

## VM-506

SOLDADORA DE PVC - LÍNEA PESADA



- Apertura de prensores 200mm.
- Gabinete extra grande y robusto preparada para trabajo pesado.
- Controlada electrónicamente.
- Permite regular el cordón de soldadura a 0.2mm para perfiles foliados.
- Temperatura de soldado ajustada digitalmente.
- Tiempo de soldado ajustado digitalmente.

Trabajo con pedal ó desde el PLC digital.

Sujeción neumática de la ventana con dos brazos de apoyo.

Permite soldado en ángulos entre 0, 45° y 180°.

Presiones de aire ajustables para lograr óptimo soldado.

Voltaje 220V.



# VM-506

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## 1. GENERAL INFORMATION

### 1.1. INTRODUCTION

The user's manual given by the manufacturer contains necessary information about the machine parts. Each machine operator should read these instructions carefully, and the machine should be operated after fully understanding them.

Safe and efficient use of the machine for long term depends on understanding and following the instructions contained in this manual. The technical drawing and details contained in this manual constitute a guide for the operator.

\*In case of any technical problem please contact your nearest OK INDUSTRIAL dealer, or OK INDUSTRIAL head office through the above mentioned phone fax or e-mail address

\* Technical labels with the model description of the machine are fixed onto the front side of each machine.

\*The machine's serial number and manufacturing year are stipulated on the technical label.

**Average life usage of production is 10 years. If you have any further failure and complaint, please inform to our below mentioned technical service by verbal or written**

### AUTHORIZED TECHNICAL SERVICE CENTER ADDRESS ;

**For minimize the documentation, It is very necessary to mention below details at the agreements signed with suppliers and dealers of the purchased machines..**

OK INDUSTRIAL SRL

Moreno (148) N° 1900 esquina Italia (41)

CP: 1653 Villa Ballester

Bs. As. Argentina

T: 0054 9 11 4738-2500 rotativas

info@okindustrial.com.ar

www.okindustrial.com.ar

\*Machine's serial number

\*Date of purchase

\*Machine model

\*Average daily operation period

\*Voltage and frequency

\*Description of the machine fault

\*Name of dealer where machine was purchased



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## CERTIFICADO DE GARANTIA

Los productos OK INDUSTRIAL tienen garantía total contra eventuales defectos de fabricación, evidenciados en condiciones de uso y manejos normales, por el término de 12 meses contados a partir de su entrega. Si OK INDUSTRIAL recibiera aviso de algún defecto bajo las circunstancias anteriormente detalladas podrá, discrecionalmente, reparar o sustituir el producto defectuoso sin costo para el cliente.

En caso de reclamo justificado, la responsabilidad máxima de la empresa para con el cliente quedará limitada al precio de compra pagado a OK INDUSTRIAL o al canal de venta autorizado y no incluye compensación o indemnización alguna por otros conceptos.

### Limitaciones y Exclusiones

La garantía no será aplicable en los siguientes casos:

- 1) Cuando el producto haya sufrido mal uso; modificaciones no autorizadas, funcionamiento o almacenamiento, desplazamientos, instalación, mantenimiento y transporte en condiciones inadecuadas.
- 2) Daños causados por desastres naturales o provocados (inundaciones, rayos, terremotos, etc), fluctuaciones de la corriente eléctrica, interacción con otros productos de otras marcas.
- 3) Derrame de sustancias corrosivas o deteriorantes sobre el producto.
- 4) Cuando se detecte que el producto fue desarmado total o parcialmente, o sufrió algún intento de reparación por personal no autorizado por el fabricante.
- 5) Daños ocasionados por pruebas, instalación, mantenimiento o ajustes inapropiados.
- 6) Desgaste generado por el uso inherente a la propia naturaleza del material.
- 7) La garantía se rige por la ley del lugar de fabricación del producto.

Las garantías de componentes y/o accesorios de otras marcas que formen parte de nuestros equipos tales como motores, mandos neumáticos, hidráulicos y/o eléctricos, fresas, freselines, hojas de corte, etc, corren por cuenta de su respectivo fabricante.

OK INDUSTRIAL garantiza el aprovisionamiento de todos los componentes que puedan haber sufrido accidentes y/o desgaste natural cobrando su costo de lista y los gastos de envío.

Para obtener el servicio de garantía, el cliente debe acudir al establecimiento de OK INDUSTRIAL con una copia de su factura de compra ó a su distribuidor autorizado que le proveyó del equipo.

Si el cliente prefiere usar servicios de transporte para enviar su equipo a reparación, deberá llamar con anterioridad a los teléfonos de OK INDUSTRIAL donde se le darán instrucciones de seguridad y embalaje para su equipo. Los gastos de envío, transporte y embalaje, estarán a cargo del cliente.

OK INDUSTRIAL SRL no se responsabiliza de los accidentes que se puedan ocasionar por el uso de sus productos o de modificaciones ajenas al fabricante.

