

INSTRUCTION MANUAL

DUPLEX LITE



CE

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WARRANTY TERMS

The warranty period shall come into effect on the day on which the equipment is brought into service at the user's premises, as attested on the returned warranty certificate and the delivery note, and shall run for two years, based on a standard equipment operating schedule of 8 hours per day, i.e. 3,000 hours.

The warranty is strictly limited to our equipment, and covers faulty materials and workmanship, which the purchaser shall be required to substantiate.

Our liability shall be limited to making good or replacing free of charge parts that are acknowledged by us to be defective, and no claims for damages for any reason may be made against us.

Parts replaced under warranty shall:

- remain our property
- be invoiced on consignment

A credit note will be issued upon return of the faulty parts.

Returns must be made **NO LATER THAN ONE MONTH** after the work is performed under warranty.

THIS WARRANTY DOES NOT COVER:

Commercially sourced wearing parts, material and equipment such as:

- Fuses, bulbs, seals, hoses, nozzles, filters, etc.
- Material and equipment not manufactured wholly by us, which are covered by the warranty of the manufacturer thereof.

THIS WARRANTY DOES NOT EXTEND TO:

Replacements or repairs arising from fair wear and tear of the appliances or machines, damage or accidents arising from negligence, lack of supervision or maintenance, improper use or alterations made without our written consent.

Defects arising from material provided by the purchaser or mandatory design requirements issued by the purchaser.

Repairs made necessary by damage or accidents arising during carriage.

Normal maintenance and adjustment procedures required during use of the machine, as set out in the maintenance instructions, such as:

- adjustment of intermediate components
- tightening of pipes, hoses, etc.



Any traces of detergent oil in the air system of pneumatic machines shall invalidate the aforementioned warranty terms.

Quote the machine reference and serial number when making technical enquiries or ordering spare parts.

INDEX

WARRANTY TERMS	1
INDEX	2
TECHNICAL DATA	3
SETTING UP THE MACHINE	3
OVERVIEW	4
OPERATION	4
1. SAFETY	5
<i>a) International symbols</i>	5
<i>b) Important safety precautions</i>	5
<i>c) Safety features</i>	5
<i>Safety system checks</i>	6
<i>After an emergency stop</i>	6
<i>Instructions and manuals</i>	6
2. SWITCHING ON	7
3. CONTROL PANEL	7
4. SETTINGS	8
<i>a) Temperature</i>	8
<i>b) Timer</i>	8
<i>c) Pressure</i>	8
<i>d) Swing-away speed</i>	8
5. OPERATING CYCLE	8
6. ELECTRONIC BOARD SETTINGS.....	9
<i>a) Presets</i>	9
<i>b) Settings menus</i>	9
<i>c) Sleep mode</i>	10
<i>d) Machine settings</i>	10
<i>e) User comfort settings</i>	10
<i>f) Energy saving mode</i>	11
PARTS LAYOUT	12
WIRING AND PNEUMATIC DIAGRAM	13
SERVICING	15
1. REPLACING WORN PARTS	15
<i>a) Silicone foam pads</i>	15
<i>b) Other parts</i>	15
2. MAINTENANCE.....	15
3. ELECTRONIC BOARD MESSAGES.....	16
WEAR PARTS	16
TROUBLESHOOTING TIPS	17
MAINTENANCE LOG	18

TECHNICAL DATA

Weight in working order	140 kg
Height	713 mm
Depth	1005 mm
Width	1071 mm
Platen size	400 x 500 mm
Power supply	220/240 V Single phase + Earth 50/60 Hz
Power consumption	3200 W
Amp rating	14A
Electronic temperature controller	
Accuracy	+/- 1%
Setting range	0 to 255 °C
Electronic timer	
Accuracy	+/- 1%
Setting range	0 s to 11 min
Noise level	Below 70 dB (A)
Maximum pressing force	925 daN

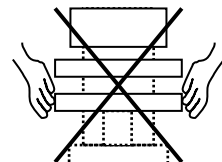
Non-contractual document: we reserve the right to alter our product specifications in line with advances in technology.

