



## FULLY AUTOMATIC CLIP IRONING MACHINE

### INSTRUCTIONS FOR USE MAINTENANCE AND INSTALLATION

NORTH SPECIAL EQUIPMENT B.V.  
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MODEL: FLORENZIA  
CODE: NEC-1



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# 1. FUNCTION

This machine is used to mechanically press and shape suits and trousers made of wool, synthetic fiber, silk and cotton fabrics according to each part and process.

## Universal ironing machine



### ★★★ Main features of the product

- ☞ After dehydration, ironing can be arranged;
- ☞ Computer program control, programmable control of the ironing process; Parameters can be set as needed to meet different process requirements;
- ☞ Adopting high-quality pneumatic components and reasonable air circuit design, the fully compressed air controls the operation of the ironing machine, without the need for external power supply, ensuring stable, reliable and safe operation.

### ★★★ Main technical parameters

Model	Unit	NEC-1
Table size	mm	1100*360
Electric power	KW	0.3
Power supply voltage	V	220-380
Vapor pressure	Map	04-0.6
Steam consumption	KG/H	18
Overall (L × W × H)	mm	1200*1280*1600
Total Weight	kg	260

\* Due to continuous updates and upgrades of product technology, some parameters may change without further notice. Please confirm the details before purchasing!

## 2.Specification

1	Drive mode	Fully automatic air drive
2	Upper and lower mode heating mode	Steam
3	Steam injection mode	Automatic and manual upper mold, automatic and pedal lower mold
4	Vapor working pressure	0.4~0.5Mpa
5	Compressed air pressure	0.6Mpa
6	Steam consumption	12~17kg
7	Air consumption	15L/T
8	Power pressure	220V
9	External size	1200×1250×1400mm
10	Total weight	260KG

## 3. Structural features of this machine

- frame and actuator and other mechanical system;
- pneumatic transmission system;
- steam heating system;
- vacuum extraction and air cooling system;
- up and down the hot mold;
- electric heating control system;
- H3CT-8H timer setting system;
- the computer LOGO sequence setting system.

The LOGO computer is input by a logic module to perform work. It has strong functions and is easy to operate. The setting time can be modified at any time according to the user's production product requirements to achieve the best effect. The upper and lower ironing molds are composed of steel plates or aluminum molds, which have rapid heat transfer and are pre-heated. The heat is usually ready to work after 15 to 30 minutes. By adjusting the pressure of the pressurized air and the exhaust throttle of the cylinder, you can easily adjust the total pressure of the ironing mold fabric and the opening and closing of the ironing action. The time settings for initial pressure, upper and lower steam injection, hot pressing, and dehumidification and cooling can be selected and controlled through the time controller or LOGO computer to adapt to various fabrics and materials. Iron your suits and trousers to ensure they look crisp and smooth.

## 4.Start-up preparation

### ◆ Hot mold heating:

First close the bypass stop valve at the drain device, close the valve and directly release the water vapor channel, then open the steam inlet stop valve, introduce 0.4~0.5Mpa steam to the upper and lower ironing molds, and heat until the drainage stops (you can carefully open the left side of the machine to Observe the air valve and then close it) and observe the surface of the ironing mold. If there is dripping water, it means that it has not been heated yet. It needs to be heated until steam comes out (generally the preheating time is about 30 minutes). In addition, you can try spraying before starting. To steam, the upper mold can be sprayed by pressing the steam spray control lever by hand, and the lower mold can be sprayed by stepping on the lower right pedal (middle position switch). (But the time should not be too long, generally no more than 2 to 3 seconds).

### ◆ Intake air of compressed air:

Open the compressed air intake valve to flow the compressed air into the ironing machine pneumatic system.

### ◆ Operation and control:

- a. Close the power supply switch.
- b. The initial pressure is generally adjusted at about 0.3~0.4Mpa (refers to the value of the lower side pressure gauge) until the mechanical action is stable. The thermal pressure adjustment is about 0.5~0.6Mpa (refers to the pneumatic pressure).

C.The lowering and resetting speed of the upper mold can be adjusted respectively by adjusting the left and right throttle valve handles at the lower end of the muffler at the outlet of the electromagnetic reversing valve. Turn to the right to slow down, and to the left to speed up.

### ◆ Timing setting:

- a. Set the initial pressure time (generally does not need to be adjusted frequently).
- b. Setting of pressure time (it can be adjusted according to product requirements).
- c. Setting of steam injection time (it can be adjusted appropriately according to the requirements of the product).
- d. Setting of the wet cooling time (it can be adjusted according to the requirements of the product).

## 5.operation

Place the ironing fabric in the working position of the lower ironing mold. After stepping on the left lower footboard, the lower ironing mold will immediately dehumidify and absorb the object to be ironed. After it is flattened, press the "Start" button on the operation panel, and the upper mold will be pressed down. Then the fully automatic ironing cycle starts (the dehumidification pedal should be released immediately when the upper and lower molds are closed). When the ironing process ends, the upper ironing mold automatically resets and the next cycle of ironing operation can be continued.

## 6. Matters needing attention after the end of the work

When the day is done, do the following:

- (1) Cut off the power supply switch.
- (2) Close the compressed air intake valve.
- (3) Close the steam intake valve.
- (4) Finally, open the bypass valve at the drain device.

