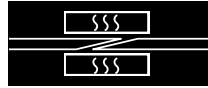


PM-2009/160A-B/45

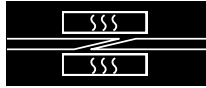
Heat press with air cooling





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0 Preface

Habasis thanks you for purchasing the

PM-2009/160A-B/45 press.

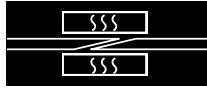
This press belongs to the press range called PM-09/160A.

If you handle your PM-2009/160A-B/45 press with care, it will guarantee joint reliability and quality for many years to come..

This document includes spare parts and product diagrams



Observing the instructions in this manual lets you work during: handling, installation, use and maintenance phases in safe conditions while guaranteeing good machine working order and economies of scale. HABASIT Italiana S.p.A. is not liable for damages due to negligence or failure to observe these instructions.

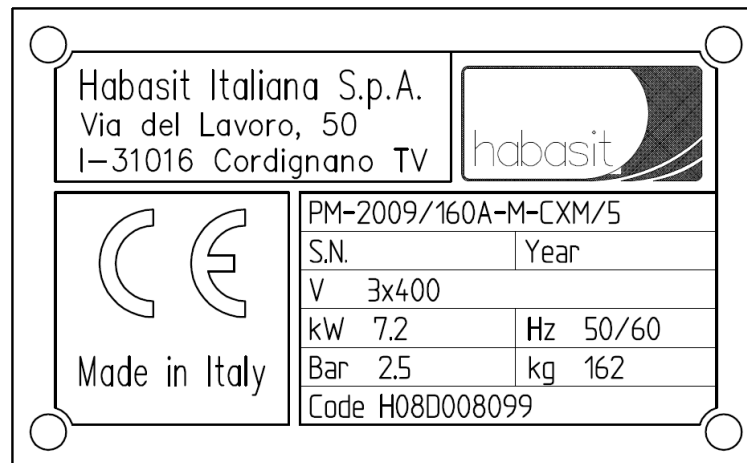


1 Machine identification data

Machine	Heat press
Type/Series	PM-2009/160A-B/458
Serial number	See EC identification plate
Year of construction	See EC identification plate

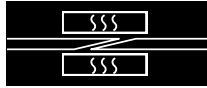
1.1 Identification plate and EC markings

The following identification plate was affixed to the press (FAC SIMILE):



This plate SHOULD NOT BE REMOVED for any reason. If damaged, please request a copy.

If necessary, the plate data must be communicated for service or spare parts.



DICHIARAZIONE DI CONFORMITÀ

DECLARATION OF CONFORMITY

2006/95/CE



Noi We

HABASIT ITALIANA S.p.A.
Via del Lavoro, 50
I - 31016 Cordignano (TV) - ITALY

dichiariamo sotto la nostra esclusiva responsabilità *declare under our sole responsibility*
che l'apparecchiatura tipo: *that the device type:*

Pressa a caldo Hot press

Modello: *Series:*

PM-1209/160A-B/45

Matricola: *Serial Number:*

è conforme alle seguenti direttive: *is in conformance with the following directives:*

2006/95/CE

Direttiva Bassa Tensione *Low Voltage Directive*

2004/108/CE

Direttiva Compatibilità Elettromagnetica *Electromagnetic Compatibility Directive*

ed è conforme alle disposizioni delle seguenti norme *and is in conformance with the rules of the*
armonizzate: *following harmonized standard:*

UNI EN ISO 12100/2010

CEI EN 60204-1/2006

Il Fascicolo Tecnico viene conservato presso: *The Technical File is stored at:*

HABASIT ITALIANA S.p.A.
Via del Lavoro, 50
I – 31016 Cordignano (TV) - ITALY

Cordignano,

Il Direttore Generale
General Manager

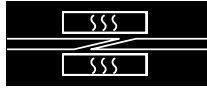
Ugo Passadore

Il Responsabile del Fascicolo Tecnico
Technical File Manager

Matteo Mapelli

.....

.....



DICHIARAZIONE DI INCORPORAZIONE

DECLARATION OF INCORPORATION

2006/42/CE – Allegato II - B



Noi We

HABASIT ITALIANA S.p.A.
Via del Lavoro, 50
I - 31016 Cordignano (TV) - ITALY

dichiariamo sotto la nostra esclusiva responsabilità *declare under our sole responsibility that the partly*
che la quasi-macchina tipo: *completed machinery type:*

Pressa a caldo Hot press

Modello: *Series:*

PM-2009/160A-B/45

Matricola: *Serial Number:*

è conforme ai requisiti essenziali della salute e *is in conformance with the essential health and*
sicurezza il cui elenco è riportato nella *safety requirements, the list of such is reported in*
documentazione tecnica pertinente, secondo *the relevant technical documentation, according*
l'allegato VII – B della Direttiva 2006/42/CE, *with the annexed VII – B of 2006/42/EC directive,*
conservata presso: *at:*

HABASIT ITALIANA S.p.A.
Via del Lavoro, 50
I - 31016 Cordignano (TV) - ITALY

ed è inoltre conforme alla Direttiva Bassa Tensione *and is also in conformance with the 2006/95/CE*
2006/95/CE. *Low Tension Directive.*

Ci impegnamo a trasmettere le informazioni *We strive to provide the relevant information on*
pertinenti su richiesta adeguatamente motivata dalle *reasoned request by national authorities.*
autorità nazionali.

E' comunque espressamente vietato procedere *It is however expressly forbidden to proceed with*
all'avviamento della quasi-macchina in oggetto *the start up of the said partly completed machinery*
prima che il sistema al quale è prevista la sua *before the system which is intended for its*
incorporazione sia dichiarato conforme alle vigenti *incorporation is declared to be in conformity with*
direttive CE. *the current EC directive.*

Cordignano,

Il Direttore Generale
General Manager

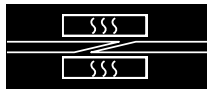
Ugo Passadore

Il Responsabile della documentazione tecnica
Technical documentation manager

Matteo Mapelli

.....

.....



2 Regulations and general warnings

2.1 Manual layout criteria

This manual observes the organizational rules and requirements of Directive 2006/42/, duly amended, being the Directive of the Council of the European Community, concerning the reconciliation of the laws of member states regarding machines, and also all the other Directives and Regulations referred to in the said Machine Directive, inspired by criteria which, in addition to illustrating the technical characteristics of the machine and its use, maintenance and troubleshooting methods, also clearly indicate the following:

- All the protection measures adopted on the machine, fully integrating design safety planning and construction safety
- All protection measures to be adopted to meet those risks that cannot be completely eliminated
- All indications for the training of personnel using the machine, while indicating where it is necessary to provide for individual safety protection devices.
- The manual is divided up into sections. Each section deals with a specific subject in which every aspect of safety is considered and clearly highlighted in the text.

2.2 Manual use criteria

HABASIT encourages the reader to fully read this manual when receiving the equipment it comes with and, in any case, before handling the equipment. This manual is designed to provide all the instructions, indications and warnings needed by the user to learn about the equipment, understand its main operating principles and be suitably informed for safe use.

In addition to the instructions in this manual, we would ask users to observe any specific current laws.

This manual must be considered as an essential part of the equipment. Its contents must be made known to the entrusted maintenance persons and users.

The purpose is to provide all the information required for good, correct use of the equipment.

The manuals must be kept throughout the equipment's life and must be updated in the event of modifications aimed at improving the equipment's performance.

The manuals must be available to qualified personnel.

Consultation of this manual is facilitated by the general index on the first page, which makes it possible to immediately find the subject of interest.

If the subject dealt with is particularly important it is highlighted with references to the type of technical personnel required to intervene.

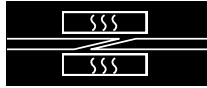
All updates HABASIT considers necessary to improve the quality of the equipment will be communicated by way of sending of further specific documentation or a new manual to replace the previous one.

Should the equipment be transferred to another customer, manuals must be included and HABASIT informed in order to provide future modifications or updates.

