

Practix OK-06

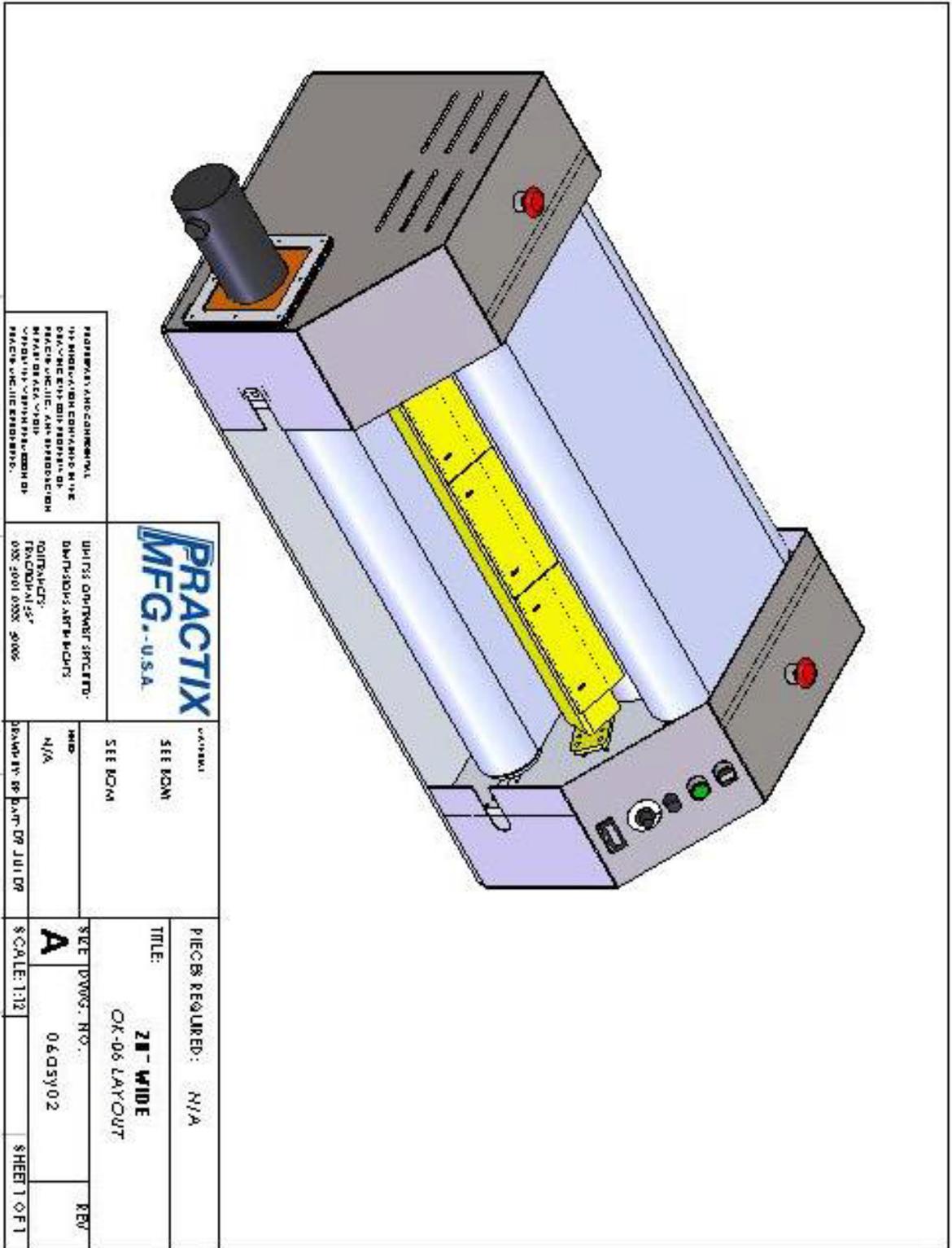
**6" Dia Drum
Rotary Transfer Printer
Dye Heat Set Machine**

Operations Manual

Serial No. _____

Voltage: _____

Purchaser: _____



PROPRIETARY AND CONFIDENTIAL
 THIS DRAWING CONTAINS THE
 TRADE SECRETS AND PROPRIETARY
 INFORMATION OF PRACTIX MFG. U.S.A.
 ANY REPRODUCTION OR
 DISSEMINATION OF THIS
 DRAWING WITHOUT THE WRITTEN
 PERMISSION OF PRACTIX MFG. U.S.A.
 IS STRICTLY PROHIBITED.