## 7.Maintenance

### 1. Air regulation

#### ● air filter

The air filter plays a filtration role. If water accumulates in the device, you can turn the small handle at the bottom of the device to drain it. The location can drain water outwards.

#### ● b.pressure regulating valve

Rotate the handle to adjust the air pressure entering the cylinder. After adjustment, it must be tightened nut.

#### ● c. Oil mist apparatus

**1. The function of the oil mist is to atomize the lubricating oil and inject it into the compressed air flow.**

The function of the oil mist device is to atomize the lubricating oil and inject it into the compressed air flow to lubricate the reversing valve and the cylinder. Put spindle oil into the device. When replenishing oil into the device, first close the compressed air inlet valve, and then filter the air. Open the water drain cock at the bottom of the device to completely let out the air, and then unscrew the filling plug of the lubricator to replenish oil inward. Add oil to 80%. When adjusting the lubricator, you only need to rotate the upper knob. The oil output of the small cylinder lubricator is.

It is advisable to add one drop for each action. For the oil mist in the cylinder, add one drop for every three actions should.

## **2. Refueling and lubrication**

In order to keep the machine running normally and extend its service life, the connecting rod and other rotating parts must be regularly lubricated with oil.

## **3. Air and steam pressure**

The maximum air pressure is 0.6Mpa and the maximum steam pressure is 0.6Mpa. They cannot be used under overpressure.

## **4. Other**

steam trap

When the steam passes through the upper and lower molds, a certain amount of condensed water will be generated, which will be discharged by the steam trap. It can save steam without causing the accumulation of condensed water.

# **8. Installation method**

**Hot machine setting should fully meet the following conditions:**

- The ironing machine should be kept as close to the boiler and vacuum pump as possible to improve the use efficiency.
- The distance between the ironing machine should be more than 30cm, and the distance near the wall should be more than 90cm, so as to facilitate the maintenance of equipment.
- The foundation should be concrete, and then fixed with foot screws.

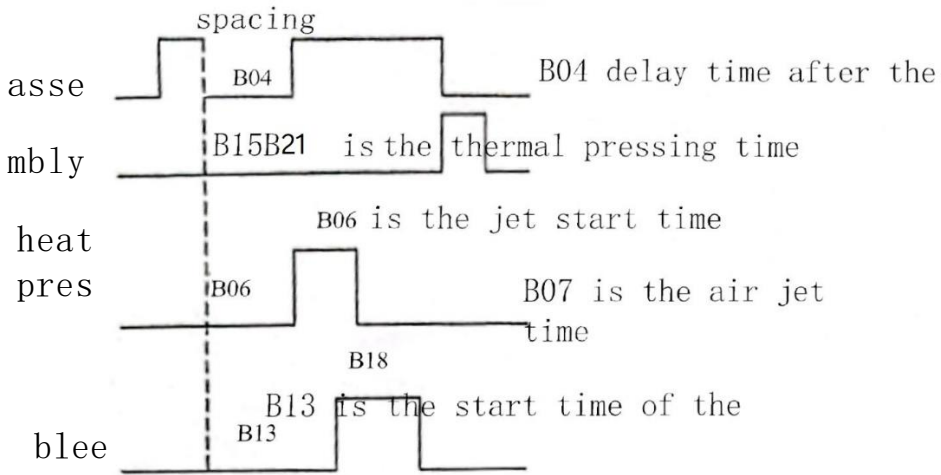
## 9.Pneumatic schematic diagram (attached drawing)

## 10.Schematic diagram of electrical appliance (attached drawing)

### List of electromechanical control components for automatic single cylinder ironing

number	name	quantity	specifications and models	Action function
1	On the jet cylinder	1	φ 3510 High-temperature resistance	Control the upper die injection
2	Urgent stop limit switch	2	D4MC-500	Emergency stop work, emergency reset on the mold.
3	Sequential work order limit position	1	D4D-212N	Give the computer work instructions.
4	button switch	3	The LAY 1 series	Red button emergency stop work, two green button press at the same time, hot machine start work
5	Air pump cylinder	1	φ 3236 high temperature	The lower mold is wet
6	Two-position five-position ventilation control valve	1		Hot die mold and open die cylinder control
7	foot pedal	2 Or 3		Left control pumping, middle control spray, right control hot machine work start
8	working cylinder	1	φ100×165	Function ironing machine close mold and open mold
9	priority valve	Group 2	The φ 23 D-1.8 type	Control the pumping work and the spraying work
10	buffer	1		Smooth ironing machine work

## Single cylinder ironing motor for the sequence diagram



### Computer-OBA 4 type time sets the operation order

1. Press the ESC " key
2. Press ▼ or ▲ to Set p aram
3. Press the OK key
4. Press "▼" or "▲" key to find the desired modified function block number, such as: BXX.T.
5. Press OK to confirm that the "■" flash appears
6. Press "▼" or "▲" key to move the "■" mark to change
7. "■" to your confirmation time
8. Press the word " OK, key, and confirm
9. Press the "ESC" key twice, and the computer LOGO can enter the normal working computer-

### LOGO OBA 4 type

