

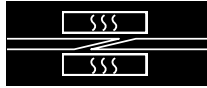
Heat press with air cooling **PM-309/160A-B/458**





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0 Preface

Habasis thanks you for purchasing the

PM-309/160A-B/458

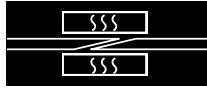
This press belongs to the press range called PM-09/160A.

If you handle your PM-309/160A-B/458 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..

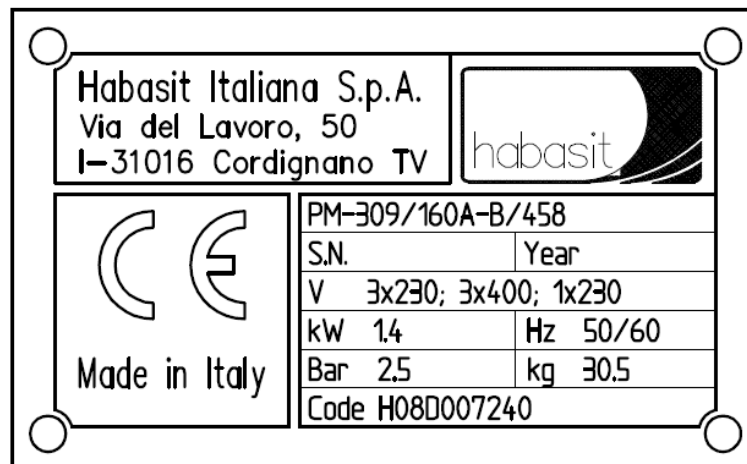


1 Machine identification data

Machine	Heat press
Type/Series	PM-309/160A-B/458
Serial number	See EC identification plate
Year of construction	See EC identification plate

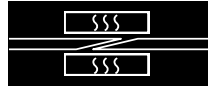
1.1 Identification plate and EC markings

The following identification plate was affixed to the press:



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-309/160A-B/458

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 che la quasi-macchina tipo: *declare under our sole responsibility that the partly completed machinery type:*

Pressa a caldo Hot press

Modello: *Series:*

PM-309/160A-B/458

Matricola: *Serial Number:*

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

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

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

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

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

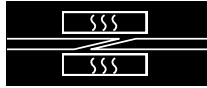
All updates HABASIT considers necessary to improve the quality of the equipment will be communicated by way of sending of further specific documentation or a new manual to replace the previous one.

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-309/160A-B/458 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-309/160A-B/458 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 700W = 1400W
Supply voltage	230V ~
Frequency	50-60 Hz

3.2 Pneumatic characteristics

Fluid characteristics	Filtered, non-lubricated air
Maximum working pressure	2.5 bar (0.25MPa or 2.5Kg/cm ²) +/- 0.2 bar (0.3MPa or 3 Kg/cm ²) / 36.25 psi
Min. supply diameter	Rapid connector of 1/4"

3.3 Dimensions and environmental characteristics

Dimensions (LengthxWidthxHeight) (including handles)	790 x 315 x 300 mm 31.1 x 12.4 x 11.8 inches
Total Weight	30.5 kg / 67 lbs
Upper part weight	12 kg / 26.5 lbs
Lower part weight	16 kg / 35.3 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	300 mm / 11.8 inches
Max width of belt/tape	10 mm / 0.4 inches
Minimum length of belt/tape	940 mm / 37 inches
Heating plate width	160 mm / 6.3 inches
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

