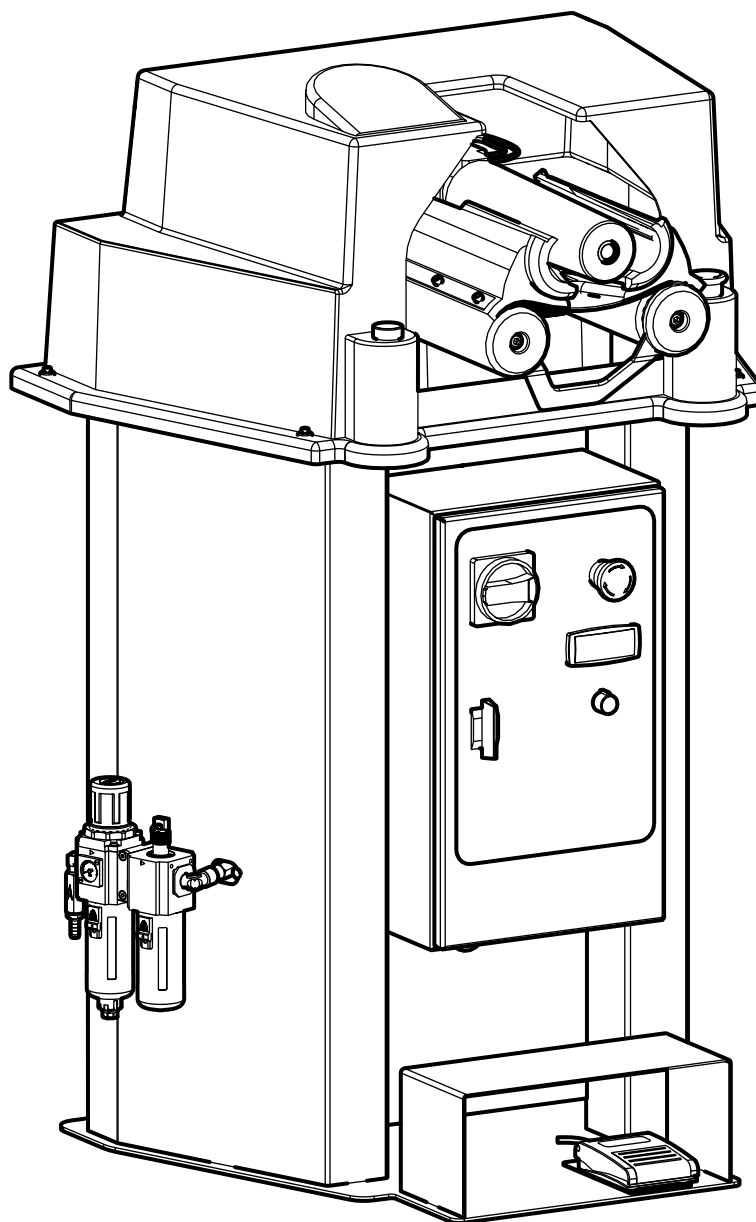


OPERATOR'S MANUAL



RF-22

VER. ASM-00209-B

RF-22C

VER. ASM-00199-B

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Introduction

The purpose of this manual is to inform the owner of this machine for its operation, its maintenance and for all the safety regulations. Please read carefully all the instructions and follow them in order to use the machine properly in the production and avoid any case of injuries.

Our company does not have any responsibility for any changes happened on the machine by the owner or actions, which are different to 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.

Only qualified and authorized personnel must use the machine.

- 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 machine frame must be earthed using the outside connection point marked according to the CE norms.