SETTING UP THE MACHINE

TO BE PERFORMED BY QUALIFIED PERSONNEL



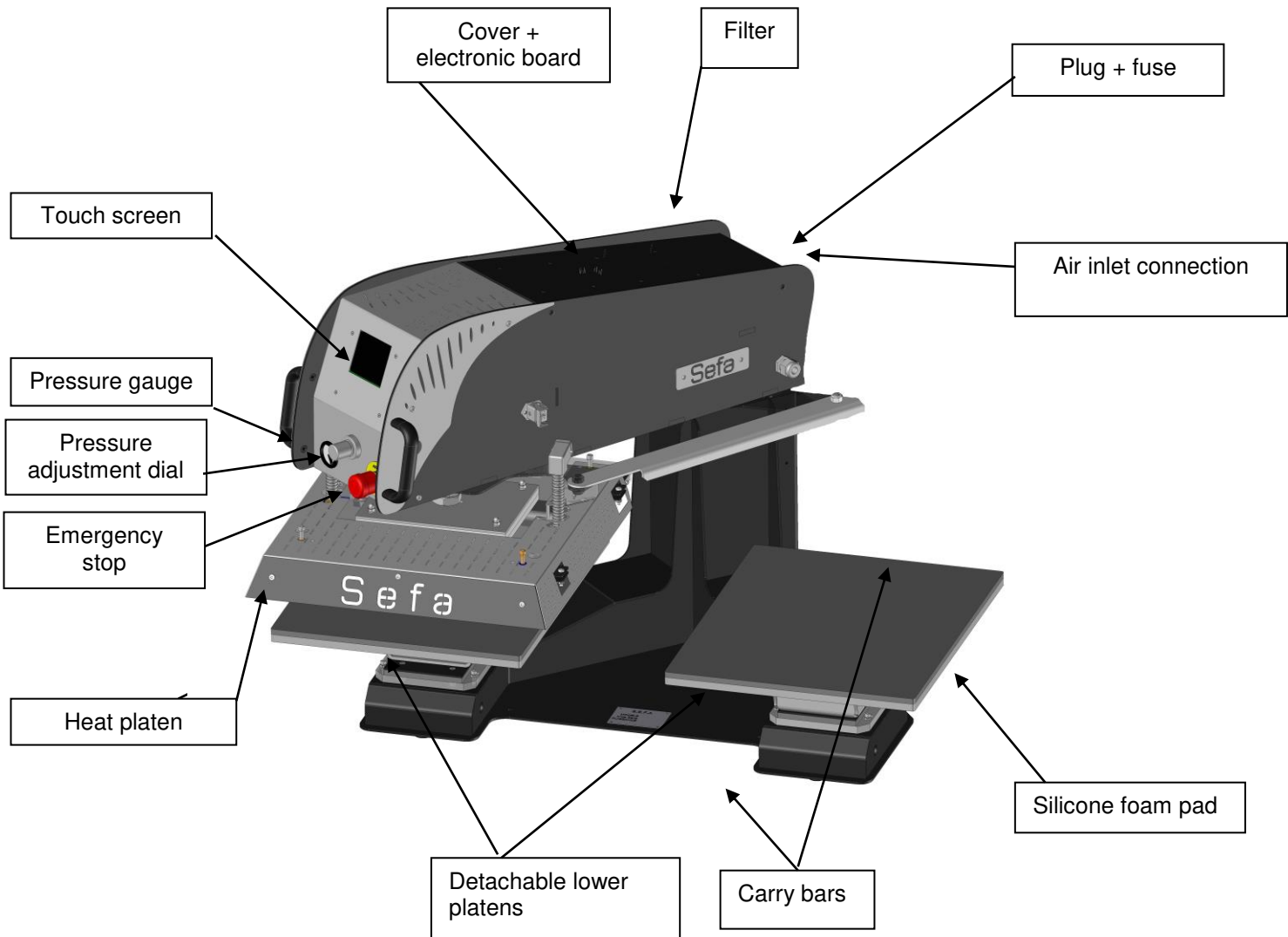
Do not hold the machine by the platens!



Remove the machine from its packaging. The machine is secured to a pallet.
Place the machine on a stable, level table using the carry bars.
Secure the machine to the table.
Plug in the press using the plug provided (230 Volt + Earth / 50 or 60 Hz).
Connect the press to your compressed air supply (min. 3.5 bar, max. 10 bar).

OVERVIEW

This heat press has been designed to operate at high output without risk to operator safety in accordance with article L 233-5 of the French labour code.
It has been designed for use by a single operator positioned in front of the machine.



OPERATION

Please read the Operating Manual carefully before operating the press.

The press should be operated by a qualified person who is aware of the potential dangers arising from improper use of the equipment.

The factory-installed pneumatic, electrical and mechanical settings programmed by our technicians and the safety features must not be altered under any circumstances. SEFA accepts no liability for problems that may be caused by the machine if such alterations are made.

1. SAFETY

THIS MACHINE IS DESIGNED FOR USE BY A SINGLE OPERATOR

FOR USE BY QUALIFIED PERSONNEL

a) International symbols



OFF



ON



DANGER, WARNING



HOT SURFACE



ELECTROCUTION HAZARD



b) Important safety precautions

Personal protective equipment should be worn (e.g. safety gloves and glasses).

Do not touch hot parts of the machine during use.

Do not place hands between the platens when the machine is switched on.

Make sure the operator is not exposed to risks of burns, electrocution or other hazards when handling the machine.

Check the machine each day before use.

Make sure there is nobody in the vicinity of the machine before starting work.

If the machine malfunctions, cut the power supply and look for the cause of the problem (see the Servicing section).



c) Safety features

No changes must be made to the safety covers and safety systems.

They must be refitted if they are removed for servicing work.

They must be held securely in place and kept in good condition during normal use.

DUPLEX PRO presses are fitted with safety systems to protect the operator from pinch-point hazards.

The main safety components are:

Emergency stop button

Front-mounted button that switches the machine off when pressed.

Safety cover

Two contact switches are located on top of the upper heat platen.

This system helps safeguard the operator against pinch points and crushing hazards.

If the system detects an obstacle, it raises the heat platen, immediately shuts off the swing function and puts the press into safe mode.

To restore the machine to operating mode, press the RESET button, position the swing arm over one of the lower platens and depress the foot pedal.

Safety system checks

Test the emergency shut-off and the safety cover daily.

After an emergency stop

Make sure there are no other unresolved problems preventing use before restoring the machine to normal operating mode.

Turn the red button to release the emergency stop. The machine will be reset automatically.

Instructions and manuals

Technical parts documents are supplied with the machine. Please read them before starting to use your SEFA machine.

2. SWITCHING ON

Press the main switch at the back of the machine to turn the power on.