OK INDUSTRIAL SRL







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## 2. MACHINE'S DESCRIPTION AND USER FEATURES

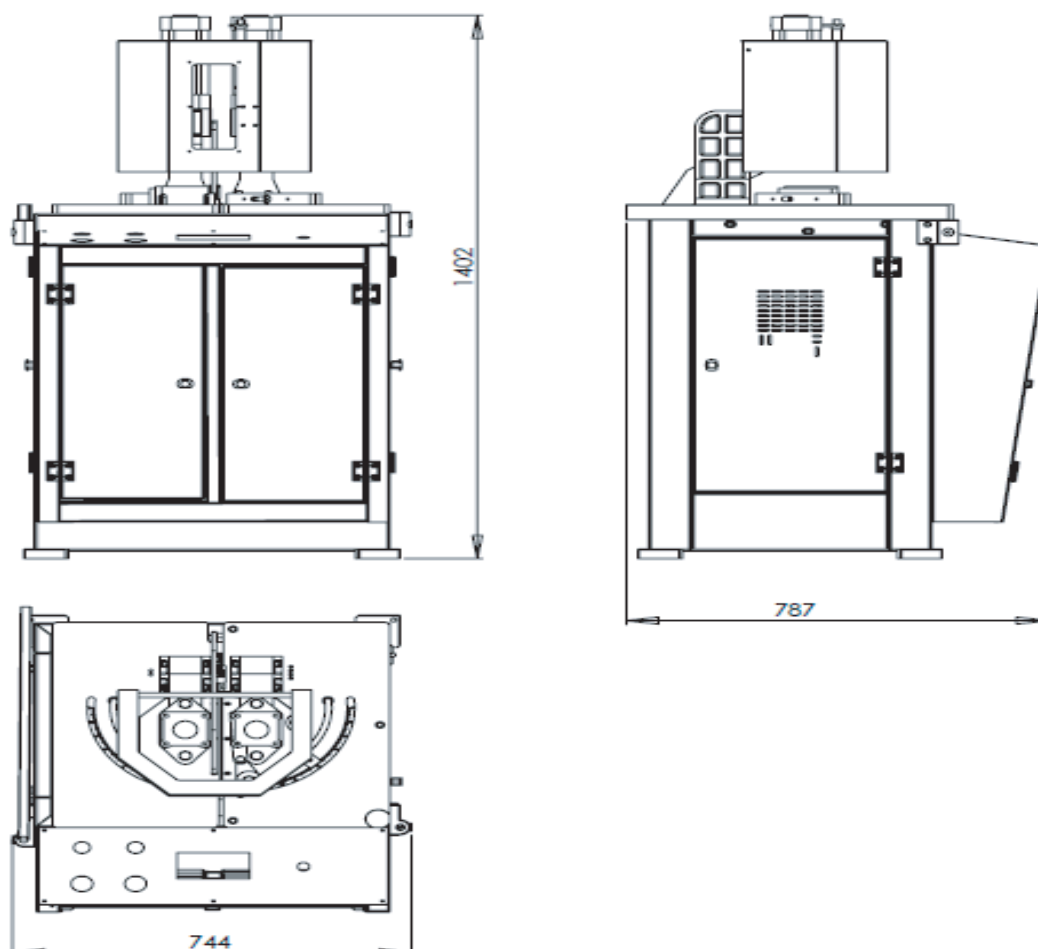
### 2.1. MACHINE'S DESCRIPTION

- \* Machine is designed for the joining of PVC profiles through corner welding.
- \* Capable of adjusting the clamp and welding pressure according to the profile type.
- \* Equipped with a timer for melting and welding time. Capable of welding at angles between 30° – 180°
- \* Profiles are clamped one by one via foot pedal
- \* After clamping the profiles, the welding is carried out automatically.
- \* The thermostat is electronic and can be adjusted in a temperature range between 0°-260°