WARNING

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

WARNING

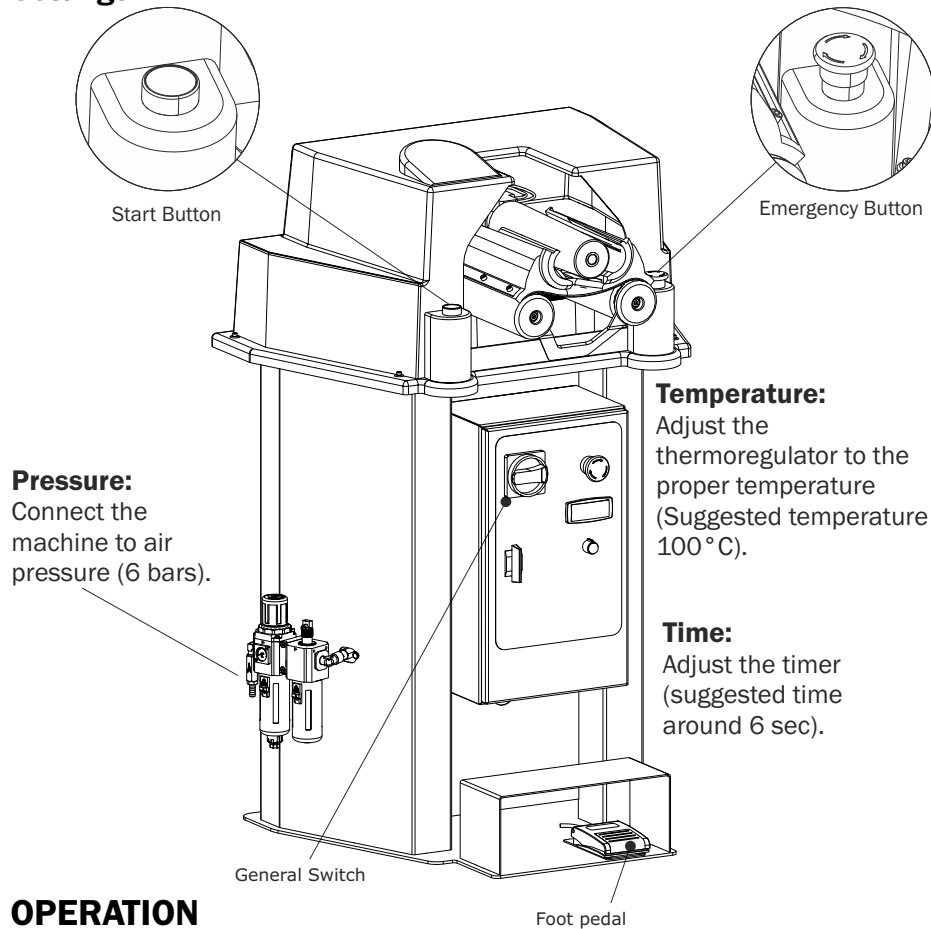
Use only original spare parts, which can be supplied by the manufacturer or the local agent. Otherwise, your machine will not be a CE product.

Installation, Adjustments, Operation & data

Installation

- Connect the machine to electric power 230V single phase.
- Connect the machine to air pressure (6 bars).

Settings



TECHNICAL DATA

Operation	Electric - Pneumatic
Pressure	6 bar
Voltage	1 PHASE 230V, 50/60 Hz
Power	800W
Air consumption	0.02 cfm
Capacity	150 pairs per hour
Dimensions (mm)	690 x 390 x 1320 h
Weight	70 kg
Noise level when running	65 dB

OPERATION



Fig.1

Step 1. Switch on the machine, and wait for a few minutes until the machine reaches the selected temperature.



Fig.2

Step 2. When the machine is ready, start placing your uppers.



Fig.3

Warning:

- The upper must be always placed as shown in the picture (Fig. 2-3)
- The upper must have been sprayed with latex or other suitable water based adhesives. In case you use a brush for the application of the adhesive you may cause wrinkles or marks on the upper.