UNITS: DIMENSIONS ARE IN
 INCHES
 DIMENSIONS ARE IN
 MILLIMETERS
 PRACTIX MFG. U.S.A.
 2000 2000 2000 2000



UNITS	SEE ROW
NO. OF PARTS	SEE ROW
NO. OF PARTS	SEE ROW

PIECES REQUIRED:	N/A
TITLE:	21" WIDE OK-06 LAYOUT
SEE DWG. NO.	0605Y02
SCALE:	1:12
SHEET	1 OF 1

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 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.

**PRACTIX MFG.
4400 Cantrell Road
Acworth, GA 30101
Phone: (770) 974-1480
Fax: (770) 974-1584**

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
(770) 974-1480

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 and unwind and rewind units (if applicable) for material movement and maintenance personnel.

1. The electrical connections be made by a certified electrician in accordance with local standards and electrical codes for 240 Volt- 1 Phase industrial equipment
2. Bring the power supply to the wall adjacent to the machine. Install a breaker.
3. Connect to the power cord of the machine to the disconnect switch either directly or through a disconnect plug..
4. This machine **does not** require compressed air supply.

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

Leveling and squaring

1. Place this machine on a table with a load capacity of at least 350 lbs!!!
2. Use a spirit level. Adjust the table so that it is level. An unlevel table will cause the belt to track incorrectly!!

Operation

To energize the rotary transfer machine, move the switch marked MAIN SWITCH to the "RUN" position. The belt will start to move!

Set the motor speed control to the desired speed. To test your transfer printing dwell time, run a blank piece of paper through the machine and time the paper when it goes to the pinch point and comes out.

The machine has a guide channel that will keep the belt centered on the machine only after the belt is adjusted manually in the center.

If the belt fails to track, adjust the front tension roller accordingly. The belt will move to the looser side. Turn the knob clockwise to tighten the respective side. The belt will move over very slowly due to the machine rotational speed being very low. Turn the knob in 1 turn increments every ½ to 1 hour.

To heat the belt and drum, set the speed control to low speed setting. This will facilitate the heating of the drum quicker. The temperature controller should activate as soon as the machine is turned on. This machine is equipped with high technology solid state temperature control. The temperature controller has been "tuned" for your specific machine to give the best-controlled temperature allowable on the machine. To set the temperature on the machine, press up or down arrows to adjust the set point temperature in the lower right corner. The amber indicator light "OUT" on the temperature controller will turn on when the heaters are energized and stay on until the machine reaches its full 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 printing.

FIRST RUN

1. Run the machine cold.
2. Check the belt tracking.
3. Check speed regulation.
4. Turn on the heat and check the same functions.
5. If the machine is not functioning properly turn it off. Check the TROUBLESHOOTING section or the TRACKING section. If the problem cannot be corrected call Practix Mfg.

OPERATIONAL TESTING

The variety of speeds available with the OK-06 offers a higher production potential. The drum speed should be adapted to the lay-up rate. Temperature and belt speed settings must be varied in proportion to obtain the proper printing quality. Although most print papers come with manufacturer's suggested printing specifications, a higher production rate and a more consistent product is usually obtainable by thorough testing.

A digital thermometer is designed to give an accurate reading of actual temperature on the drum. If there is a discrepancy between the actual drum temperature and the temperature controller shown temperature, then refer to the Temperature Controller Section of this manual. Temp Strips are also designed to provide a temperature test.

Suggested Digital Thermometer with Bow Probe

Practix Model No. 3879K83 (Digital Thermometer)

Practix Model No. 3863K91 (Bow Probe)

Temp Strips Selection Chart

Type	Temperature Range (°C)	Order NO.
0	41-104	30/520SQ
1	104-143	30/521SQ
2	143-182	30/522SQ
3	182-224	30/523SQ
4	224-260	30/524SQ

SHUTTING OFF THE MACHINE

At the end of each working day when the machine is to be turned off it should be run through a 30 minute cool down with the speed at a high setting. To do this, move the MAIN SWITCH to the "COOL DOWN" position.