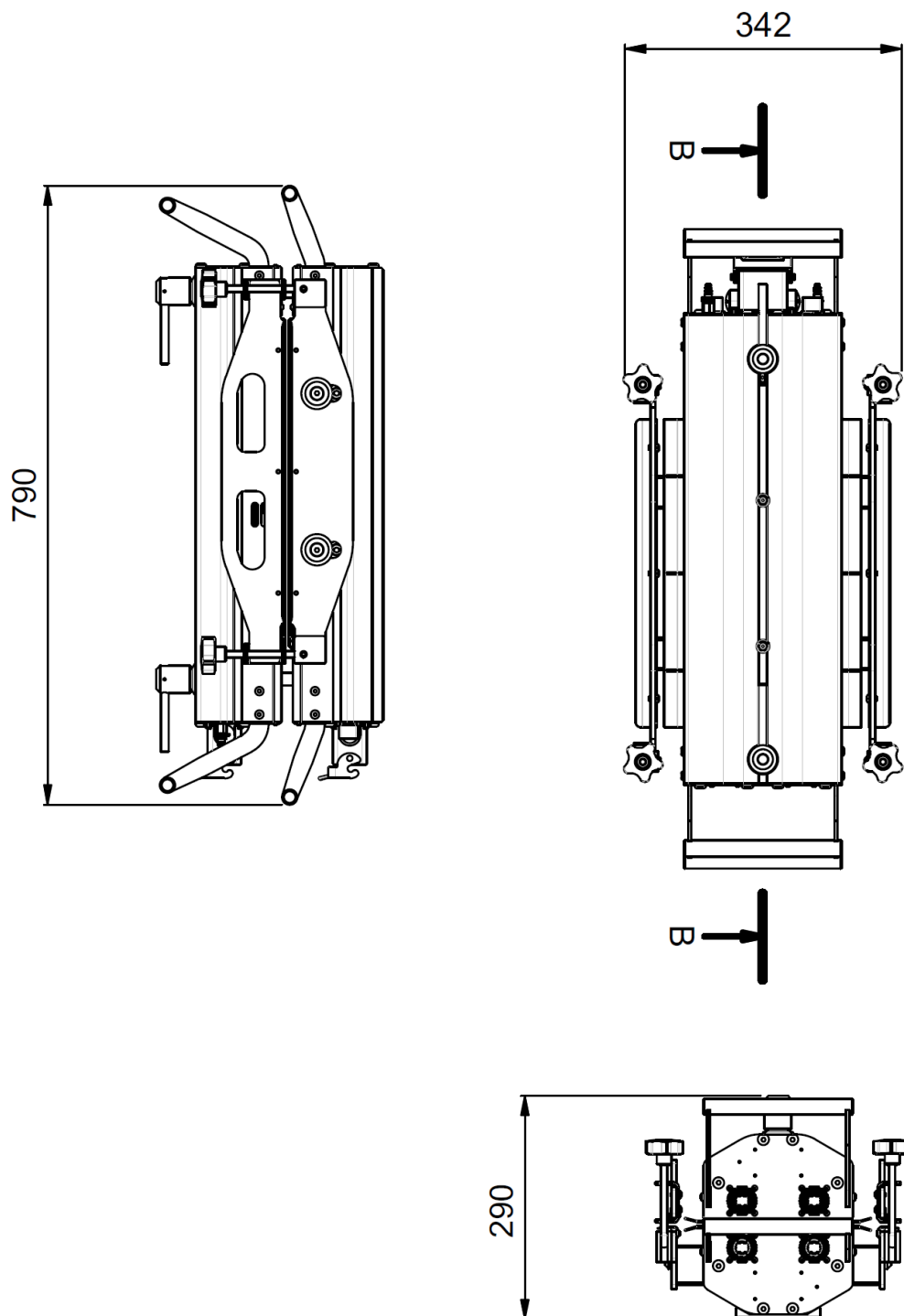


Figure 1– Press general dimensions PM-309/160A-B/458



4 Drawings and spare parts list