A copy of this manual, delivered with the equipment, is meant for the maintenance operators, who shall read and keep it near the equipment, and consult it before undertaking any action on the equipment.

The **PM-2009/160A-B/45** press has been specifically developed for hot joining of HABASIT drive and conveyor parts using the Flexproof process.

It was exclusively designed for the applications described hereto. Other or unsuitable applications are prohibited. Habasis shall not be liable for unintended application consequences. The **PM-2009/160A-B/45** press was professionally manufactured in accordance with EC safety instructions. All assembly, maintenance and repair work, as well as the operation of the equipment, is expected to be carried out by qualified personnel or staff under the supervision of responsible specialists and experts.



For space reasons, these instructions for use cannot cover all possible operating, maintenance and repair aspects. The indications provided concern normal machine use by qualified personnel. In the event of doubt or in need of further information, always contact the manufacturer.



3 Technical specifications

3.1 Electrical specifications

Power	2 x 3600 W = W 7200
Supply voltage	400V or 230 V ~
Frequency	50-60 Hz

3.2 Pneumatic characteristics

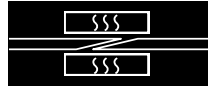
Fluid characteristics	Filtered, non-lubricated air
Maximum working pressure	2.5 bar \pm 0.2 bar / 36.25 psi
Min. supply diameter	Rapid connector of 1/4"

3.3 Dimensions and environmental characteristics

Dimensions (LengthxWidthxHeight) (including handles)	2490L x 300W x 400H mm 98.03 x 11.81 x 15.74 inches
Total Weight	162 kg / 357.15 lbs.
Upper part weight	70 kg / 154.32 lbs.
Lower part weight	92 kg / 202.83 lbs.
Noise level	< 70 db
Working temperature	Between 15°C – 38°C / 59°F – 100.4°F
Humidity tolerance	Between 45 ÷ 70%

3.4 Production specifications

Max length of belt/tape	2000 mm / 78.74 in
Max width of belt/tape	10 mm / 0.4 in
Minimum length of belt/tape	1200 mm / 47.24in
Heating plate width	160 mm / 6.3 in
Max. working temperature	2.5 bar / 36.25 psi
Max. working temperature	199° C / 390° F
Temperature interval	+ 2° / - 4° C + 3.6° / - 7.2° F
Maximum heating plate temperature deviation from nominal value	+/- 2°C / 3.6° F
Mean heating time at 180° C	3 min. (230V~) 4 min. (400V~)
Cooling time from 180° C to 80° C	15 min.



3.5 Dimensions

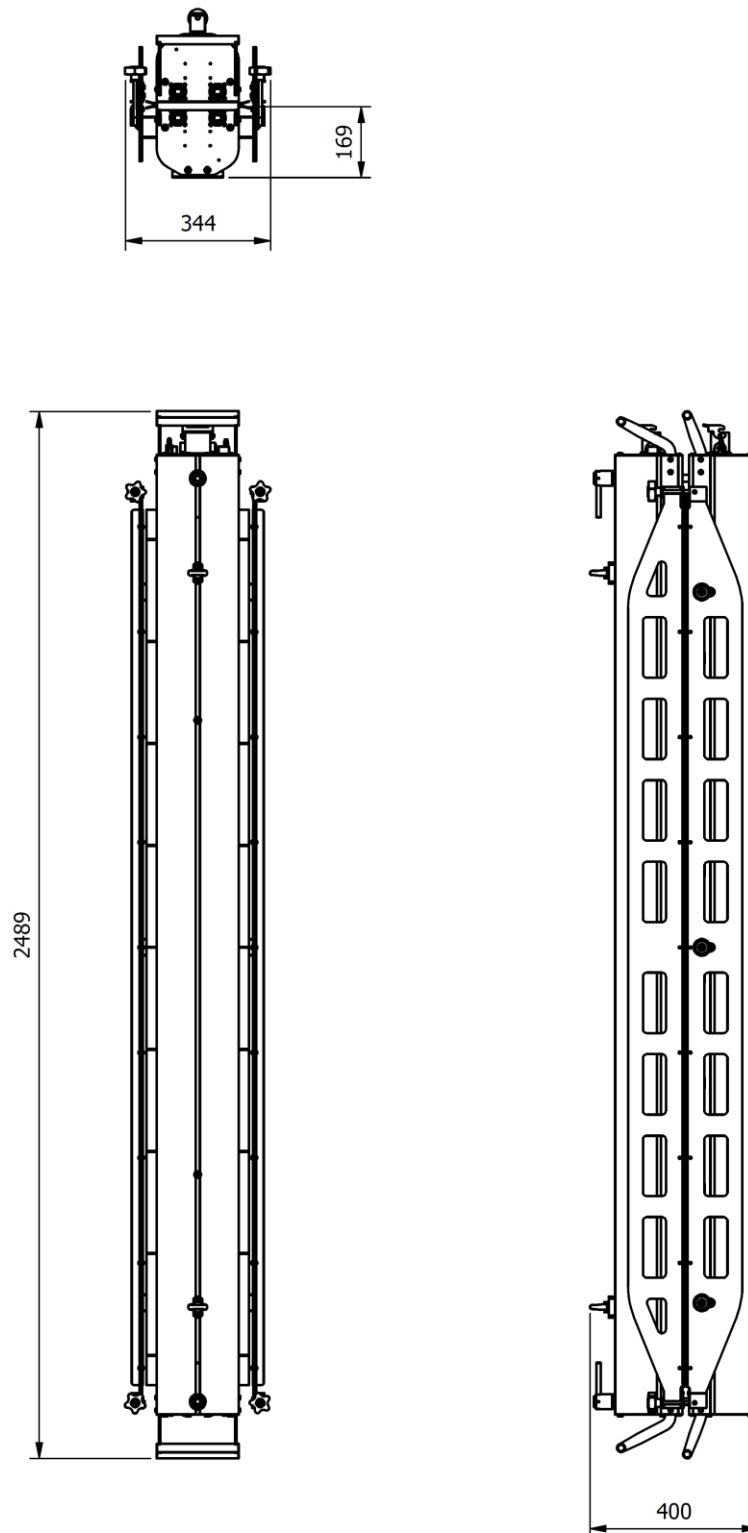
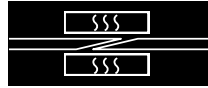