It is not necessary to move any other controls. With the switch in the "COOL DOWN" position the heaters are automatically de-energized with all remaining functions preserved. When the timer runs out, the machine will shut itself off completely. To restart the machine move the MAIN SWITCH to the "ON" position.

Belt Replacement

Nomex Belt

1. Disconnect the power to the machine.
2. Make sure the Nomex belt tension is off. After this is done, remove the lock bolt from the tracking roller torsion arms.
3. Due to the weight of the rollers, the next few procedures will require the use of two or more people. Lifting both sides evenly, lift the tracking roller from its rests and slide it out of the machine.
4. Next slide the top front idler roller out of its bearing housings.
5. Remove the lower front main idler roller from the bottom of the belt. This will require removal of the bearing housings.

Install the replacement belt using the reversal of this procedure. Then read the Tracking Section of this manual to find out how to set the belt for the best results.

Heater Rod Replacement

This procedure can be extremely dangerous. Use extreme caution!

1. Remove the side covers from the machine.
2. With a 3/8" or 10 mm wrench, disconnect the wire from both ends of the heater.
3. To remove a heater, the two set collars on the heater must also be removed.
4. Slide out the old heater and replace it with a new heater of the same type.
5. Replace the wires with new wires as they were previously.
6. Replace everything using the reverse of the above procedure.
7. BE SURE TO ONLY TIGHTEN THE HEATER IN THE SAME LOCATION AS PREVIOUSLY IE DISTANCE FROM THE WALL. One side of the heater must be fixed and the other must be able to expand freely.
8. Replace all covers onto the machine and test the machine for proper operation.

Tracking System

The belt is adjusted using the two tension knobs on the front lower roller.

If the belt is tracking over to the right side, turn the knob on the right side one $\frac{1}{2}$ turn clockwise and wait. As the machine rotates, the belt will move over slightly. Do only one $\frac{1}{2}$ turn at a time. The belt reacts **very slowly** due to the belt speed. Make adjustments in $\frac{1}{2}$ hour to 1 hour intervals.

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 scraper and rollers.
Remove any visible accumulation of dust, lint, or resin.
- B. Spot-check electrical and mechanical components.
- C. Lubrication Lubricate the idler sprockets on both sides of the input conveyor.

3. Monthly Maintenance

- A. Cleaning Remove thread and lint deposits
Remove dust and lint accumulation from pivot points.
- B. Lubrication Lubricate bearings with fittings using Hi-Temp grease. All other bearings are greased for life.
Lubricate drive chain.
Lubricate all roller slide guides with fittings using Hi-Temp grease.

Belt Maintenance

Main Belt

1. Ink buildup on the Nomex belt should be avoided if possible since it may print back onto the fabric. Blotting paper should be positioned through the machine so that no printback occurs onto the nomex belt.
2. If the Nomex belt becomes worn or damaged, replacement may be necessary. Read the Belt Replacement section in this manual before attempting to change the belts.

Troubleshooting

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

<u>Problem</u>	<u>Check List</u>
1. Main controls fail to energize	<ul style="list-style-type: none"> a. Electrical power supply b. Control fuses c. Incomplete circuit
2. Heaters fail to energize with main controls energized	<ul style="list-style-type: none"> a. main fuses b. Contactor c. Thermocouple probe d. Temperature controller e. Incomplete circuit
3. Heaters energize but fail to come up to temperature	<ul style="list-style-type: none"> a. Incorrect line voltage b. Thermocouple probe c. Temperature controller faulty d. Temperature controller calibration off e. Heater element f. Incomplete circuit
4. Incomplete Circuit	<ul style="list-style-type: none"> a. Drive motor fails to energize b. Motor power supply c. Motor speed setting d. Motor console fuse e. Motor
5. Belt fails to move with motor energized	<ul style="list-style-type: none"> a. Tension roller fails b. Chain drive
6. Belt fails to track properly	<ul style="list-style-type: none"> a. Fuse b. Squaring of machine is off c. Leveling inadequate

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.