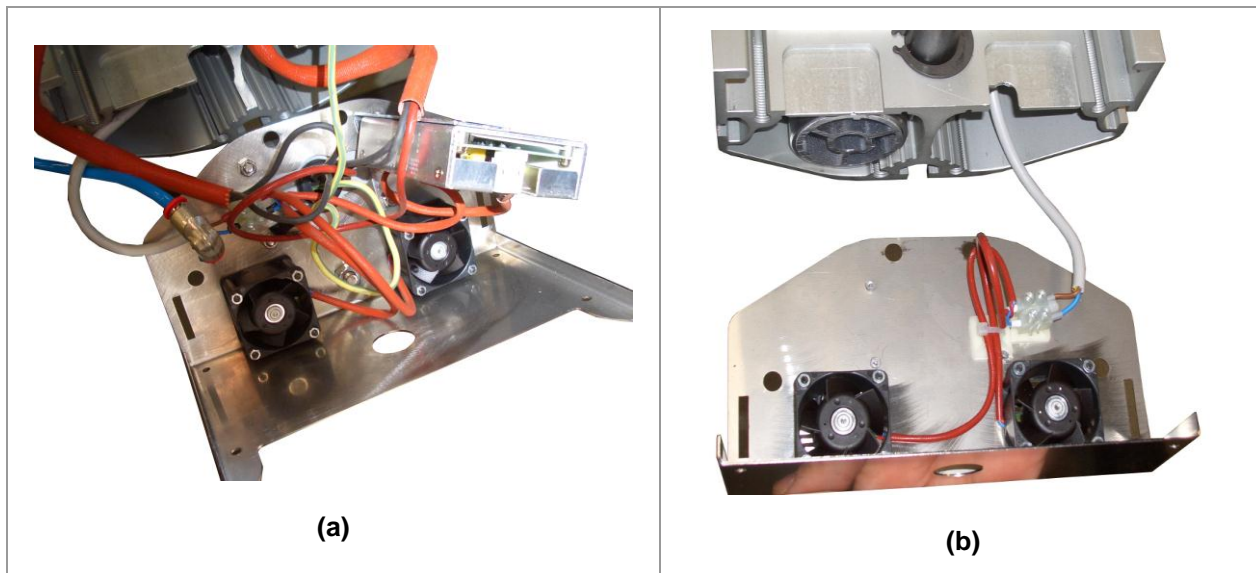
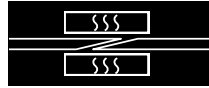
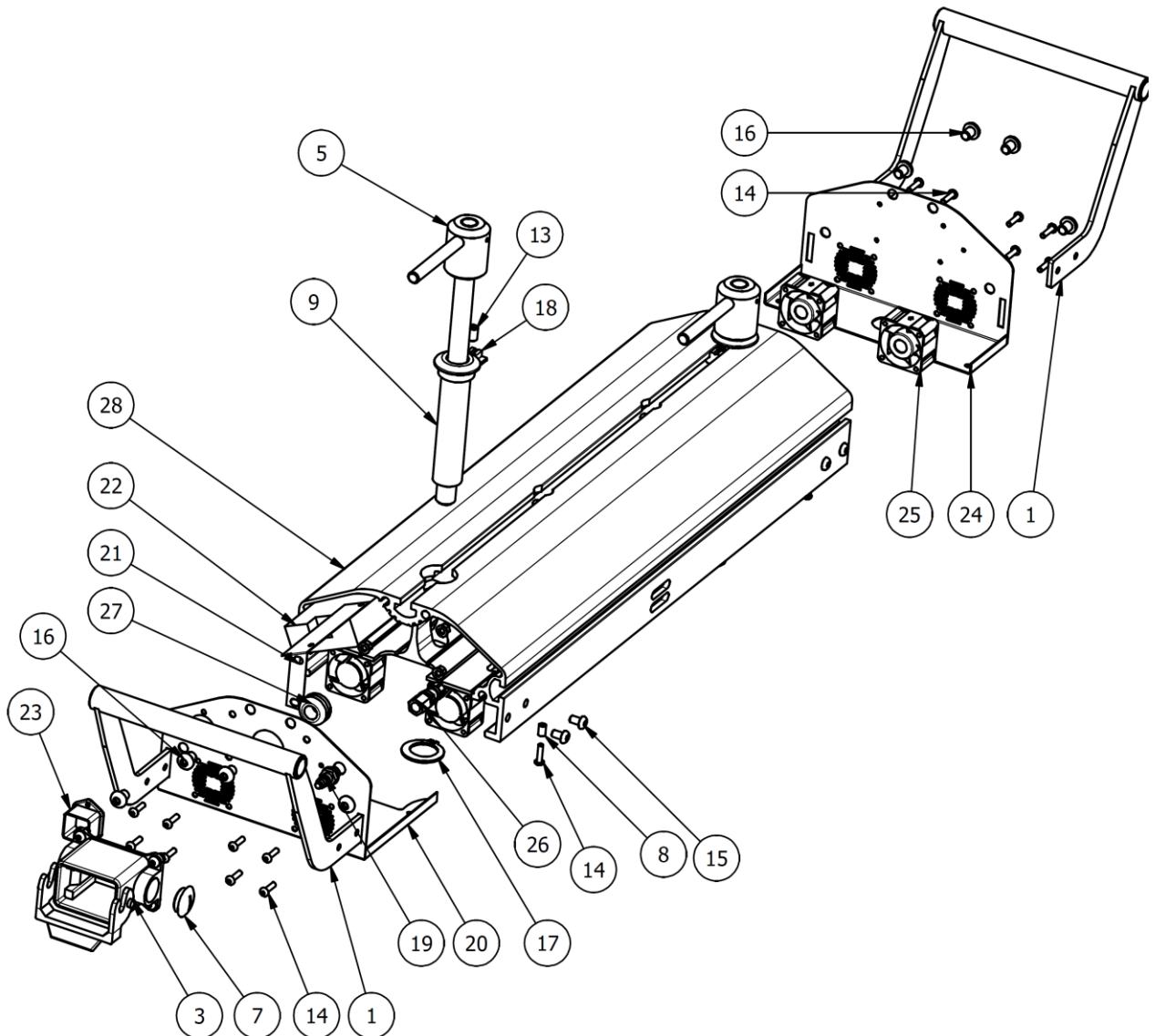


