

QUALITY
PRACTIX
MFG. - U.S.A.
THROUGH INNOVATION

**4400 Cantrell Road
Acworth, Georgia 30101
Phone: (770) 974-1480
Fax: (770) 974-1584**

Practix OK-160

**PLATEN PRESS
42" x 66"**

Operations Manual

Serial No. _____

Voltage: _____

Purchaser: _____

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WARRANTY

Practix Mfg. LLC will replace free of charge, F. O. B. Purchaser's plant, within 365 days (1 year) from time of shipment to the original purchaser, any mechanical part, within six (6) months any electronic component, and within six months (6) on a prorated basis any belt found in our judgment to be defective. This Warranty is based on an eight (8) hour per day work/operating schedule.

This Warranty does not cover damage to the Machine or any part thereof found in our judgment to be the result of accident, negligence, or misuse. This warranty shall become ineffective if the product or component is altered by anyone other than Practix employees. Damage incurred in shipment should be reported to the designated carrier. It is his responsibility to ensure arrival in perfect condition.

This Warranty covers only labor and material. Expenses will be charged at cost. This warranty does not include installation of the product or component.

This Warranty is registered in the name of the original Purchaser and is non-transferable.

Practix Mfg. LLC will, in no case and under no circumstances, be liable for special or consequential damages, loss of profit or commission or for loss or delay in production.

Warranty will be non-redeemable if the balance on the Purchaser's account for the product is delinquent.

I have received and read this manual.

Signature

PRACTIX MFG.
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Mechanical Warranty Begins _____ **through** _____

Electrical Warranty Begins _____ **through** _____

WARNING!

At no time during the operation of the machine should any beverages or liquids be placed anywhere on the top of the Machinery to prevent injury from electric shock.

It is the responsibility of the Purchaser of this Machinery to train his personnel in the proper manner of operation.

It is further understood that Practix Mfg. assumes no responsibility for injuries, disabilities, or death resulting from the improper operation of, removal from the Machinery, or bypassing of any electrical or mechanical safety devices incorporated in the design and manufacture of this Machinery.

NOTE: During the first few hours of operation the Machinery will release fumes due to the normal curing of coating materials.

**PRACTIX MFG.
4400 Cantrell Road
Acworth, GA 30101**

We at Practix Mfg. appreciate your purchase of our product. Your new machine is built to perform flawlessly for years to come.

This Operations Manual should be referred to for the installation, operation, and maintenance of this machine. Regular maintenance will ensure a long and trouble-free service life.

Design and development of Practix Machines are subject to constant improvement. There is no obligation on our part to carry out improvements, free of charge, on machines already delivered.

For further questions concerning machine maintenance, call:

PRACTIX MFG.
4400 Cantrell/Practix Mfg.
Acworth, GA. 30101
TEL (770) 974-1480
FAX (770) 974-1584

INSTALLATION

Position the machine on a solid, level section of the floor before removing it from the skid.

NOTE: Leave sufficient clearance around the machine for material movement and maintenance personnel.

1. The electrical connections should be made by a certified electrician in accordance with local standards and electrical codes for 220/240 Volt-1 Phase or 3 Phase industrial equipment.
2. Bring the power supply to the wall adjacent to the machine. Install a breaker.
3. Run wire from the wall to the junction box on the side of the machine. Connect the wire to the power distribution block locating inside the junction box.
4. Bring air supply to the machine using hose or pipe. Airline must be a minimum 1/2" I.D. to achieve proper pressure and fast filling of cylinder. No quick disconnect.

In case of problems or questions, please contact Practix Mfg.

Leveling and Squaring

1. Use a spirit level.
2. Place the level first on the top of the lower platen across the longer side of the platen. Adjust the legs as necessary.
3. Place the level on the top of the lower platen across the shorter side of the platen. Adjust the legs as necessary.

OPERATION

To energize the machine, move the toggle switch on the control panel marked MAIN SWITCH to the “ON” position. Make sure to turn on the compressed air to the machine. Make sure the emergency stop buttons are pulled out all the way.

Adjust the pressure regulator on the side of the control panel box marked PRESSURE.

To heat the top platen, set the temperature on the controller to the desired temperature. Wait for the machine to reach the correct temperature.

NOTE: ***FOR MORE DETAILED INSTRUCTION ON THE TEMPERATURE CONTROLLER, SEE THE TEMPERATURE CONTROLLER SECTION IN THE BACK OF THIS MANUAL.***

When the machine reaches full temperature, the temperature controller indicator light will cycle on and off to maintain the desired temperature. If the heaters or temperature controllers do not energize properly consult the TROUBLESHOOTING section. After the machine has reached full temperature, it is ready to be used for production.