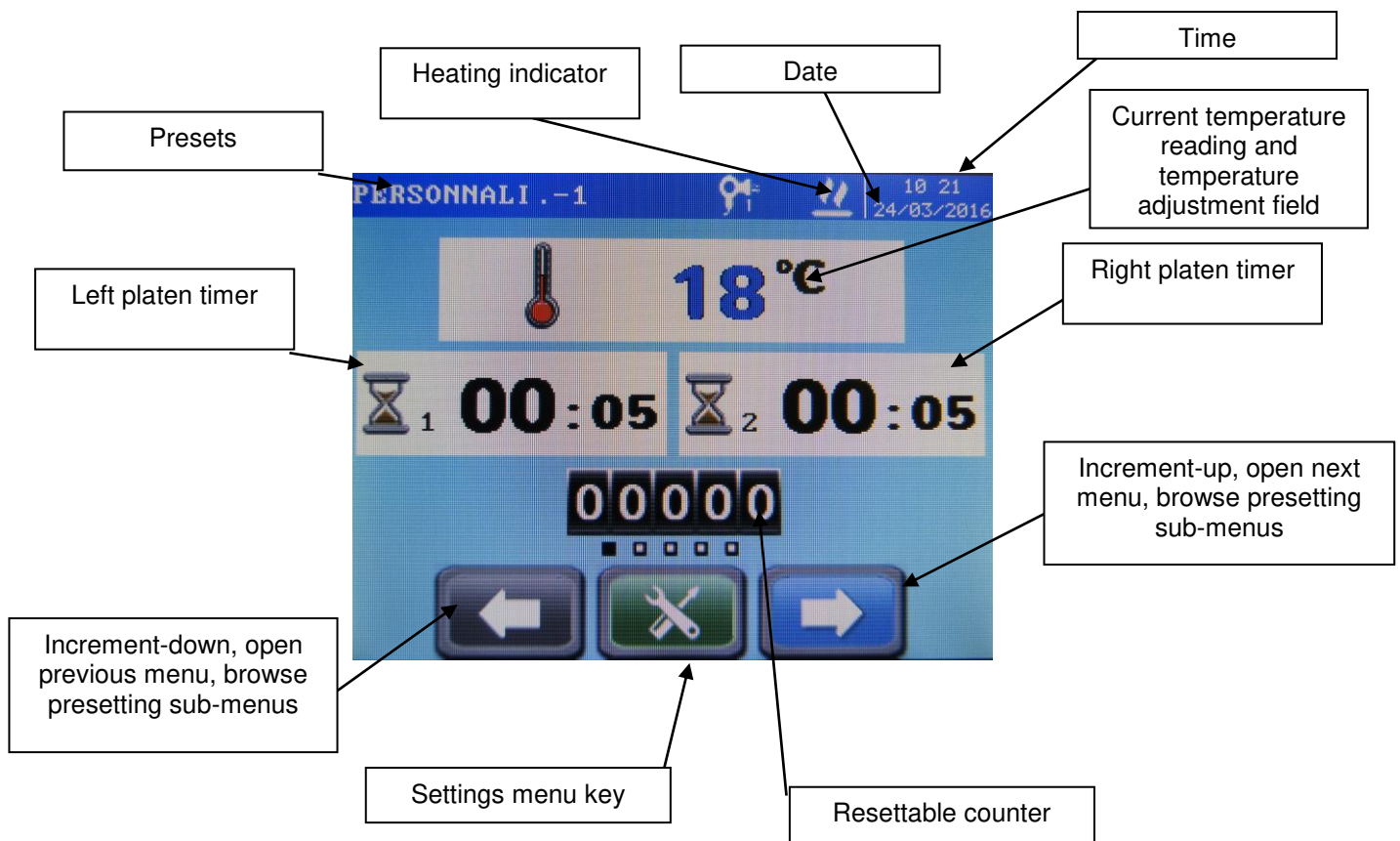
Check that the display panel comes on. The screen will show a welcome message, followed by the factory settings.

Adjust the temperature (to suit the type of transfer).

Adjust the press time (to suit the type of transfer).

Adjust the pressure using the dial (to suit the type of transfer) and check the pressure gauge reading.

3. CONTROL PANEL



4. SETTINGS

a) Temperature

Press the temperature field on the touch screen

Press and hold the "-" or "+" key to decrease or increase the setting respectively.

Press the "welcome" key to confirm and accept.

You can also select presets using the arrow keys.

b) Timer

Press one of the two timer fields on the touch screen (each side, left and right, has a different setting)

Press and hold the "-" or "+" key to decrease or increase the setting respectively.

Press the "welcome" key to confirm and accept.

You can also select presets using the arrow keys.

c) Pressure

Use the front-mounted pressure adjustment dial.

The pressure is shown on the pressure gauge indicator.

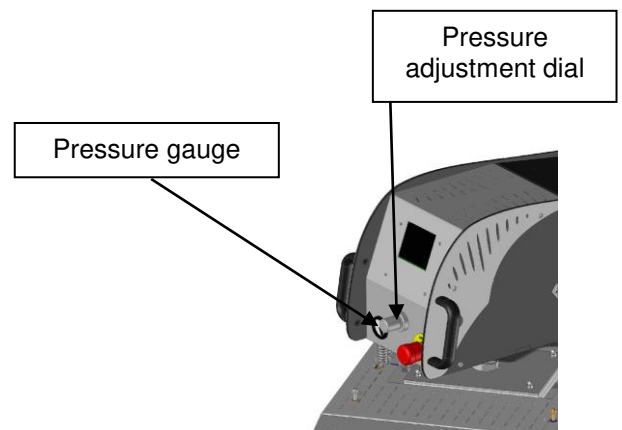
Pull and then turn the adjustment dial:

clockwise to increase the pressure,
anticlockwise to reduce the pressure.

