Table of contents

1. INTENDED USE

This machine has been developed, designed and built for industrial and commercial use only.

The double leg pressing machine serves the simultaneous pressing of both trouser legs by means of applying steam and pressure followed by a cooling phase after the trousers have been completed.

Note

The machine is intended for the working of textiles only. The manufacturer shall not assume any responsibility for modifications and changes which are not stated in the declaration of conformity.

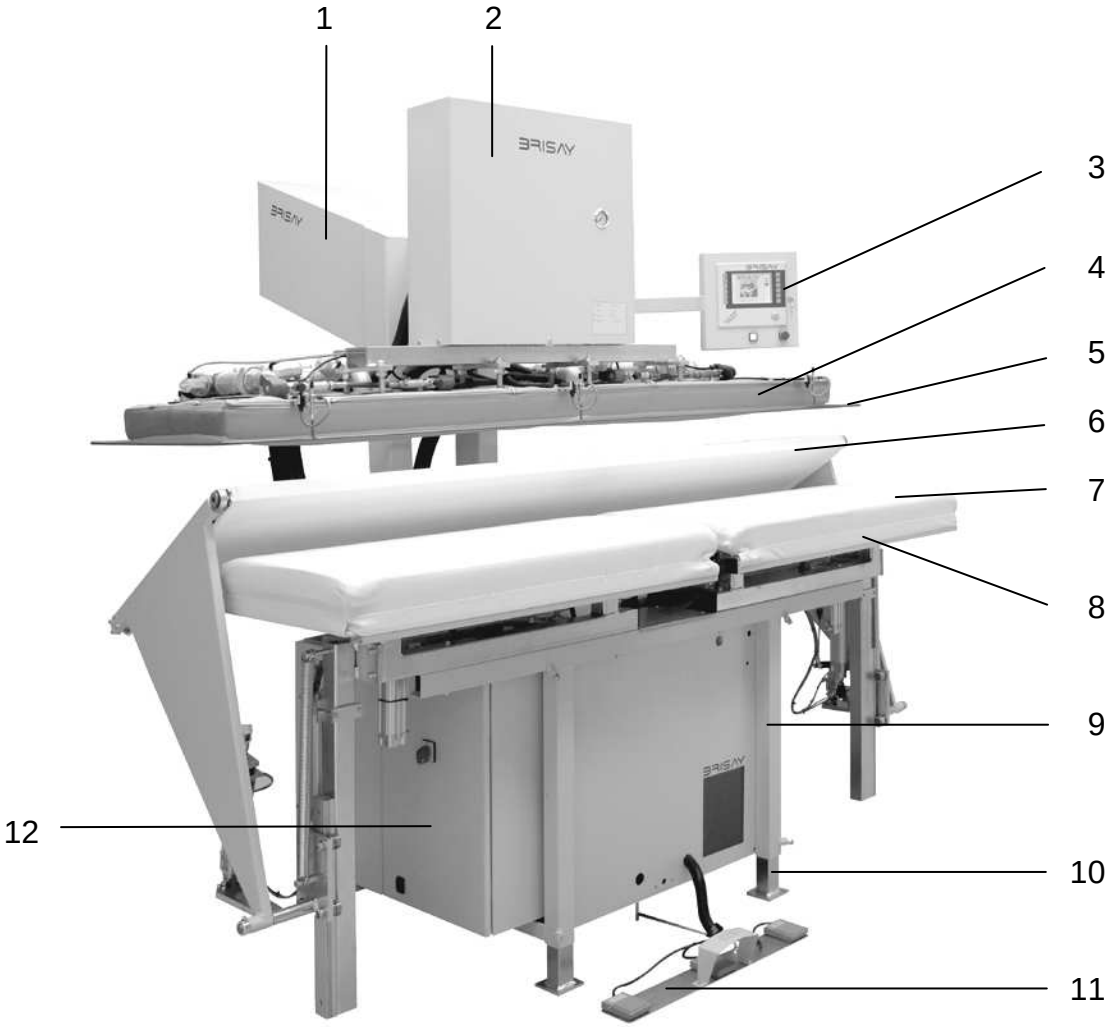
If the place of installation does not comply with the intended use, rebuilding measures must be taken to obtain a higher level of protection (see chapter 1.3, Technical data).

This machine serves the above-mentioned purpose only. Any other or further use as well as any rebuilding or retrofitting of the machine without the written consent of the manufacturer will be considered as non-compliance with the intended use. The manufacturer shall not be liable for damages caused by such use. The user alone bears the risk.

This also applies to the installation and setting-up of safety equipment and valves as well as to any changes in the supporting parts of the machine.

The intended use also comprises the observance of operating instructions and compliance with the inspection and maintenance intervals prescribed by BRISAY.

1.1. DESCRIPTION OF THE MACHINE



Ill. 1, Description of the machine

The machine is composed of the following subassemblies:

1 Linear travelling frame
2 Guiding unit head buck
3 Control panel with machine control BRIfashion
4 Head buck
5 Safety frame
6 Stretching device with holding down function (option)
7 Lower bucks
8 Stretching device lower bucks
9 Ground frame
10 Machine mounting pad
11 Pedal strip
12 Switch cabinet
13 Stretching device head buck (option, not visible)

1.2. FUNCTION

The double leg pressing machine serves the simultaneous pressing of both trouser legs by means of applying steam and pressure followed by a cooling phase after the trousers have been completed.

All the machine's movements are electro pneumatic. The edge suction extracts the steam outside of the pressing surface. The process cycle is controlled by the machine control.

Operating procedure:

- The garment has to be inserted and aligned by the operator. The garment is fixed on the lower bucks by activating the suction.
- Laser positioning lights (option) may be used to position the garment on the lower bucks.
- After having started the operating cycle, the stretching device head buck (option) or the stretching device with holding-down function (option) is lowered mechanically onto the garment.
- Once the head bucks are closed, the suction switches off.
- The steam supply is switched on. Steam is admitted to the garment via steam exhaust ports in the head buck or the activated lower bucks.
- The stretching device is activated if necessary.
- Once the pressing cycle is completed, the head buck is raised.
- Due to the subsequent suction of the lower bucks and head buck, the temperature of the garment is lowered and the pressing result is fixed. As an option, a fine suction may be activated on the lower bucks (option) or the suction may be supported by aeration (option).
- The garment is removed by the operator. As an option, the stretching device with holding-down function is opened before the removal of the garment.
- A light scanner is installed to recognise the garment and to prevent the lower stretching device from moving back before the garment is removed.
- The steam iron with mounting set (option) is intended for manual refinishing.

1.3. TECHNICAL DATA

Product-related data

Note

The machine is intended for the working of textiles only. The manufacturer will not assume any responsibility for modifications and changes which are not stated in the declaration of conformity.

Dimensions and weight of the machine

Breadth:	2260 mm
Depth:	1945 mm
Height:	2200 mm
Weight:	ca. 820 kg

Power supply

Input voltage:	230 V 1P / N / PE
Power:	0,4 kW
Frequency:	50 / 60 Hz
Control voltage:	24 V DC
Protection category:	IP 43

Compressed-air supply

Connected load:	6 bar / 0,6 MPa
Consumption:	92 l / min
Connection (1x):	8 x 1,25 mm

Steam supply

Connection load:	4,5 - 6 bar / 0,45 - 0,6 MPa
Consumption:	32 kg / h
Connection (2x):	1/2“

Suction

Connection load:	min. 120 mbar / 0,012 MPa
Consumption:	7200 l / min
Connection (2x):	1 1/2“

Condensate

Connected load:	max. 0,5 bar / 0,05 MPa
Connection (2x):	3/8“

General data

Ambient temperature:	+ 5℃ bis + 45℃
Noise level:	≤ 70 dB (A)

1.4. SCOPE OF DELIVERY

The delivery comprises:

1. Double leg pressing machine
   - BRI-222 / 101 standard design or
   - BRI-222 / 201 with additional oil heating system:

     Standard:
     - Steam head and lower bucks
     - Suction head buck
     - Separate suction for right and left lower buck
     - Edge suction head and lower bucks
     - Stretching device lower bucks

     Options:
     - Stretching device head buck
     - Stretching device head buck with holding down function
     - Fine suction lower bucks
     - Aeration
     - Steam iron with mounting set
     - Positioning lights

2. Operating instructions

3. Documentation

Note

These operating instructions cover the maximum scope of delivery.

The individual delivery is detailed in the purchase contract.

Accessory device for the transport of the garment:
- conveyor belt BRI-33
- belt extension BRI-33
  (see separate operating instructions)

The additional oil heating system is described in separate operating instructions provided by the manufacturer.

2. SAFETY

2.1. WARNING SYMBOLS AND DANGER SIGNS

On the machine and in these operating instructions, the following designations or symbols are used for particularly important information:

Reference to external **operating instructions**

Danger symbol for the prevention of accidents and damages

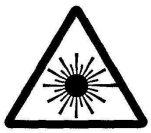
Note

Request to **pay particular attention**

Symbol indicating **danger due to electric current!**

Symbol indicating danger of **hand injuries!**

Symbol indicating **danger of burn** due to hot surfaces!



Symbol indicating **danger of eye injuries** due to laser!

The **protective conductor connection** is marked with this symbol.

2.1.1. Designation of the machine

The information given in these operating instructions only applies to machines with the machine number as indicated on the cover of these instructions.

The type plate with the machine number is located on the switch cabinet or the ground frame.

For extensive repairs, servicing or relocations of the machine, please contact the BRISAY service department. When enquiring or ordering in writing or on the phone, please always quote

- type of machine
- machine number
- article number of the relevant component (see chapter SPARE PARTS LISTS)

Address

BRISAY-Maschinen GmbH

Mittelweg 4

D-63762 Grossostheim-Ringheim, Germany

Phone: ++49 (0) 6026/997-0

Fax: ++49 (0) 6026/997-100

e-mail: info@brisay.com

www.brisay.com

Service department: Tel: ++49 (0) 6026/997-0

Fax: ++49 (0) 6026/997-100

e-mail: service@brisay.com

2.2. SAFETY STANDARDS

The machine has been built in accordance with the German version of the regulations.

1. EC Machinery Directive (2006/42 /EC)

1.1 EN ISO 12100-1:2003+A1:2009 Safety of machinery; basic concepts, general principles of design; Part 1: Basic terminology, methodolody

1.2 EN ISO 12100-2:2003+A1:2009 Safety of machinery; basic concepts, general princples of design; Part 2: Technical principles

1.3 EN ISO 13857:2008 Safety of machinery; Safety distances to prevent danger zones being reached by the upper limbs

1.4 EN 349:1993+A1:2008 Minimum gaps to avoid crushing of parts of the human body

1.5 EN ISO 13850:2008 Safety of machinery; Emergency stop

1.6 EN ISO 13732-1:2008 Ergonomics of the thermal environment Part 1: Hot surfaces

1.7 EN 983:1996+A1:2008 Safety requirements for fluid systems and their components - Pneumatics

2. EC Low Voltage Directive (2006/95/EC)

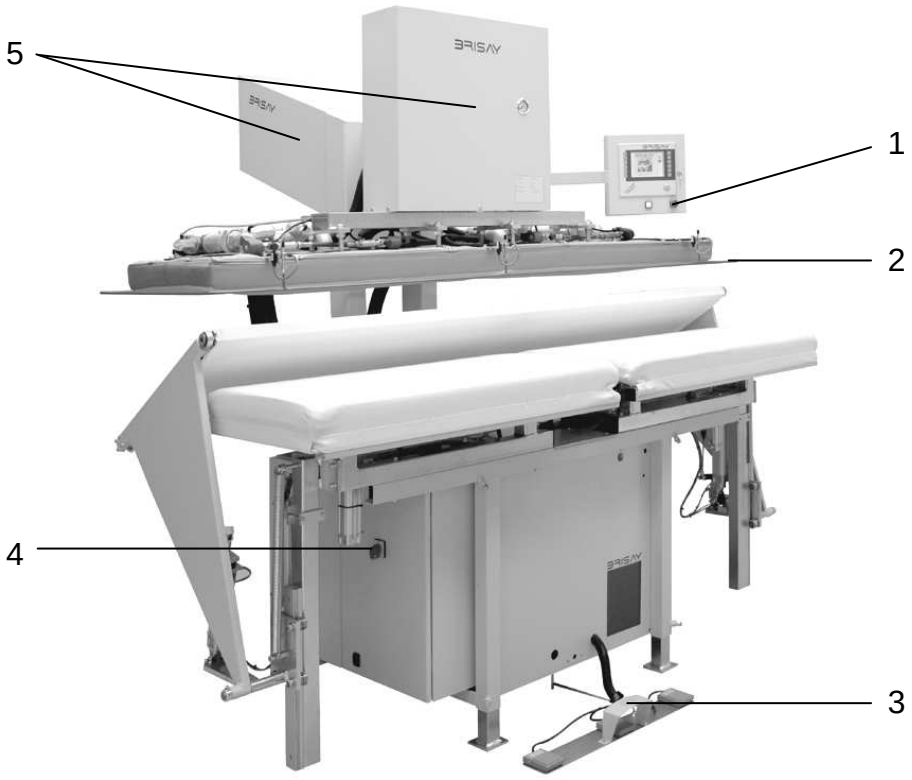
2.1 EN 60204-1:2006+A1:2009 Safety of machinery, electrical equipment of machinery

3. EC Directive EMC (2004/108/EC)

3.1 EN 61000-6-2:2005, EMC, Part 6-2: Industry

3.2 EN 61000-6-4:2007, EMC, Part 6-4: Industry

2.3. BUILT-IN SAFETY SYSTEMS



Ill. 2, Safety systems of the machine

Before commissioning the machine, the following checks (**S** = visual inspection, **F** = functional inspection, **M** = gauging) have to be carried out on the safety systems at the stated intervals (**t** = daily, **w** = weekly, **m** = monthly, **j** = annually).

The machine disposes of the following safety devices:

- **Main switch (Pos. 4)**

  It disconnects/connects the machine from/to the power supply and is located at the side of the machine on the switch cabinet.

Interval	Check
w	F

In case of maintenance or repair work, the main switch has to be padlocked in the OFF position.

- **Emergency stop button (Pos. 1)**

Interval	Check
t	F

The machine has an emergency stop button which is located on the control panel.