Figure 2 - PM-309/160A-B/458, press internal connection, electrical connector side (a) and opposite side (b).

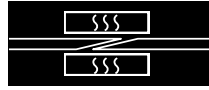


4.1 H08D007242 – Upper press beam unit

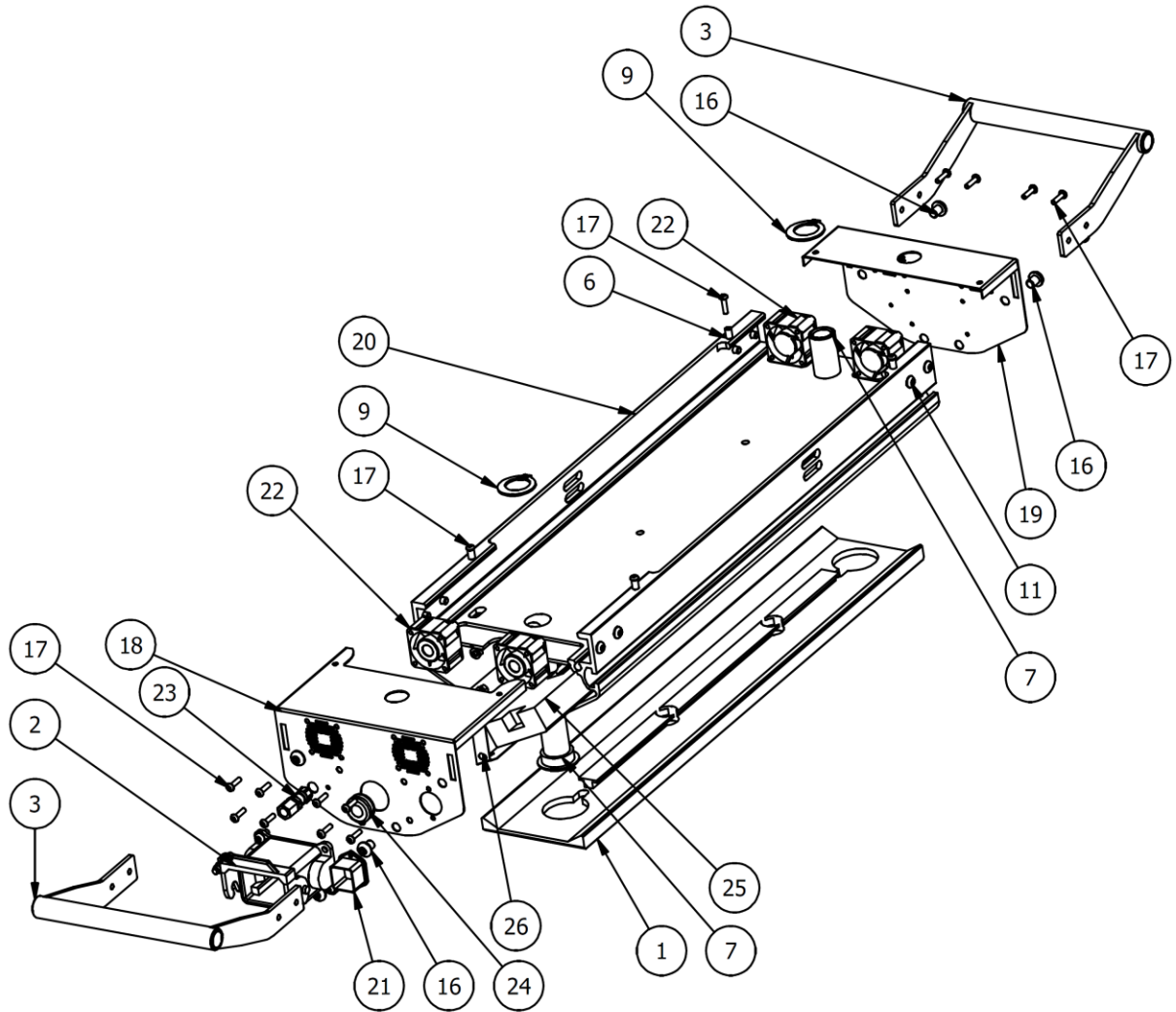




PM-309/160A-B/458 Press		H08D007242 – Upper press beam unit	
Position	Q.ty	Code	Description
1	4	H08D005755	UPPER HANDLES
3	1	H08D007299	FIXED CASE WITH LEVER ILME - CHP 06 L
5	2	H08D002868	CLOSING SCREW
7	1	H08N012128	CAP PG 16 cod.1844 CEMBRE
8	4	H08D005772	CALIBRATED ELECTRO-WELDED TUBE Ø6X1
9	2	H08D005773	UPPER BUSHING V2
13	2	H08N011536	FLAT-TIPPED GRUB SCREW ISO 4026 M8x12
14	20	H08N012122	SCREW VTBEI UNI-ISO 7380-M4X16 GALVANIZED
15	8	H08N011451	SCREW VTBEI UNI-ISO 7380-M6X10 GALVANIZED
16	8	H08N012005	SCREW VTBEI UNI-ISO 7380-M8X10 STAINLESS STEEL
17	2	H08N010408	SELF-LOCKING STOP RING WA-G 24 GANDINI
18	2	H08N010958	DAT0810 MECHANICAL NUT
19	1	H08N020953	MALE COUPLING 11 mini 1/8" cod. 0102011
20	1	H08D005756	FAN CONNECTION SIDE HEAD
21	1	H08D007211	TRANSFORMER SUPPORT PLATE
22	1	H08N040432	AIMTEC AMEC 15-24 SMAZ TRANSFORMER
23	1	H080704506	RECESSED CASE CKA 03 I - ILME
24	1	H08D005771	FAN NEUTRAL SIDE HEAD
25	4	H08N040418	AXIAL FAN 24VDC - 412 JHH - 40X40X25 - EBMPAPST
26	1	H08N020951	FESTO 9425 QCK-1/8-PK-4-B
27	1	H08N040434	LEGRAND PITCH CODE 098093
28	1	H08D007248	DRAWN PROFILE BEAM PM-309A