- Push the dial back in to save the new setting.

d) Swing-away speed

Contact your official SEFA stockist to adjust this setting.



5 .OPERATING CYCLE

Place the work item on the lower platen.

Position the transfer sheet correctly.

Move the swing arm away the platen you want to work on.

Press the 2 bimanual buttons, the plate will go down

The heat platen will lower and the press timer will start.

Use this time to prepare the next work item and transfer sheet on the second workstation.

The heat platen will lift open when the timer has finished.

Remove the work item from the first workstation and get the next one ready.

Repeat from step three above.

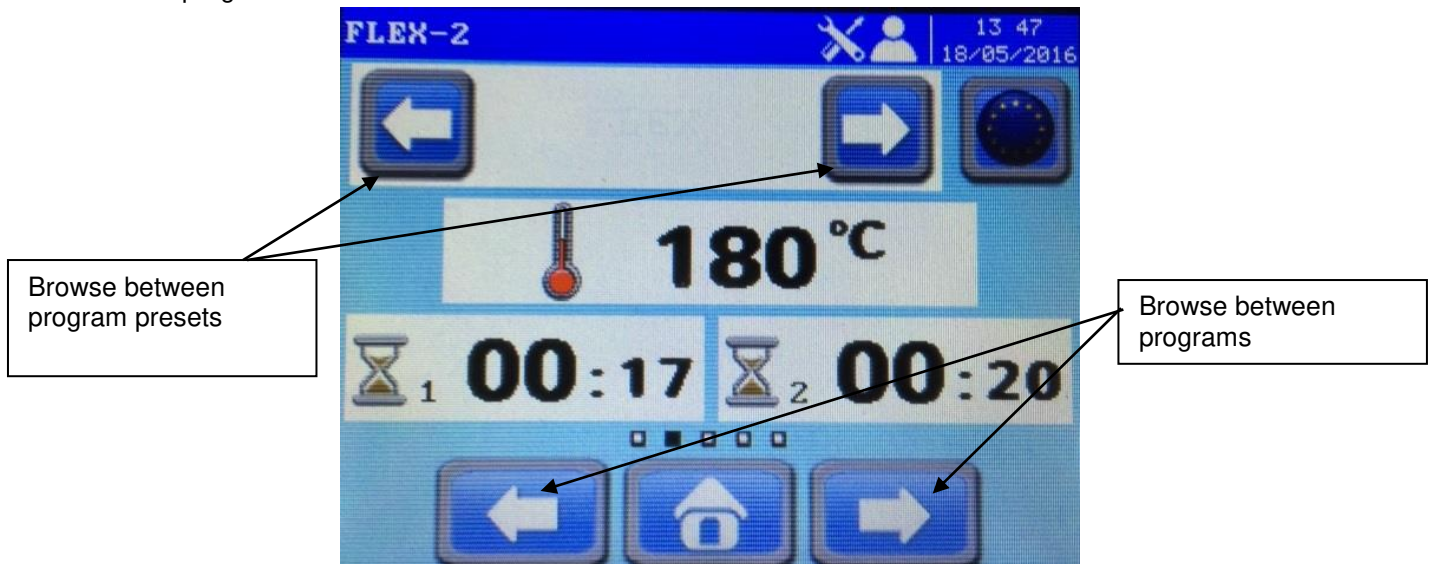
Pressing the stop button during a cycle will stop the cycle.

6. ELECTRONIC BOARD SETTINGS

a) Presets

This menu contains nine pre-saved operating programs; up to five presets can be assigned to each program by entering the required setpoints.

The operating programs must be suited to the processes you use. The temperature adjustment system is fine-tuned for each program.



Available programs:

Customised: the system applies the user-defined settings keyed in at the control panel

Flex: for placing flex and flock

DTG 1: for drying pre-treated materials

DTG 2: for pressing pre-treated materials

SUBLI T: for sublimation printing on textiles

SUBLI R: for sublimation printing on rigid materials

SCREEN: for placing screen transfers

LASER: for placing laser transfers

QUICKFLEX: for placing flex in under 5 seconds

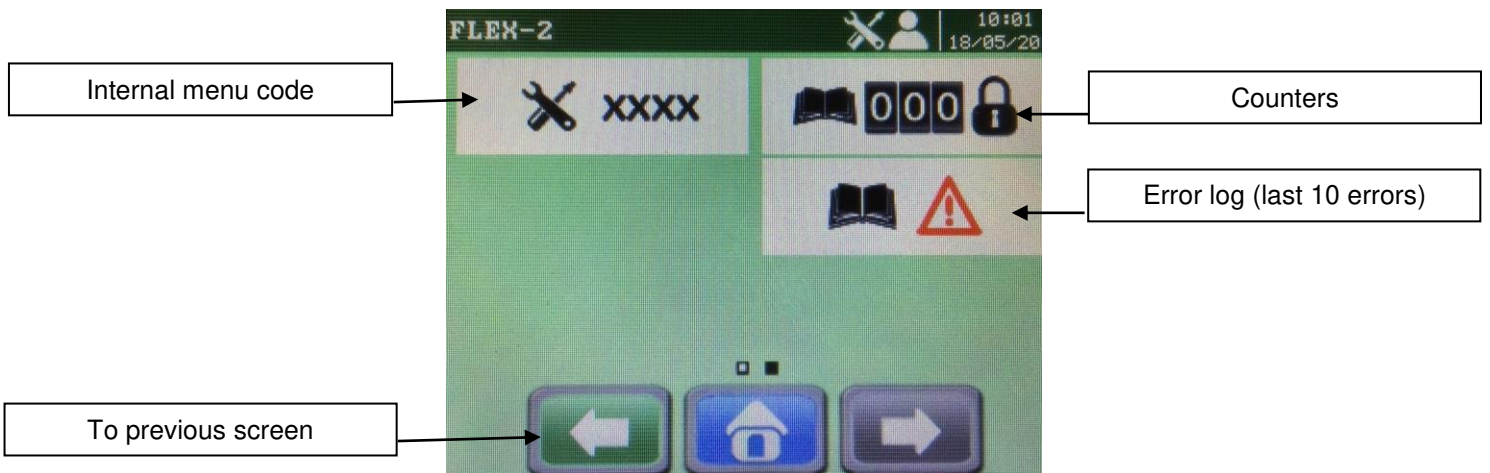
b) Settings menus

Press the green key in the centre of the screen to open the settings.