Fig.4

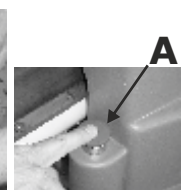


Fig.5

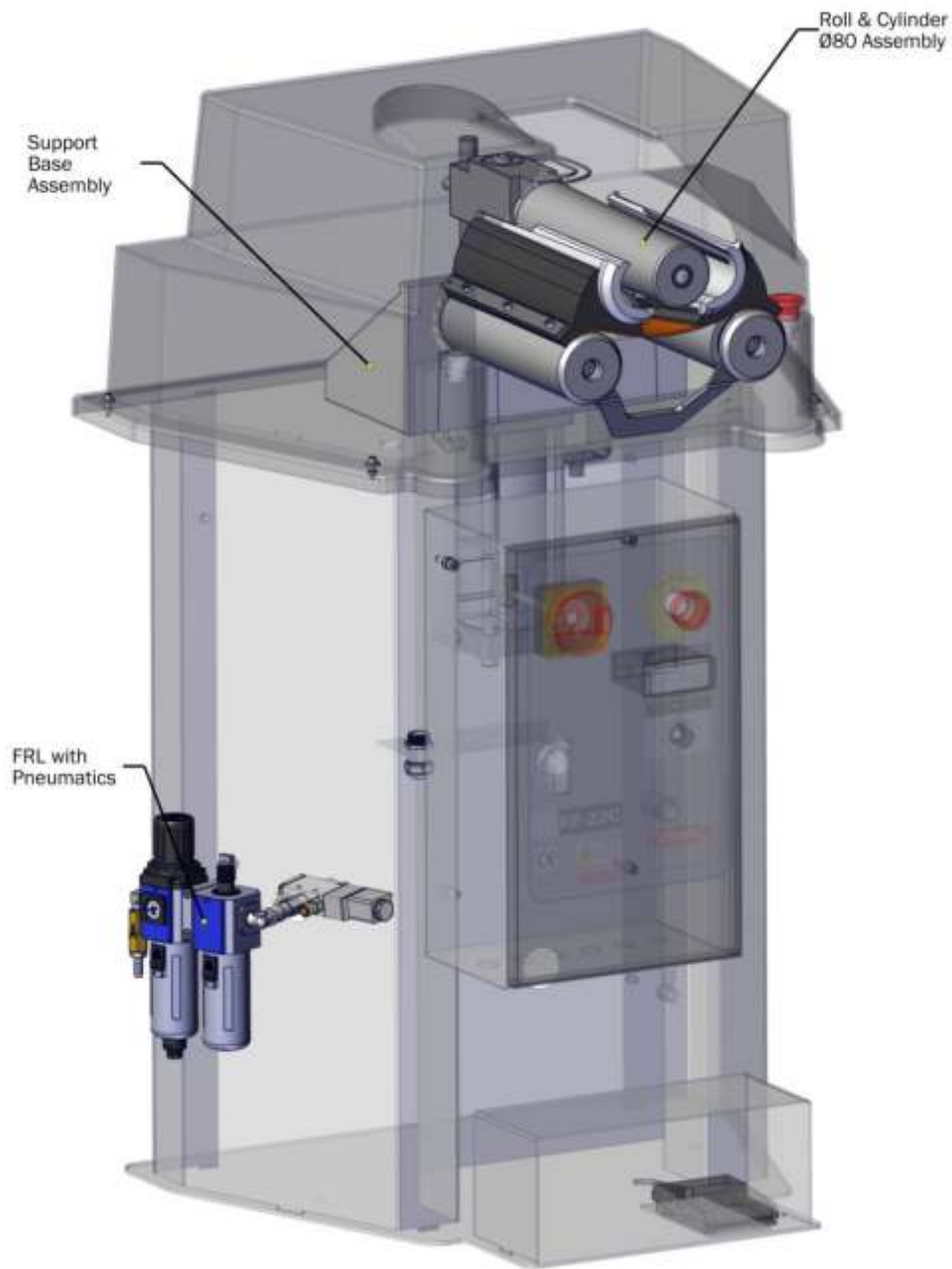
Step 3. Press at the same time the black button and the foot pedal to start the operation cycle and wait until it is completed (Fig. 4)

In case of emergency, press the emergency button A (Fig. 5).