By pressing the emergency stop button, the following programme run is triggered:

- the head buck moves into home position,
- the stretching device with holding-down function (option) moves into home position,
- the steam exhaust is switched off.

The emergency stop button may be released by pulling.

- **Safety frame (Pos. 2)**

Interval	Check
t	F

The safety frame is fitted with a define margin around the head buck.

By activating the safety frame, the following programme run is triggered:

- the head buck moves into home position,
- the stretching device with holding-down function (option) moves into home position,
- the steam exhaust is switched off.

- **Hoop guard (Pos. 3)**

Interval	Check
m	S

A hoop guard is mounted on the Start pedal to prevent the machine from being started unintentionally.

- **Protective hood (Pos. 5)**

Interval	Check
m	S

The linear travelling frame and the guiding unit head buck are covered with a protective hood each to prevent people from reaching inside.

- Internally, the machine control is fitted with a one-phase feed system, with a current carrying N-type conductor and a **separate earth connection** marked with a GREEN/YELLOW sheath.

Interval	Check
m	S + F + M

The electric switch cabinet is equipped with a special key. It is to be taken into safekeeping by authorised staff only.

These operating instructions are a part of the machine and have to be available to the operators at any time.

The included safety instructions must be observed.

It is strictly forbidden to put the safety devices out of service or to modify their function.

2.3.1. Instructions

Operating and maintenance staff will be instructed on site by staff of BRISAY-Maschinen GmbH unless otherwise agreed in the purchase contract.

In case of questions or uncertainties, please contact BRISAY.

The operating company undertakes to introduce any new operating and maintenance staff with the same care to the operation and maintenance of the machine as well as to all safety instructions.

An appropriate training of operating and maintenance staff at BRISAY is recommended. Please contact the BRISAY service department for further information on training opportunities.

2.4. SAFETY MEASURES

(to be carried out by the operating company)

The operating company must

- instruct its operating and maintenance staff in the handling of the machine's safety devices,
- monitor the observance of safety measures and
- ensure that unauthorised staff (i.e. no operating or maintenance staff) is prevented from entering the danger zone of the machine.

The statutory minimum age for operating and maintenance staff must be observed.
These operating instructions must be kept for further use.
The prescribed frequency of inspection and control measures must be complied with.

In these operating instructions, the operations to be carried out are described in such a way that

- an **instructed person** may understand the instructions given in the chapter OPERATION,
- an **authorised person** may understand the instructions given in the chapter MAINTENANCE,
- a **qualified person** may understand the instructions given in the chapters TRANSPORT, INSTALLATION, SETTING-UP, MAINTENANCE.

In the chapter REMEDY OF FAULTS / ELIMINATION OF DEFECTS, the person in charge is stated depending on the kind of fault.

Instructed person
A person who has been introduced to the tasks assigned to him/her and the possible dangers in case of improper handling, who has been trained, if necessary, and who has been instructed in the necessary safety devices and safety measures.

Authorised person
A person who operates the machine at a regular basis and who has been instructed by BRISAY-Maschinen GmbH in particular in setting-up and servicing the machine unless otherwise agreed in the purchase contract.

Qualified person
A person who is capable of judging tasks assigned to him/her and of identifying dangers due to his/her technical training, knowledge and experience as well as knowledge of the relevant industrial standards.

The definition follows EN 60204-1:2006+A1:2009.

2.5. SAFETY TESTS

carried out by BRISAY-Maschinen GmbH in its plant:

- Airborne sound measurement
  - according to the directive on machines, appendix 1 (Pos. 1.7.4/f)
- Control and inspection according to EN 60204-1:2006+A1:2009 (Chapter 19.1 – 19.6)
  - check if electrical equipment and technical documentation match
  - continuous connection of the protective conductor system
  - insulation resistance controls
  - voltage controls
  - protection against residual voltage
  - functional inspection of the electrical devices, in particular the safety systems.

3. POTENTIAL DANGERS

The safety systems and safety instructions described in these operating instructions must be observed.

The machine is operated from the front.

The operator's working area and the access to the machine must be kept free of tools and other devices. The working area at and around the machine must be clean and accessible.

Never place tools or other objects on the machine. Due to vibrations, such objects may fall into the machine and cause severe damage.

Pay attention to the linear and closing movement of the head buck as well as to the swivelling and closing movement of the stretching device with holding-down function (option) since there is a **risk of bruises**!

Pay attention to the **risk of burns** when handling the steam iron (option).

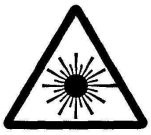
Particular care must be taken when setting up and servicing the machine since the risk of **burns and bruises** is increased**!** Particular attention must be paid to the rotary movement of the lower bucks, the closing movement of the head bucks and the swivelling movement of the unloading device.

When setting-up the machine
- protective gloves must be worn when handling heated parts of the machine to avoid **burns** and
- safety boots must be worn to avoid **bruises**.

There is an increased **risk of burns** with all parts connected to steam and condensate such as buck shapes, buck shape supports, hoses, hose connections, steam valves, steam distributors, steam admission units etc.

Never leave the machine unattended. The **fire risk** increases, if the head bucks are closed over a longer period during operation.

Do not wear open, long hair, loose clothes or jewellery. It increases the **risk of injury** because they might get caught in the machine or be subject to heat.



Never look straight into the laser beam of the positioning lights since there is a **danger of eye injuries**!

When carrying out installation work above body height, the provided ladders or service platforms must be used or any other ladder meeting the required safety standards. Do not climb on components of the machine - **danger of falling**! A safety harness should be worn when carrying out maintenance work in greater heights.

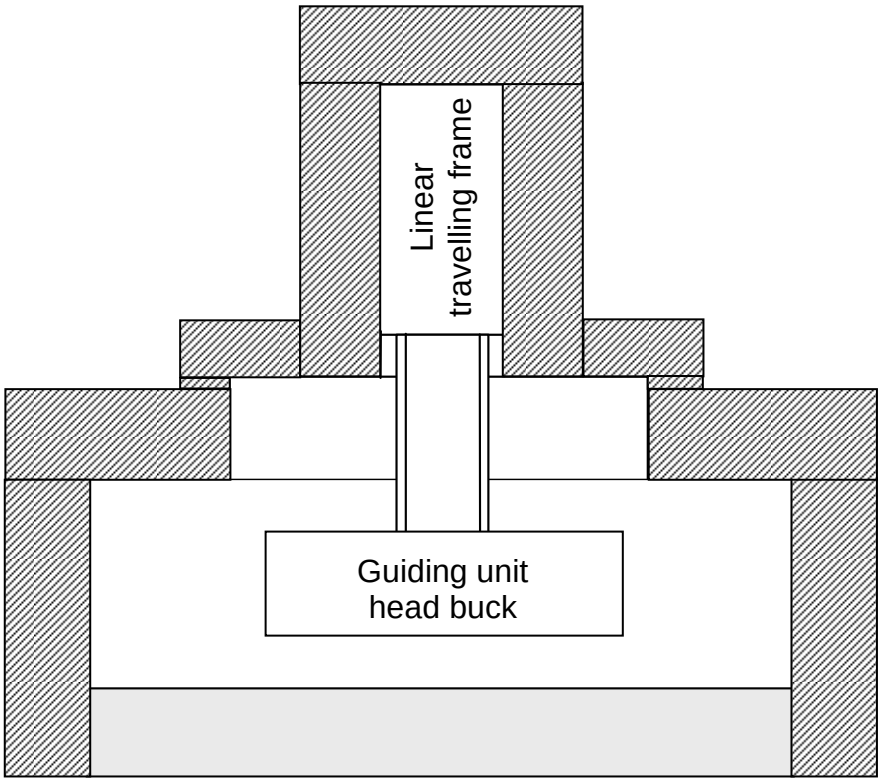
Welding, burning, and grinding work on the machine must only be carried out, if this work has been explicitly approved. There might be a **risk of fire and explosion**!
Remove any dust and inflammable material from the machine and the area around it and see to sufficient ventilation before carrying out welding, burning and grinding work - **risk of explosion**!

3.1. DANGEROUS AREAS OF THE MACHINE

The operator has access to the following parts of the machine:

Operating area

Dangerous area during commissioning, servicing, maintenance and repair



Ill. 3, Dangerous areas of the machine

The dangerous area extends 1 m around the machine.

The risk of injury is increased during maintenance work.

3.2. DUTIES OF THE OPERATING COMPANY

Note

In the EEA (European Economic Area), the operating company must observe and comply with the national implementation of the general directive (89/391/EC) as well as the relevant individual directives, in particular with the directive (89/665/EC) on minimum requirements for safety and health when using working appliances provided by the employer as amended.

The operating company has to obtain the local operating permit and observe the conditions imposed.

Moreover, the company has to comply with the local provisions on

- the safety of staff (safety regulations)
- the safety of working appliances (protective clothing and maintenance)
- the disposal of products (waste management law)
- the disposal of materials (waste management law)
- cleaning (cleaning agents and disposal)
- as well as with environmental regulations.

Note

Should the operating company set up and install the machine itself, it must ensure that the local regulations e.g. on electric and pneumatic connections are complied with before commissioning the machine.

3.3. OPERATING AND MAINTENANCE STAFF

Each person (operating and maintenance staff only) who is engaged in installing, commissioning, operating or maintaining the machine has to be aware of the risks involved when handling the machine.

This is the case if

- the machine is operated, serviced and maintained by trained and authorised persons. Staff that is being trained or instructed in operating the machine or is receiving general training is only allowed to operate the machine when being supervised by an experienced person!
- the responsibility is clearly defined and observed should the machine be operated by several people in order to avoid uncertainties with regard to safety,
- the disconnect procedures indicated in the operating instructions are observed when carrying out work (operation, maintenance, repair etc.),
- unauthorised people are kept away from the working range of the machine,
- the compliance with the operating instructions regarding the awareness of the risks involved when working at the machine is checked on a regular basis,
- the operating company operates the machine in a mechanically faultless condition only,
- in case of malfunctions, the machine is stopped and locked immediately! The relevant person/department has to be informed and the fault has to be remedied immediately by those in charge.
- the operator informs the department/person in charge immediately on any changes observed at the machine which might impair the safety of the machine.

3.4. DISCONNECT PROCEDURES

Before starting with cleaning, maintenance or repair work (by qualified staff only), the following disconnect procedure must be observed:

1. Cut off steam supply
   - Shut off both valves for steam supply.
   - Depressurise steam system by activating machine start.
   - Make sure that no steam emerges from the machine.
2. Switch off machine from power supply
   - Set main switch on switch cabinet to „0“.
   - Padlock main switch to prevent the machine from being switched on again.
   - Remove power plug.
   - Make sure that no current is carried.
3. Cut off pneumatic
   - Shut off compressed-air lines.
   - Remove air from compressed-air lines.
   - Check if the machine is without pressure.
4. Switch off additional oil heating system or oil heating unit (only with BRI-222/111)
   - It is absolutely necessary to follow the disconnect procedures described in the separate operating instructions!
5. Switch off accessory device (if available)
   - It is absolutely necessary to follow the disconnect procedures described in the separate operating instructions!

In case of non-observance, the life of staff may be in danger.

4. TRANSPORT AND PACKING

Although machines of BRISAY-Maschinen GmbH are carefully checked and packed before being delivered, damages during transport may not be ruled out.

4.1. DELIVERY

(also applies to spare parts and return parts)

Receiving inspection

- Check delivery for completeness using the delivery note!
- Check delivery for damages (visual inspection).

Objections

- Should the goods have been damaged during transport contact the carrier immediately and
- keep the packing (for a possible examination by the carrier or for return shipment)!

Packing for return shipment

Use the original packing and the original packing material, if possible.

If both cannot be used

- engage a packing company with qualified staff,
- place the machine on a pallet and fasten it with a securing device. (The pallet has to be designed for the weight of the machine.)

For questions on packing and securing devices, please contact BRISAY-Maschinen GmbH.

Make sure that there is no water in the steam pipe system since this might cause damage to the machine.

Add desiccants when packing electric parts.

Land shipment

The machine will be delivered by truck or train.

Overseas shipment
In case of overseas shipment, the machine will be welded into a plastic sheet and covered with a drying agent. The machine will be shipped in a sea freight transport container.
The drying agent is designed for a storage of 3 months and has to be renewed if the machine is stored for longer time.

Note

Transport insurance
On prior consultation, a transport insurance may be effected before shipment.

Storage conditions
A closed and dry room with a room temperature between +5 °C and +45 °C.

The packing of the machine and the spare or return parts is designed for a storage of 3 months upon delivery.

4.2. UNLOADING AND TRANSPORT TO THE PLACE OF INSTALLATION

Make sure that the lifting device is designed for the weight of the machine.

Should suitable lifting devices not be not available, a transport company has to be engaged with unloading and transporting the machine.

Secure the machine before transporting it (see chapter 4.3).

Pay attention to the machine´s centre of gravity (see page 26, Ill. 4).

The head bucks and the stretching devices have to be closed during transport.

Avoid shocks and pay attention to hoses on the floor since there is a **risk of injury and machine damages**.

It is forbidden to stay under suspended loads!