Figure 1– Press general dimensions PM-2009/160-B/45



4 Drawings and spare parts list

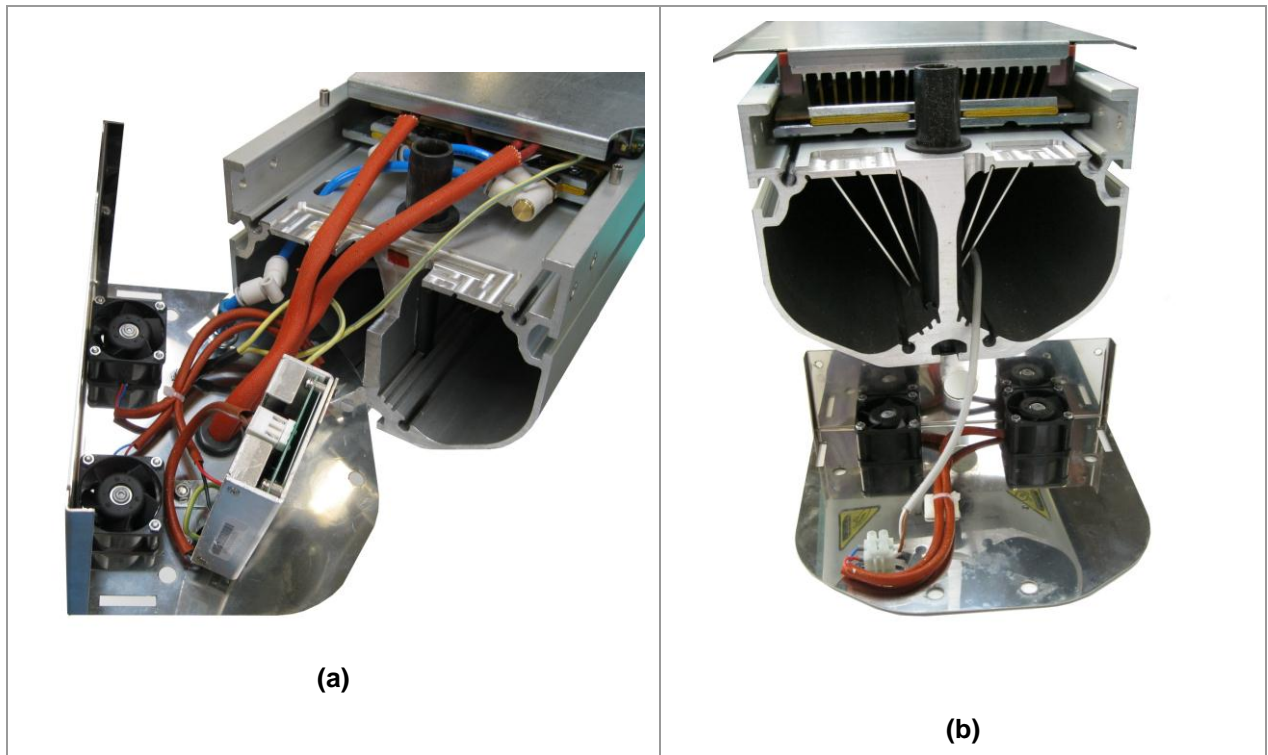
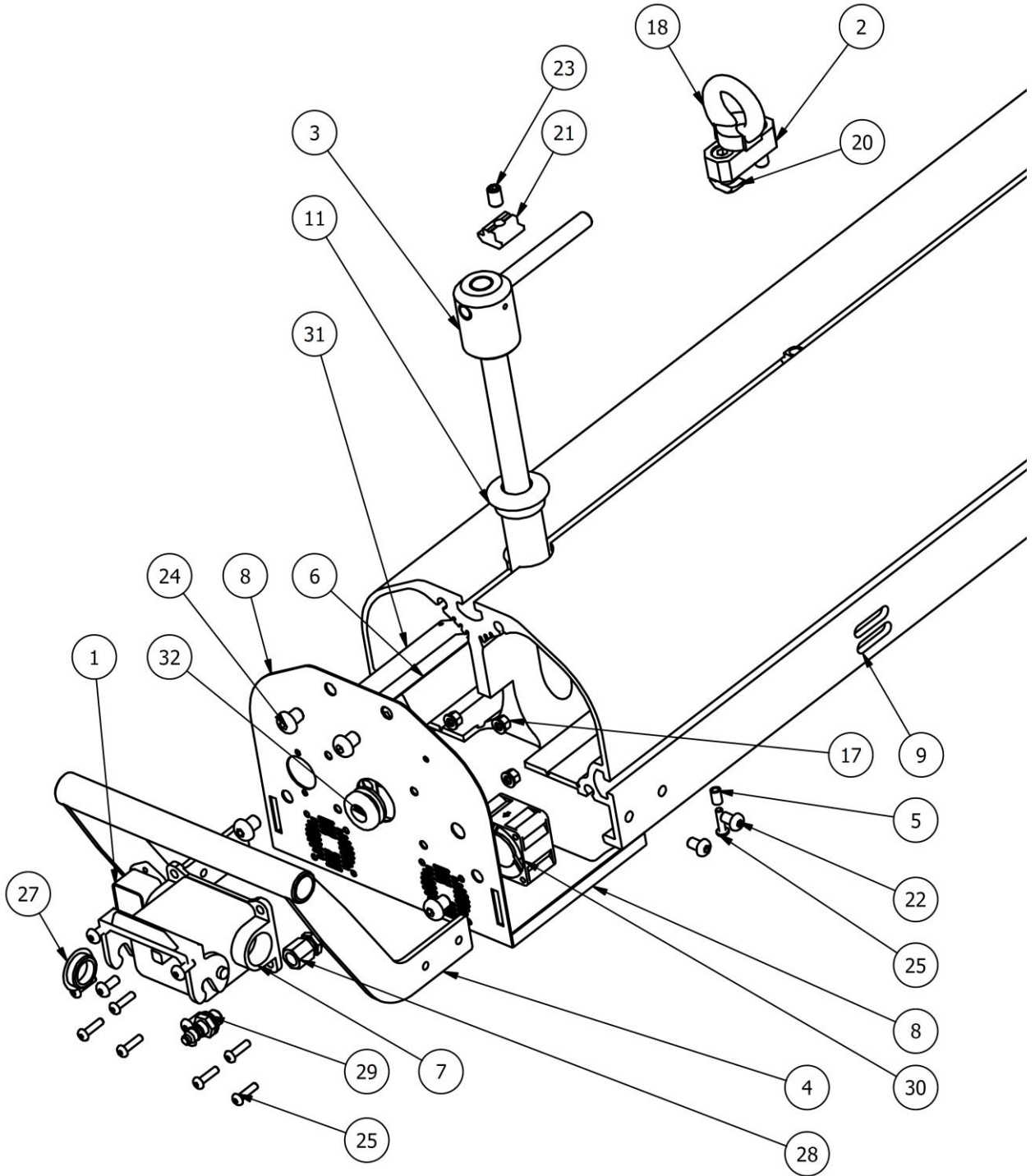
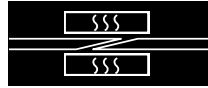


Figure. 2 - PM-2009/160-B/45 press internal connection, electrical connector side (a) and opposite side (b).

