

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

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Practix OK-25

SWING AWAY PLATEN

20" x 25"

Dual Station Heat Transfer Press

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.

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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.

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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.

If you need to procure parts or services for you machinery please contact us:

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INSTALLATION

1. Place the machine on a level section of table.
2. Connect the press to a power supply outlet rated for 240 VAC 20Amps. The machine fuses are located in the rear control box.
3. Connect the air supply. The airline going to the machine should be a minimum of 1/2" diameter to achieve proper pressure on the machine and fast filling of the cylinder.
4. Adjust the air pressure regulator as required, however, not more than 120 psig.
5. To turn the machine on, turn the main disconnect switch on the rear electrical box to the ON position. Next, flip the main toggle switch on the upper control panel to the ON position.
6. Set the temperature controllers to the desired temperature. The heat platens will take approximately 15 minutes to reach the correct temperature. With the temperature at setpoint, the LED at the controller will go off, indicating the platen is ready to be used. To operate the lower platen, turn on the respective toggle switch on the control panel. (For more instructions on operation of the temperature controller, see the temperature controller instructions at the end of this manual).
7. Set the timer for the dwell time required. The mode button must be set to either an "A" or a "B".
8. Start the cycle by depressing both green start buttons simultaneously. The top heater must be in position above the lower heater platen in order for the cylinder to activate.

HEATER STRIP REPLACEMENT

DISCONNECT THE POWER TO THE MACHINE BEFORE BEGINNING THIS PROCEDURE!!

1. Remove the six bolts attaching the heater platen to the black mounting bracket.
2. Remove the wires from inside the control box.
3. Remove the rear riser block from the heater platen.
4. Disconnect the power wires going to the heater platen from the terminal posts on the heater. Also, disconnect the thermocouple wire from the heater platen.
5. Exchange the entire heater platen with a new platen from Practix Mfg. Use the reverse of the above instructions to install the new heater platen.

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

A. Cleaning

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

3. Monthly Maintenance

A. Cleaning

- Remove thread and lint deposits.
- Remove dust and lint accumulation from pivot points
- Grease fittings with Hi-Temp grease

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
Heaters fail to energize with Main controls energized	A. Main fuses B. Power Relay C. Thermocouple probe D. Temperature controller E. Incomplete circuit
Heaters energize but fails 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

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.