Click to open the required menu.

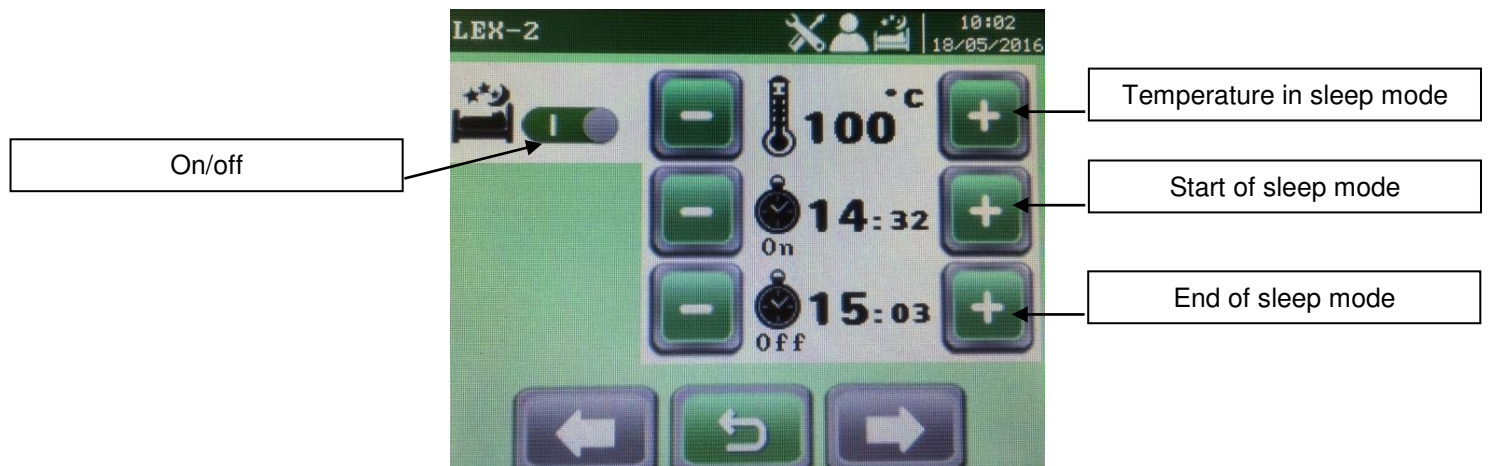
Press the arrow in the bottom centre of the screen to exit.



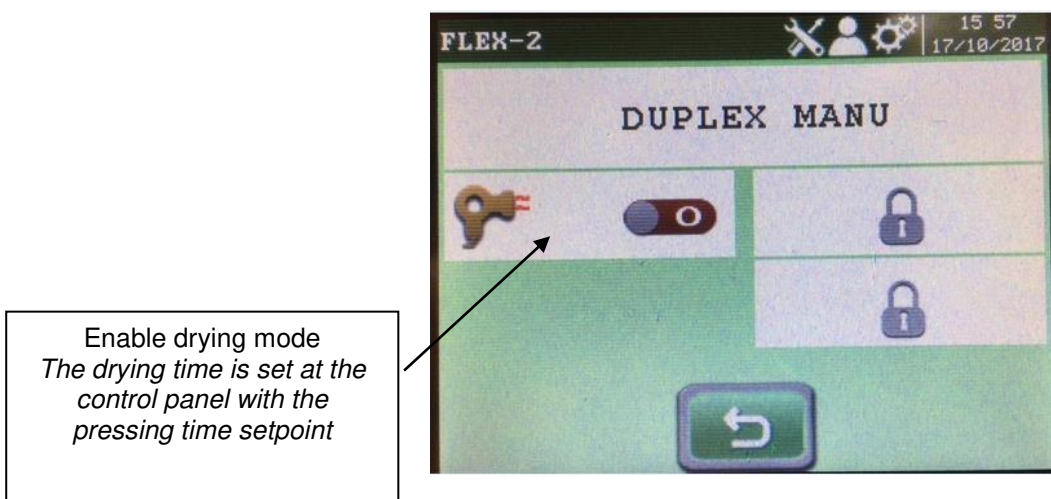


c) Sleep mode

Sleep mode keeps the machine temperature at a certain level for a certain length of time