4.2 H08D007244 – Lower press beam unit

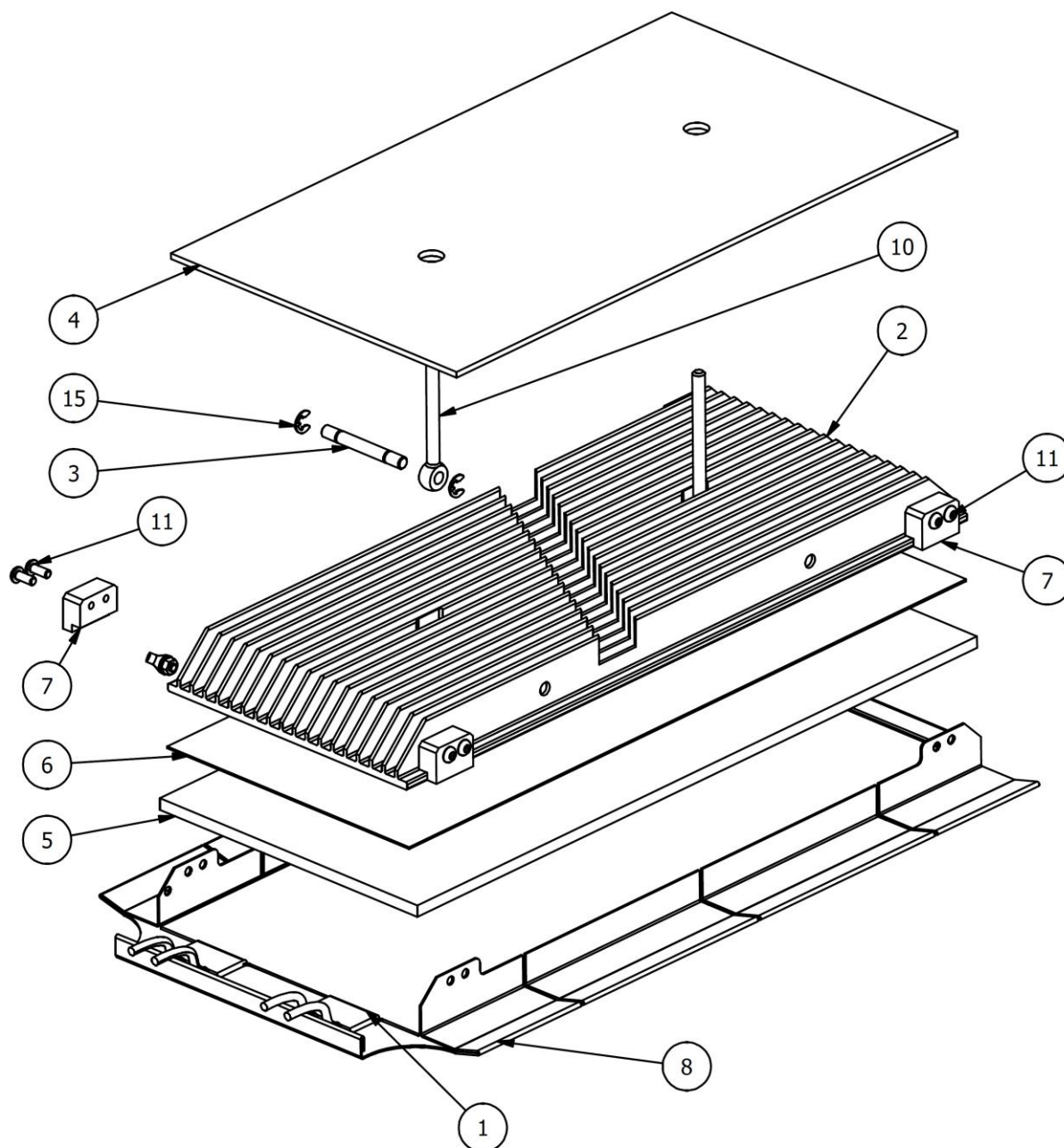




PM-309/160A-B/458 Press		H08D007244 – Lower press beam unit	
Position	Q.ty	Code	Description
1	1	H08D007255	PEDESTAL PM-309A
2	1	H08D007299	FIXED CASE WITH LEVER ILME - CHP 06 L
3	2	H08D005758	LOWER BEAM HANDLE
6	4	H08D005772	CALIBRATED ELECTRO-WELDED TUBE Ø6X1
7	2	H08D005774	LOWER BEARING V2
9	2	H08N010408	SELF-LOCKING STOP RING WA-G 24 GANDINI
10	1	H08N020953	MALE COUPLING 11 mini 1/8" cod. 0102011
11	8	H08N011451	SCREW VTBEI UNI-ISO 7380-M6X10 GALVANIZED
16	8	H08N012005	SCREW VTBEI UNI-ISO 7380-M8X10 STAINLESS STEEL
17	20	H08N012122	SCREW VTBEI UNI-ISO 7380-M4X16 GALVANIZED
18	1	H08D005756	FAN CONNECTION SIDE HEAD
19	1	H08D005771	FAN NEUTRAL SIDE HEAD
20	1	H08D007248	DRAWN PROFILE BEAM PM-309A
21	1	H080704506	RECESSED CASE CKA 03 I - ILME
22	4	H08N040418	AXIAL FAN 24VDC - 412 JHH - 40X40X25 - EBMPAPST
23	1	H08N020951	FESTO 9425 QCK-1/8-PK-4-B
24	1	H08N040434	LEGRAND PITCH CODE 098093
25	1	H08N040432	TRANSFORMER AIMTEC AMEC 15-24SMAZ
26	1	H08D007211	TRANSFORMER SUPPORT PLATE