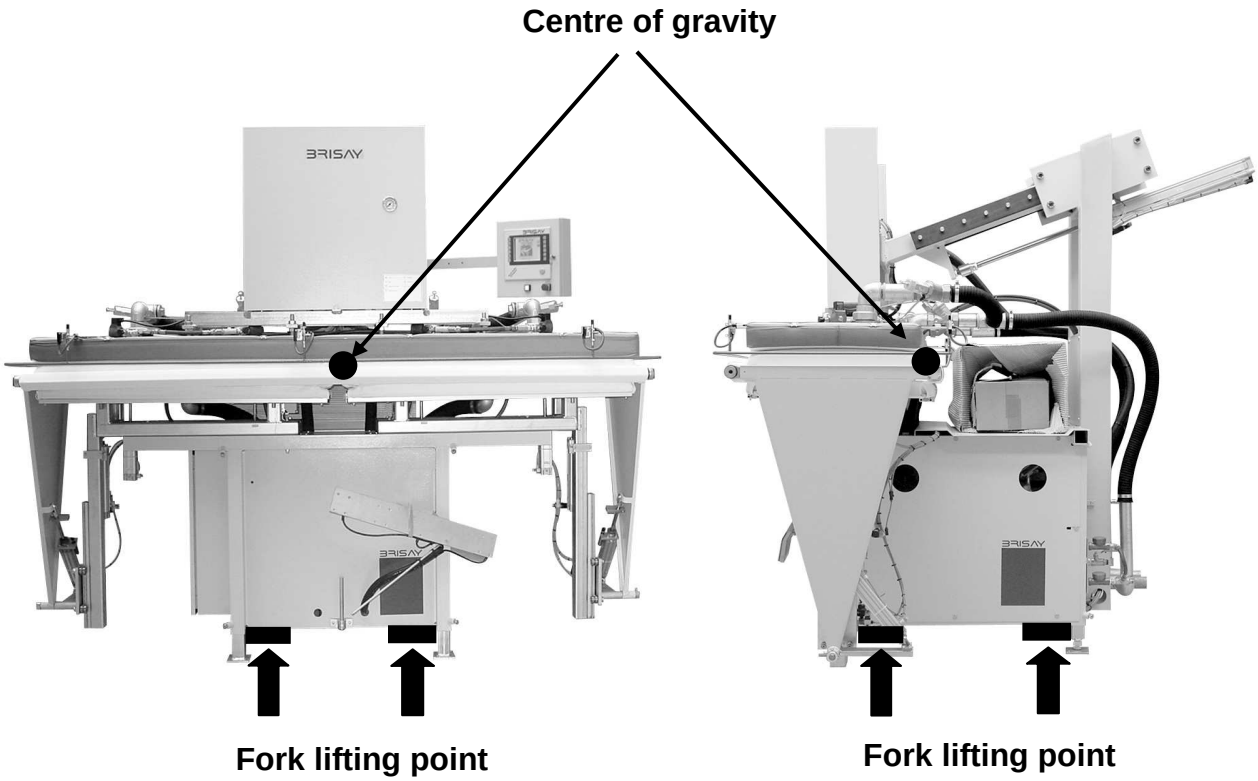
If the machine is delivered in a transport container (ISO container), the information required for unloading (lifting points, crane load) is marked on the container.

When unloading, proceed as follows:

- Unload the machine from the truck using the appropriate means of transport.
- Remove transport material.
- Withdraw all loose and additional parts and transport them separately.
- Lift the machine and transport it to the place of installation.

In case of subsequent deliveries or repairs, the machine must only be transported by qualified staff using the appropriate means of transport.

Transport by forklift truck



Ill. 4, Transport by forklift truck, centre of gravity

- Lift the machine by means of a forklift truck.
  - Adjust the width of the fork the ground frame dimensions (see Ill. 4).
  - Make sure that the fork, reaches entirely under the machine and, for safety reasons, comes out on the other end (see Ill. 4).
  - Make sure that the pedal strip, cables, hoses etc. are not damaged during transport.

4.2.1. Lifting points

Subassemly	Weight	Centre of gravity	Lifting points	Lifting device
Entire machine	approx. 820 kg	see Ill. 4	Below the ground frame, see Ill. 4	Forklift truck

4.3. TRANSPORT SAFEGUARD

Before being transported, the machine has to be secured as follows den:

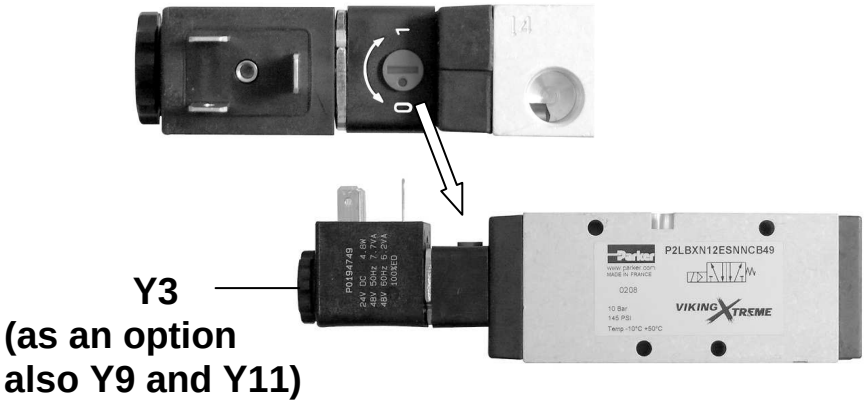
1. Cut off steam supply.
   - Shut off both valves for steam supply.
   - Depressurise steam system by means of machine start.
   - Make sure that no steam emerges from the machine.

Make sure that head buck and lower bucks as well as all parts in connection with steam and condensate are cool, since there is a **risk of burn!**

Hinweis

2. **If the option stretching device with holding-down function is available**, set the manual setting in the described order from position „0“ to position „1“ (see Ill. 5):
   - Solenoid valve Y9. The stretching device swivels over the lower bucks.
   - Solenoid valve Y11. The stretching device closes.

   Both valves are located in the switch cabinet.

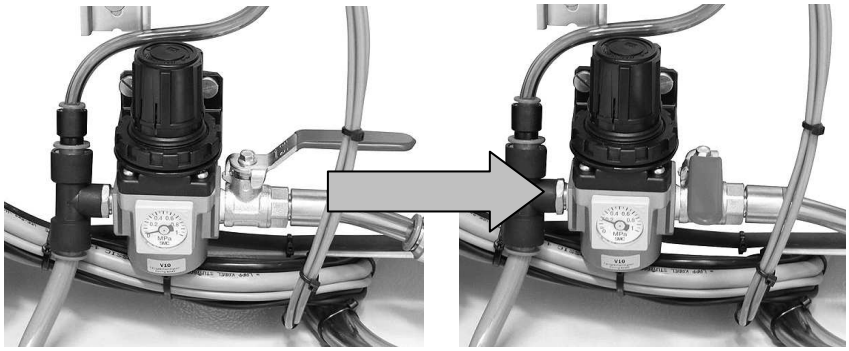


Ill. 5, Manual setting

3. Use the supervisor function „single track“ track 1 to select „pressure level 2 bar“ (see separate **BRIfashion** manual).

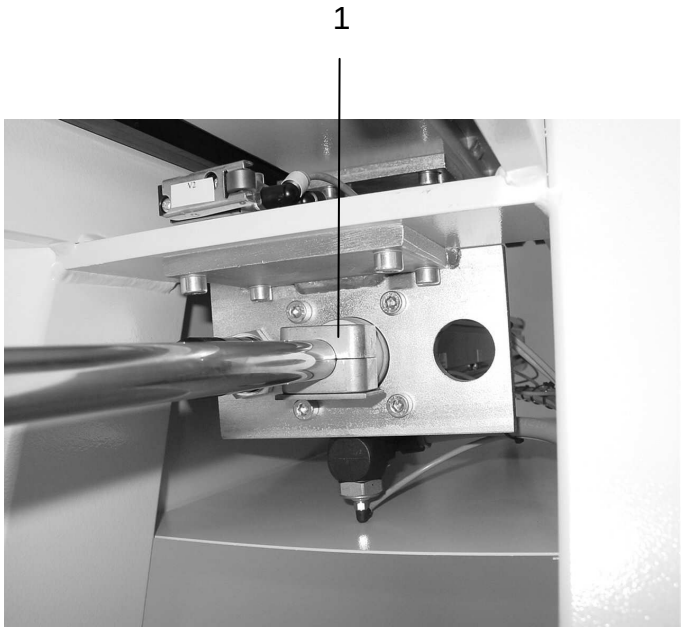
4. Press pedal „Suction“ and „Start“ (see page 46, Ill. 21) one after the other. The head buck closes.

5. Close the ball valve „V6“ (see Ill. 6, Close ball valve).



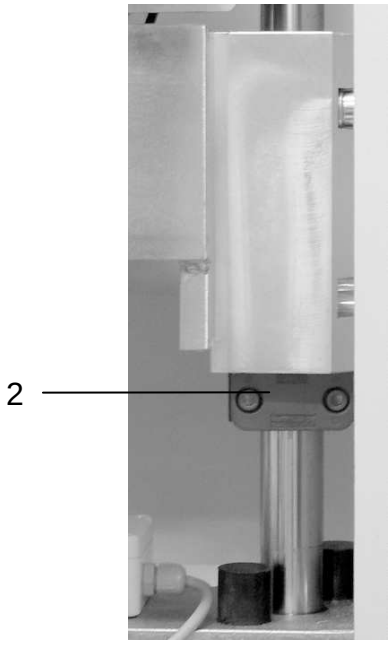
Ill. 6, Close ball valve

6. Cut off compressed-air supply and remove air from compressed-air lines.
7. Switch off machine and remove power plug.



Ill. 7, Transport safeguard linear travelling frame

8. Lock piston rod with securing device (see Pos. 1).



Ill. 8, Transport safeguard guiding unit head buck

9. Lock guiding unit head buck with securing device (see Pos. 2).

10. Remove all supply lines.

11. Make sure that packing of the steam iron (option) is shock-proof.

12. Fasten pedal strips to the machine and make sure that the fixing is shock-proof.

5. INSTALLATION

5.1. SETTING-UP

The machine will be set up, assembled and installed by qualified staff of BRISAY-Maschinen GmbH or by qualified staff provided by the customer. In case of subsequent deliveries, the subassemblies must be disassembled or assembled by qualified staff only.

- Make sure that the static of the building is designed for the weight of the machine.
- The machine has to be set up on an even surface.
- Energy supply (electric and compressed-air connection, connection for steam supply) as well as the connection for the condensate and the suction must be provided.
- Make sure that there is enough space around the machine to carry out maintenance work.

Note

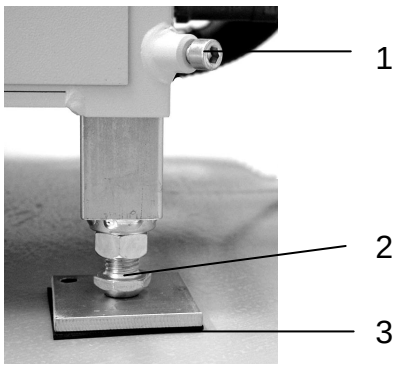
If the place of installation does not comply with the intended use, rebuilding measures must be taken to obtain a higher level of protection (see chapter 1.3, Technical data).

Adjusting

Ergonomic guidelines	
Men and women working in upright position	**Women working in upright position**
Working height: floor – upper edge lower buck ca. 113 cm	Working height: floor – upper edge lower buck ca. 103 cm

- Move the forks of the truck underneath the machine (see chapter 4.2 TRANSPORT). Lift the machine to the desired working height (see „Ergonomic guidelines“).

- Place the supplied rubber plates (Pos. 3) under the four machine mounting pads.
- Open check screws (Pos. 1) and lower machine mounting pads to the ground and fasten check screws again.



Ill. 9, Adjusting height

- After having put down the machine, place a water level on the frame of the machine and adjust it by moving the machine mounting pads in X and Y direction.
- Use adjustable machine mounting pad to level out uneven patches (Pos. 2).

- Mount the pedal strips in accordance with the operating position.
- Remove transport safeguards (see page 28, Ill. 7, Pos. 1 and Ill. 8, Pos. 2).

Note

Degrease all the guide rods and/or linear guides before commissioning the machine.

5.2. INSTALLATION

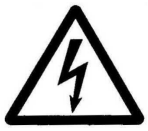
Connection of electric supply

- Current is supplied via a safety plug with earthing.

Pay attention to the input voltage.

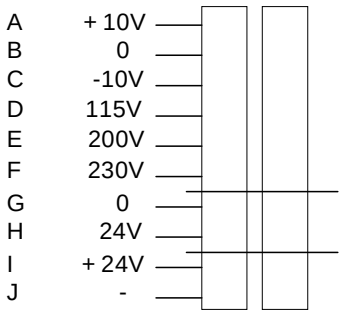
A socket is installed in the switch cabinet which is current-carrying even if the main switch is switched off.

The standard model of this machine is designed for an input voltage of **230V**. If the voltage provided at the place of installation is higher or lower, the transformer T1 has to be connected in the switch cabinet of the machine.



Work on electric supply lines must only be carried out by qualified staff.

Remove power plug on the switch cabinet before opening the terminal box. **Danger to life !**



	A	B	C	D	E	F
105V			X	X		
115V		X		X		
125V	X			X		
190V			X		X	
200V		X			X	
210V	X				X	
220V			X			X
230V		X				X
240V	X					X

Ill. 10, Connection of power supply

Compressed-air connection

- Connect-compressed-air connection (Pos. 2) to the compressed-air supply provided by the customer.

Connection for condensate drain

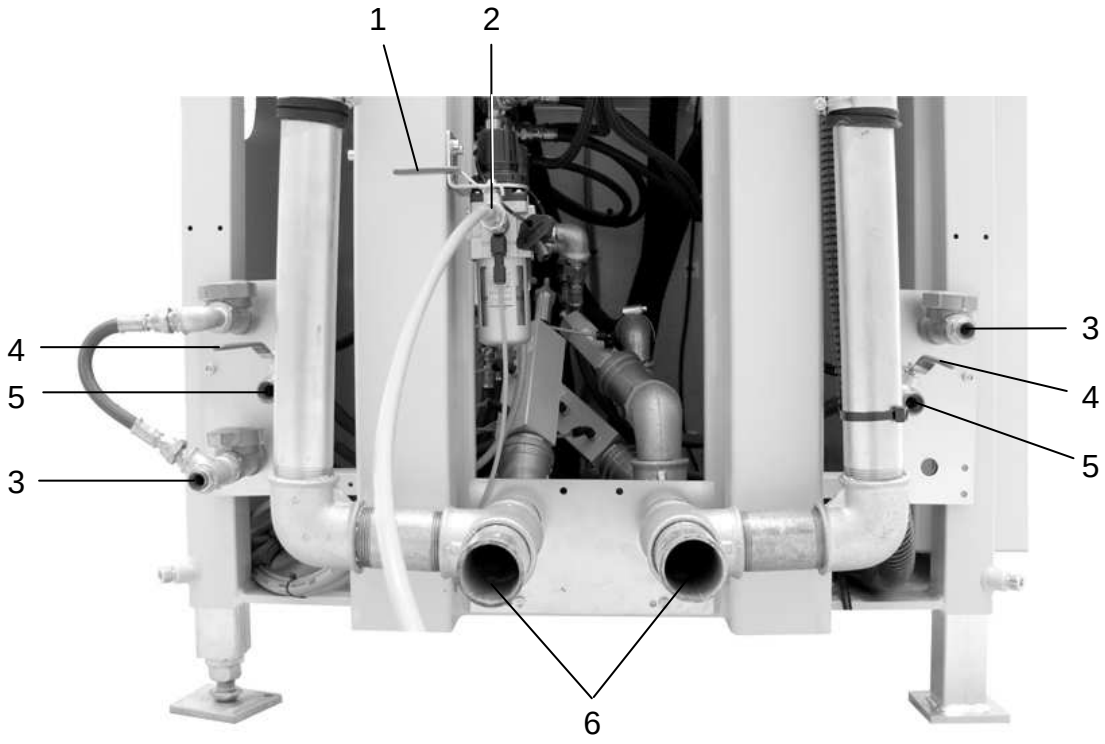
- Connect both condensate drains (Pos. 3) to the appropriate access line of the customer.