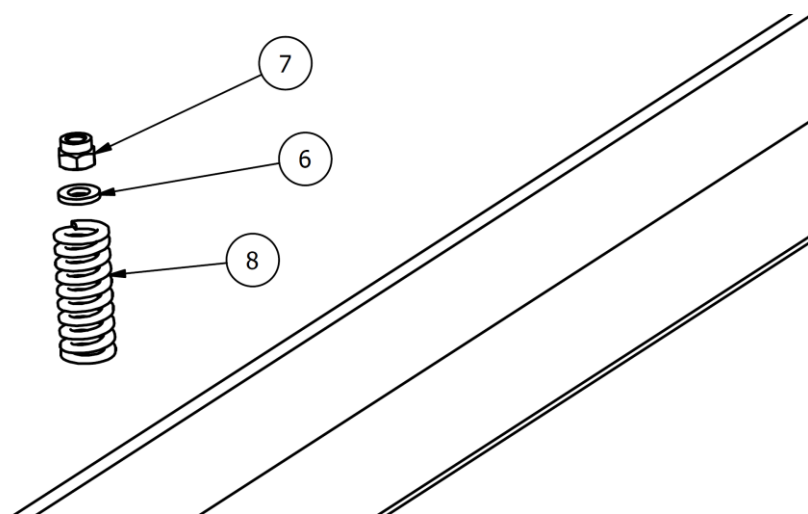


4.1 H08D008090 – Upper press beam unit – heads

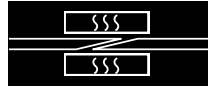




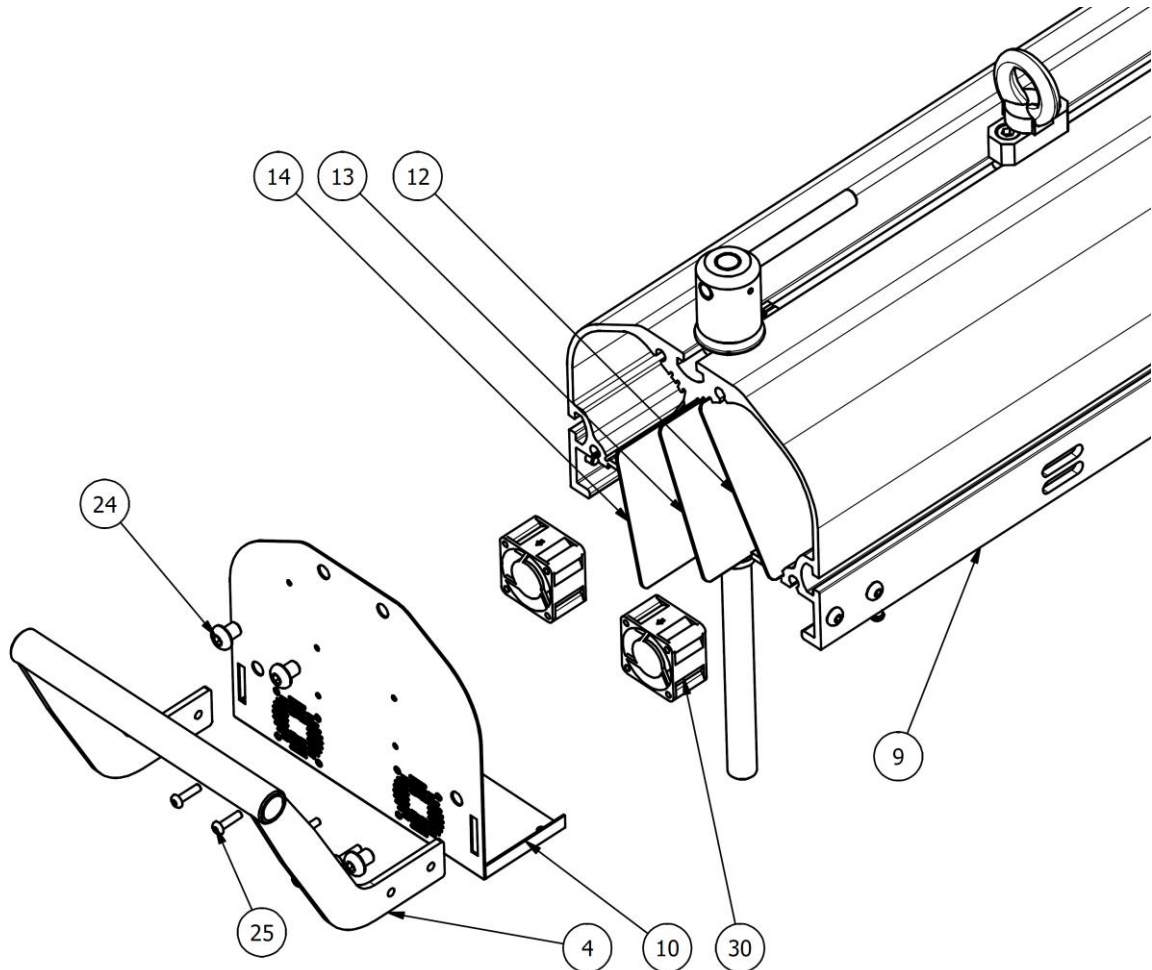
PM-2009/160A Press		H08D008090 – Upper press beam unit – heads	
Position	Q.ty	Code	Description
1	1	H080704506	RECESSED CASE CKA 03 I - ILME
2	2	H08D003604	LIFTING RING LOCK
3	2	H08D004626	HIGH PROFILE CLOSING SCREW
4	2	H08D005755	COMPLETE HANDLE FOR UPPER BEAM
5	4	H08D005772	CALIBRATED ELECTRO-WELDED TUBE Ø6X1
6	1	H08D007211	TRANSFORMER SUPPORT PLATE
7	1	H08D007299	PERFORATED FIXED CASE WITH LEVER ILME - CHP 06 L
8	1	H08D008091	FAN CONNECTION SIDE HEAD
9	1	H08D008092	PRESS BEAM PM-2009A
11	2	H08D008094	UPPER BUSHING
17	4	H08N010113	UNI 5588-68 M5 GALVANIZED NUT.
18	2	H08N010151	MALE LIFTING RING UNI 2947 M10 GALVANIZED.
20	4	H08N010956	DAM0810 HAMMER NUT M8X10
21	2	H08N010958	DAT0810 MECHANICAL NUT
22	8	H08N011451	SCREW VTBEI UNI-ISO 7380-M6X10 GALVANIZED.
23	2	H08N011536	FLAT-TIPPED GRUB SCREW ISO 4026 M8X12
24	8	H08N012005	SCREW VTBEI UNI-ISO 7380-M8X10 STAINLESS STEEL
25	20	H08N012122	SCREW VTBEI UNI-ISO 7380-M4X16 GALVANIZED.
27	1	H08N012128	CAP PG16COD.1844 CEMBRE
28	1	H08N020951	QCK-1/8-PK-4-B THROUGH CONNECTOR COD.9425 FESTO
29	1	H08N020953	MALE COUPLING 11 MINI 1/8" COD. 0102011
30	4	H08N040418	AXIAL FAN 24VDC 19M3/H COD.414J COD. RS 250-836
31	1	H08N040432	TRANSFORMER AIMTEC AMEC15-24SMAZ..
32	1	H08N040434	LEGRAND PITCH CODE 098093



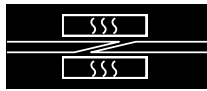
Position	Q.ty	Code	Description
6	4	H08N010065	UNI 6592-6.4x12.5 GALVANIZED WASHER
7	4	H08N012069	UNI 7473-68 M6 galvanised self-locking nut
8	4	H08N012250	VERDE V16-038 SPECIAL SPRINGS series rectangular wire spring



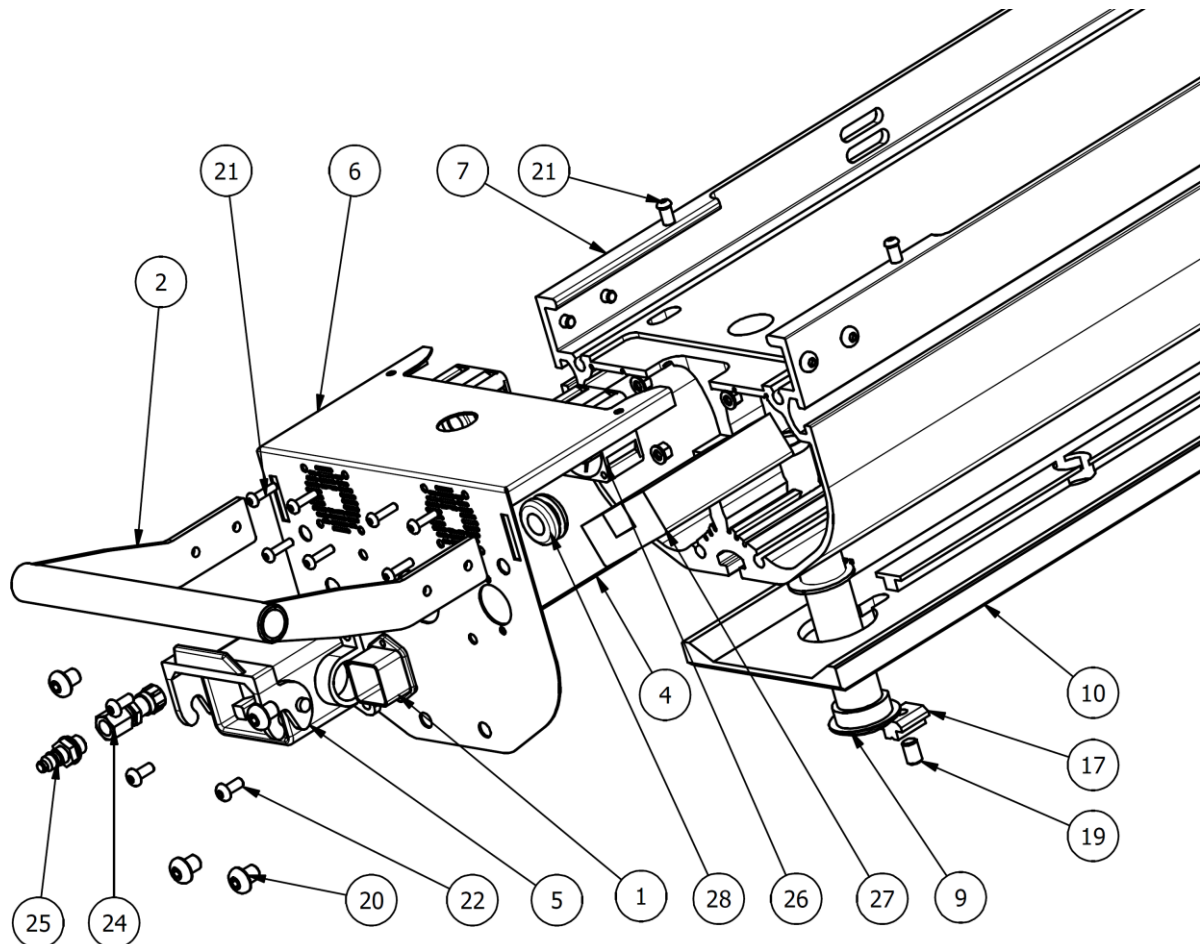
H08D008090 – Upper press beam unit – heads