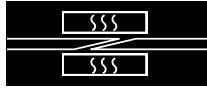


4.3 H08D007243 – Heating unit

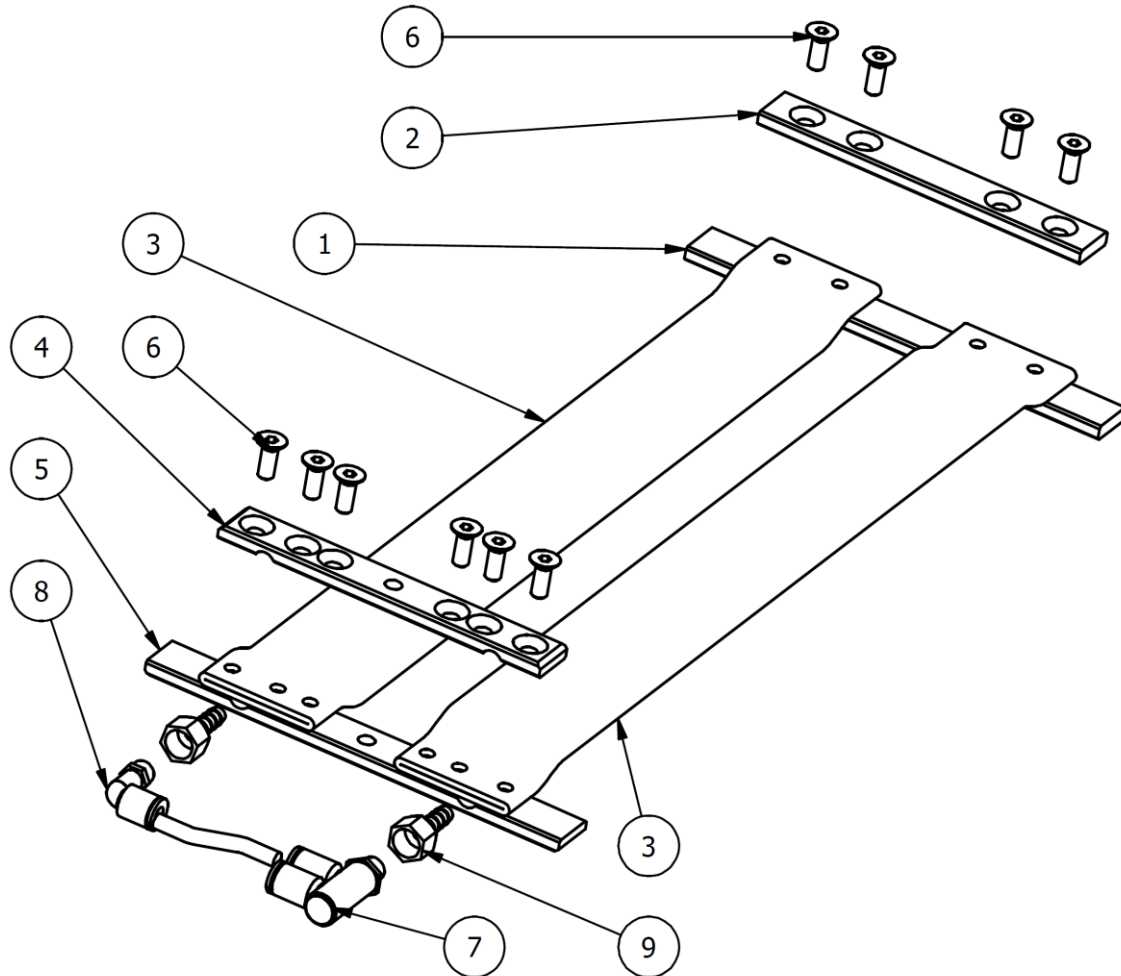




PM-309/160A-B/458 Press		H08D007243 - Heating unit	
Position	Q.ty	Code	Description
1	1	H08D007250	RESISTANCE PM-309A
2	1	H08D007249	CHANNELLED RADIATOR PM-309A - OMAR 2118
3	2	H08D005764	TIE FASTENING PIN
4	1	H08D007251	MULTILAYER BEACH SEPARATOR
5	1	H08D007253	NEUTRAL SILICON INSULATING STRIP 6MM
6	1	H08D007254	GALVANISED IRON INSULATING PLATE S=1MM PM-309A
7	4	H08D005762	INSULATING SPACER BLOCK
8	1	H08D007252	WIDE WELDING PLATE PM-309A SILICON S.6
9	1	H08N010148	UNI 5588-68 M4 STAINLESS GALVANIZED NUT
10	2	H08N011786	GN.12504 DIN444-M6-75 ELESA EYE SCREW
11	8	H08N012126	VTBEI UNI-ISO 7380-M4x10 GALVANIZED SCREW
15	4	H08N012125	UNI 7434-d5 DIN 6799 elastic lock ring



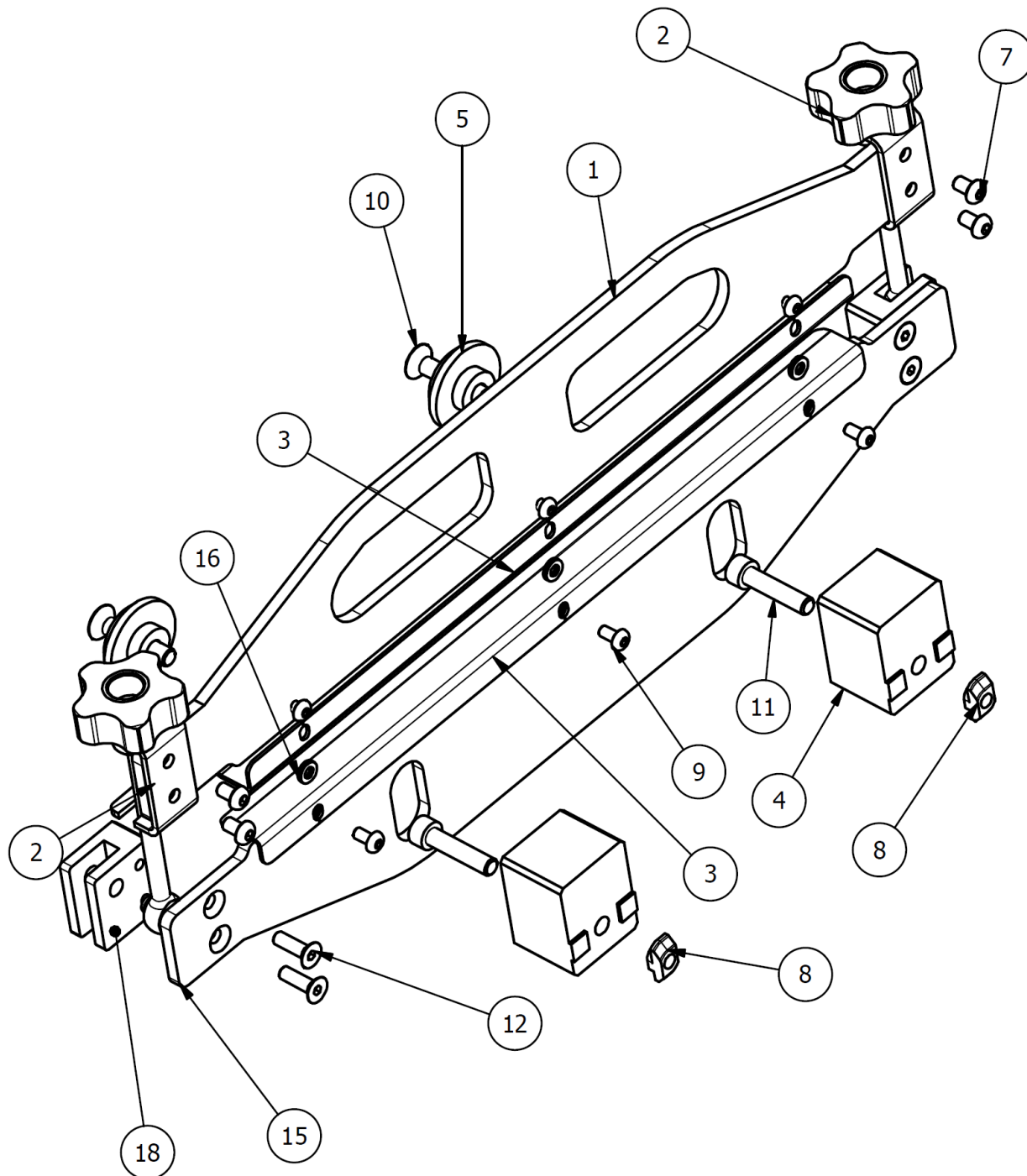
4.4 H08D007241 – Pressure pad unit



PM-309/160A-B/458 Press		H08D007241 – Pressure pad unit	
Position	Q.ty	Code	Description
1	1	H08D005767	CUSHION RESTRAINING THREADED PLATE
2	1	H08D005770	CUSHION RESTRAINING COUNTERSUNK PLATE
3	2	H08D007246	FLATTENING TUBE \varnothing i 32 Code1640860 IVG COLBACHINI
4	1	H08D005769	CUSHION RESTRAINING COUNTERSUNK PLATE – Connections
5	1	H08D005768	CUSHION RESTRAINING THREADED PLATE – Connections
6	10	H08N010003	OHH SCREW UNI 5933-M6x16 GALVANIZED
7	1	H08N020875	1/8" D. 6-KQ2VD06-01S-SMC DOUBLE ELBOW COUPLING
8	1	H08N020538	1/8" D. 6 - KQ2L-06-01S-SMC ELBOW
9	2	H08N021242	HOSE-END ACCESSORY 7X1/4"

