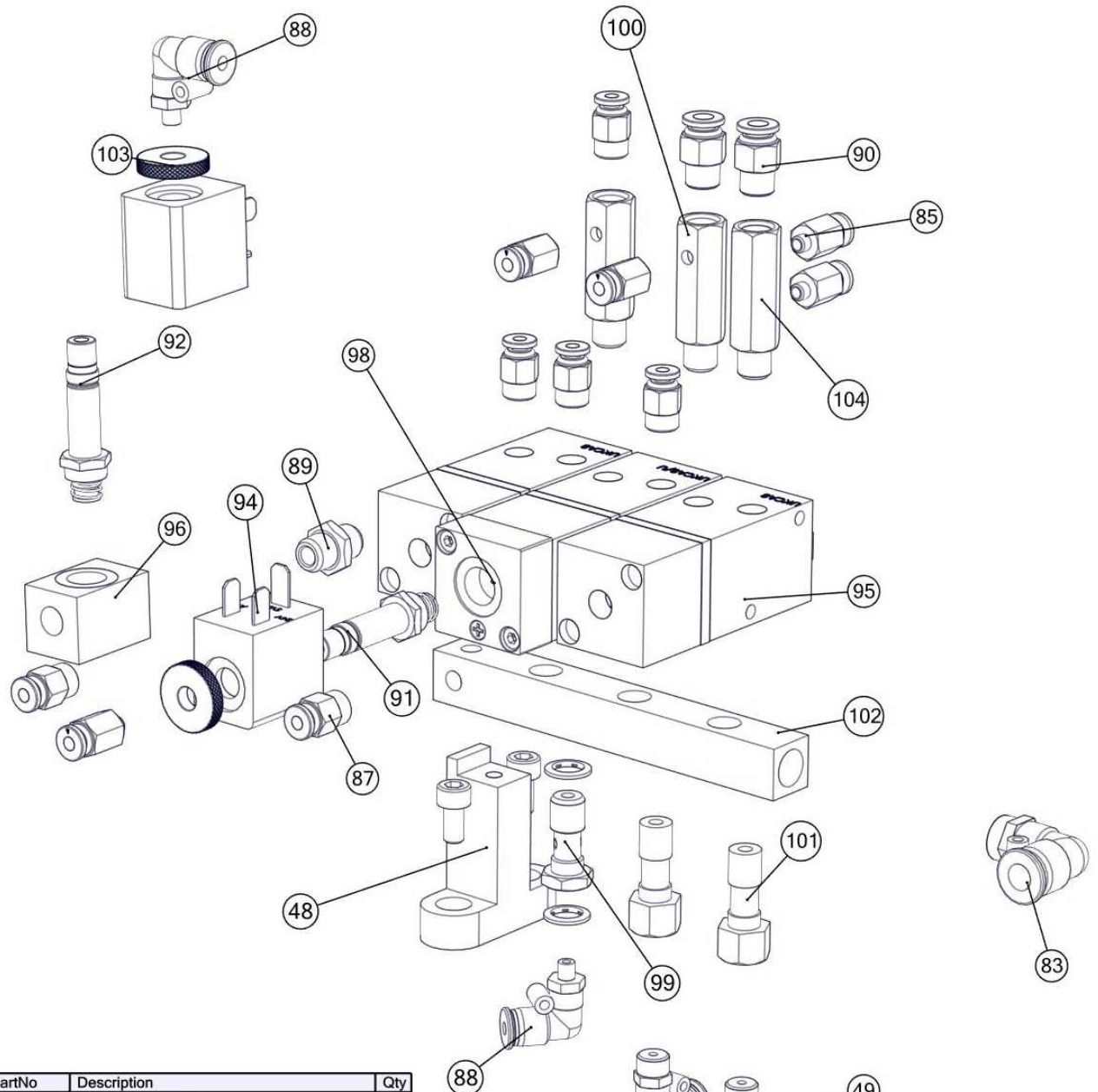
PNEUMATIC DIAGRAM



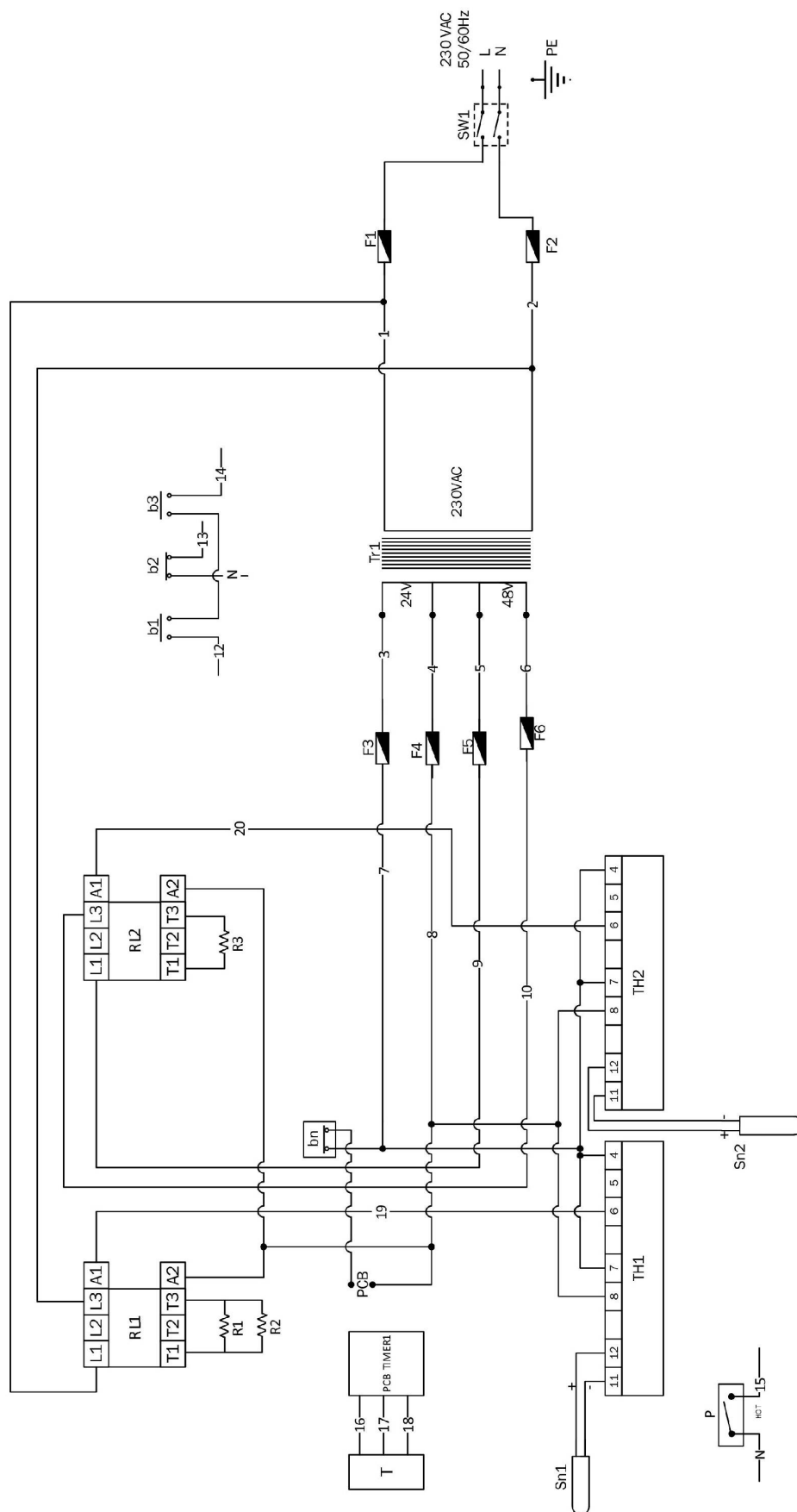
PNEUMATIC COMPONENTS

No	PART NUMBER	DESCRIPTION
A	PNE-00950	0230 - 3-way pilot valve 8/12 UKC WAIRCOM
B	PNE-00965	0212 - 5-way solenoid pilot valve type 1/8 WAIRCOM UKCA/U
C	PNE-00956	0207 - 5-way pilot valve 1/8 WAIRCOM UKCA 8
D	D	0216 - 3-way solenoid valve normally open (Amisco AZ Ø9)
E	E	0216 - 3-way solenoid valve normally open (Amisco AZ Ø9)
P1	PNE-00001	Filter regulator and lubricator 1/4 insert
P8	CYL-00027	Double effect cylinder Ø50
P13	ASM-00328	Single effect cylinder Ø40
P14	PNE-00098	Exhaust valve 1/8 AIGNEP
P20	CYL-00028	Double effect cylinder Ø63
P25	86P18	Flow control valve 1/8 AZ 8/3
P27	F11-52	Flow Control Valve 1/8 RV8