Connection of steam supply

- Connect both steam connections of the machine (Pos. 5) to customer`s steam supply.

Connection for suction

- Connect suction tubes (Pos. 6) to the appropriate suction provided by the customer.



Ill. 11, Supply connections at the back of the machine

Note

The connection data mentioned below are detailed in chapter 1.3 TECHNICAL DATA.

To connect the machine properly, we recommend the original connections supplied by BRISAY-Maschinen GmbH (optional).

Should the operating company set up and install the machine itself, it must ensure that the local regulations e.g. on electric and pneumatic connections are complied with before commissioning the machine.

5.3. COMMISSIONING

When commissioning the machine, proceed as follows:

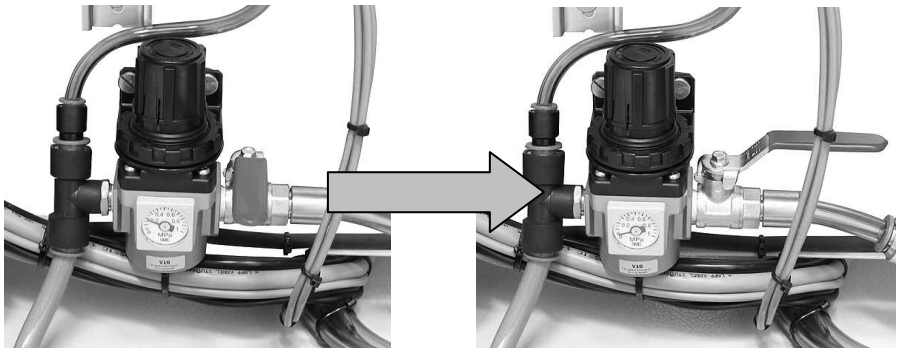
Make sure, that transport safeguards are removed.

1. Switch on the main switch at the switch cabinet (see page 43, Ill. 18, Pos. 4).
2. Release emergency stop button (see page 44, Ill. 19, Pos. 1) by pulling it.
3. Press reset button (see page 44, Ill. 19, Pos. 2).
4. Open shut-off valve of the compressed-air **slowly** (see page 34, Ill. 11, Pos. 1).

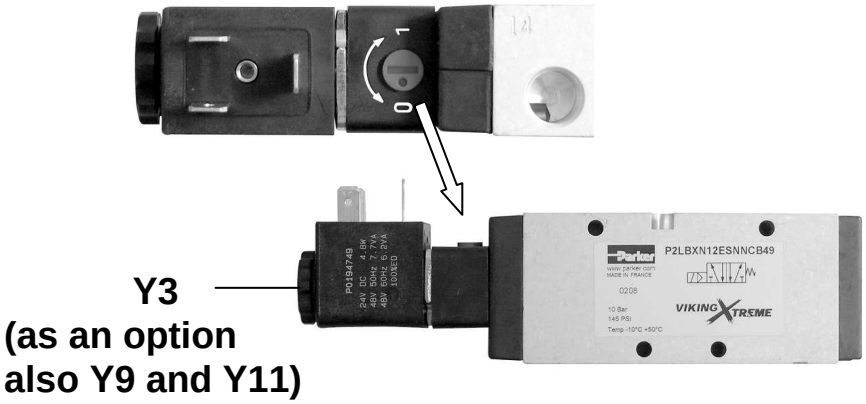
The head buck is raised.

5. Open switch cabinet and open the ball valve V6 (only when commissioning the machine for the first time, see Ill. 12).

The head buck moves into home position.



Ill. 12, Open ball valve



Ill. 13, Manual setting

Note

6. **If the option stretching device with holding-down function is available**, set manual setting in the described order from position „1“ to position „0“ (see page 36, Ill. 13):
   - Solenoid valve Y11. The stretching device is raised.
   - Solenoid valve Y9. The stretching device moves into home position.

   Both valves are located in the switch cabinet.

7. Open condensate shut-off valves.
8. Open both shut-off valves for steam supply **slowly** (see page 34, Ill. 11, Pos. 4).
9. If necessary, adjust steam and suction valves (see chapter 5.3.1 + chapter 5.3.2 + optional chapter 5.3.3).
10. Set steam iron (see chapter 5.3.4).

5.3.1. Setting instructions steam valve

Setting must only be carried out by a **qualified person** (definition see chapter 2.4). This person must make sure that it is not possible to start the machine when setting it.

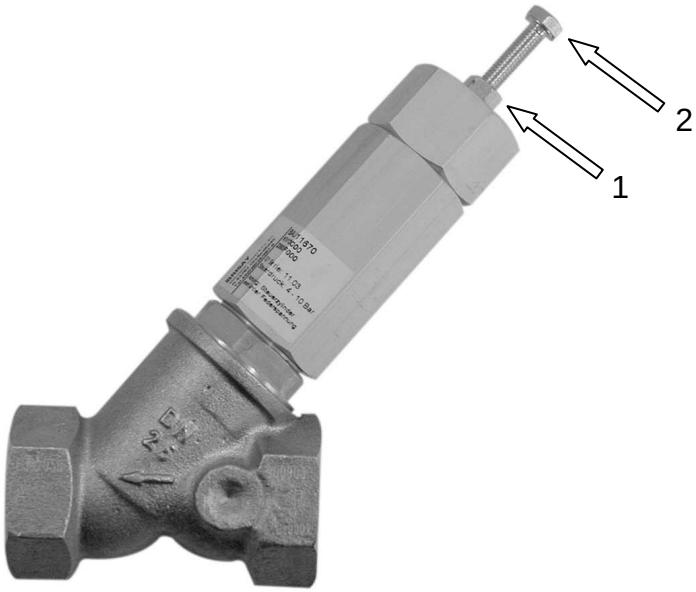
Ill. 14, Steam valve

Turn setting screw:

- to the **right** to **reduce** the amount of steam,
- to the **left** to **increase** the amount of steam.

5.3.2. Setting instructions suction valve (one stage)

Setting must only be carried out by a **qualified person** (definition see chapter 2.4). This person must make sure that it is not possible to start the machine when setting it.



Ill. 15, suction valve (one stage)

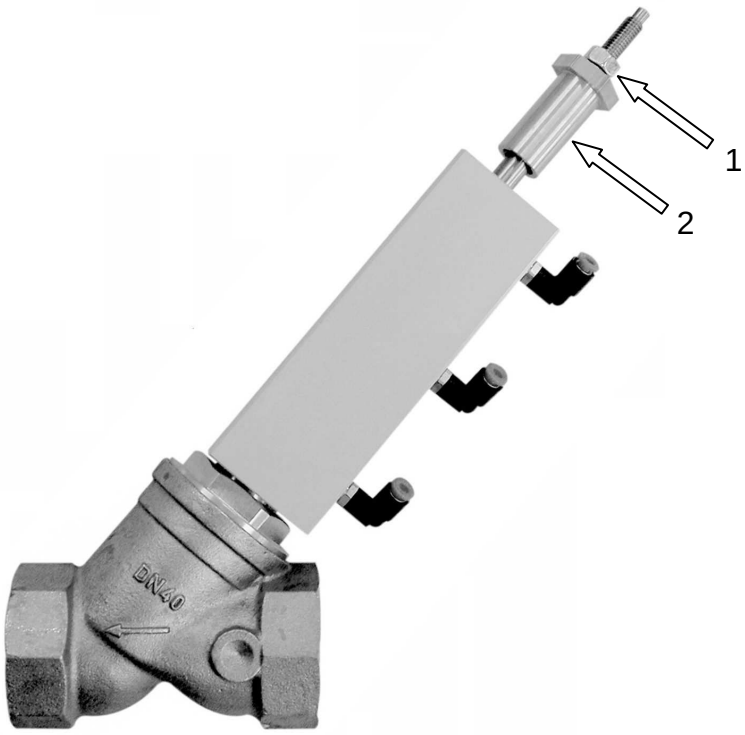
1. Release check nut (Pos. 1).

2. Turn setting screw (Pos. 2):
   - to the **left** to **increase** the amount of suction,
   - to the **right** to **reduce** the amount of suction.

3. Tighten check nut (Pos. 1).

5.3.3. Setting instructions suction valve (two stage, option fine suction)

Setting must only be carried out by a **qualified person** (definition see chapter 2.4). This person must make sure that it is not possible to start the machine when setting it.



Ill. 16, suction valve (two stage)

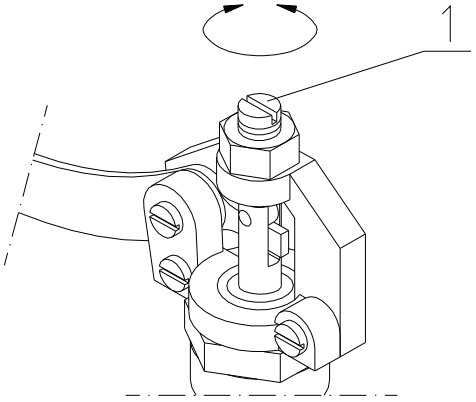
The strong suction cannot be adjusted.

To adjust the fine suction, proceed as follows:

1. Release check nut (Pos. 1).
2. Turn setting screw (Pos. 2):
   - **clockwise** to **reduce** the amount of suction,
   - **anticlockwise** to **increase** the amount of suction.
3. Tighten check nut (Pos. 1).

5.3.4. Setting of pressing iron

There is an increased **risk of burns** with all parts connected to steam and condensate!



Ill. 17, Steam setting of pressing iron

The amount of steam admitted from the sole of the iron can be adjusted.

1. To increase the steam volume, loosen the plastic nut on top of the valve and turn the adjustment screw anticlockwise (Pos. 1).

2. If the adjustment screw is turned clockwise, the steam emission is reduced.

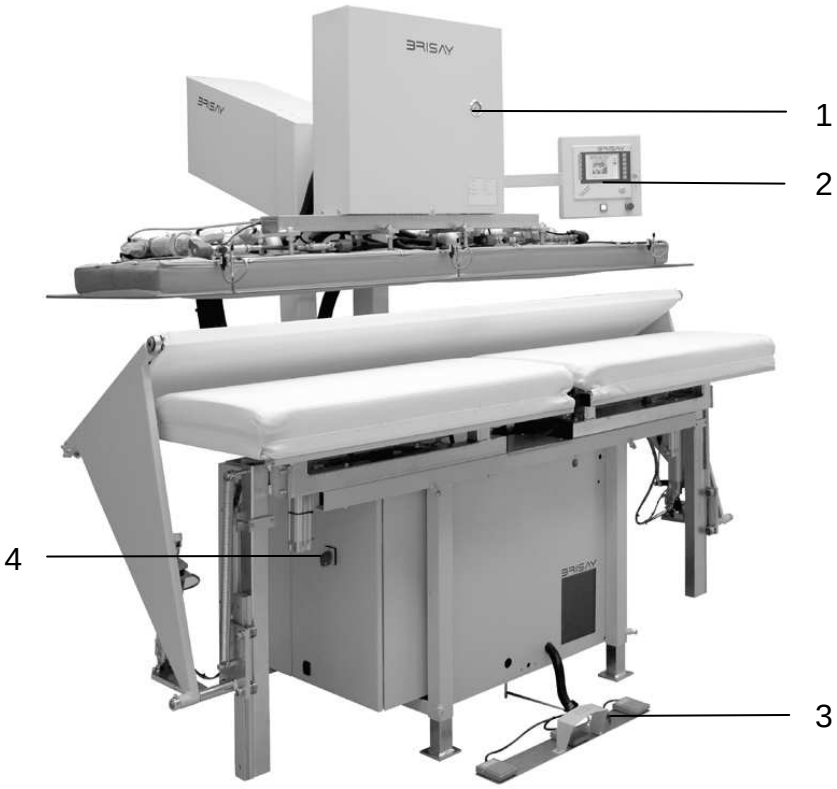
3. Retighten the adjustment screw with the check nut after each adjustment.

Note

Please note that with this adjustment only serves to control the amount of steam emitted from iron´s sole. This has nothing to do with the steam pressure adjustment of the steam supply.