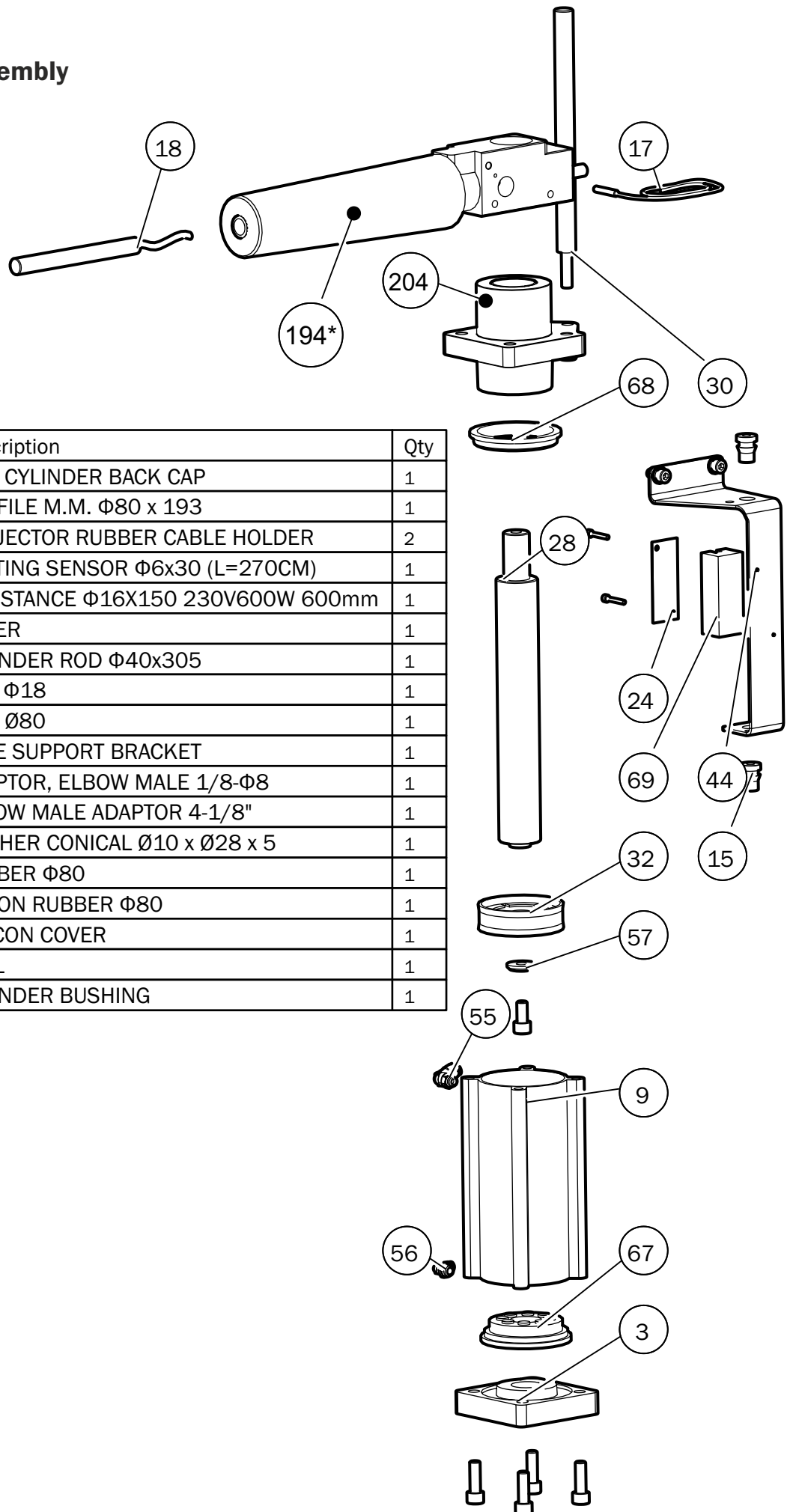
Useful tips

- For better results use the highest temperature in the roll according the material.
- The time can be reduced up to 4" according to the material processed.