Set the desired time on the timer. **The mode selector must be either “A” or “B” for proper functionality.**

To activate the pressing cycle, depress both of the green start buttons simultaneously. Both green start buttons must be depressed until the bottom platen completely rises up to meet the top heater. Only then will the pressing cycle activate.

This machine has current display panel meters. The current draw of each platen is displayed on the corresponding panel meter. The current is only displayed when the output from the corresponding temperature controller is on.

HEATER STRIP REPLACEMENT TOP HEATER PLATEN

- 1. DISCONNECT POWER FROM THE MACHINE!!**
- 2. DISCONNECT AIR SUPPLY FROM THE MACHINE!!**
3. Remove the access plate from the upper part of the c-frame above the heater platen.
4. Remove the eight (8) knob nuts attaching the heater cover to the c-frame. Remove the screws from the side using a Phillips head screw driver.



5. Remove the heater cover from the heater platen. Use care when removing the cover so that the wires are not damaged.
6. To remove a heater, loosen the hold down brackets on and around the heater.
7. Disconnect the wires, slide out the old heater, and replace it with a new heater of the same type. **When replacing the wires, make sure to hold the lower jam nut on each terminal post as the upper jam nut is tightened on the terminal.**
8. Replace everything using the reverse of the above procedure.

HEATER STRIP REPLACEMENT BOTTOM HEATER PLATEN (IF EQUIPPED)

- 1. DISCONNECT POWER FROM THE MACHINE!!**
- 2. DISCONNECT AIR SUPPLY FROM THE MACHINE!!**
3. Remove the cover plate from the junction box below the lower heater platen on the right side of the machine.
4. Remove the tray wires from their pulleys.
5. Slide the trays forward to provide access to the heater platens.
6. Remove the eight (8) knob nuts attaching the heater cover to the bottom pressure frame.
7. Remove the outside cover from the heater platen. Use care when removing the cover so that the wires are not damaged.
8. To remove a heater, loosen the hold down brackets on and around the heater.
9. Disconnect the wires, slide out the old heater, and replace it with a new heater of the same type. **When replacing the wires, make sure to hold the lower jam nut on each terminal post as the upper jam nut is tightened on the terminal.**
10. Replace everything using the reverse of the above procedure.

MAINTENANCE

NOTE: We recommend a regular maintenance plan as outlined below. These maintenance points are considered a very minimum. Additional maintenance is left to the Owner's discretion.

1. Daily Maintenance

Cleaning: Vacuum or blow off any visible dust and lint.

2. Weekly Maintenance

- Cleaning
- Clean any buildup off the heater platen and bottom rubber pad.
- Remove any visible accumulation of dust, lint, or resin.

3. Monthly Maintenance

- Cleaning
- Remove thread and lint deposits.
- Remove dust and lint accumulation from pivot points.
- Place grease onto spring guide bolts for bottom buck.

TROUBLESHOOTING

This section is provided for the identification and repairs of items considered as field serviceable and are part of the maintenance of any machine. Problems falling outside the areas covered in the Manual should be first isolated as far as possible, then repaired only after consultation with your Deal or our service department.

<u>Problem</u>	<u>Checklist</u>
Main controls fail to energize	A. Electrical power supply B. Control Fuses C. Incomplete circuit D. Check emergency stops to see if they are fully extended
Heaters fail to energize with Main controls energized	A. Main fuses B. Contactor C. Thermocouple probe D. Temperature controller E. Incomplete circuit
Heaters energize but fail to Come up to temperature	A. Incorrect line voltage B. Thermocouple probe C. Temperature controller faulty D. Temperature controller calibration off E. Heater element F. Incomplete circuit G. Check fuses

OMRON E5GN

To Set Temperature Desired on the Controller

Depress up or down arrow keys. Setpoint temperature is in the lower right corner.

To Recalibrate Controller (i.e. controller display temperature is different than actual temperature).

Press  (gray button) once. AT OFF is displayed

Press  until in5 is displayed. Input value of the difference with up and down arrow keys.

Press  once to return to display temperature.

To Tune Controllers

Press  once. AT OFF is displayed.

Press up arrow once. AT ON is displayed. Allow machine to run. Will take 10 minutes to 1 hour.

AT OFF is displayed when the controller is finished.