6. OPERATION

6.1. OPERATOR'S CONTROLS AND DISPLAYS



Ill. 18, Operator´s controls and displays

1 **Pressing pressure head buck** (manometer)
Display of the current pressing pressure of the head buck (pressure range: 0 – 6 bar)

2 **Control panel** (see chapter 6.1.1)

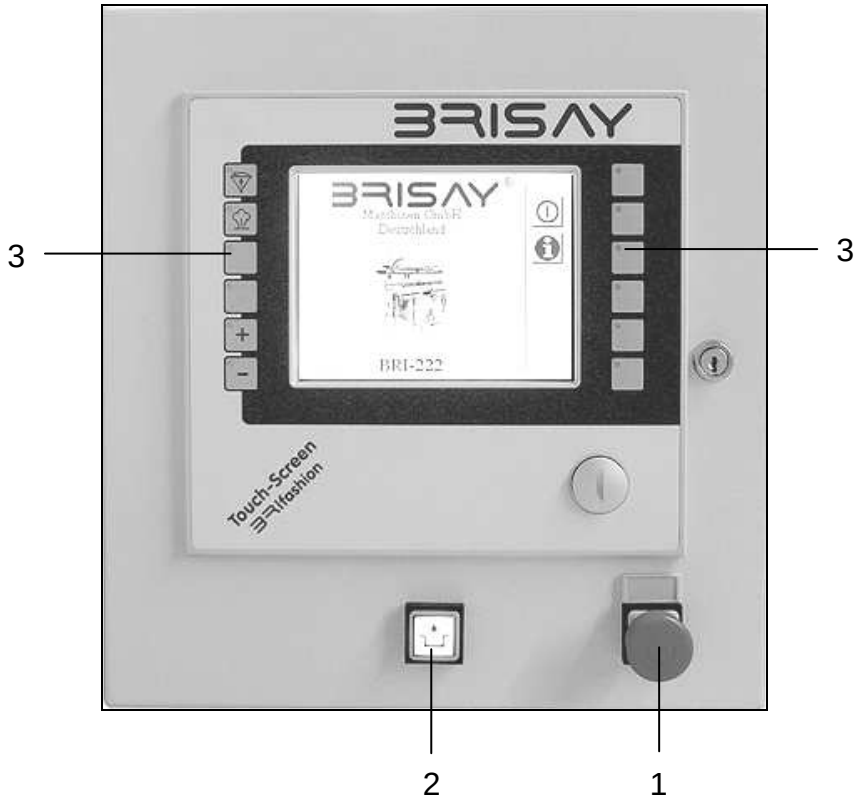
3 **Pedal strip** (see chapter 6.1.3)

4 **Main switch**
It disconnects/connects the machine from/to the power supply.

In case of maintenance or repair work, the main switch has to be padlocked in the OFF position.

5 **Steam iron** (option, not visible)
Steam supply is activated by manipulating the lever.

6.1.1. Control panel



Ill. 19, Control panel

1 **Emergency stop button** (mushroom-headed heavy-duty push-button)
By pressing the emergency stop button, the following programme run is triggered:

- the head buck moves into home position,
- the stretching device with holding-down function (option) moves into home position,
- steam exhaust is switched off.

The emergency stop button may be released by pulling.

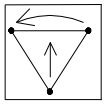
2 **Release** (button)
By pressing the button, the machine control is activated. The button lights up.

3 **Function keys** (see chapter 6.1.2)

The machine control BRIfashion is described in a separate technical manual.

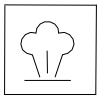
6.1.2. Function keys

Ill. 20, Function keys



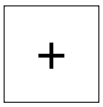
1 Stretching device with holding-down function (option)

By activating the button, the stretching device with holding-down function moves back into home position.



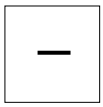
2 Steam lower bucks

By activating the button, the steam supply of the lower bucks is switched on. The steam supply remains active as long as the button is pressed.



3 Programme selection

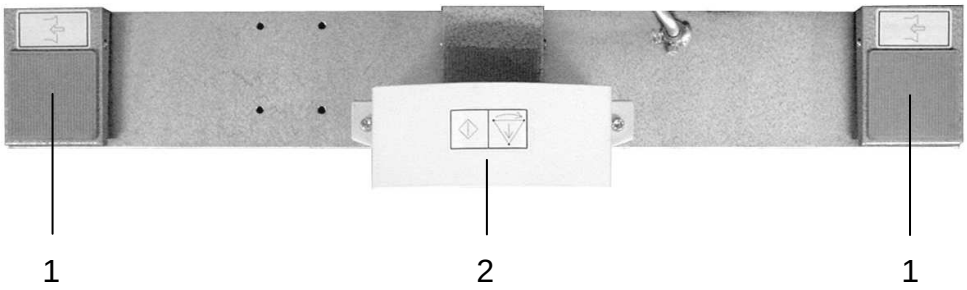
By pressing the button, you can page forward through the programmes.



4 Programme selection

By pressing the button, you can page backward through the programmes.

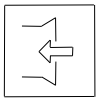
6.1.3. Pedal strip



Ill. 21, Pedal strip (with stretching device with holding down function, option)

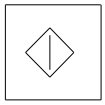
Note

The suction from the right and left lower buck are operated separately.



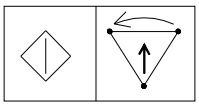
1 Sution

Short tap (first time < 0,4 s)	-	When pressing the pedal shortly for the first time, the suction is switched on.
Short tap (second time < 0,4 s)	-	When pressing the pedal shortly for the second time, the suction is switched off manually.
Long activation	-	The suction is switch on and remains active as long as the pedal is pressed.



2 Start

By pressing the pedal, the operating cycle is started.



2 Start (with option stretching device with holding down function)

Long activation (first time)	-	With a long activation of the pedal, the stretching device swivels to the front.
kurzes Antippen (second time < 0,4 s)	-	With a short tap on the pedal, the pressing programme is started.

Quick start

Short tap (first time < 0,4 s)	- With a short tap on the pedal, the stretching device with holding-down function swivels to the front and the pressing programme is started.

6.2. SETTING-UP OF THE MACHINE

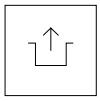
The machine may only be set up by a **qualified person** (definition see chapter 2.4 SAFETY MEASURES).

Do not forget that the risk of injury is increased when setting-up the machine.

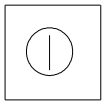
The machine control BRIfashion is described in a separate technical manual.

6.3. STARTING THE MACHINE

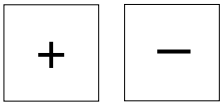
- Switch on the main switch at the switch cabinet (see page 43, Ill. 18, Pos. 4).
- Release emergency stop button (see page 44, Ill. 19, Pos. 1) by pulling it.



- Press rest button.
- Check safety devices.



- Press touch button to change into RUN mode.



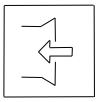
- Use function buttons to select desired programme.

6.4. AUTOMATIC OPERATION

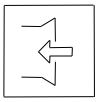
Pay attention to the potential dangers indicated in chapter 3 when operating the machine.

6.4.1. Operating procedure

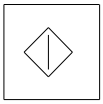
- Place the garment on the lower buck and align the first trouser leg.



- Tap on the appropriate pedal „Suction“.The trouser leg is fixed on the lower buck.



- Align the second trouser leg and tap on the second pedal „Suction“.The suction of the second lower buck is activated as well.

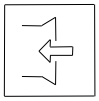


- Tap on the pedal „Start“. The operating cycle is started.

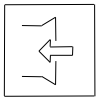
- Upon completion of the pressing programme, remove the garment from the lower bucks.

6.4.2. Operating procedure with option stretching device with holding down function

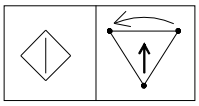
- Place the garment on the lower buck and align the first trouser leg.



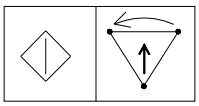
- Tap on the appropriate pedal „Suction“.The trouser leg is fixed on the lower buck.



- Align the second trouser leg and tap on the second pedal „Suction“.The suction of the second lower buck is activated as well.

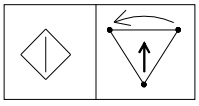


- Activate pedal „Start“. The stretching device swivels to the front.
- If necessary, eliminate creases on the garment.



- Short tap on pedal „Start“ (< 0,4 s). The pressing programme is started.

Quick start



- Short tap on pedal „Start“ (< 0,4 s) an. The stretching device with holding-down function closes and the pressing programme is started.

- Upon completion of the pressing programme, remove the garment from the lower bucks.

6.5. SWITCHING OFF THE MACHINE

- Switch off main switch at the switch cabinet (see page 43, Ill. 18, Pos. 4).

7. MAINTENANCE

Maintenance must only by carried out by an **authorised person** (definition see chapter 2.4 SAFETY MEASURES).

This authorised person will be instructed on site by staff of BRISAY-Maschinen GmbH unless otherwise agreed in the purchase contract.

Do not forget that the risk of injury is increased during maintenance.

7.1. CHANGING OF COVER MATERIAL

The wear of the covers depends on the number of parts being pressed and the pressing parameters.

We recommend a change of

- the stretching covers after a maximum of 3 months,
- the pressing covers after a maximum of 6 months.

Use the appropriate original cover material of BRISAY-Maschinen GmbH, since cover material, cover composition and fitting may not be guaranteed otherwise.

When using non-original cover materials, take into account the cover materials and cover composition recommended by BRISAY-Maschinen GmbH.Templates are by BRISAY-Maschinen GmbH. Templates are available at BRISAY's.

The manufacturer shall not be liable for damages caused by non-observance. The user alone bears the risk.

Observe the local regulations when disposing of the worn pressing covers.

When ordering material, please always quote BRISAY machine number and shape number (see cover).

Address
BRISAY-Maschinen GmbH

Mittelweg 4

D-63762 Grossostheim-Ringheim, Germany

Phone: ++49 (0) 6026/997-0

Fax: ++49 (0) 6026/997-100

e-mail: info@brisay.com

www.brisay.com

Service department: Tel: ++49 (0) 6026/997-0

Fax: ++49 (0) 6026/997-100

e-mail: service@brisay.com

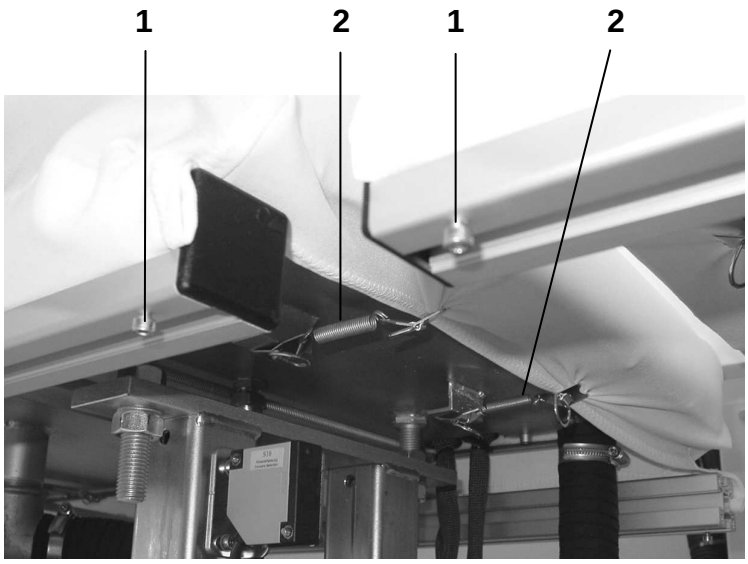
- Cut off steam supply before changing pressing covers.
  - Shut off both valves for steam supply.
  - Depressurise steam system by means of machine start.
  - Make sure that no steam emerges from the machine.
- Switch off main switch.
- The compressed-air supply remains switched on.

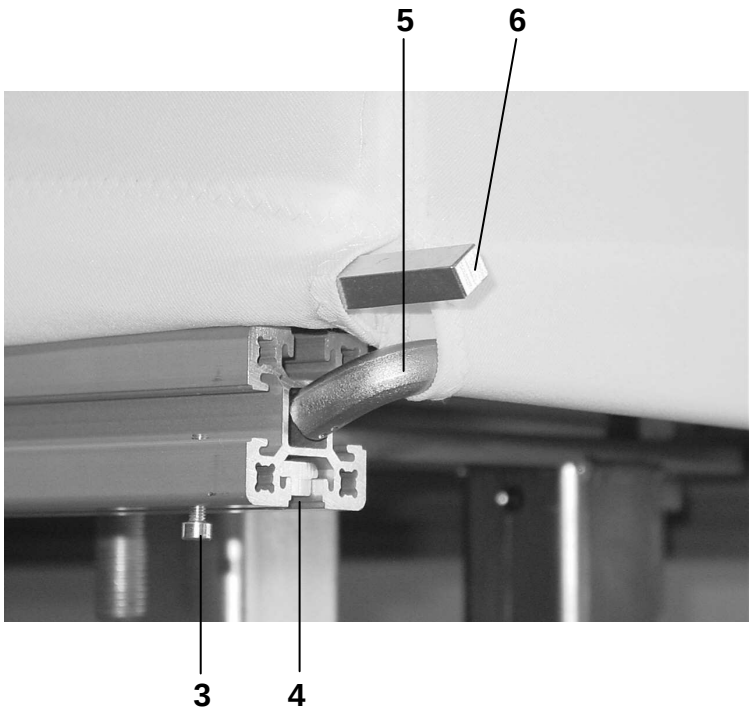
Make sure that head buck and lower bucks as well as all parts which are connected to steam and condensate are cool, since there is a **risk of burn!**

7.1.1. Changing stretch covers of lower bucks

1. Removing worn stretch cover

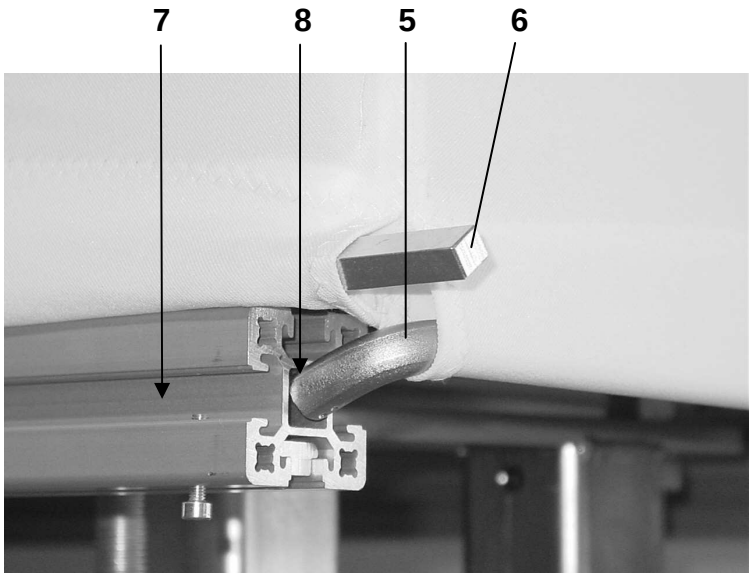
- Remove tension springs (Pos. 2).
- Release clamping screws (Pos. 1).
- Unscrew clamping screws on both sides (Pos. 3 + 4).
- Remove fastening strips (Pos. 5 + 6).
- Dispose of stretch cover.