d) Machine settings



e) User comfort settings

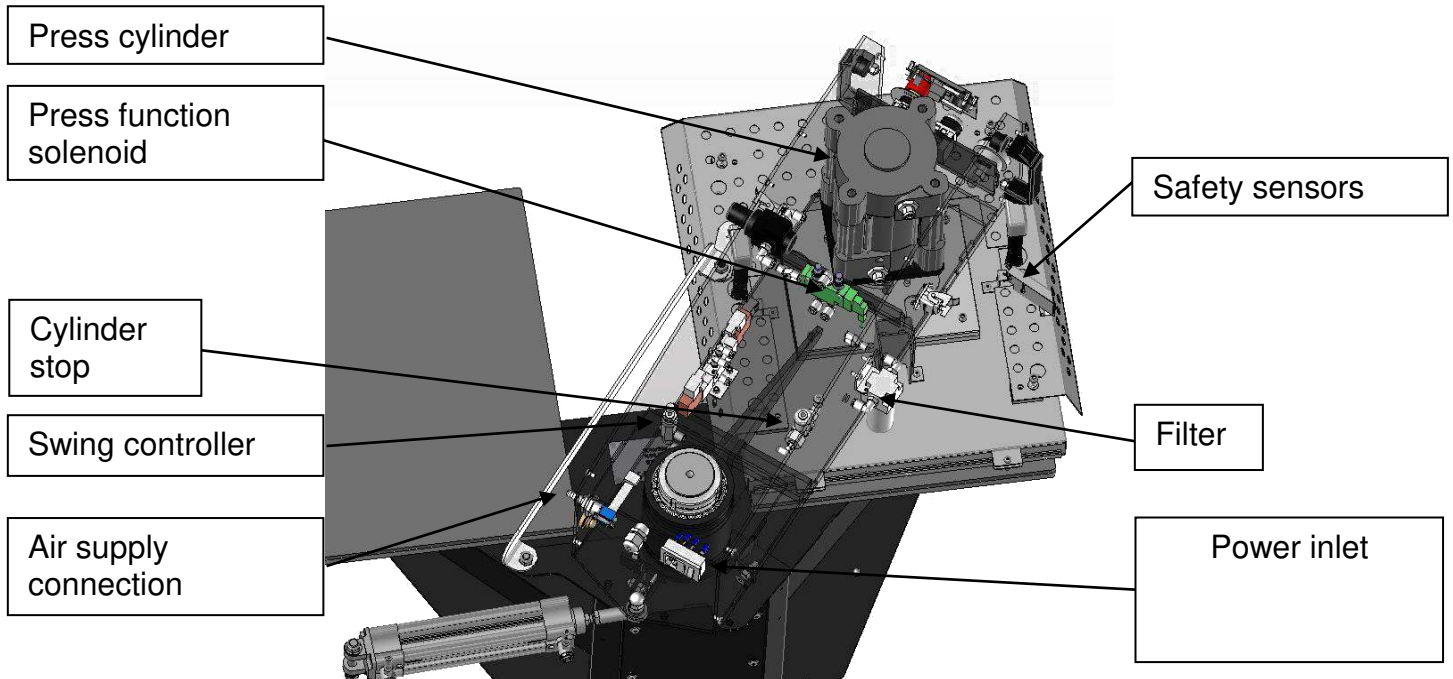


f) Energy saving mode

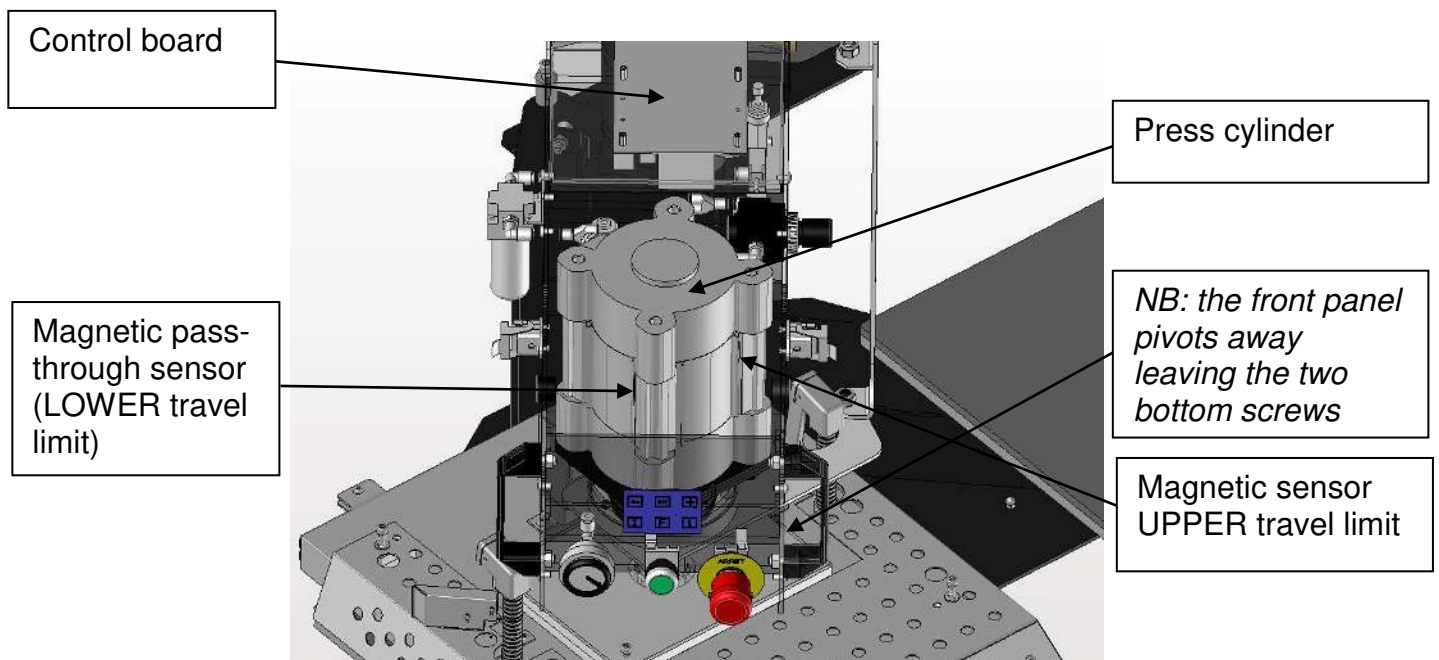
Energy saving mode reduces the machine temperature to the set temperature when the defined idle time has elapsed.