### 2.2. TECHNICAL FEATURES

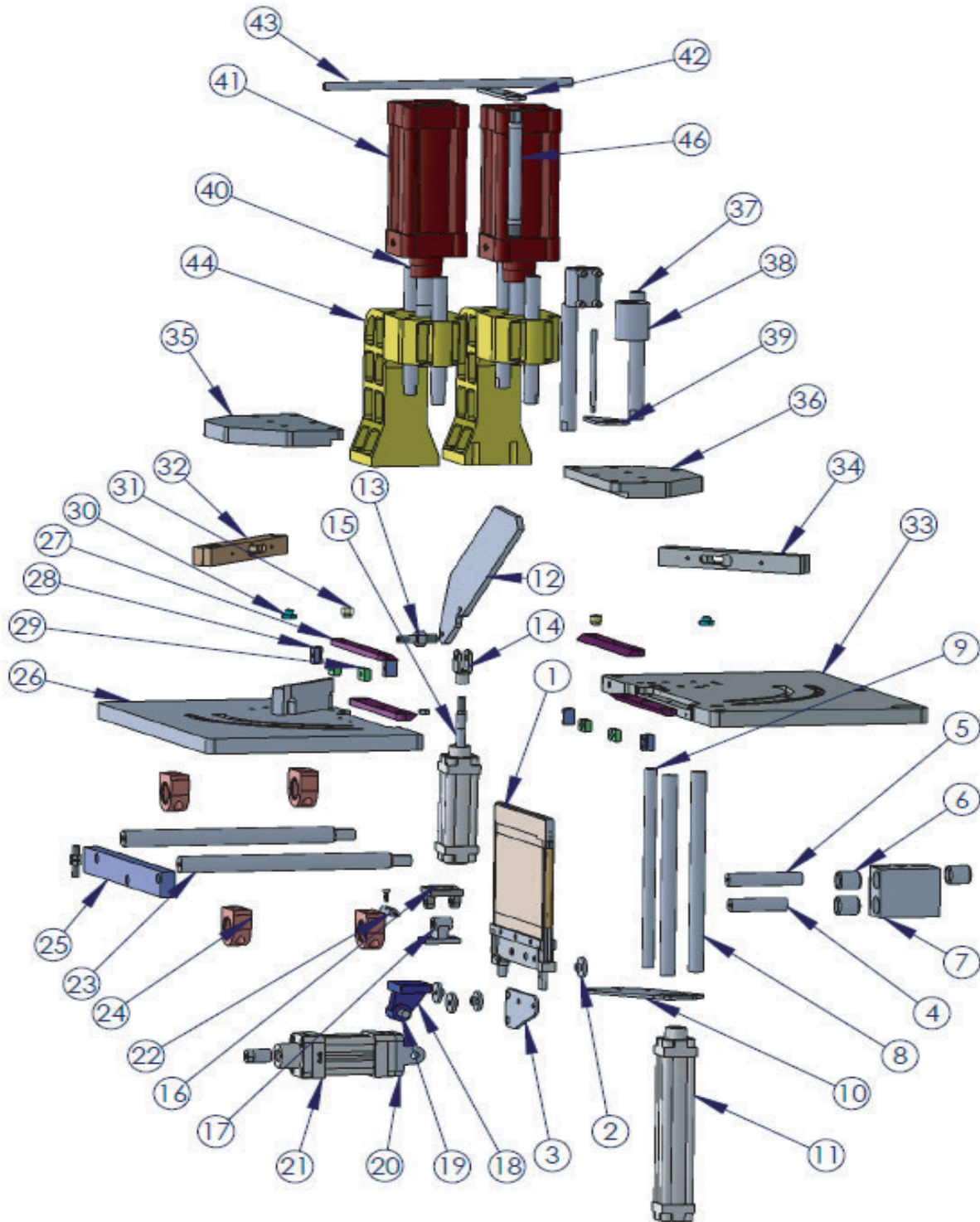
					
1,5 kw 50/60 hz	17 Lt/ dak.	6/8 Bar	max h:130 mm a:30°-180°	W: 85 L: 88 H: 149 cm	195kg

### 2.3. DIMENSIONS



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## 2.4 PART LIST AND TECHNICAL DRAWINGS





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PART NO	STOC CODE	UNITE
01	150.011.0135	1
02	152.01.004	4
03	150.013.0019	1
04	152.005.0021	1
05	152.005.0020	1
06	150.006.0217	4
07	150.001.0066	1
08	150.005.0015	2
09		1
10	150.013.0022	2
11	150.010.0032	1
12	150.013.0024	1
13		1
14	150.011.0124	1
15	150.010.0033	1
16	150.011.0013	1
17		1
18		1
19		2
20	150.011.0010	1
21	150.010.0037	1
22		1
23	150.005.0017	2
24	150.001.0079	4
25		1
26	150.011.0034	1
27	150.006.0175	2
28		4
29		4
30		2
31		2
32		1
33	150.011.0034	1
34		1
35	150.001.0037	1
36	150.001.0037	1
37	150.005.0016	1
38		2
39	150.02.0661	1
40	150.005.0016	5
41	150.0010.0027	2
42	150.02.0662	1
43		1
44	150.001.0078	2
45	150.001.0087	2



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## 3. SAFETY



### 3.1 SAFETY INFORMATION

The symbols shown hereunder are necessary to be read with special attention. Not reading or observing of them may cause damage to the equipment or personal injury.

#### IMPORTANT

The IMPORTANT symbol above is one telling to apply special care and to be careful at carrying out the specific operation.

#### CAUTION !

The CAUTION! Symbol above warns you against specific dangers, and requires to read the text. Not observing may cause damage to the equipment.



#### DANGER WARNING

The above symbol DANGER WARNING, warns you against specific dangers, and you have definitely to read them. Negligence may cause damage to the equipment and bodily injury.

Read the user's manual carefully before using the machine or carrying out maintenance works.



### 3.2. ACCIDENT PREVENTION

3.2.1. Our machines are manufactured in accordance with EN 60204-1 and EN 292-2 CE safety directives, which cover national and international safety directives.

3.2.2. It is the task of the employer to warn his staff against accident risks, to train them on prevention of accidents, to provide for necessary safety equipment and devices for the operator's safety.

3.2.3. Before starting to work with the machine, the operator should check the features of the machine, learn all details of the machine's operation.

3.2.4. Machine should be operated only by staff members, who have read and understood the contents of this manual.

3.2.5. All directives, recommendations and general safety rules contained in this manual have to be observed fully. The machine cannot be operated in any way for purposes other than those described herein. Otherwise, the manufacturer shall not be deemed responsible for any damages or injuries. And such circumstances would lead to the termination of the warranty.

### 3.3. GENERAL SAFETY INFORMATION

3.3.1. The power cable should be led in such a way that nobody can step on it or nothing can be placed on it. Special care has to be taken regarding the and outlet sockets.







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3.3.2. If the power cable should be damaged operation, don't touch and unplug it. Never use damaged power cables

3.3.3. Don't overload machines for drilling and cutting. Your machine will operate more safely with power supply in accordance with the stipulated valued..

3.3.4. Don't place your hands between parts in motion



3.3.5. Use correct illumination for the safety of the operator. ( ISO 8995-89 Standard The lighting of indoor work system )

3.3.6. Use protective eye glasses and ear plugs. Don't wear oversized clothes and jewelry. These can be caught by moving parts



3.3.7. Don't use any materials other than those recommended by the manufacturer for welding operations on the machine

3.3.8. Ensure that the work piece is clamped appropriately by the machine's clamp or vice.

3.3.9. Ensure safe working position, always keep your balance

3.3.10. Don't leave anything on the machine



3.3.11. Keep your working place always clean, dry and tidy for accident prevention and operation

3.3.12. Keep your machine always clean for safe operation. Follow the instructions at maintenance and replacement of accessories. Check the plug and cable regularly. If damaged, let replace by a qualified electrician. Keep handles and grips free of any oil and grease.