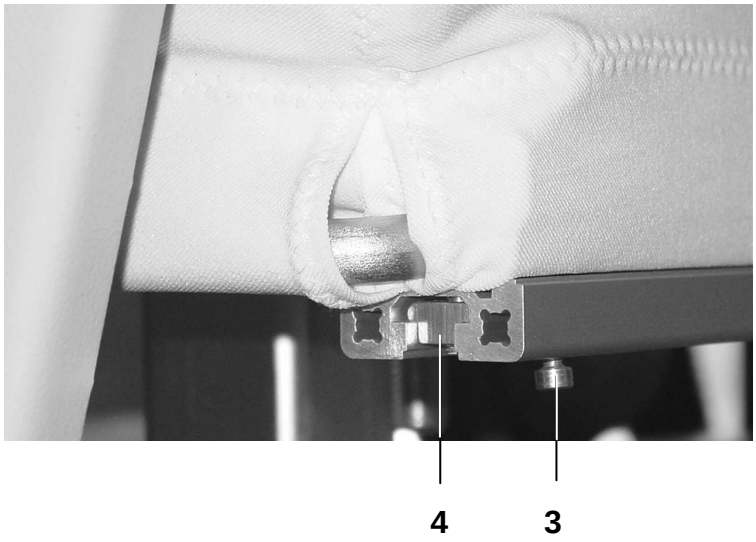


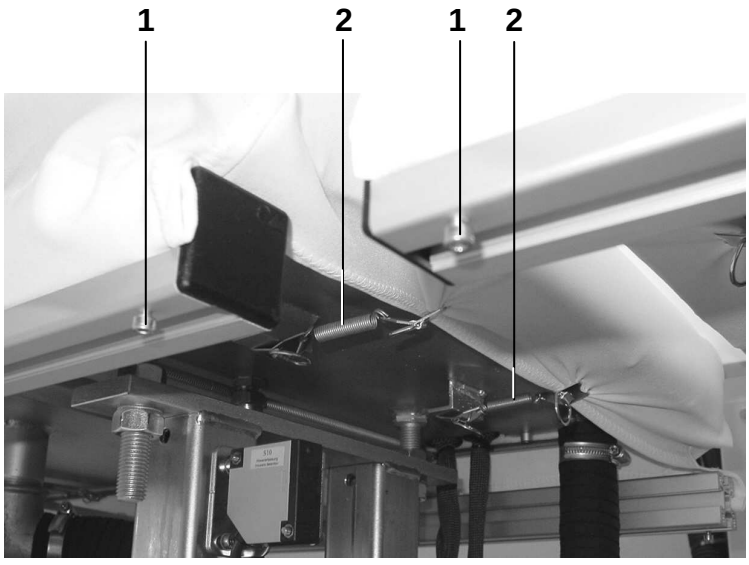


2. Changing covers of stretching device

- Place the new stretch cover on the pressing cover of the lower buck.
- Slide the fastening strip (Pos. 5 + 6) in the vertical loops of the stretch cover.
- Place the fastening strip (Pos. 6) in the groove (Pos. 7) of the profile tube.
- Fix the fastening strip (Pos. 6) with the clamping screws (Pos. 3 + 1).
- Slide the fastening strip (Pos. 5) in the centering (Pos. 8) of the profile tube.
- Fix the fastening strip (Pos. 5) with the screw in the sliding block (Pos. 4).
- Fasten the tension springs (Pos. 2) to the cover.
- Change the cover of the second lower buck.





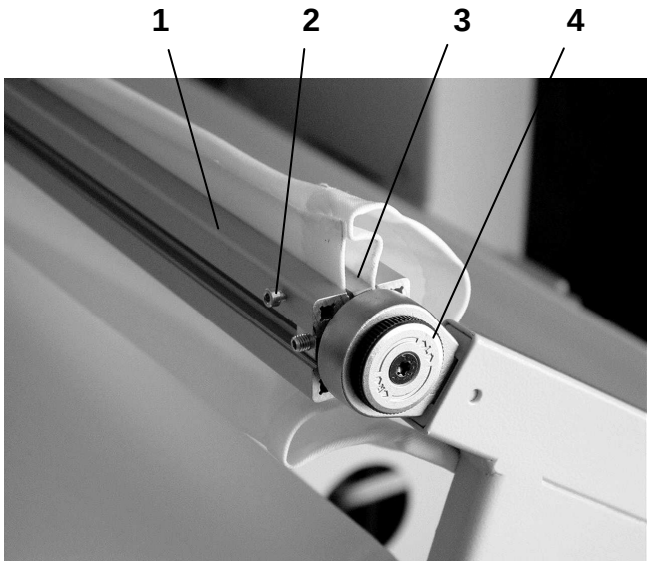


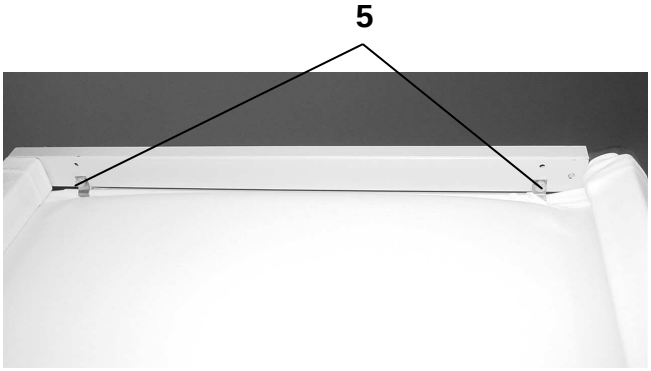
7.1.2. Changing of stretch cover on stretching device head buck / with holding-down function (option)

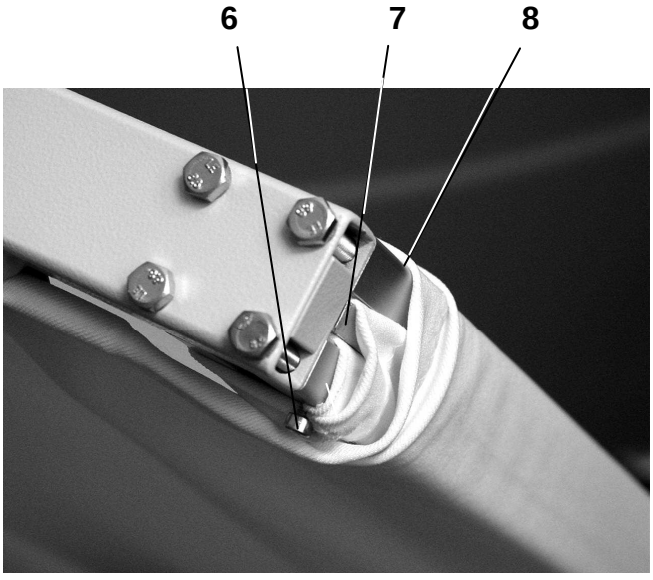
When changing the stretch cover, proceed as follows:

1. Removing stretch cover

- Switch on main switch (see page 43, Ill. 18, Pos. 4).
- Press „Reset“ button (see page 44, Ill. 19, Pos. 2).
- Select screen „Set single track“ in supervisor menu (see separate BRIfashion manual).
- Press pedal „Start“ (see page 46, Ill. 21, Pos. 2). Stretching device swivels to the front.
- Press function key „Stretching device“ (see page 45, Ill. 20, Pos. 1). The stretching device is raised.
- Turn both clamping wheels (Pos. 4) in opposite directions and release stretch cover by turning the profile tube (Pos. 1).
- Unscrew clamping screws on both sides (Pos. 2) and remove fastening strip (Pos. 3) from the stretch cover.
- Release fastening strips from the fixing hooks (Pos. 5) and remove fastening strips.
- Unscrew clamping screws on both sides (Pos. 6).
- Remove fastening strip (Pos. 7)
- Dispose of stretch cover.

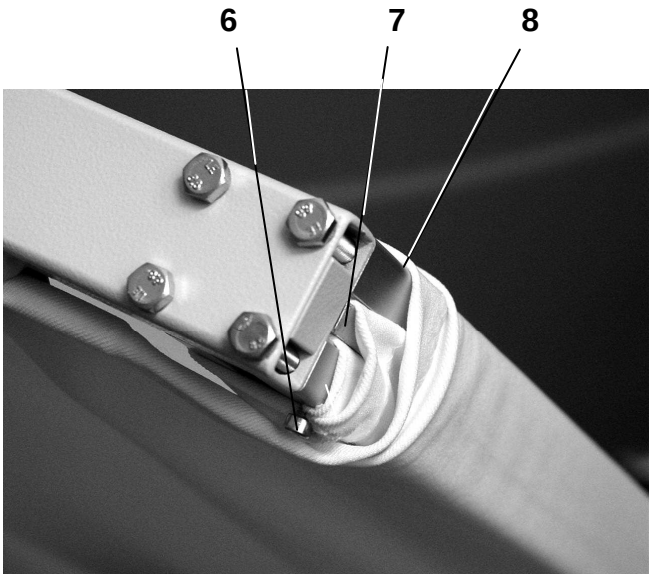


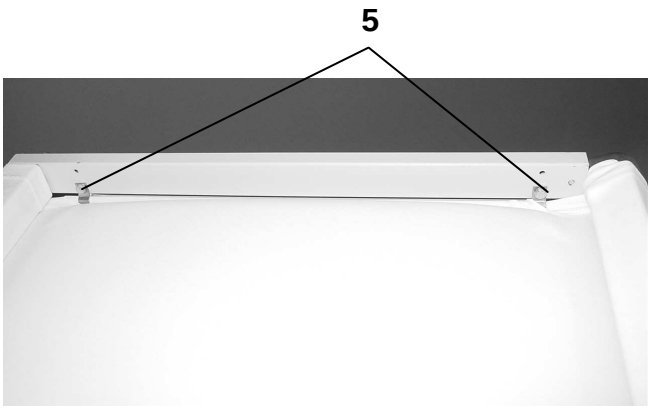


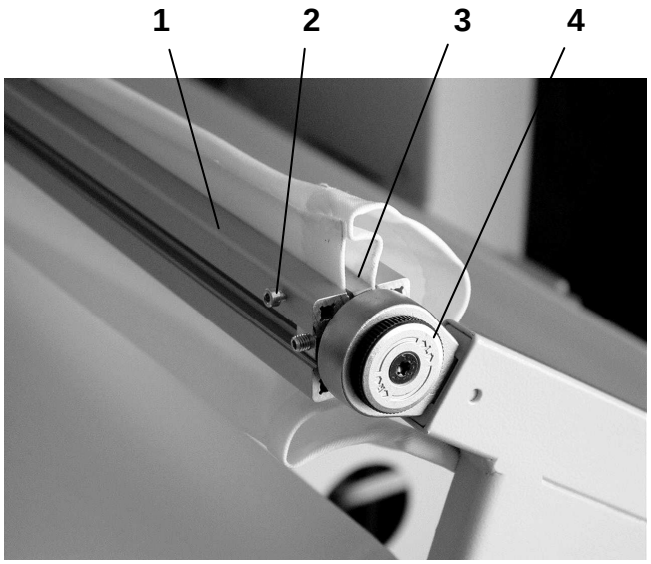


2. Changing covers of stretching device

- Place new stretch cover on lower bucks.
- Slide fastening strip (Pos. 7) into the vertical loops of the stretch cover.
- Place stretch cover around the back frame (Pos. 8).
- Clamp fastening strip (Pos. 7) on both sides with clamping screws (Pos. 6).
- Cut openings in the vertical loops of the stretch cover.
- Slide the round steel through the openings into the vertical loops.
- Clamp fastening strips into fixing hooks (Pos. 5).
- Slide fastening strip (Pos. 3) into the vertical loops of the stretch cover.
- Fasten fastening strip on both sides with clamping screws (Pos. 2) in the profile tube (Pos. 1).

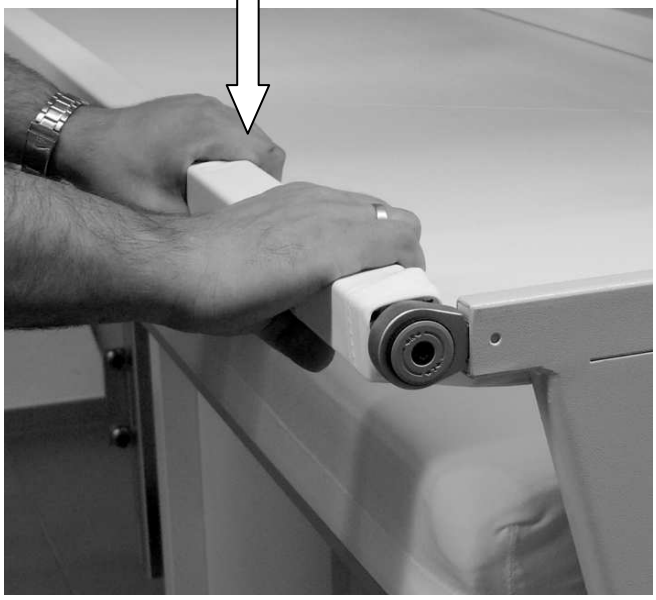






- Turn both clamping wheels (Pos. 9) in opposite directions and tighten stretching device by turning the profile tube (Pos. 10).
- Press function key „Stretching device“ (see page 45, Ill. 20, Pos. 1). The head buck moves into home position.
- Switch off main switch (see page 43, Ill. 18, Pos. 4).

10 9



7.1.3. Changing cover of lower bucks

1. Remove stretch cover from lower buck (see chapter 7.1.1, item 1).
2. Release tension springs (Pos. 1) on the bottom side of the lower buck, remove round steel and dispose of the pressing cover.
3. Slide round steel in loops of new polyester fabric.
4. Pull new pressing cover onto the lower buck taking into account the cover composition.

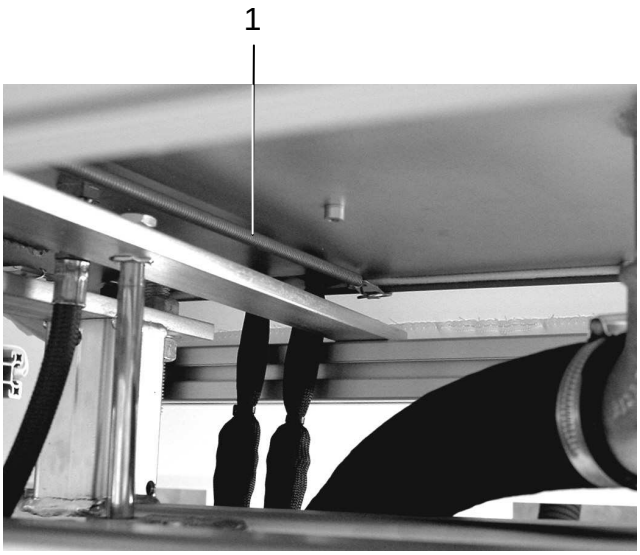
   Cover composition (see chapter 12.4)

   1. Layer - copper wire
   2. Layer - nomex needle felt
   3. Layer - silicon foam
   4. Layer - polyester wire with pressing table cover

Note

Make sure that the seams of the cover are not on the pressing surface.