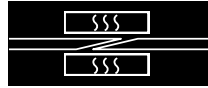


PM-2009/160A Press		H08D008090 – Upper press beam unit – heads	
Position	Q.ty	Code	Description
4	2	H08D005755	COMPLETE HANDLE FOR UPPER BEAM
9	1	H08D008092	PRESS BEAMPM-2009°
10	1	H08D008093	FAN NEUTRAL SIDE HEAD
12	2	H08D008100	INTERNAL PROFILE REINFORCEMENT
13	2	H08D008201	INTERNAL PROFILE REINFORCEMENT
14	2	H08D008202	INTERNAL PROFILE REINFORCEMENT
24	8	H08N012005	SCREW VTBEI UNI-ISO 7380-M8X10 STAINLESS STEEL
25	20	H08N012122	SCREW VTBEI UNI-ISO 7380-M4X16 GALVANIZED.
30	4	H08N040418	AXIAL FAN 24VDC 19M3/H COD.414J COD. RS 250-836

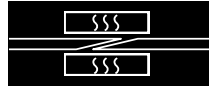


4.2 H08D008096 – Lower press beam unit – Heads

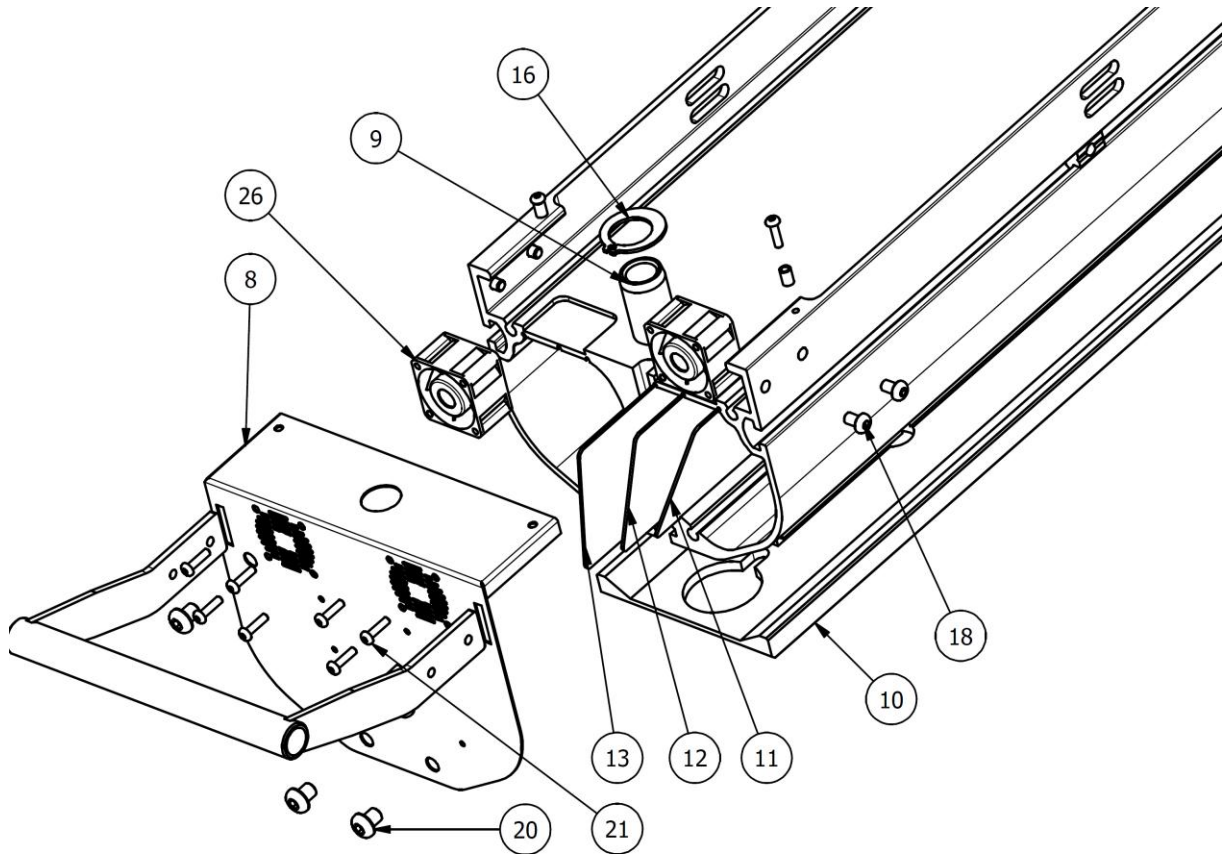




PM-2009/160A Press		H08D008096 - Lower press beam unit – Heads	
Position	Q.ty	Code	Description
1	1	H080704506	RECESSED CASE CKA 03 I - ILME
2	2	H08D005758	LOWER BEAM SIMPLE HANDLE
4	1	H08D007211	TRANSFORMER SUPPORT PLATE
5	1	H08D007299	PERFORATED FIXED CASE WITH LEVER ILME - CHP 06 L
6	1	H08D008091	FAN CONNECTION SIDE HEAD
7	1	H08D008092	PRESS BEAMPM-2009°
9	2	H08D008097	LOWER BEARING
10	1	H08D008098	PEDESTALPM-2009°
17	8	H08N010958	DAT0810 MECHANICAL NUT
19	2	H08N011536	FLAT-TIPPED GRUB SCREW ISO 4026 M8X12
20	8	H08N012005	SCREW VTBEI UNI-ISO 7380-M8X10 STAINLESS STEEL
21	20	H08N012122	SCREW VTBEI UNI-ISO 7380-M4X16 GALVANIZED.
22	4	H08N012123	SCREW VTBEI UNI-ISO 7380-M5X12 GALVANIZED.
24	1	H08N020951	QCK-1/8-PK-4-B THROUGH CONNECTOR COD.9425 FESTO
25	1	H08N020953	MALE COUPLING 11 MINI 1/8" COD. 0102011
26	4	H08N040418	AXIAL FAN 24VDC 19M3/H COD.414J COD. RS 250-836
27	1	H08N040432	TRANSFORMER AIMTEC AMEC15-24SMAZ..
28	1	H08N040434	LEGRAND PITCH CODE 098093