RF-22 Series Assembling

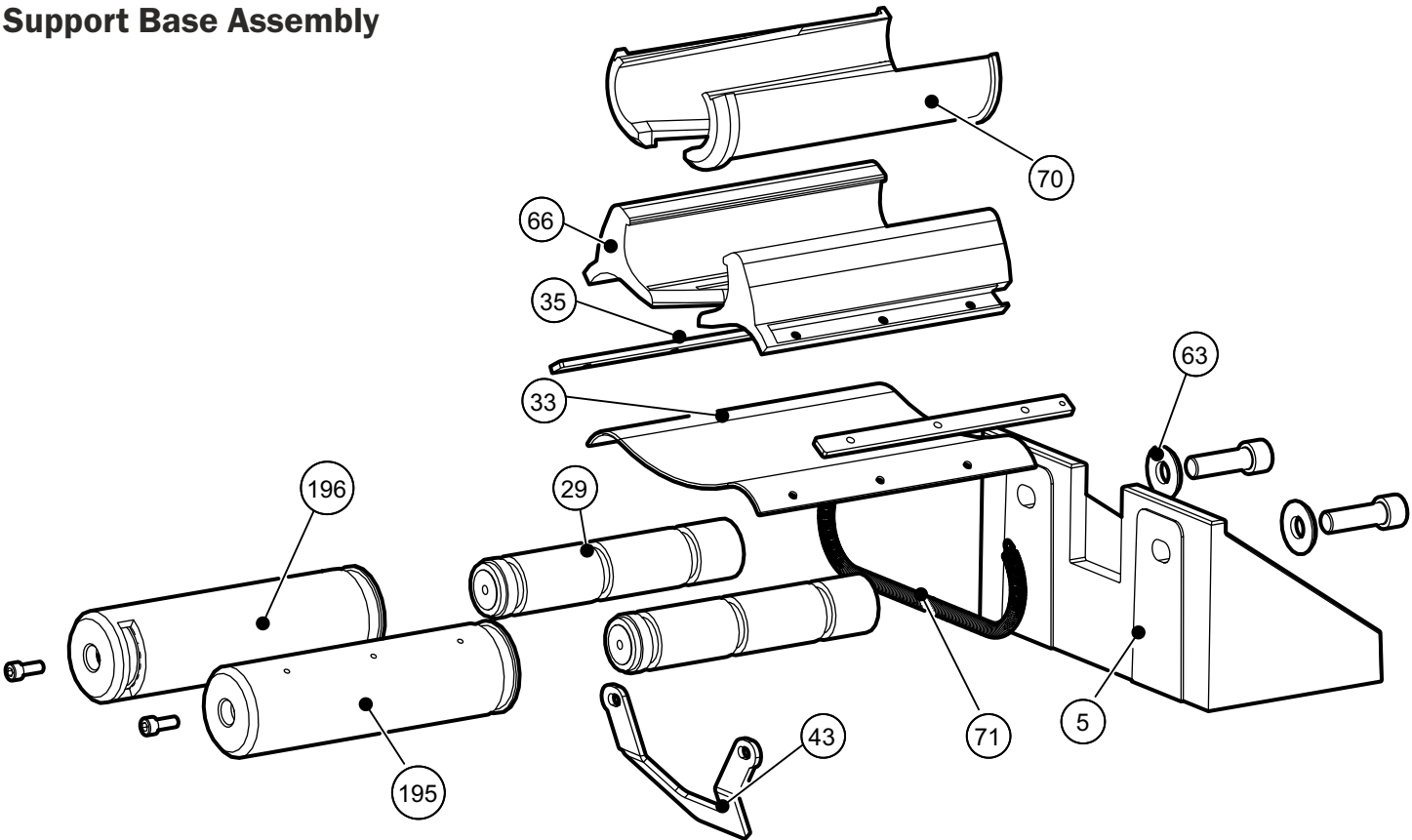


Roll & Cylinder Ø80 Assembly



BOM ID	PartNo	Description	Qty
3	CAS-00015	Φ80 CYLINDER BACK CAP	1
9	CYL-00017	PROFILE M.M. Φ80 x 193	1
15	ELE-00019	PROJECTOR RUBBER CABLE HOLDER	2
17	ELE-00176	HEATING SENSOR Φ6x30 (L=270CM)	1
18	ELE-00216	RESISTANCE Φ16X150 230V600W 600mm	1
24	ELE-00628	COVER	1
28	GEN-00083	CYLINDER ROD Φ40x305	1
30	GEN-00085	ROD Φ18	1
32	GEN-00087	DKN Ø80	1
44	LAS-00178	WIRE SUPPORT BRACKET	1
55	PNE-01064	ADAPTOR, ELBOW MALE 1/8-Φ8	1
56	PNE-09916	ELBOW MALE ADAPTOR 4-1/8"	1
57	REV-00045	WASHER CONICAL Ø10 x Ø28 x 5	1
67	RUB-00037	RUBBER Φ80	1
68	RUB-00038	PISTON RUBBER Φ80	1
69	RUB-00039	SILICON COVER	1
194*	ASM-00194	ROLL	1
204	ASM-00204	CYLINDER BUSHING	1

Support Base Assembly

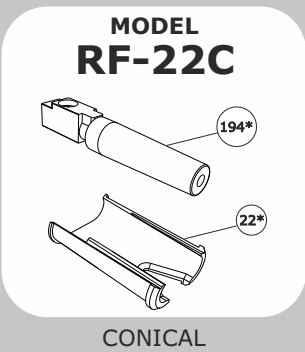
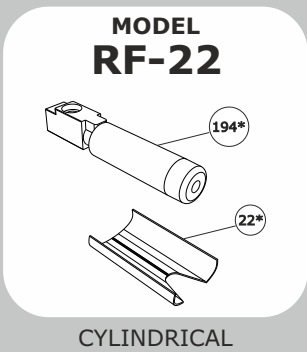


BOM ID	PartNo	Description	Qty
5	CAS-00056	SUPPORTING BASE	1
29	GEN-00084	ROLL ROD, RF-22 & RF-22C	2
33	GEN-00089	TUBULAR RF-22, RF-22C	1
35	LAS-00168	SECURING PLATE	2
43	LAS-00177	BRACKET	1
63	REV-00143	WASHER, CUSTOM, Φ40XΦ16.5X5	2
66	RUB-00035	MAIN PAD RF-22, RF-22C	1
70	RUB-00040	SILICON PAD FOR CONIC ROLL	1
71	SPR-00010	SPRING	1
195	ASM-00195	RF-22 BOTTOM ROLL, RIGHT	1
196	ASM-00196	RF-22 BOTTOM ROLL, LEFT	1

ATTENTION:

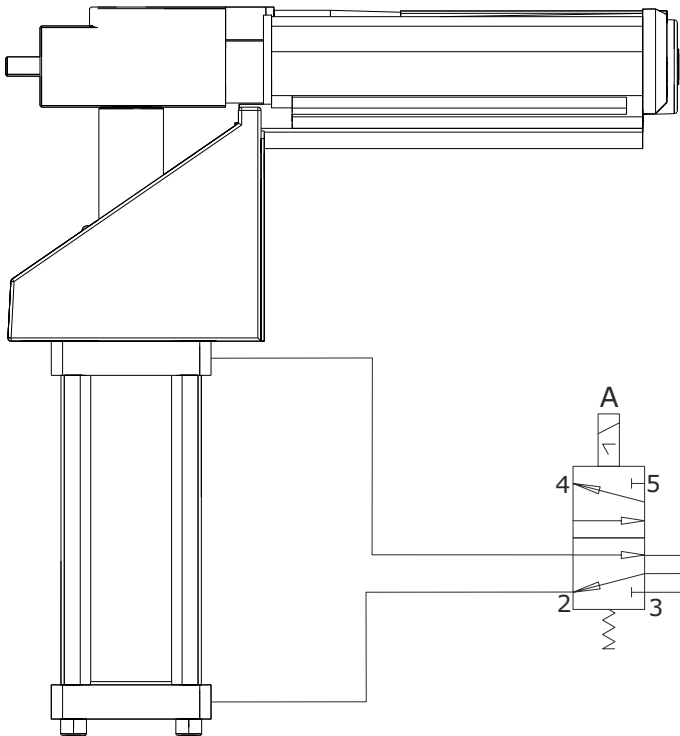
Before order, please confirm your machine model.