5. Fasten tension springs (Pos. 1) to the round steel of the cover.



Ill. 22, Changing cover of lower bucks

6. Proceed in the same order for the second lower buck.
7. Place stretch cover on lower bucks (see chapter 7.1.1, item 2).

7.1.4. Changing cover of head buck

1. Unscrew the safety frame (see page 60, Ill. 23, Pos. 1) from the head buck.

Make sure that no safety functions are active.

2. Switch on main switch (see page 43**,** Ill. 18, Pos. 4).
3. Press „Reset“ button (see page 44, Ill. 19, Pos. 2).
4. Use supervisor mode and select track 1 in screen „Set single track“. Slowly close head buck by pressing relevant arrow key (see separate BRIfashion manual).
5. Release all tension springs (siehe Seite 60, Ill. 23, Pos. 2) and remove round steel of the pressing cover.
6. Dispose of pressing cover.
7. Open head buck by approx. 10 cm.
   Use supervisor mode and select track 1 in screen „Set single track“. Slowly open head buck by pressing relevant arrow key (see separate BRIfashion manual).
8. Slide round steel in loops of new polyester fabric.
9. Place new pressing cover on the stretching device with holding-down function or the lower bucks and pay attention to the cover composition.

   Cover composition (see chapter 12.4)

   1. Layer - copper wire
   2. Layer - nomex needle felt
   3. Layer - silicon foam
   4. Layer - polyester wire with pressing table cover

10. Pull pressing cover over head buck and fasten tension springs (Pos. 2) to the round steel of the cover.

Note

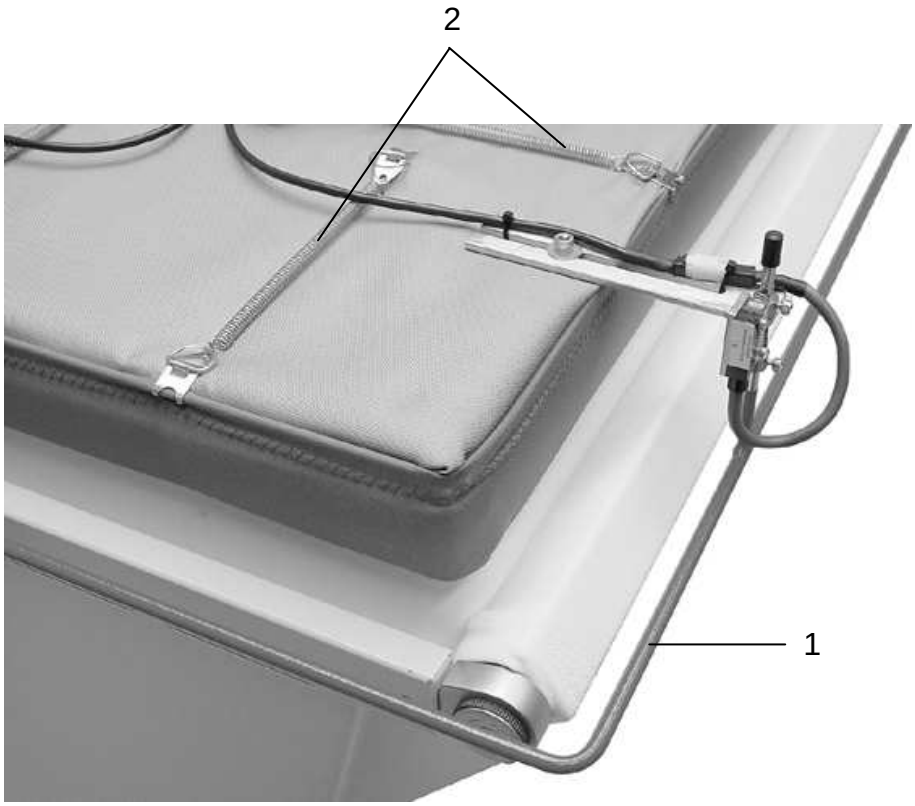
Make sure that the cover is not folded.

11. Exit screen „Set single track“. The head buck opens.

12. Switch off main switch (see page 43**,** Ill. 18, Pos. 4).

13. Mount the safety frame (Pos. 1) to the head buck.

Before commisioning the machine, check the functioning of the safety frame.



Ill. 23, Changing cover of head buck

8. MAINTENANCE / CLEANING

The chapter MAINTENANCE / CLEANING is addressed to qualified staff only. Maintenance, cleaning and repair work must be carried out by qualified staff (definition see chapter 2.4 SAFETY MEASURES) only.

Operating and maintenance staff will be instructed on site by staff of BRISAY-Maschinen GmbH unless otherwise agreed in the purchase contract.

Qualified person
A person who is capable of judging tasks assigned to him/her and of identifying dangers due to his/her technical training, knowledge and experience as well as knowledge of the relevant industrial standards.
The definition follows EN 60204-1:2006+A1:2009.

To assure a faultless operation of the machine, it is indispensable to clean and service the machine on a regular basis.

Appropriate workshop equipment is indispensable for any kind of maintenance work.

During operation, the machine is subject to vibration which might cause bolted and clipped connection to loosen. To prevent damage, check the machine at regular intervals for loose connections (recommendation every three months).

When carrying out installation work above body height, the provided ladders or service platforms must be used or any other ladder meeting the required safety standards. Do not mount on components of the machine. A safety harness should be worn when carrying out maintenance work in greater heights.

Make the maintenance area safe to the extent to which it is necessary.

Inform operating staff before starting with maintenance work. Appoint a person to supervise the work.

Comply with the existing local environmental regulations when disposing of the exchange parts.

Make sure that head buck and lower bucks, as well as all parts in connection with steam and condensate are cool, since there is a **risk of burn!**

Before starting with cleaning, maintenance or repair work (by qualified staff only), the following disconnect procedure must be observed:

1. Cut off steam supply
   - Shut off both valves for steam supply.
   - Depressurise steam system by activating machine start.
   - Make sure that no steam emerges from the machine.
2. Switch off machine from power supply
   - Set main switch on switch cabinet to „0“.
   - Padlock main switch to prevent the machine from being switched on again.
   - Remove power plug.
   - Make sure that no current is carried.
3. Cut off pneumatic
   - Shut off compressed-air lines.
   - Remove air from compressed-air lines.
   - Check if the machine is without pressure.
4. Switch off additional oil heating system or oil heating unit (only with BRI-222/111)
   - It is absolutely necessary to follow the disconnect procedures described in the separate operating instructions!
5. Switch off accessory device (if available)
   - It is absolutely necessary to follow the disconnect procedures described in the separate operating instructions!

In case of non-observance, the life of staff may be in danger.

8.1. CLEANING

Remove oil and grease from the machine at regular intervals, in particular **before** carrying out maintenance and repair work.

Do not use

- chlorinated hydrocarbon, e.g. PER or TRI,
- inflammable, easily gasifying or caustic liquids.

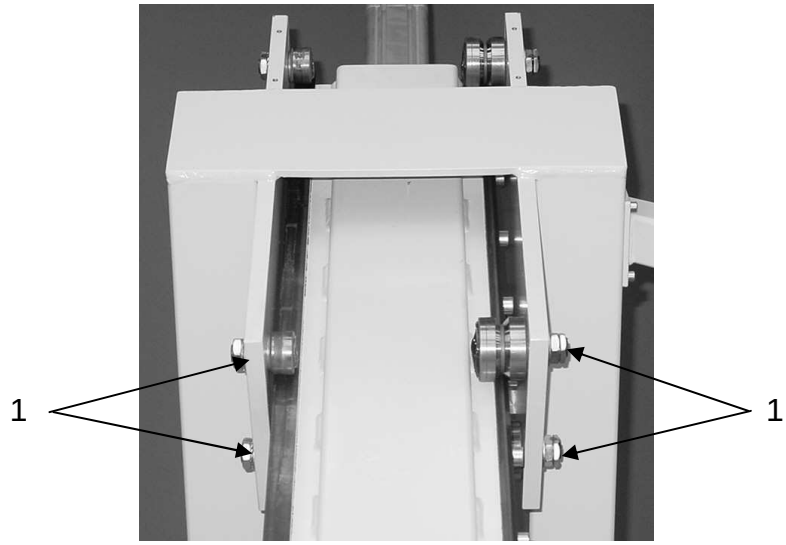
Do **under no circumstances** clean the machine with compressed air or a steam or water jet. Non-observance my result in malfunctions of the machine, in particular regarding the safety functions. This might cause a machine damage or injuries.

- Clean the machine with a fibre-free cloth, included the linear-guidings.

8.2. MAINTENANCE AND INSPECTION TABLE

INSPECTION AND MAINTENANCE PLAN			
Interval	**Parts to be inspected**	**Work to be carried out**	**Remarks**
8 hrs	Safety devices	Functional inspection	see chapter 2.3 BUILT-IN SAFETY SYSTEMS
40 hrs	Maintenance unit compressed air	Visual inspection	Drain off water/oil Pressure range: 6 bar **1 x annually** replace dirty air filter
	Entire machine	Cleaning	Wipe with a clean, lint-free cloth.
	■ Main switch ■ Switch and switch fixtures	Functional inspection	Check and replace if necessary.
160 hrs	■ Manometer pressing pressure	Visual inspection	Pressure range: 0 – 6 bar
	■ Pneumatic valves ■ Cylinders ■ Steam valves ■ Suction valves ■ Hoses and screw connections ■ Bucks	Leak test	Check and replace if necessary. Should leaks be discovered on the bucks, the BRISAY service department has to be informed immediately.
	■ Guiding unit head buck ■ Linear travelling frame	■ Visual inspection for abrasion ■ Check guiding clearance	Should irregularities in the guiding system occur, the BRISAY service department has to be informed immediately.

8.3. LUBRICATION



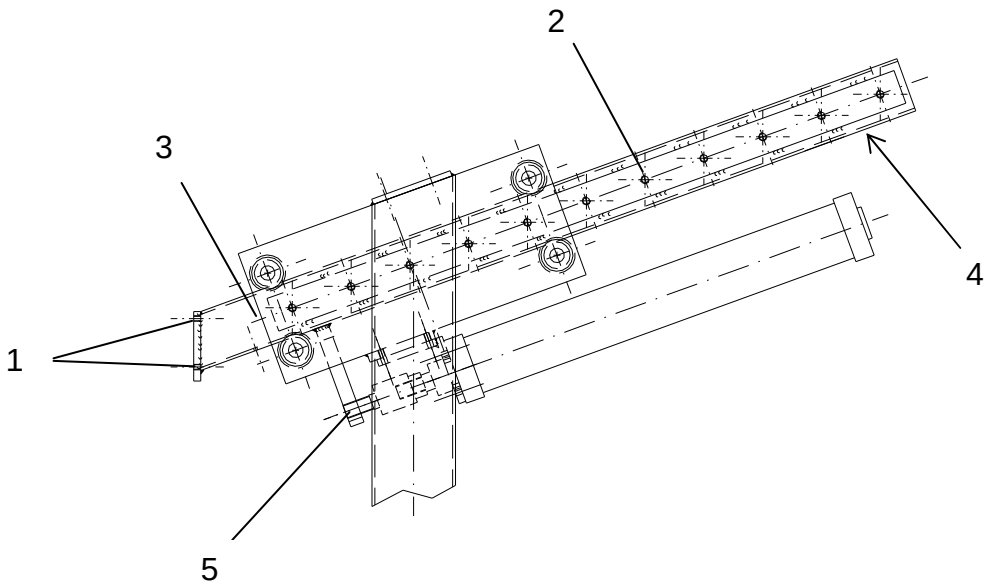
Ill. 24, Lubrication

MAINTENANCE PLAN ROLLER BEARING			
Intervals	**Point of Intervention**	**Work to be carried out**	**Remarks**
500 hrs	Roller bearing (Pos. 1)	Lubrication via grease nipple (1 lifts)	Type of grease KC00147 Grease gun with extension BW00080

8.4. SETTING OF ROLLER BEARING

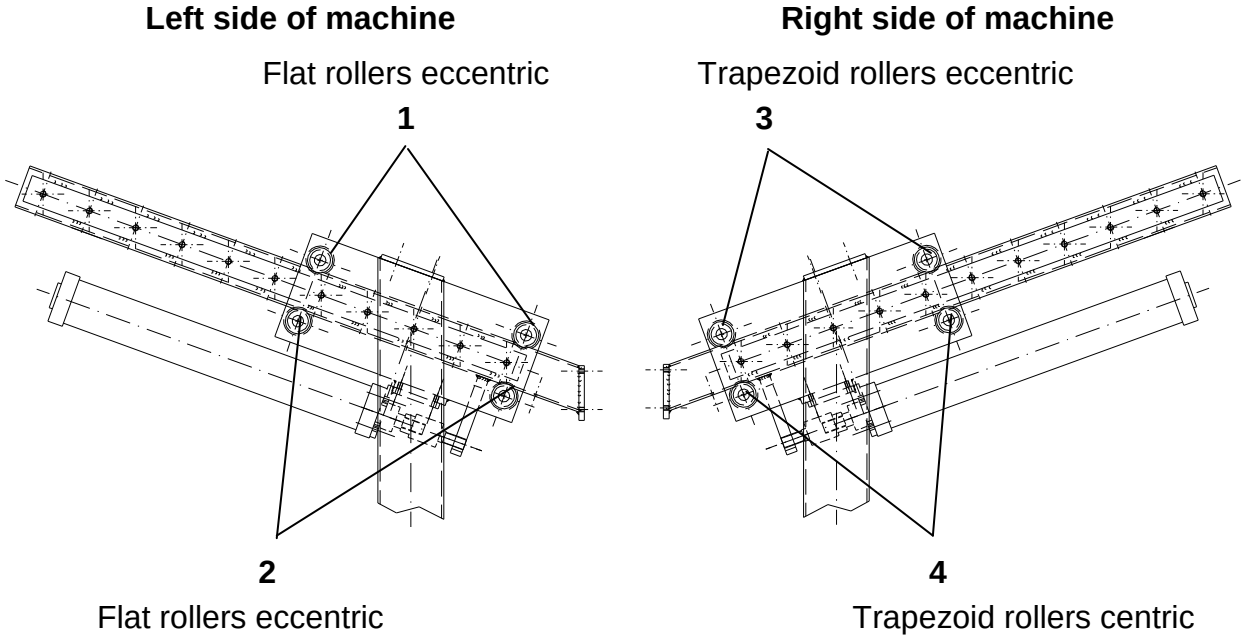
8.4.1. Dismantling of linear travelling frame

1. Disconnect all cable and hose connections on head buck supporting unit.
2. Mark position of head buck supporting unit on travelling arm.
3. Unscrew the 4 joint bolts (Pos. 1) and remove head buck supporting unit.
4. Dismantle shock absorber buffer (Pos. 4).
5. Mark position of travelling arm on flat or trapezoid rail (Pos. 3).
6. Release piston rod of pneumatic cylinder (Pos. 5) and pull travelling arm (Pos. 2) to the front out of the linear travelling frame.