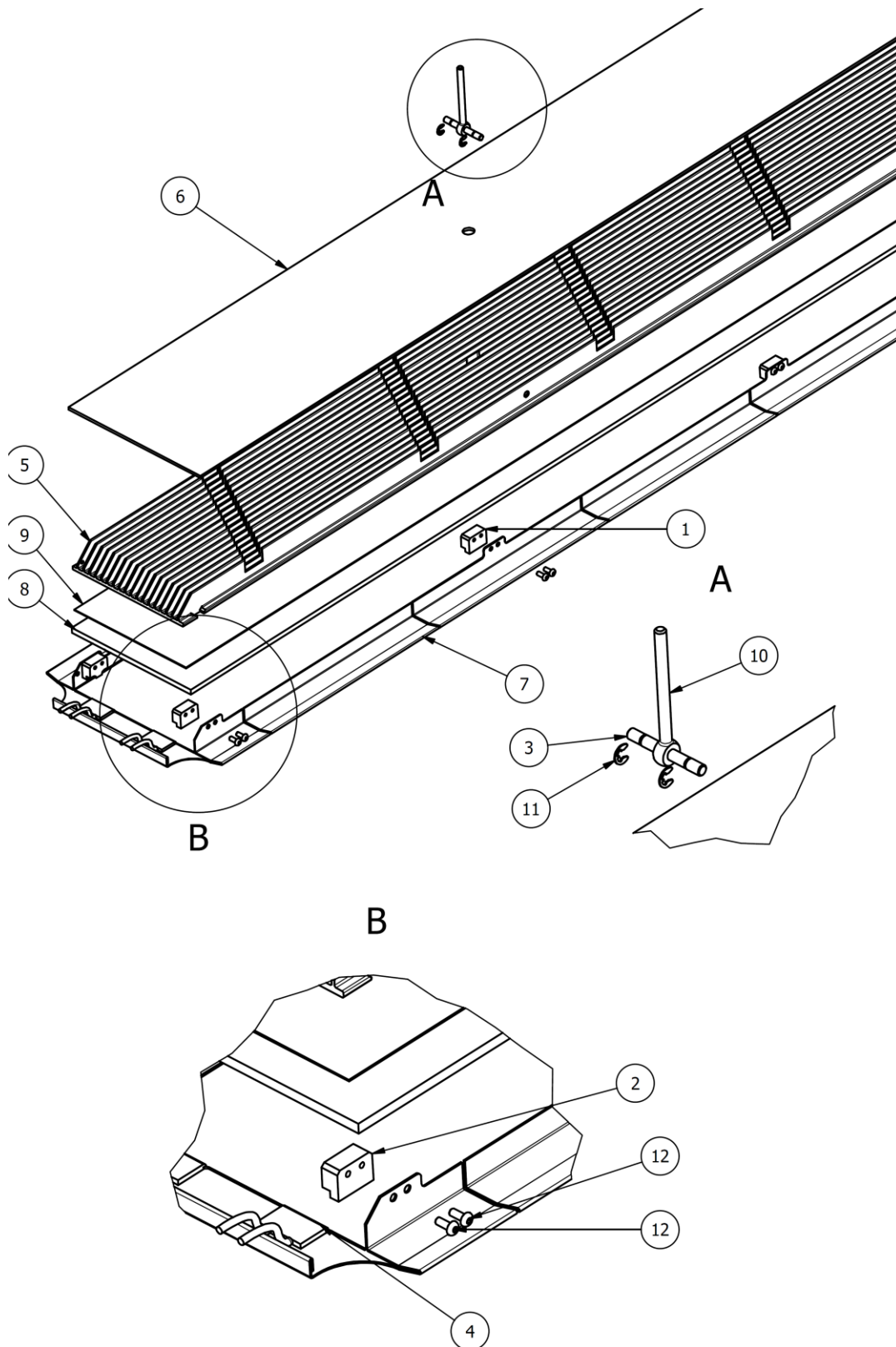
4.3 H08D008096 - Lower press beam unit – Heads

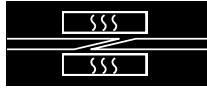


PM-2009/160A Press		H08D008096 - Lower press beam unit – Heads	
Position	Q.ty	Code	Description
8	1	H08D008093	FAN NEUTRAL SIDE HEAD
9	2	H08D008097	LOWER BEARING
10	1	H08D008098	PEDESTALPM-2009°
11	2	H08D008100	INTERNAL PROFILE REINFORCEMENT
12	2	H08D008201	INTERNAL PROFILE REINFORCEMENT
13	2	H08D008202	INTERNAL PROFILE REINFORCEMENT
16	2	H08N010408	SELF-LOCKING STOP RING WA-G 24 GANDINI
18	8	H08N011451	SCREW VTBEI UNI-ISO 7380-M6X10 GALVANIZED.
20	8	H08N012005	SCREW VTBEI UNI-ISO 7380-M8X10 STAINLESS STEEL
21	20	H08N012122	SCREW VTBEI UNI-ISO 7380-M4X16 GALVANIZED.
26	4	H08N040418	AXIAL FAN 24VDC 19M3/H COD.414J COD. RS 250-836



4.4 H08D008074 – Heating unit

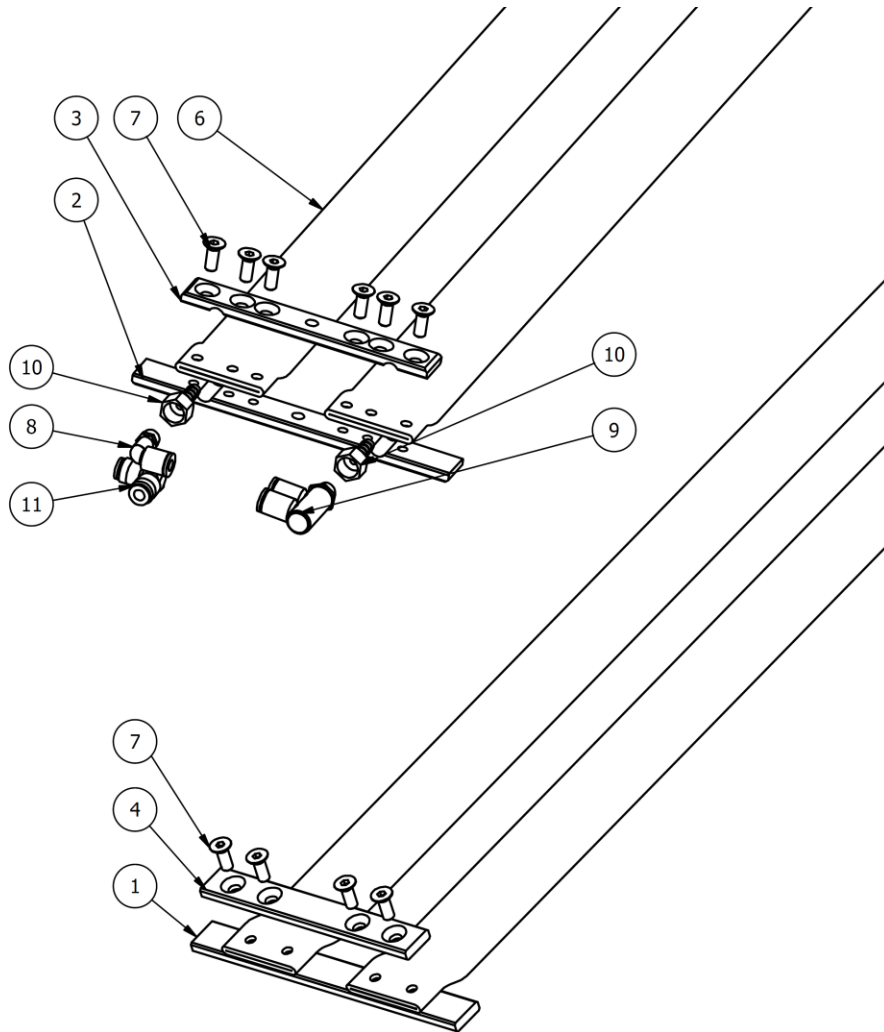


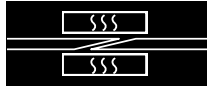


PM-2009/160A Press			H08D008074 – Heating unit
Position	Q.ty	Code	Description
1	10	H08D005762	INSULATING SPACER BLOCK
2	2	H08D005763	LOCKING INSULATING SPACER BLOCK
3	2	H08D005764	TIE FASTENING PIN
4	1	H08D008075	Res. 230V xx00W PM-2009A code xxxxxxxx
5	1	H08D008076	CHANNELLED RADIATOR 2080 - OMAR 2118
6	1	H08D008077	MULTILAYER BEACH SEPARATOR
7	1	H08D008078	WIDE WELDING PLATE PM-2009A
8	1	H08D008082	SILICON INSULATING STRIP 6mm PM-2009A
9	1	H08D008083	GALVANISED IRON INSULATING PLATE S=1MM PM-1609A
10	2	H08N011786	GN.12504 DIN444-M6-75 ELESA EYE SCREW
11	4	H08N012125	UNI 7434-d5 DIN 6799 elastic lock ring
12	24	H08N012126	VTBEI UNI-ISO 7380-M4x10 GALVANIZED SCREW.