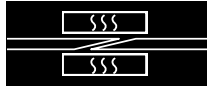


4.5 H08D007245 – Belt lock bar unit





PM-309/160A-B/458 Press		H08D007245 – Belt lock bar unit	
Position	Q.ty	Code	Description
1	1	H08D007256	UPPER PRESSER PANEL PM-309A
2	2	H08D007213	PRESSER CLOSING ROD
3	2	H08D007257	PM-309A BELT PRESSURE PROFILE
4	2	H08D005795	PRESSER SUPPORT BLOCK
5	2	H08D005796	PRESSER LOCK WASHER
7	4	H08N011451	SCREW VTBEI UNI-ISO 7380-M6X10 GALVANIZED
8	2	H08N010956	DAM0810 HAMMER NUT M8X10
9	6	H08N011450	VTBEI UNI-ISO 7380-M5x10 GALVANIZED SCREW.
10	2	H08N012028	VTSEI UNI 5933-M8x40 GALVANIZED SCREW.
11	2	H08N010126	VTCEI UNI 5931-M8x35 GALVANIZED SCREW
12	4	H08N010266	VTSEI UNI 5933-M6X20 GALVANIZED SCREW.
15	1	H08D007258	LOWER PRESSER PANEL PM-309A
16	12	H08N010061	UNI 6592-5.3X10 GALVANIZED WASHER.
17	1	H08D007215	LH PRESS LOCK BLOCK
18	1	H08D007214	RH PRESS LOCK BLOCK
19	2	H08N012248	EYE SCREW M8x100 DIN444 B STEEL
20	2	H08N012249	ISO 8752 8x20 STAINLESS STEEL Elastic plug
21	2	H08N011407	VCT.50 FP-M8 code 69956 LOBE HAND WHEEL



4.6 H08008E100 – Pneumatic connection

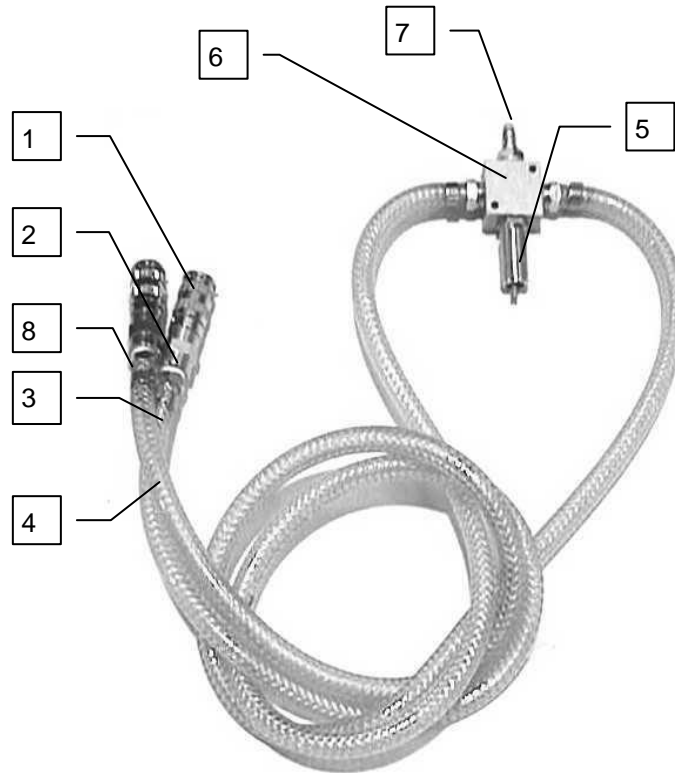
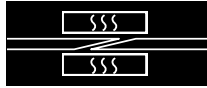
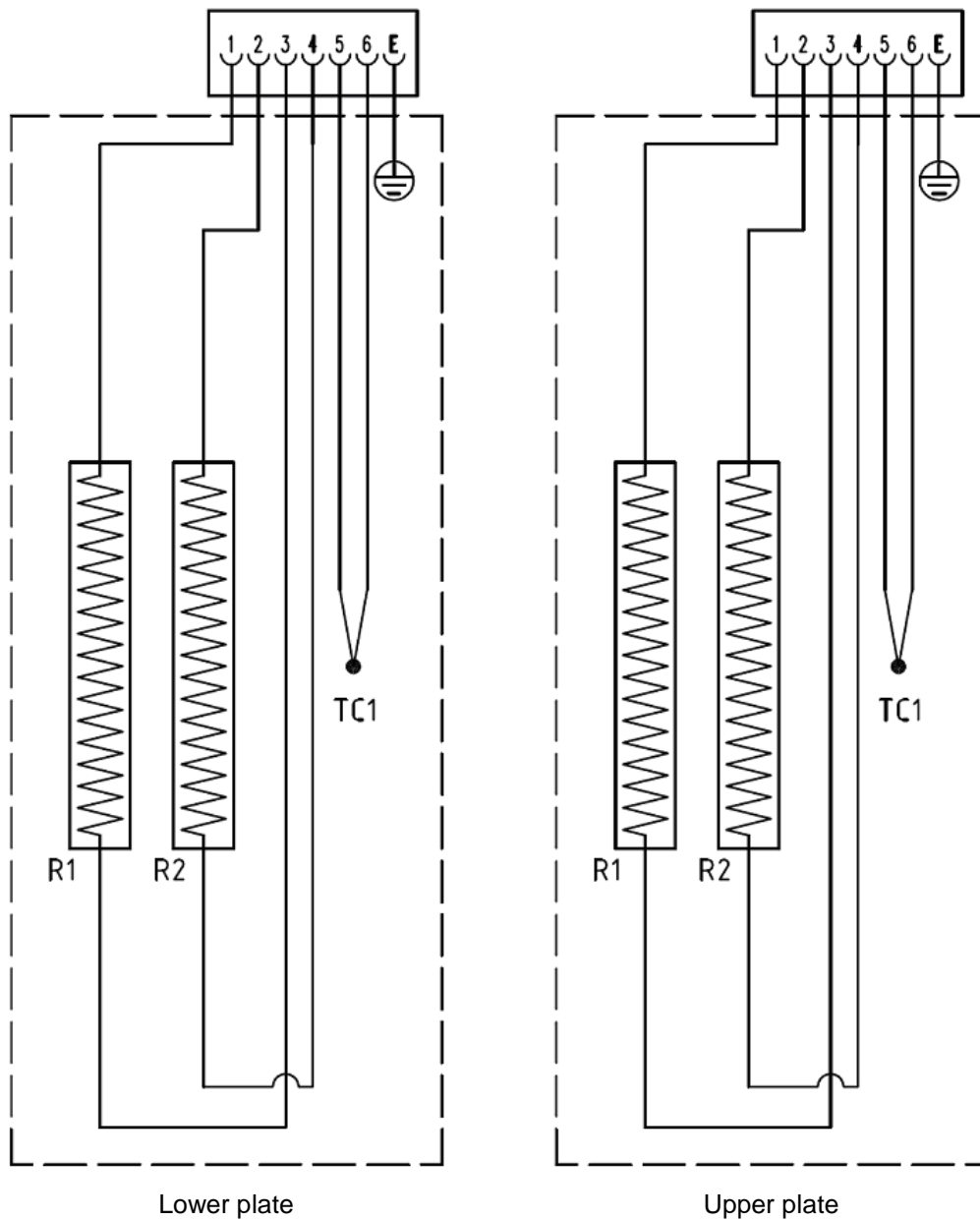