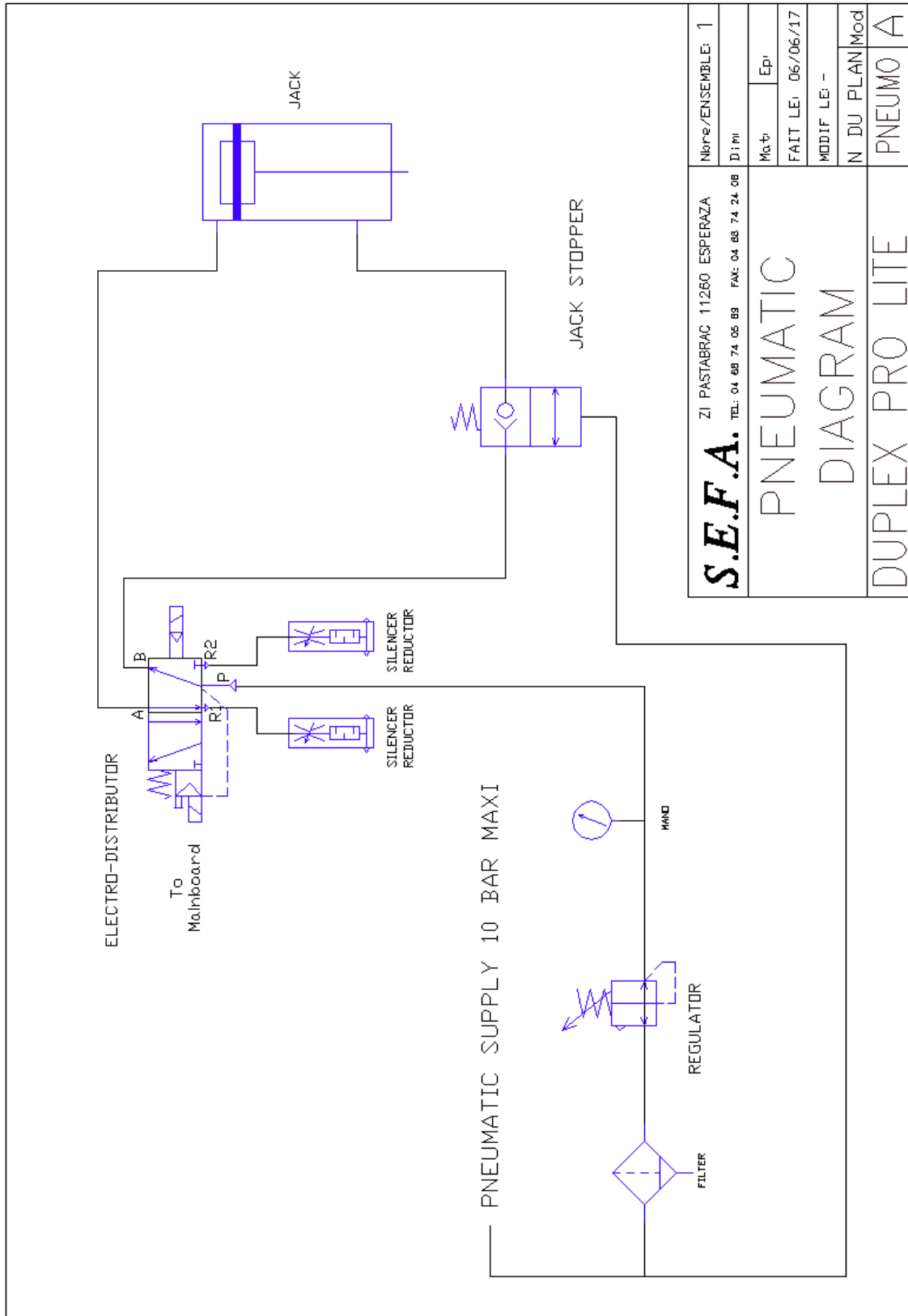


PARTS LAYOUT



NB: the electronic board is underneath the housing cover (not shown)





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				PNEUMO A	
				DUPLX PRO LITE	
				PNEUMATIC DIAGRAM	

SERVICING

TO BE PERFORMED BY QUALIFIED PERSONNEL

**THE MACHINE MUST BE SWITCHED OFF AND LOCKED AND TAGGED
PRIOR TO SERVICING
(ELECTRIC AND PNEUMATIC POWER SOURCES DISCONNECTED)**

The following tools should be available at hand:

- Phillips and flat-blade screwdrivers
- Set of open-ended spanners and box spanners
- Set of Allen keys
- Multimeter

1. REPLACING WORN PARTS

a) Silicone foam pads

Check that the platen is cold.

Make sure the surface of the platen is clean.

The surface can be cleaned using a mild solvent such as isopropyl alcohol. Suitable personal protective equipment must be worn.

Use RTV-1 glue to stick the foam pad to the aluminium platen (NB: read the instructions for use on the packet).

The pad and the platen must be clean and dry before they are stuck together.

Apply a thin layer of glue evenly over the platen and then stick the pad immediately into place, making sure there are no air bubbles trapped between the platen and the pad (NB: a notched adhesive comb of the type used for floor tiling would be suitable).