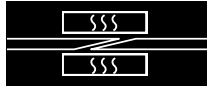


4.5 H08D008084 – Pressure pad unit

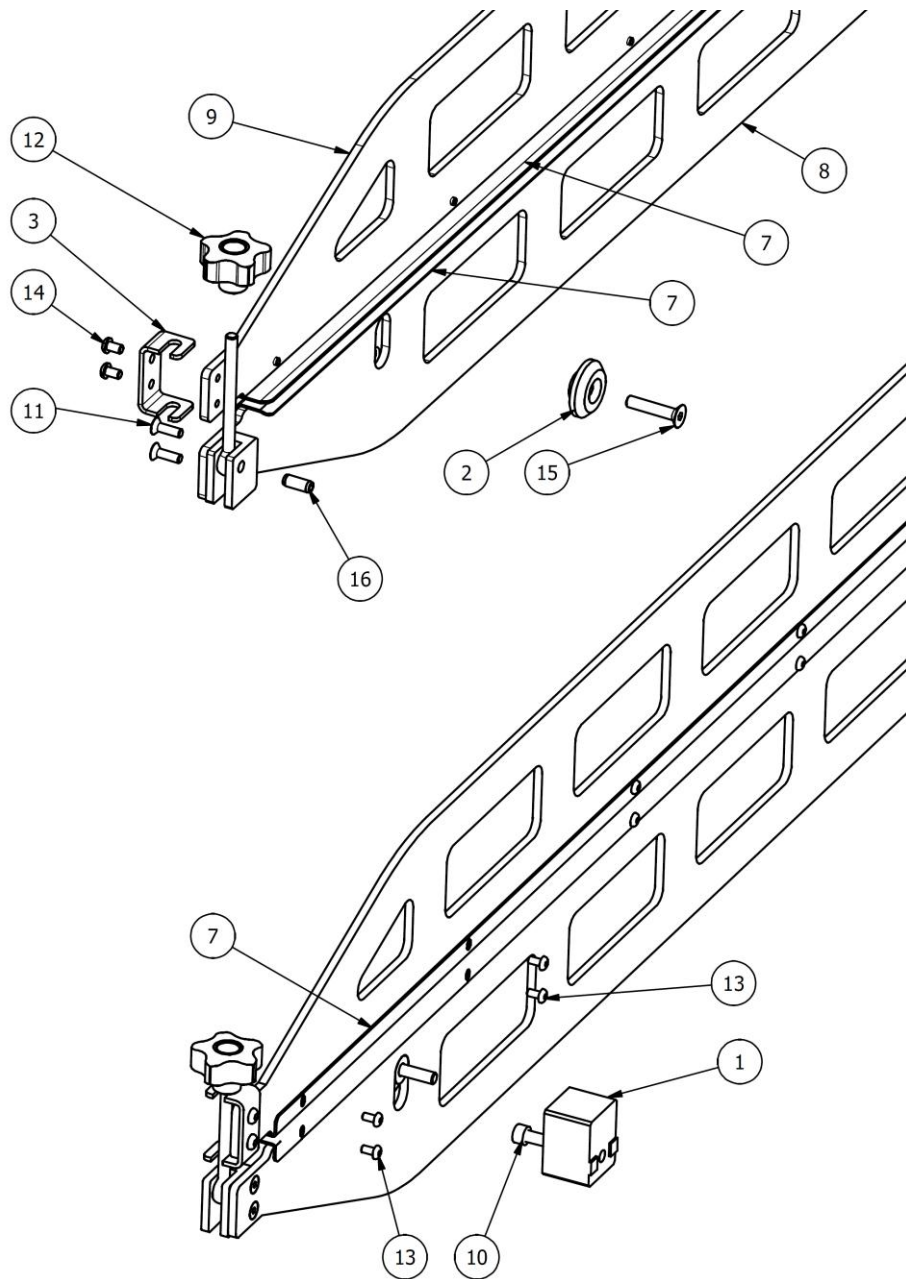




PM-2009/160A Press		H08D008084 – Pressure pad unit	
Position	Q.ty	Code	Description
1	1	H08D005767	CUSHION RESTRAINING THREADED PLATE
2	1	H08D005768	CUSHION RESTRAINING THREADED PLATE - CONNECTIONS
3	1	H08D005769	CUSHION RESTRAINING COUNTERSUNK PLATE – CONNECTIONS
4	1	H08D005770	CUSHION RESTRAINING COUNTERSUNK PLATE
6	1	H08D008085	FLATTENING TUBE øi 32 Cod.1640860 IVG COLBACHINI
7	10	H08N010003	OHH SCREW UNI 5933-M6x16 GALVANIZED.
8	1	H08N020538	KQ2L-06-01S ELBOW END COUPLING D6 X 1/8"SMC
9	1	H08N020875	KQ2VD06-01S DOUBLE ELBOW END COUPLING 1/8" D.6SMC
10	2	H08N021242	HOSE-END FITTING 7x1/4" code 3050
11	1	H08N021243	KQ2L-06-00 ELBOW END COUPLING D6 SMC

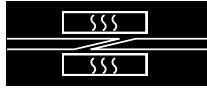


4.6 H08D008089 – Presser Unit

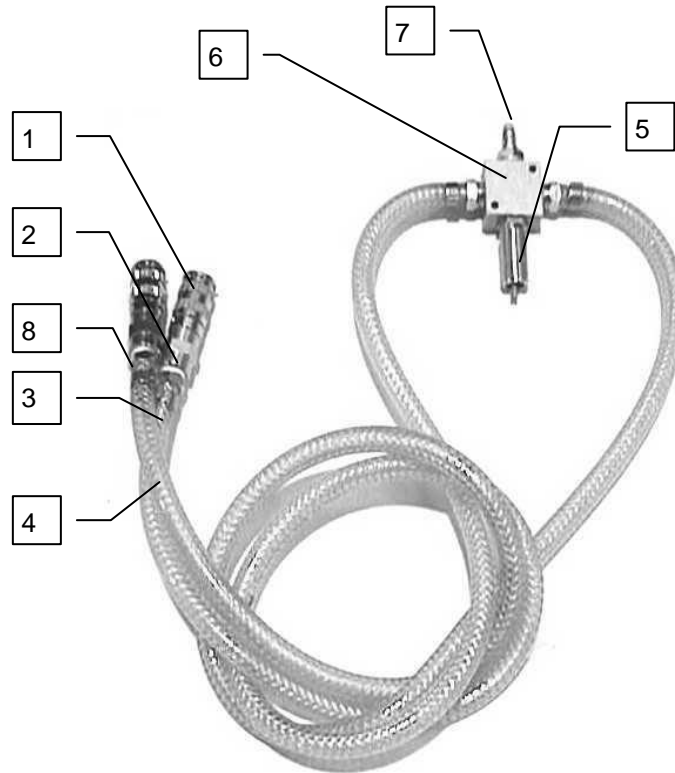




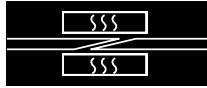
PM-2009/160A Press			H08D008089 – Presser Unit
Position	Q.ty	Code	Description
1	3	H08D005795	PRESSER SUPPORT BLOCK
2	3	H08D005796	PRESSER LOCK WASHER
3	2	H08D007213	PRESSER CLOSING ROD
4	1	H08D007214	RH PRESS LOCK BLOCK
5	1	H08D007215	LH PRESS LOCK BLOCK
6	2	H08D008073	EYE SCREW H08N012248 MODIFIED
7	2	H08D008086	PM-2009A BELT PRESSURE PROFILE
8	1	H08D008087	PM-2009A LOWER PRESSER PANEL
9	1	H08D008088	PM-2009A UPPER PRESSER PANEL
10	3	H08N010126	VTCEI UNI 5931-M8x35 GALVANIZED SCREW
11	4	H08N010266	VTSEI UNI 5933-M6X20 GALVANIZED SCREW
12	2	H08N011407	VCT.50 FP-M8 code 69956 LOBE HAND WHEEL
13	18	H08N011450	VTBEI UNI-ISO 7380-M5x10 GALVANIZED SCREW
14	4	H08N011451	SCREW VTBEI UNI-ISO 7380-M6X10 GALVANIZED.
15	3	H08N012028	VTSEI UNI 5933-M8x40 GALVANIZED SCREW.
16	2	H08N012249	ISO 8752 8x20 STAINLESS STEEL Elastic plug