3.3.13. Unplug first, before conducting and maintenance Works

3.3.14. Ensure that any keys or adjustment tools have been removed before operating the machine.

3.3.15. If you are required to operate the machine outside, use only appropriate extension cables.

3.3.16. Repairs should be carried out by qualified technicians only. Otherwise, accidents may occur

3.3.17. Before starting a new operation, check the appropriate function of protective devices and tools, ensure that they work properly. All conditions have to be fulfilled in order to ensure proper operation of your machine. Damaged protective parts and equipment have to be replaced or repaired properly (by the manufacturer or dealer)..

3.3.18. Don't use machines with improper functioning buttons and switches.



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3.3.19. Don't keep flammable, combusive liquids and materials next to the machine and electric connections

**IMPORTANT**

## 4. SAFE TRANSPORT OF THE MACHINE

\* The transport should be done by qualified personnel only.

4.1. The machine should be transported by lifting with proper equipment (not touching the ground during the transport).

4.2. The Machine is delivered wrapped in nylon as packaging, unless other form of packing is agreed upon with the customer.

4.3. For the weight and overall dimensions of the machine see Technical Features.

## 5. INSTALLATION OF THE MACHINE

### 5.1. Preparation

5.1.1. The machine should be located at least in front of the back wall. The machine is equipped with a burr collection bag connector and power supply socket on the back side

5.1.2. Position of the rear wall should be approximately 100 cm in the machine

5. 1.3. Feet at the bottom of the chassis with the help of the machine can adjust the balance.

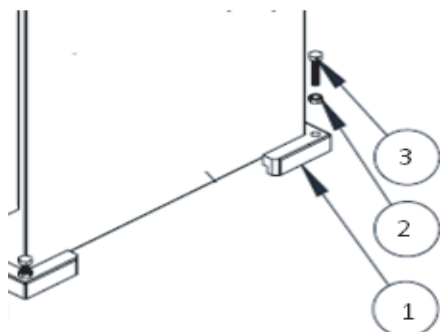


Figure 1



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## **5.2. ELECTRIC CONNECTION**

5.2.1 220V 50 Hz mains voltage is applied.

5.2.2 Apply Plug the machine into a grounded outlet.

## **6. MACHINE SAFETY INFORMATION**

6.1. The machine used for removing the protective enclosure.

6.2. Remove the machine, place, qualified and authorized personnel should be used for electrical maintenance work.

6.3. Routine scheduled maintenance with maintenance work by authorized and qualified personnel should be done after the removal of the electrical power supply circuit.

6.4. Cleaning of the machine before working on the machine, ensure that the testing and maintenance made.

6.5. Safety equipment and moving parts of the electrical power cord as a routine check. If you see damage to equipment or parts to fulfill the functions of security with a new one without changing the machine operate.

6.6. Never change blades for disconnecting electric power.

6.7. Holds of foreign bodies in the area where the operation, Do not put your hands in between the moving parts.

## **7. OPERATION**

### **7.1. OPERATION INFORMATION**

7.1.1. Table tops clean of foreign materials, Resistance, and a clean plate to make sure that tears the paper on the Teflon.

7.1.2. Please check the machine's electrical and air connections are made correctly.

7.1.3. Air adjustment unit and check the oil level on the air pressure.

7.1.4. According to the source of heat and time settings on PVC profile, be sure to check the accuracy.

7.1.5. Movement of the pressing is 100 mm.

7.1.6 Avoid touching the buttons on the panel at random. If you feel a threat during the cutting process the cutting process immediately by pressing the emergency stop button Terminate half.

### **7.2. PROFILE CUTTING and ANGLE ANDJUSTMENT**

7.2.1. Cut in the PVC profiles to a certain extent, as a result of melting by heating two parts are combined together. During this merge from 2.5 to 3 mm on profiles from the total melting is 5-6 mm. Therefore, a measure which is cut at 5-6 mm larger than the cut PVC profile is a perfect fit can be done.

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7.2.2. Angles of the cutting profile trays use the arrow keys on the trench (Figure 2) are required to bring the angles shown. For this purpose;

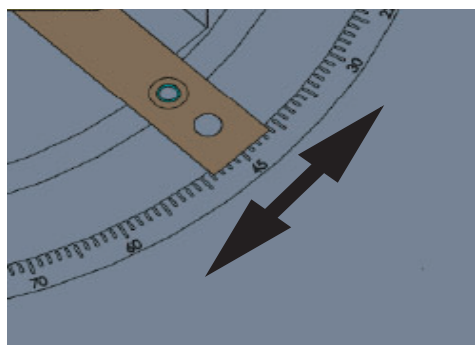


Figure 2.

Use the arrow keys on the table and trenches, the desired angle by loosening the set screws on the allen bolts in the tightening and fix the trench.