FIGURE 4-1 - PNEUMATIC CONNECTION SPARE PARTS

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



5 Press wiring diagram



Code

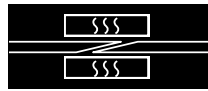
R1 H08D007250

TC1 H08N040431

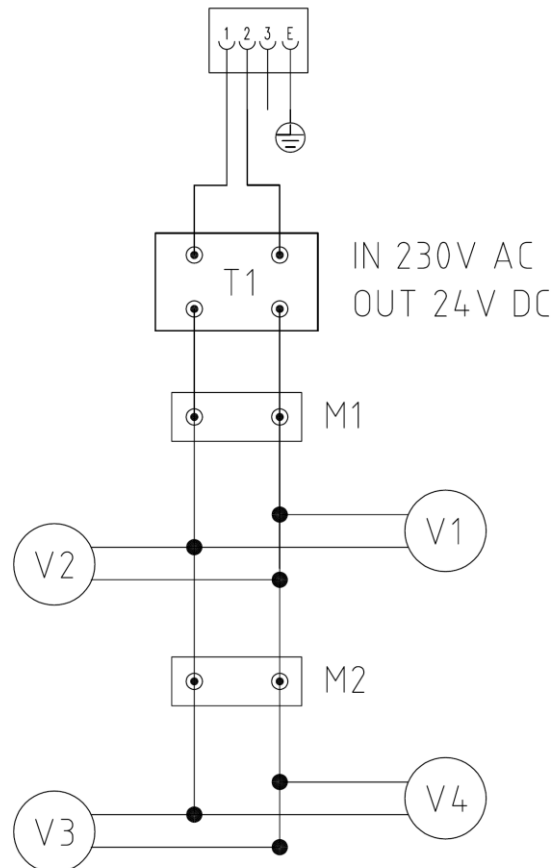
Description

RESISTANCE 230V 350W

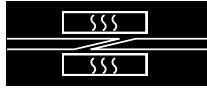
Thermocouple



5.1 Fan connection diagram



T1	H08N040434	230V ac / 24V dc transformer AIMTEC AMEC15-24SMAZ
V1, V2, V3, V4	H08N040432	Fan coil 24VDC - 412 JHH - 40X40X25 - EBMPAPST
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

Product liability, application considerations

The proper selection and application of Habasis products, including the related area of product safety, is the responsibility of the customer.

All indications / information are recommendations and believed to be reliable, but no representations, guarantees, or warranties of any kind are made as to their accuracy or suitability for particular applications. The data provided herein are based on laboratory work with small-scale test equipment, running at standard conditions, and do not necessarily match product performance in industrial use. New knowledge and experiences can lead to modifications and changes within a short time without prior notice.

BECAUSE CONDITIONS OF USE ARE OUTSIDE OF HABASIT'S AND ITS AFFILIATED COMPANIES CONTROL, WE CANNOT ASSUME ANY LIABILITY CONCERNING THE SUITABILITY AND PROCESS ABILITY OF THE PRODUCTS MENTIONED HEREIN. THIS ALSO APPLIES TO PROCESS RESULTS / OUTPUT / MANUFACTURING GOODS AS WELL AS TO POSSIBLE DEFECTS, DAMAGES, CONSEQUENTIAL DAMAGES, AND FURTHER-REACHING CONSEQUENCES

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