PNEUMATIC VALVE ASSEMBLY



BOM ID	PartNo	Description	Qty
48	CAS-00113	MOUNTING BASE	1
49	PNE-00007	FITTING, ELBOW, 1/8 - Φ4	2
83	PNE-00008	FITTING, ELBOW, 1/4 - Ø8	1
85	PNE-00013	FITTING, STRAIGHT, M5 - Ø4	5
86	PNE-00018	SILENCER, 1/8, PLASTIC, BLUE	2
87	PNE-00028	FITTING, PARALLEL, 1/8 - Ø4	6
88	PNE-00030	FITTING, ANGLE, M5 - Φ4	2
89	PNE-00033	NIPPLE, TAPER, 1/8 (M) - 1/8 (M)	1
90	PNE-00039	FITTING, STRAIGHT, MALE, 1/8 - Φ6	2
91	PNE-00551	CANNOTTO NC Φ9 3/2 6W 09F07360A3CNN	1
92	PNE-00552	CANNOTTO NO Φ9 3/2 6W 09F07401A30NN	1
93	PNE-00741	SILENCER, SPRING REGULATOR, 1/8	4
94	PNE-00752	COIL Ø9 - 24VAC, 5W	2
95	PNE-00956	VALVE, UKCA8	2
96	PNE-00957	BRASS PILOT BASE 1/8	1
98	PNE-00966	OPERATOR BASE 1/8	1
99	PNE-00967	STEM SINGLE, CUSTOM, 1/8 WITH M5	1
100	REV-00011	BRASS ROD 1/8	2
101	REV-00041	FITTING, CUSTOM, 1/8	2
102	REV-00293	PNEUMATIC MANIFOLD, 3-POSITIONS	1
103	REV-00294	KNURLED ROUND NUT	2
104	REV-00297	SPACER 1/8, 2-M5	1



ELECTRIC COMPONENTS

No	PART NUMBER	DESCRIPTION
U	ELE-00026	Simultaneously Circuit Board
SW	ASM-00807	General switch / Telergon 3x20A
F ₁ ,F ₂	ELE-00027	Fuse (10A)
F ₃ ,F ₄	ELE-00377	Fuse (4A)
F ₅ ,F ₆	ELE-00027	Fuse (10A)
TH ₁ ,TH ₂	ELE-00007	Thermocouple Technologic TLK 48/24V
C ₁ ,C ₂	PNE-00017	Coil 24VAC
R ₁	ELE-00220	Resistance 48V / 450W / Ø16x85
R ₂ ,R ₃	ELE-00018	Spiral Resistance 230V / 300W
b ₁ ,b ₃	ELE-00001	Start button CHNT
b ₂	ELE-00045	Stop/Emergency button CHNT
b ₄	ELE-00002	Stop/Emergency button CHNT WITH MOUNT
RL ₁ ,RL ₂	ELE-00298	Relay 24VAC / CHNT NC6-0910
Tr		Transformer 230VAC / 48V 500W/ 24V 100W
S ₁ ,S ₂	ELE-00152	Sensor Ø6x30 - 4m
T	ELE-00006	Timer 30sec
P	ELE-00003	Electric Foot Switch

NOTE: Before ordering a new thermoregulator please check the type (THP48 or TLK48).

TROUBLESHOOTING

PROBLEMS	REASONS – SOLUTIONS
Pincers' Failure to pull	- Valve B - Piston Seal P8 - Electric Pedal - Valve B Coil
Pincers' Failure to close	- Valve B - Piston Seal P13 - Electric Pedal - Valve B Coil
Pincers' Failure to open when the system is up	- Valve A - Cylinder Piston's Shaft needs few drops of oil - Piston Seal P20
Failure to move up	- Valve C - Valve D - Valve E - Coil D - Coil E - Piston Seal P20 - START BUTTON - STOP BUTTON
Failure of Time Setting	Timer
Temperature adjustment failure (does not warm up) of the aluminium last.	- Thermoregulator - Sensor - Element - Relay
Temperature adjustment failure (does not warm up) of the cushion.	- Thermoregulator - Sensor - Element - Relay