## 7.3. THE SETTLEMENT and COMPACTION PROFILES

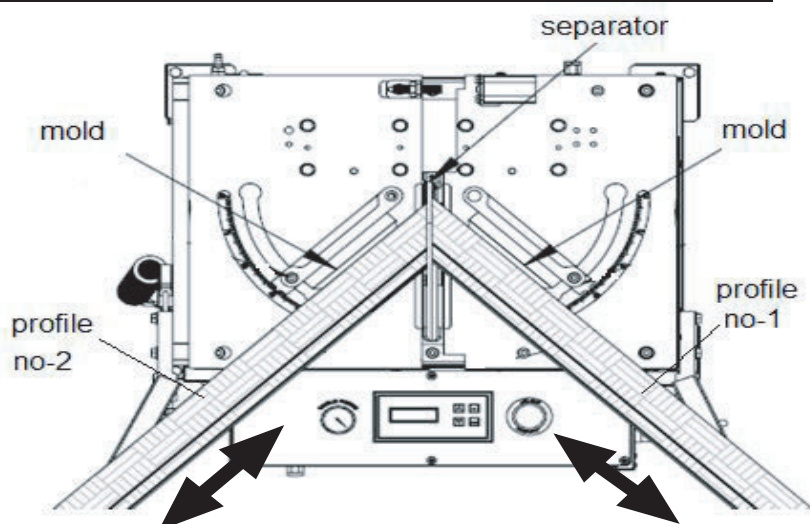


Figure 3.



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- 7.3.1. Sartel Operate the machine to take a position.
- 7.3.2. The pedal by pressing a jig (20) (FLAT) steps up to ensure that closure of the tray.
- 7.3.3. Place the tray on the bottom surface of the stationary profile No. 1. (Figure 3) of the frame side surface of the mold side surface made of profile cutting angle and carefully place the side surface of the surface of the gauge.
- 7.3.4. Pedala 1 kez basarak sağ presin profili sıkıştırmasını sağlayınız.
- 7.3.5. Put your profile on the lower surface of the moving table No. 2. The profile side surface of the mold side surface of the angled profile section made from carefully place the side surface of the surface of the gauge.
- 7.3.6. By pressing a pedal on the left of the press. Provide compression profile. (Figure 4)

## **7.4. WELDING PROCEDURE**

7.4.1 Press the pedal one more time the machine will automatically set the next operations will end the method according to the source.

\* Gauge pulls back \* Table opens \* Resistance rises \* off table\*

Resistance of the frame side surfaces of the side surfaces by contact with the temperature and defrost time allows. After the melting process (time varies according to climatic conditions);

\* Resistance goes down automatically \* Moving off table

\* Profiles remained constant during the period specified source pastes.

\* Source curuflarını upper and lower blades clean.

\* Presses the right and left moving table at the end of the welding process is opened automatically terminated.

## **7.5. RESOURCE SENSITIVE SETTING**

**\*7.5.2 Melting time selection method (ZW-505 TKK-505):** This electronic resource card with the machine to set your own parameters for welding processes based on variable factors such as thickness profile, type proximity sensor is set as described below in disabling the use of digital.



By pressing the screen shown below the melting time of the sensor is disabled and the method of selection was adopted

SET TEMPERATURE  
240

MELTING TIME  
20

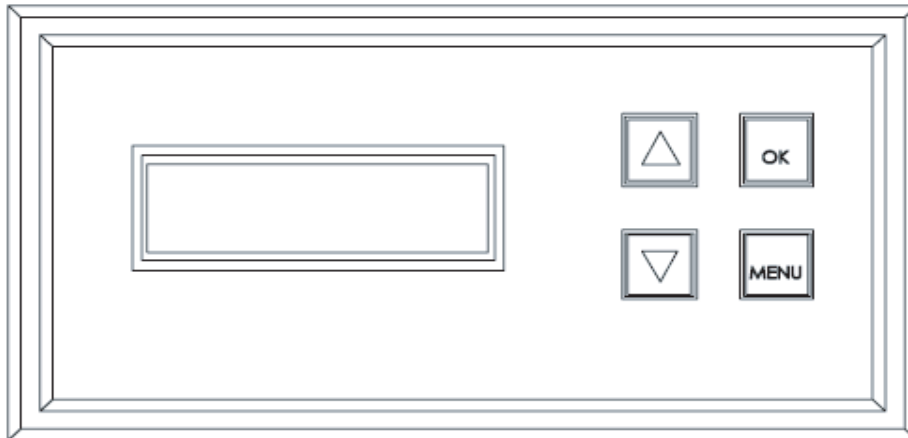
WELDING TIME  
20

As described below, the settings.

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## 7.6. INPUT OF PARAMETRES

### SOURCE EKTRONİK CARD USE:



The button with the index TOP is used for changes of values of parametres. By pressing in an indicator 2 value changes.



Button OK is used for an input in the menu...

The button with the index DOWNWARDS is used for values of parametres. By pressing in an indicator 2 value changes.



The Menu button is used for changes of parametres. By pressing in an indicator value changes.

### USER MENU

Parametres :

1. The first line on the display SET TEMPERATURE, MELTING TEMPERATURE, WELDING TEMPERATURE are changable users parametres.

SET TEMPERATURE 240
------------------------

MELTING TIME 20
--------------------

WELDING TIME 20
--------------------

2. The value on the second line on the display is the value of this parameter end can be changet USE :

To enter user menyu push



Buton. When you push this buton you can get one of the displays

Swown bellow



Push Button and choose parametes as needed. Teser parameter values SET TEMPERATURE centigrad celcius and can be changet 1 centigrad celcius interval. MELTING TIME is second and can be chagent 1 second interval WELDING TIME is second and be changed 1 second interval. Using



Or





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## 7.3. INPUT PARAMETRES

- \_ Disconnect energy of the machine tool.
- \_ Hold the menu button the pressed
- \_ Pressing the menu button,connect energy of the machine tool.