Leave to set overnight at room temperature with a slight pressure applied and the platen cold.

b) Other parts

Contact your stockist to determine whether they need to be renewed or repaired.

2. Maintenance

SEFA heat presses are practically maintenance-free. Follow the preventive maintenance instructions below to ensure trouble-free operation:

Do not heat items that could perish or score the silicone pad or damage the heat platen's teflon coating.

Clean the machine at regular intervals, with the platen cold, using a clean cloth and isopropyl alcohol (NB: isopropyl alcohol is flammable - use with care and keep away from sources of heat) and wearing suitable personal protective equipment.

Keep the heat platen in the raised position when it is hot but not in use.

DAILY CARE:

Clean the foam pad and the platen's coating (when cold) with a dry cloth or a dry cloth and grease remover.

Inspect the air inlet filter on the left side of the swing arm; drain the filter if it is heavily condensated.

MONTHLY CARE:

Check that the hinged joints are lubricated.

According to use:

Replace the foam pad every 6 months.

3. ELECTRONIC BOARD MESSAGES

- Alert 1: PT100 unplugged
- Alert 2: Platen safety device
- Alert 3: Triac 1 short-circuited
- Alert 4: Triac 1 control out of order
- Alert 5: Triac 1 relay short-circuited
- Alert 7: Clock battery
- Alert 8: Cylinder PR245 lift action
- Alert 9: Cylinder PR245 lowering action
- Alert 11: Machine cylinder manual lift
- Alert 12: Heat platen timed out
- Alert 14: PT100 > Max. temperature drop setpoint
- Alert 15: PT100 > Max. permitted temperature setpoint
- Alert 16: Triac 2 control out of order
- Alert 17: Triac 2 relay short-circuited
- Alert 18: RH travel limit not reached
- Alert 19: LH travel limit not reached
- Alert 20: Variance between lower travel limit and upper travel limit
- Alert 21: Variance between RH travel limit and LH travel limit

WEAR PARTS

When ordering: *always quote the description, reference and quantity*

<u>Reference</u>	<u>Description</u>	<u>Quantity</u>
<u>ELECTRICAL PARTS</u>		
AFF-EL3"5	MMI TOUCH SCREEN	1
CAR-EL C	POWER BOARD	1
SON-PT100	TEMPERATURE PROBE	1
RES-500x400-3200W	MICA HEATING ELEMENT 400x500 3200 W	1
<u>PNEUMATIC PARTS</u>		
VER-SM25	CYLINDER Ø125 C100	1
FIL-013	FILTER	1
ELE-SM8	SOLENOID CONTROL VALVE 24V	1
<u>PRESS COVERINGS</u>		
MOU-540	FOAM 9.53mm 400X500	2
TOI-4050	TEFLON SHEET	1

TROUBLESHOOTING TIPS



The machine must be switched off and locked and tagged prior to any service repair work (electric and pneumatic power switched off).

The heat platen can cause burns. Check that the platen temperature reading on the display panel is below 25° C before handling.

<u>PROBLEM</u>	<u>POSSIBLE CAUSES</u>	<u>SOLUTION</u>
The machine does not switch on	<p>The plug is not connected</p> <p>The switch has not been pressed</p> <p>The emergency stop has been pressed</p> <p>Faulty display panel</p>	<p>Check the mains electricity and that the machine is plugged in.</p> <p>Press the main On/Off switch to 1.</p> <p>Turn the red button to disengage the emergency stop</p> <p>Check whether the ribbon cable is connected properly; otherwise, the display is out of order</p>
The platen does not heat up	<p>Faulty heating element</p> <p>Problem with the electronic board</p> <p>Temperature setting too low</p>	<p>Check the connections and the condition of the wires.</p> <p>Contact your stockist to have the platen removed</p> <p>Check the on-screen messages and contact your stockist</p> <p>See section V about changing this setting</p>
The platen overheats	<p>Problem with the probe or the electronic board</p>	<p>Check the on-screen messages and refer to the board user manual. Contact your stockist.</p>
The timer does not count down	<p>Disabled or faulty cylinder-mounted sensor</p> <p>Problem with the electronic board</p>	<p>Check the connections. Replace if necessary.</p> <p>Check the on-screen messages and refer to the board user manual.</p>
The platen does not lower	<p>Leaking cylinder</p> <p>Faulty solenoid control valve</p> <p>Compressed air pressure too low</p>	<p>Check the seals and all the connections. Contact your stockist.</p> <p>Check the valve couplings. Contact your stockist about a possible replacement.</p> <p>Check that the supply pressure is > 3 bar.</p>
The platen does not lift up	<p>Faulty solenoid control valve</p> <p>Leaking cylinder</p>	<p>Check the valve couplings. Contact your stockist about a possible replacement.</p> <p>Check the seals and all the connections. Contact your stockist.</p>
The platen stays down after pressing	<p>Timer not counting down</p>	<p>See above.</p>

MAINTENANCE LOG

THE FOLLOWING CHECKS AND MAINTENANCE PROCEDURES SHOULD BE PERFORMED AT REGULAR INTERVALS TO ENSURE THAT YOUR PRESS REMAINS IN GOOD WORKING ORDER AND CONTINUES TO PROVIDE RELIABLE SERVICE

Date	Number of hours	Pressure check	Air filter check	Cylinder check	Condition of foam pad	Heating element check	Replaced parts	Observations

Tip - use the following abbreviations to help complete the log more quickly:
 C - Checked W - Washed/Cleaned R - Replaced