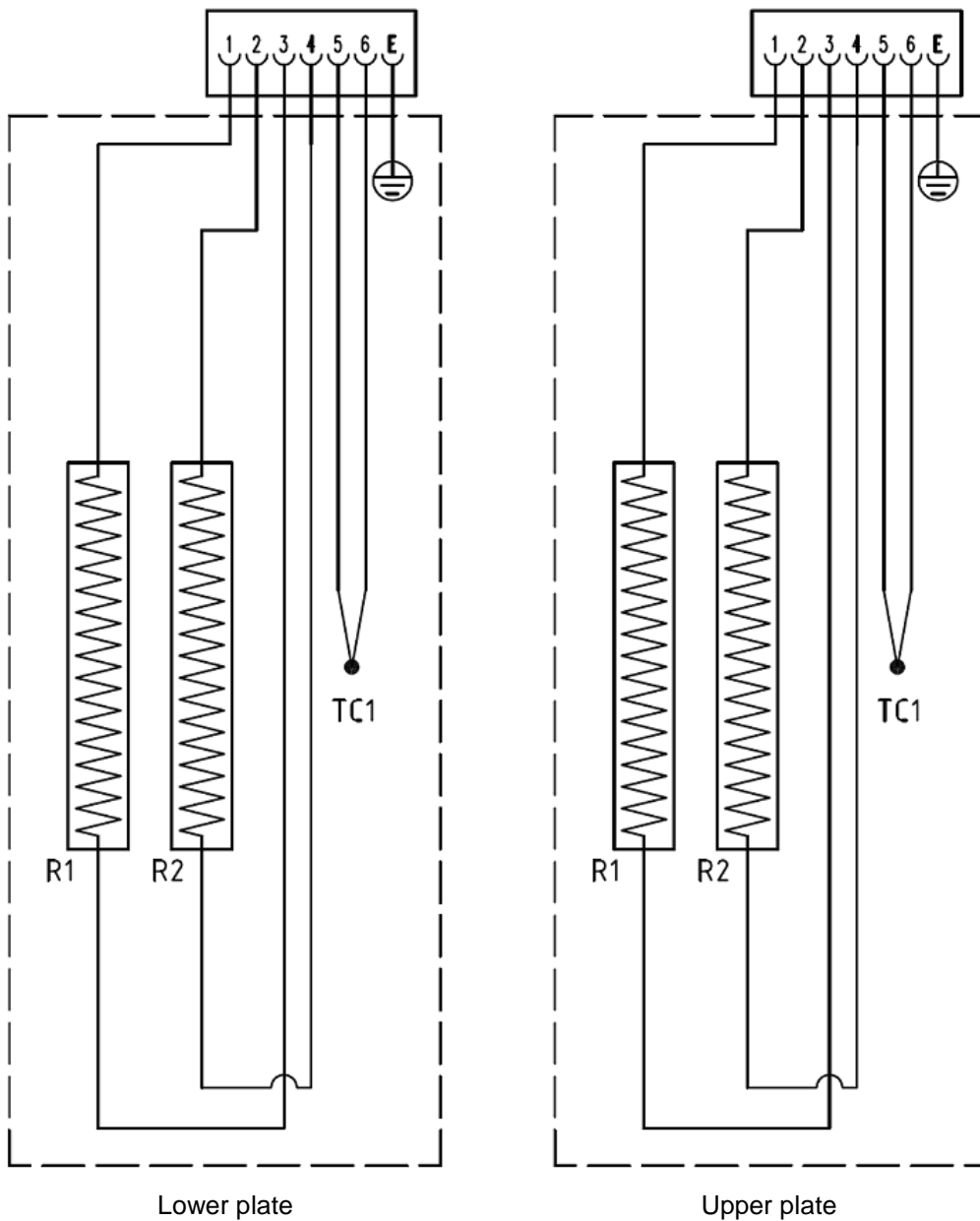
4.7 H08008E100 – Pneumatic connection



H08008E100 – Pneumatic connection			
Position	Q.ty	Code	Description
1	2	H08N020655	1/4" mini 04 QUICK COUPLING
2	4	H08N020407	HOSE-END ACCESSORY 6x1/4"
3	1	H08N020410	PLASTIC TUBE PVC 6x12
4	1	H08N020410	PLASTIC TUBE PVC 6x12
5	1	H08N020406	SAFETY VALVE MAX PRESSURE 3BAR 1/4"
6	1	H08N020950	1/4" 4-WAY AIR DISTRIBUTOR
7	1	H08N020656	1/4" mini 12 MALE QUICK COUPLING
8	4	H08N020412	2-EAR 11X13 HOSE CLAMP COLLAR



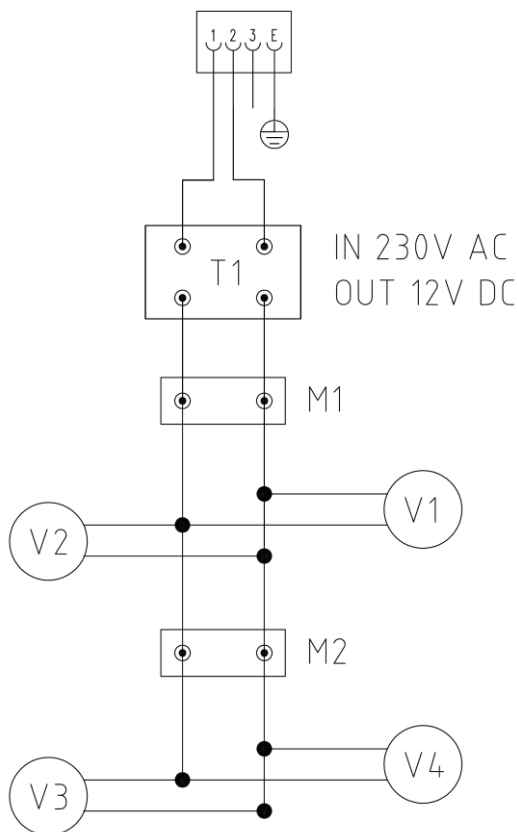
5 Press wiring diagram



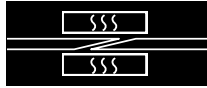
Code		Description
R1	H08D00	RESISTANCE ETCHED FOIL 230V 1600W PM-2009/A code 1KITI634001 - 165 x 1680 x 1.2mm
R2	H08D00	RESISTANCE ETCHED FOIL 230V 1600W PM-2009/A code 1KITI634001 - 165 x 1680 x 1.2mm
TC1	H08N040431	Thermocouple



5.1 Fan connection diagram



T1	H08N040434	230V AC / 24V DC transformer AMEC15-24SMAZ
V1, V2, V3, V4	H08N040432	FAN COIL 24VDC - 412 JHH - 40X40X25 -
M1, M2		Wire clamps



6 Product and product use liabilities

For any further clarifications, contact Habasis Italiana S.p.A. customer service at the following address:

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Internet : www.habasis.com

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This use and maintenance manual and its attachments are translated from original language
(Italian)