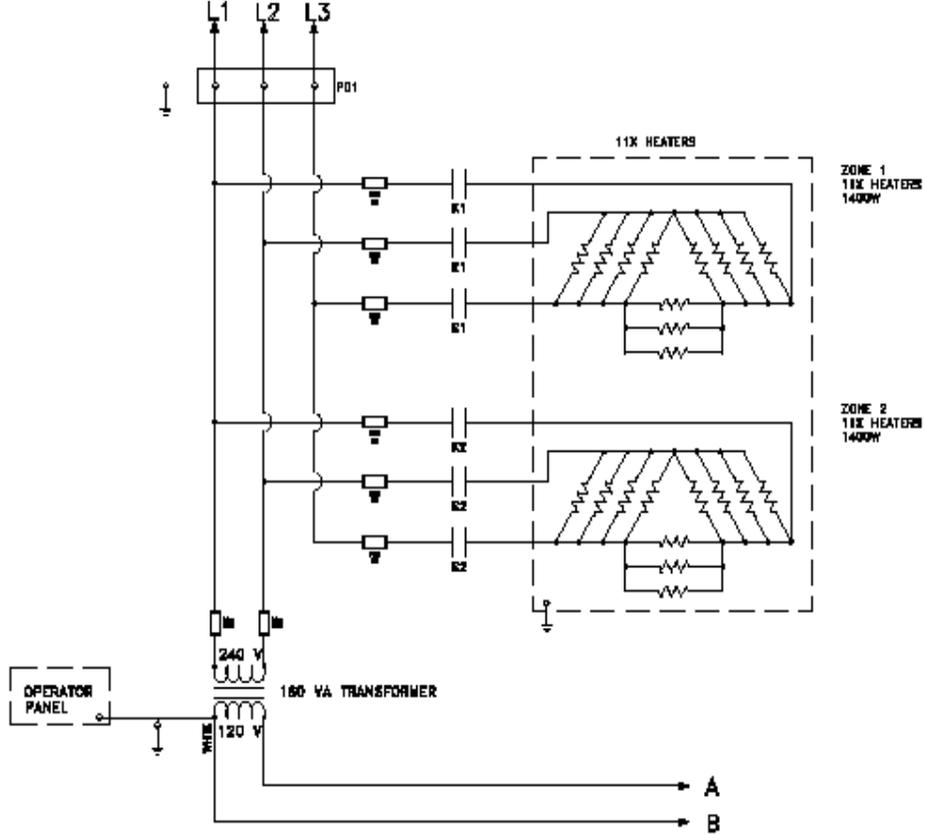
Press  once to return to display temperature.

PARTS LIST

OK-160

Item ID	Item Description	Qty Per Machine
. 10-110	Air bag 18.1dia 1conv. 1/4NPT	2.00
. 10-300	Filter Reg AW20 nut & bracket	1.00
. 10-401	Solenoid Valve 225	1.00
. 10-601	QE2 Quick Exhaust Valve	1.00
. 20-106	Temperature Controller RTC	2.00
. 20-200	Omron Timer	1.00
. 20-312b	Contactora 40A 3 Pole 120V	2.00
. 20-2204a	Circuit Breaker 40A, 3 pole	2.00
. 20-405	Transformer 150VA 1 Phase	1.00
. 20-506b	Mini Relay DPDT 120VAC 56.32	1.00
. 20-516	Relay Base Mini DPDT 96.72	1.00
. 20-600f	Limit Switch SPDT roller	1.00
. 20-605	Limit switch cover	1.00
. 20-741	ON/OFF Toggle Switch	1.00
. 20-814	Mushroom E Stop GE	2.00
. 20-815	Round Legend E-Stop	2.00
. 20-816	Start Button	2.00
. 20-903	Fuse Block 30A 250V 2 Pole	1.00
. 20-1402a	Hi Temp Wire 10 AWG	20.00
. 20-1409b	Thermocouple Wire 20 awg	0.12
. 20-1419	Thermocouple sleeve #0 .330	12.00
. 20-1429b	10 awg black 600 VAC Wire	3.00
. 20-2503	Terminal Block	11.00
. 20-2181	Watrod Form 41.5" long	22.00
. 20-2500	End stop for terminal block	2.00
. 20-3100	N.C. Contact Block GE Stop	2.00
. 20-3101	N.O. Contact Block GE	2.00
. 30-1310	40" 500# Full extension slide	2.00
. 50-208	Woven Cover 43" Fin x 52" Fin	1.00
. 50-306d	Flannel Cover 42" x 66"	1.00
. 50-906	Gray Foam Rubber 42" x 66"	1.00