PID PROP 30	Pid propondional value.
PID INT 1	Pid integral value.
PID DER 192	Pid Differential value.
GUIDE IN 1	After step on the freadle first time.Unit is 1/10 sec.For example to enter 1 enter 1 sec put 10 Value.
TABLE IN 1	After the guide enter,the table 1 st in time the machine's 3rd time.Unit 1/10 cek.For example to enter 1 cek put 10 valude.
1.CLAMP IN 1	After stepping the treadle 2 rd time the machine's 3rd time Unit 1/10 cek.For example to enter 1 cek put 10 valude.
2. CLAMP IN 0	After stepping the treadle 3 rd time the machine's 4rd time Unit 1/10 cekFor example to enter 1 cek put 10 valude..
TABLE OUT 5	Table's 1.out time.the machine's 5 th time unit is 1/10 sec.Unit 1/10 For example to enter 1 cek put 10 valude.
GUIDE OUT 5	The guide out time the machine's 6 th time.Unit is 1/10 sec For example to enter 1 cek put 10 valude.
HEATER IN 5	Heater in time machine's 7th time.Unit is 1/10 sec For example to enter 1 cek put 10 valude.
TABLE IN 11	Table's 2.time in time machine's 8th time. Unit is 1/10 sec For example to enter 1 cek put 10 valude
TABLE OUT 2 5	Table's 2.time in time machine's 10 th time. Unit is 1/10 sec For example to enter 1 cek put 10 valude.
HEATER OUT 5	The heater out time machine's 11th time. The unit is 1/10 sec. For example to enter 1 cek put 10 valude.
TABLE IN 3 10	The table's 3rd in time the machines 12th time unit is 1/10 sec. For example to enter 1 sec put 10 value.



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WELDING TIME  
20

When the table closed profiles adhesion time the machine's 13th time unit is sec. For example for 1 sec enter 1 value. This time counts down from set value to zero.

TABLE OUT 3  
0

Tables 3rd out time the machine's 16th time and the last time and Step. For example to enter 1 sec put 10 value.

2.CLAMP OUT  
0

The 2nd clamp out time the machines 14th time unit is 1/10 sec. For example to enter 1 sec put 10 value.

1.CLAMP OUT  
5

1 st clamp out time the machine's. For example to enter 1 sec put 10 value

OFFSET TEMP  
0

This value for downing real temperature – down and for calibration For example if you enter 10 and the real temperature is 220 you see 210 on the display. This value limited with 20.

EMERGENCY  
STOP NO

If you use NC contact for emergency button enter NC if you have. NO for the emergency button enter NO.

LANGUAGE  
ENGLISH

This parameter changes language standard languages are Turkish, English and Russian. Optional you can have Romanian, French and Spanish versions available when you change language all menu Messages change..

FILTER  
0

It is display temperature filter, device working 1 celcius centigrade if you enter 1 this value you don't see temperature changes.

READY TO RUN  
ALWAYS

This parameter is ready to run, if you choose 'always' device permit all temperature values for running machine. If you choose 'in set value' temperature set values over 5 degrees or lower 5 degrees you can run in other cases it is not possible to run

TYPE MACHINE  
ZERO WELDING  
NORMAL WELDING

Bu makineyi seçiniz.





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## 7.4 CAUTIONS AND FEATURES INTENDED ATTENTION

TC ERROR	Termocouple error,if you connect termocouple wrong or broken you see this warning
230 C E25s K25s STEP OF TREADLE	On the display secong line of you see this step on treadle you can run machine if you choose from fine tuning menyu ready to work option always you see step on treadle..
240 C E20s K20s WAIT!NOT READY	If you see this warning you can not run the machine you should wayt temperature to come cloose to the set temperature value,when you see step on treadle you can run
240 C E20s K20s MACHINE STOPING	When the machine is running if you push the emergency buton you see machine stoping warning.When the machine stops you see. Emergency Stop Warning
240 C E20s K20s EMERGENCY STOP	If you push emergency button first you see machine stoping then you see emergency stop.If you turn to emergency button normal end you still see this warning chek the wirings
240 C E20s K20s TABLE OUT	When the machine working on the display second line you see the running procces on the machine at that moment

### CRITICAL NOTES :

- Please use you machine with grounded socket and make sure your ground is OK .
- Please use the filtered end good quality Swich Mode Power Supply.
- Isolated J Type (Fe-Const) termocuple is necessary fort he systemi
- Please use a solid state relay for your heater instead of a contactor.

### CLUE :

In Rud Mode :

I nane case if you have problem on your treadle or start swich or emergency stop button of start and button for stop. In Setting Mode :In your controller basic rule is for changing first line on the display use button with buttons or second line on the display

## 8. REPLACEMENT BLADES

8.1. Disconnect the electrical machine.

8.2. Open the lid of the upper housing.

8.3. Unscrew the allen key bolts and replace with knives Imbus pitfall. Make sure the blades are parallel and tightly connected.