MODEL	No.	PART NUMBER	DESCRIPTION
RF-22	194*	CAS-00060	ROLL, CYLINDRICAL
	70*	RUB-00036	SILICON PAD FOR CYLINDRICAL ROLL
RF-22C	194*	CAS-00055	ROLL, CONICAL
	70*	RUB-00040	SILICON PAD FOR CONIC ROLL



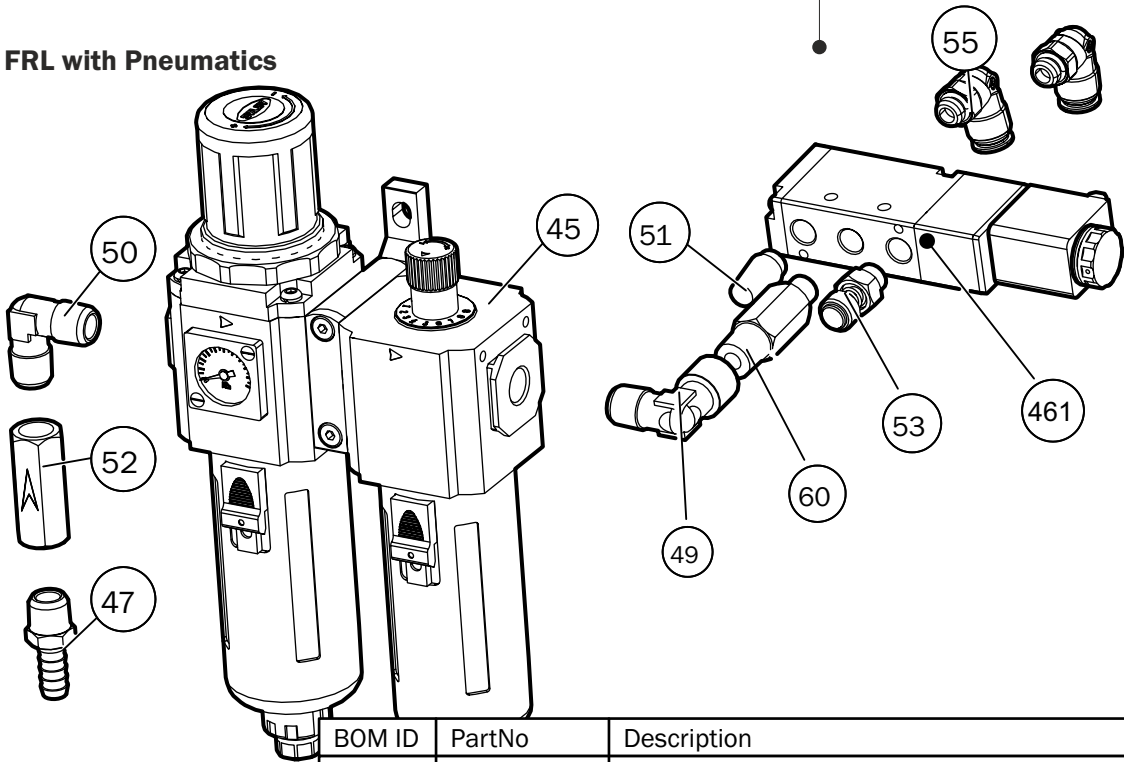
Pneumatic Diagram

RF-22 & RF-22C Pneumatic Diagram



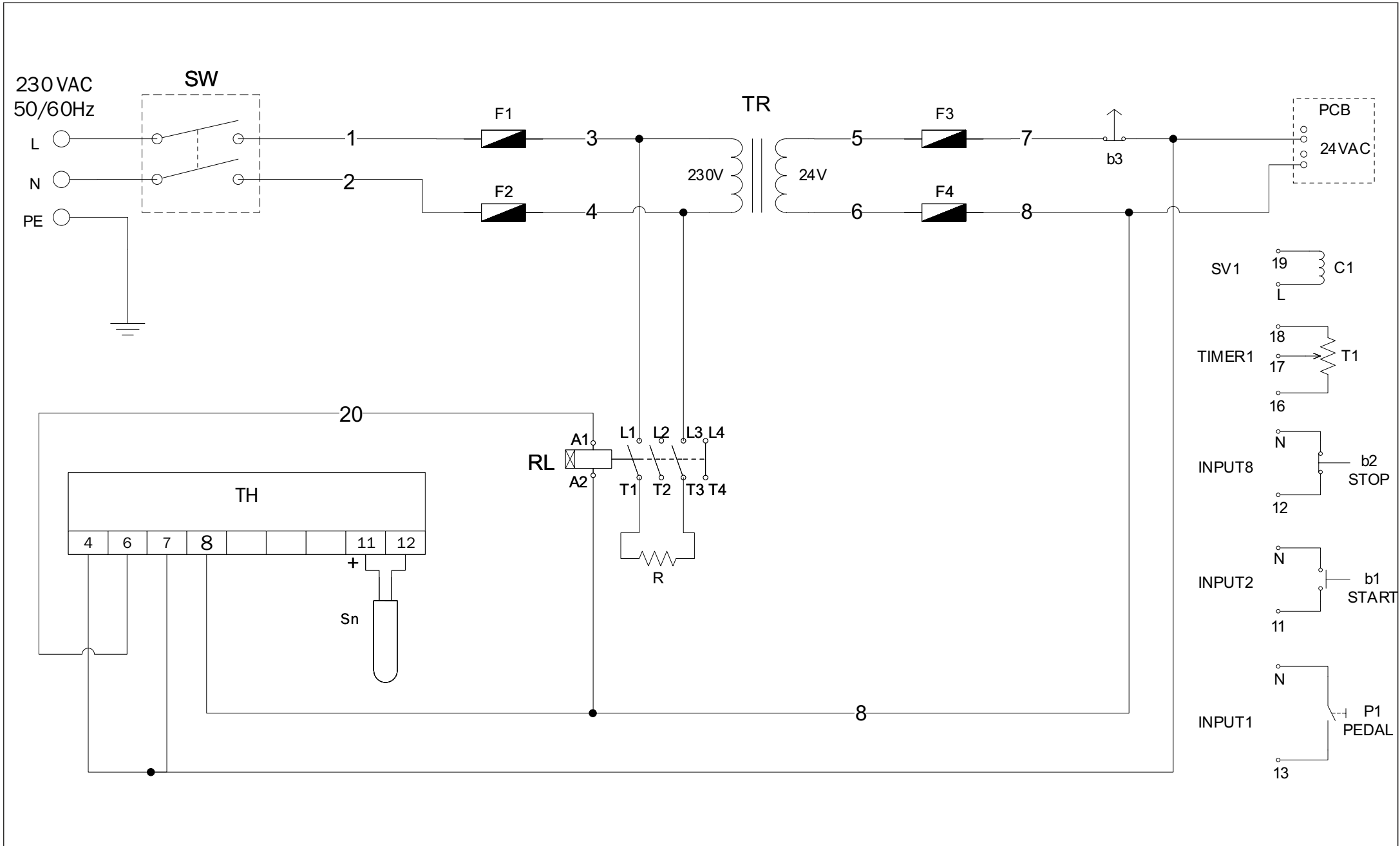
No	Part No	Description
A	ASM-00461	VALVE 5/2 1/8, 24V
P1	PNE-00001	FRL G1/4 SIZE 300
P2	PNE-00066	SILENCER 1/8
P3	PNE-00075	FLOW REGULATOR
P4	PNE-00074	NON-RETURN VALVE, 1/4, FEMALE

RF-22 & RF-22C FRL with Pneumatics



BOM ID	PartNo	Description	Qty
45	PNE-00001	FRL G1/4 SIZE 300	1
47	PNE-00020	HOSE ADAPTER, RG, MALE, TAPER, 1/4 - Ø8	1
49	PNE-00023	MALE-FEMALE ELBOW 1/4"	1
50	PNE-00046	ELBOW, MALE, 5000, 1/4	1
51	PNE-00066	SILENCER, 1/8	1
52	PNE-00074	NON-RETURN VALVE, 1/4	1
53	PNE-00741	SILENCER, SPRING REGULATOR, 1/8	1
55	PNE-01064	ADAPTOR, ELBOW MALE 1/8-Ø8	2
60	REV-00099	EXTENSION, TAPER 1/4 TO PARALLEL 1/8	1
461	ASM-00461	VALVE 5/2 G1/8, 24V	1