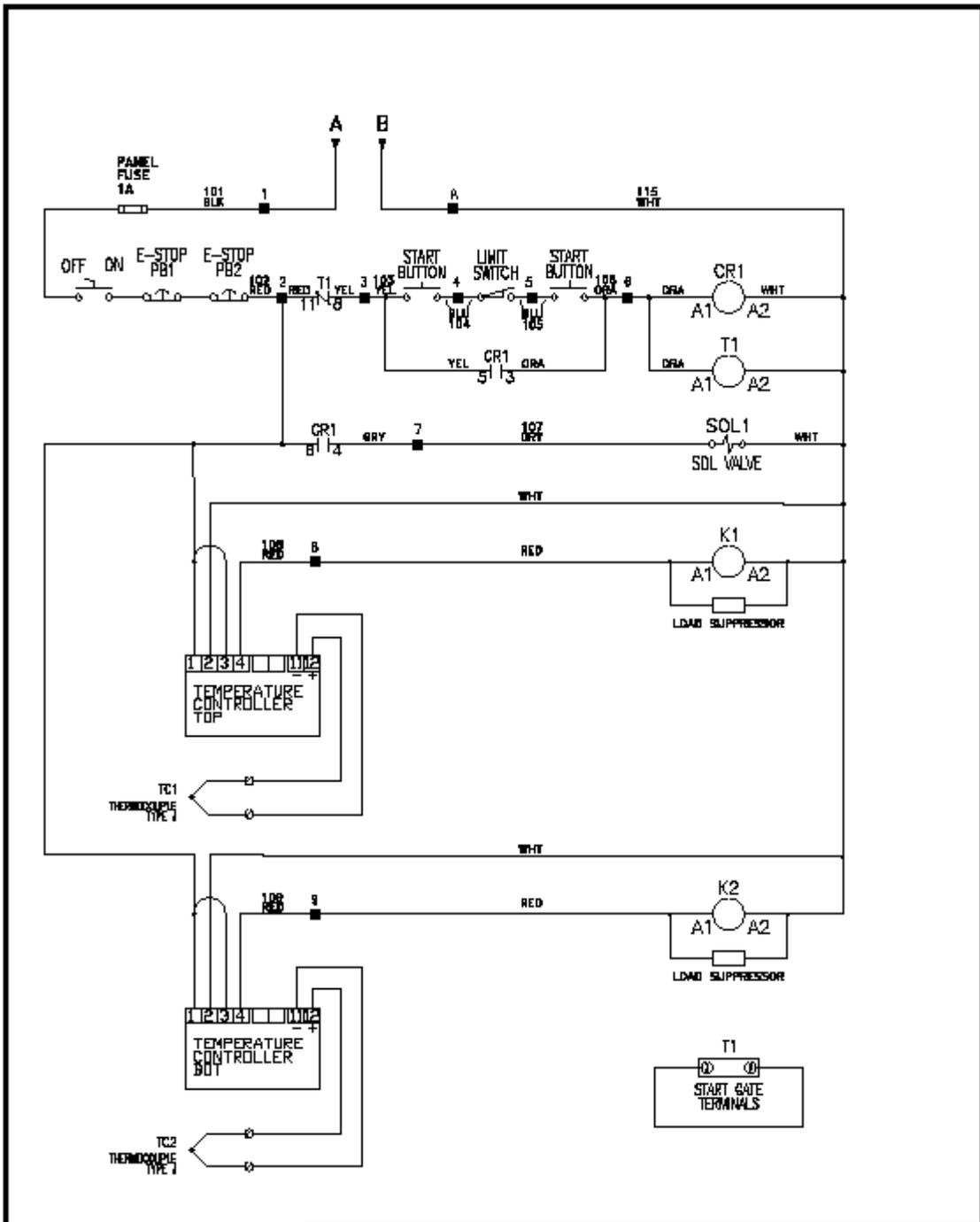
240 VAC 3 PHASE 60 HERTZ



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MFG. - U.S.A.

4400 Cantrell Road
Lawville, GA 30101
770 974 1400

PRACTIX OK-160 42X86
DWG. OK-160 EL1
Drawn By: RF/BAM
Date: 23. JAN 2015



	4400 Cantrell Road Aurora, GA 30101 770 974 1400	PRACTIX OK-160 42X66 DWG. OK-160 EL1 Drawn By: RP/BAM Date: 23. JAN 2015
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DIMENSIONS