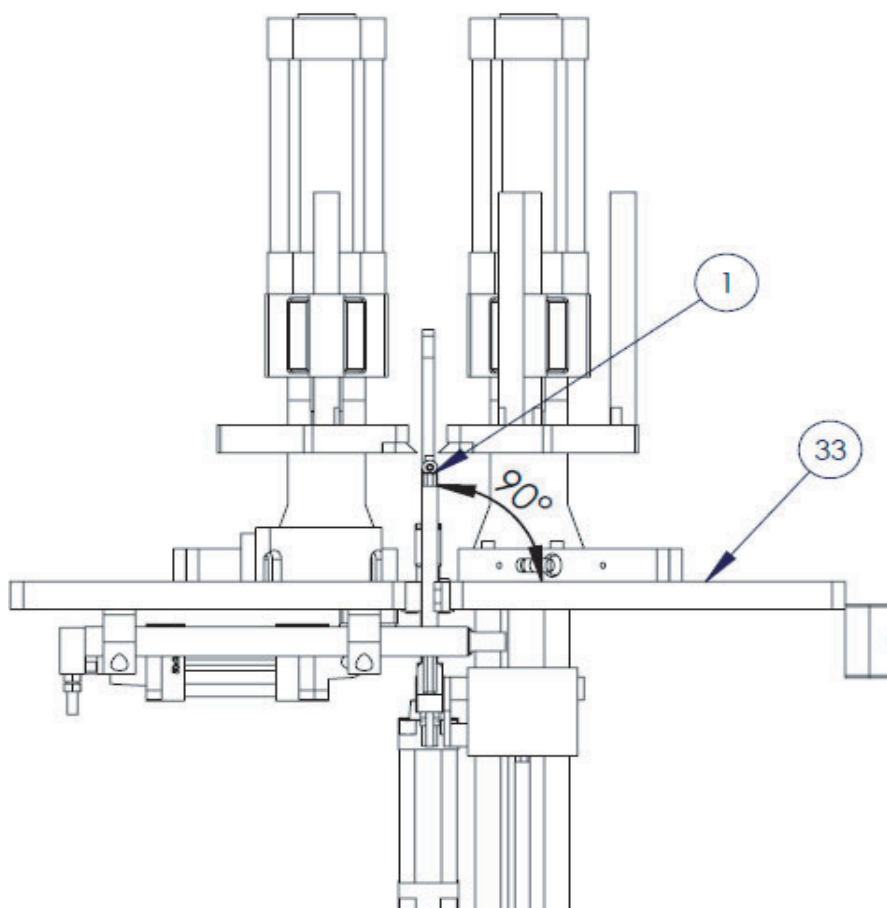
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## 8.1. RESISTANCE OF CONTROL AND TEFLON CHANGE

8.1.1 Teflon plate on the heater resistance is always clean and undamaged Pay attention to the paper. No. 5 before the operation the valve (FIG. 8) to release up switch to the plate by pressing. Teflon adhesive onto the paper oil, dirt, plastic particles, etc. Carefully clean with damp materials such as using a clean cloth.

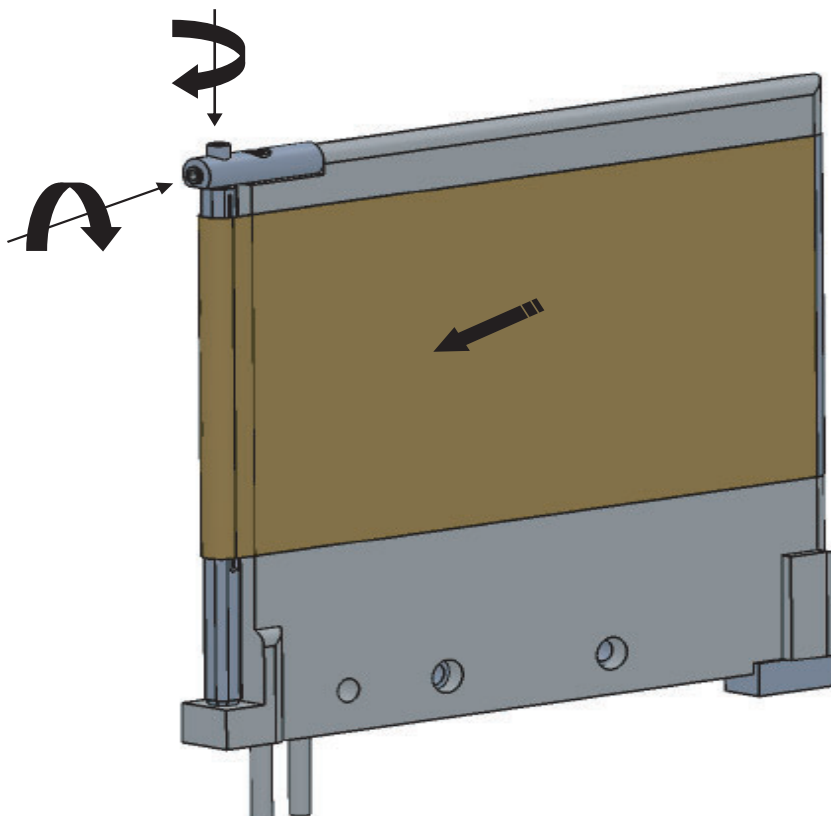
8.1.2. Turn the sartel 0.

**8.2. REZISTANS KONTROLÜ :** Resistance (1) tray (33) is always perpendicular (90 ') connected position. Occasional resistance sure to check out the steepness of. (figure 7)



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**8.3. TEFLON CHANGE:** Remove the chassis cover on the enclosure. Worn Teflon Teflon paper tensioning shaft Remove the screws loosening. New Teflon Cut the dimensions of 160x570mm. stretching Teflon shaft slotted part of the resistance to penetration of wrap. With the help of a screwdriver turn the stretched Teflon connecting pin grub screws and fix with screw ( **Figure 6.**)