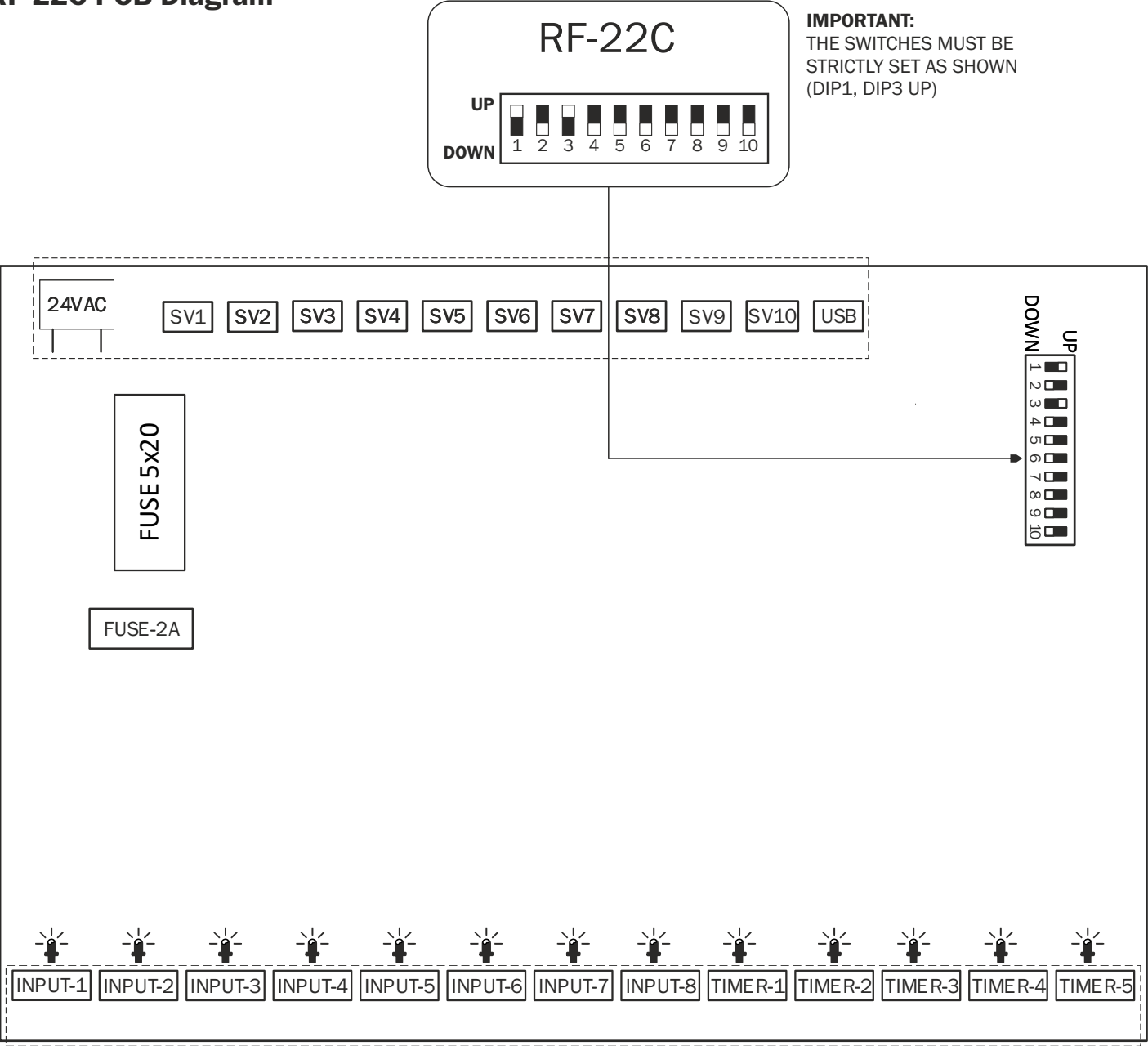
RF-22C ELECTRICAL DIAGRAM



Electric Components List

Diagram indication	Part No	Description
SW	ASM-00807	MAIN SWITCH
TR	ELE-00021	TRANSFORMER, 230V, 24V, 100VA
TH	ELE-00264	THERMOREGULATOR R38S
RL	ELE-00028	RELAY, MINI, CHINT NC6-0901
R	ELE-00209	HEATING ELEMENT $\Phi 16 \times 150$ 230V600W S1500 2CABLES
P1	ELE-00615	FOOT SWITCH BLACK
b1	ELE-00506	START BUTTON, $\Phi 22$, RED
b2	ELE-00001	START BUTTON, $\Phi 22$, BLACK
b3	ELE-00002	STOP BUTTON, $\Phi 40$, RED, WITH MOUNT
F1, F2	ELE-00336	CHINT NB1 63C10A 6KA MIKP 2P
F3, F4	ELE-00377	FUSE 4A 5X20
SV1	PNE-00017	COIL $\Phi 9/24V$ AC 5W
Sn	ELE-00506	HEATING SENSOR, $\Phi 6 \times 40$, (L=300cm)
T1	ELE-00076	POTENSIOMETER PC16S-A 10K Ω PIHER
PCB	PCB-00028	PCB M-USE V2.0

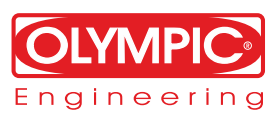
RF-22C PCB Diagram



PCB-00007 : M-USE MAIN BOARD

OUTPUTS	
SV1	CYLINDER Φ80

INPUTS	
INPUT-1	PEDAL
INPUT-2	BUTTON
INPUT-8	STOP
TIMER-1	TIMER



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REV.B