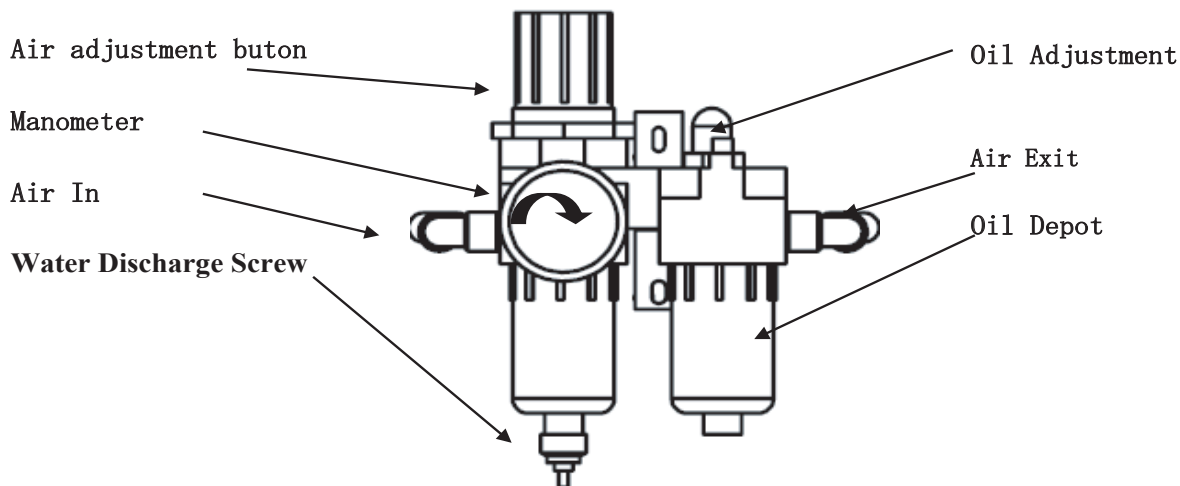
**Figure 6**

## **9. AIR PRESSURE ADJUSTMENT**

Pneumatic systems should be 6-8 bar air pressure to function as healthy. Machine to operate at pressures lower than 6 cups. Conditioner to adjust the air pressure to control and read on the manometer ( **Figure 8**)



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9.1- Increasing the pressure adjustment knob clockwise direction is flipped, rotated in the opposite direction pressure Decrease

9.2- Once you read 6-8 Bar on the manometer, push the adjustment button of the conditioner down and lock it in that position

9.3- The conditioner unit collects the water within the air system in a receptacle in order to prevent damage to the pneumatic system components. Discharge this water periodically (at the end of the working day) by pressing or opening the button under the conditioner.

9.4 The manufacturer recommends to use the following oils with the conditioner: TELLUS C 10 / BP ENERGOL HLP 10/ MOBIL DTE LIGHT / PETROL OFISI SPINDURA 10

9.5 Moving table (16) Note that the pressure is constant at 4 bar. The pressure gauge on the dashboard to turn the setting time of manometer on the panel (79) Fix reading.

9.6 Es masında adhering to the moving table with 6 bar pressure activated valve makes number 6. Allows you to make better resource

9.6 Left press (35) pressure setting valve 3 from the right of the press (36), No. 4 valve set pressure setting. To move parallel to the left and right of the press and at the same time slow the rate of return Ensure that çıkarkenki. Otherwise, damage to the resource.

## **10. MAINTENANCE**

### **10.1. ROUTINE CHECKS**

10.1.1. Before any maintenance or cleaning operation, the emergency stop button must be in the 0 position and the Location of sartel.

For example to enter 1 sec put 10 value.

10.1.2. Affecting the upper table, and use make sure that all materials are clean and dry.



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10.1.3. Blades set on the table before every use and vice wear, warping, cracking and check against breakage. If the blades are damaged or replace damaged blades.

10.1.4. Distribution filters and check the oil level air pressure. If the missing amount of fat which is low. (FIG. 8)

## 10.2. MAINTENANCE AT THE END OF WORKING DAY

10.2.1. Keep running as clean as possible and periodically parts of the Teflon sheet dirt, oil, and be sure to check for corruptions.

10.2.2. Avoid materials that harm the paint cleaning the machine

10.2.3. Periodically check the air setting unit, the system to prevent entry of water into the air, check the oil level distribution.

## 10.3. GENERAL LUBRICATION

10.3.1. The machine is equipped with a special lubricant-free bearings do not require lubrication or greasing. Periodically check the oil level in the conditioner pneumatic system. For the oil to be used.

## 10.4. SPECIAL PRECAUTIONS

10.4.1. Not work beyond a few days in case the machine is non-painted surfaces to prevent oxidation of the grease. Clean layer of fat in case of working again

10.4.2. The machine will stay out of the long-term use;

- sartel position 0
- Close the pneumatic system

## 11. TROUBLESHOOTING GUIDE

### POSSIBLE ERRORS AND REMOVAL

Emergency proposals to eliminate the problems below. If the fault can not be eliminated or encounter a malfunction other than those recommended below, please consult the technical service



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TROUBLES	CAUSES	REMEDY
The resistance does not heat	No power supply to the machine The thermocouple connection wire is displaced. The temperature display needs to be set. Card may be the problem	Check the fuse, plug and socket. Connect the thermocouple wire. Check the temperature display adjustment (245°) Call for Assistance.
The heating plate does not move.	The air pressure is too low. Valve failure Card may be the problem.	Check the air hose connections of the machine. Adjust the air pressure at the conditioner. Replace Valve. Call for Assistance.
Machine does not weld or the welding is not clean.	The profiles were cut in different angles. The Teflon is dirty or torn. Card may be the problem	Check the angles of the profile ends. The saw blade might need to be sharpened. The Teflon should be cleaned or replaced. Call for Assistance.
The heating plate does not move.	Valve failure	Replace Valve.
Energy does the machine.	Güç kaynağı ışığı yanmıyorsa May be a connection error.	Power supply light is not on Insurance, plugs, sockets, etc.. Check that.
One or more of the features that should be running on the machine.	<b>Electronic resource card failure.</b>	<b>Call for Assistance..</b>



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