Ill. 25, Dismantling

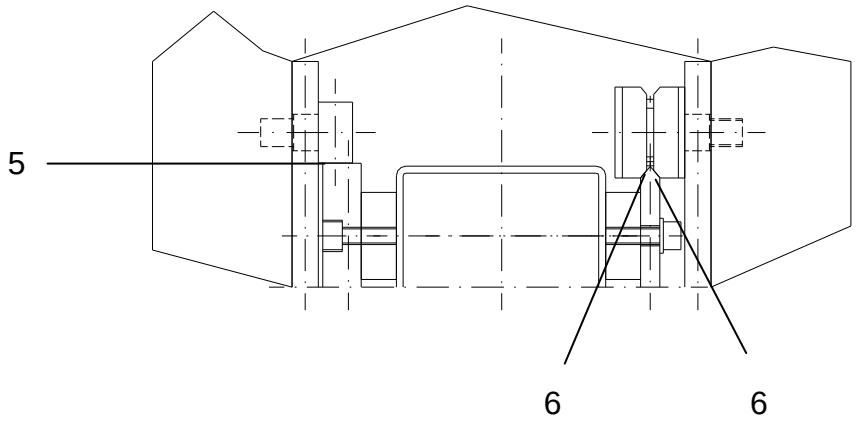
8.4.2. Mounting of linear travelling frame



*Ill. 26***,** *Mounting*

1. Replace flat and trapezoid rollers (Pos. 1 to 4) by new ones. Pay attention to article numbers when mounting them.
2. Tighten both bottom trapezoid rollers on the right side of the machine (Pos. 4).
3. Slide travelling arm (Ill. 25, Pos. 2) carefully back into linear travelling frame.
4. Fasten travelling arm at piston rod of pneumatic cylinder (Ill. 25, Pos. 5). Pay attention to the markings (Ill. 25, Pos. 3).
5. Move travelling arm in centre position of lifting movement and lock it.
6. Fasten both upper trapezoid rollers on the right side of the machine (Pos. 3) with an Allen wrench until it is no longer possible to turn them by hand.
7. Tighten trapezoid rollers (Pos. 3).
8. Fasten both bottom flat rollers on the left side of the machine (Pos. 2) with an Allen wrench.
9. Tighten flat rollers (Pos. 2).

8.4.3. Adjusting



Ill. 27, Adjusting

1. Take a feeler gauge to equalise a clearance of 0.15 mm (Pos. 5) between the upper flat rollers and the flat rail on the left side of the machine ((Ill. 26, Pos. 1) and tighten flat rollers.

2. Loosen the right upper trapezoid rollers (Ill. 26, Pos. 3) and equalise a clearance of 0.1 mm between the trapezoid rollers and the trapezoid rail.

3. Should the trapezoid rollers not be positioned exactly in the trapezoid rail, adjust them with the flat rollers on the left side of the machine (Ill. 26, Pos. 1 + 2).

4. After having adjusted the rollers, fasten head buck supporting unit with the 4 joint bolts (Ill. 25, Pos. 1).

5. Fasten all cable and hose connections.

6. Mount shock absorber buffer (Ill. 25, Pos. 4).

8.5. MACHINE CHECKS

If all functions are faultless, the machine is handed over to the operator.

After having examined and replace the wear parts, check all safety devices for their functioning.

After having finished this work, check

- the machine for loose connections of the supply lines (compressed air, steam, condensate, oil),
- the machine for wear marks or damages and remedy them if necessary,
- the earth connections at the machine,
- that the work has been carried out completely,
- that no tools have been left in the machine,
- that the switch cabinet is closed.

9. REMEDY OF FAULTS / ELIMINATION OF DEFECTS

The facts and indications which are described as **faults** in this chapter are detailed in such a way that they may be remedied by a **instructed person**.
If a fault cannot be remedied, a **qualified person** has to be informed.

The displayed **alarm messages** and the **faults** described in this chapter are detailed in such a way that they may be remedied by a skilled person specialised in

- electrics / electronics
- mechanics / maintenance.

The facts and indications which are described as **recommendations for pressing operations** in this chapter, are detailed in such a way that they may be understood by the respective person mentioned in the column **Person in charge**, either

- an instructed person
- an authorised person or
- a qualified person.

(see definition in chapter 2.4 SAFETY MEASURES)

These members of staff must be equipped with the necessary tools and test mediums.

Before starting with maintenance and repair work, the disconnect procedures (see chapter 3.4) have to be carried out.

Should the stated remedies not produce the desired results, contact the service department of BRISAY-Maschinen GmbH.

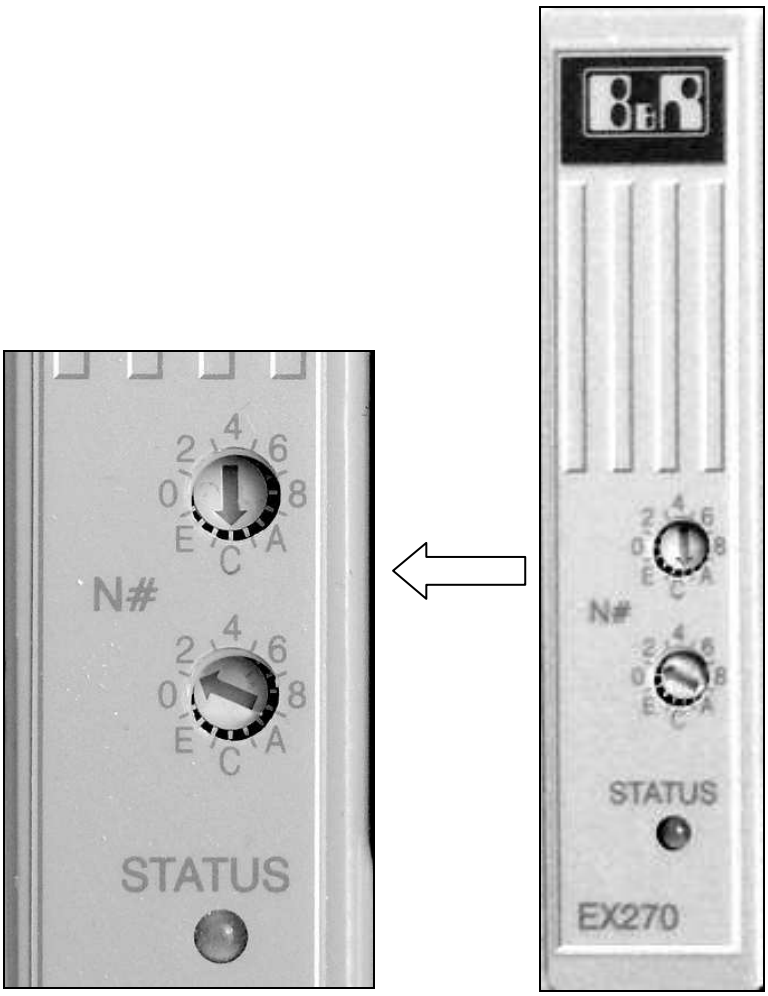
9.1. DESPLAYED ALARM MESSAGES

In case of faults, the following alarm messages are displayed.

The alarm messages are detailed in a separate technical manual.

Alarm message	Cause	Remedy
Module X defective / missing!	■ Module X defective ■ Module X incorrectly plugged	■ Replace module X ■ Plug module X correctly
Module X defective / missing! + Node / bus defective / missing	■ Bus controller or cable defective or connection to panel interrupted	■ Replace bus controller (see chapter 9.1.1). Check cable, replace if necessary
Module X defective / missing! + Control voltage side X	■ Bus controller or cable defective or connection to panel interrupted	■ Replace bus controller (see chapter 9.1.1). Check cable, replace if necessary
Node / bus defective / missing	■ Bus controller or cable defective or connection to panel interrupted	■ Replace bus controller (see chapter 9.1.1). Check cable, replace if necessary
Error programme parameter side X	■ Programme without programmed steps	■ Edit programme or load existing programme
No BRISAY power panel!	■ No original BRIfashion machine control in use	■ Use original **BRIfashion** machine control
Error programme administration!	■ General error of programme administration	■ Confirm message. If error message is displayed again, contact BRISAY.
Side X AI1 set on current mode	■ Switch on module 1 set to „I“	■ Set switch to „U“
Control voltage side X	■ Machine is not unlocked	■ Unlock machine

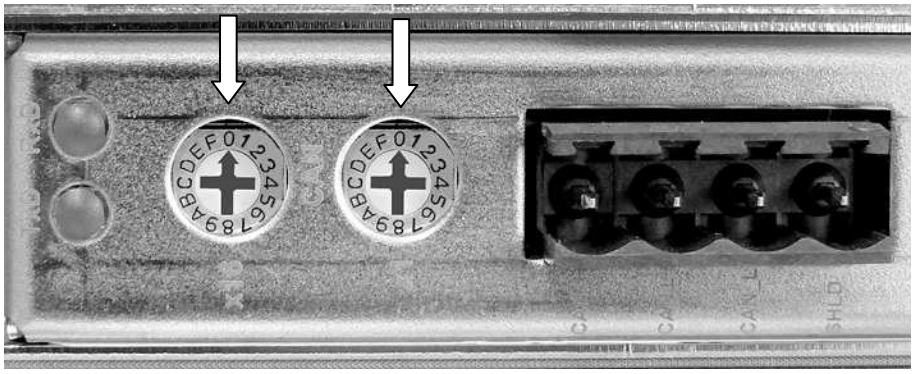
9.1.1. Setting of bus controller



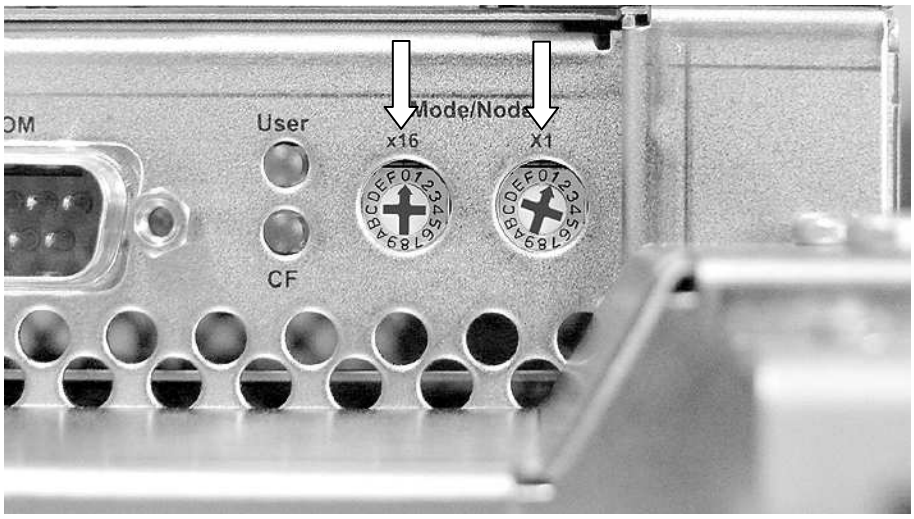
Ill. 28, Setting of bus controller

- The bus controller is located in the switch cabinet. Once replaced, set bus controller according to Ill. 28. Setting of bus controller.

9.1.2. Setting of node switch



Extension bus card IF771



Mainboard

Ill. 29, Setting of node switch

- Check these standard settings in case of problems related to machine control.
  The node switchs are located at the bottom of the BRIfashion machine control in the control panel.

9.2. FAULT, CAUSE, REMEDY

The facts and indications which are described as **faults** in this chapter are detailed in such a way that they may be remedied by an **instructed person**.
If a fault cannot be remedied, a **qualified person** has to be informed.

Fault	Cause	Remedy
No function at all	■ Main switch switched off ■ Emergency stop button activated ■ Programming device is in switch-on mode	■ Switch on main switch. ■ Release emergency stop button. ■ Press touch button START to change into RUN mode.

9.3. DEFECTS, CAUSE, ELIMINATION

The facts and indications which are described as **defects** in this chapter, are detailed in such a way that they may be eliminated by a **person qualified** in

- electrics/electronics
- mechanics/maintenance.

The machine components mentioned in the column „Cause“ are detailed in the supplied electric circuit and pneumatic diagrams.

Defect	Cause	Elimination
No function at all	■ No supply voltage	■ Reconnect power supply and check
	■ Wires not connected correctly	■ Check assignment or connection
	■ Fuse has triggered	■ Replace fuse
	■ No compressed air	■ Reconnect compressed-air supply
	■ Reset button S2 defective	■ Check and replace if necessary
	■ Safety relay K1 defective	■ Check and replace if necessary
	■ Transformator T1 defective	■ Check and replace if necessary
	■ Main switch Q0 defective	■ Check and replace if necessary
	■ Machine not in home position	■ Press emergency switch, check home position and restart machine.
	■ Ball valve V6 closed	■ Open ball valve

Defect	Cause	Elimination
Stretching device does not swivel to the front (option)	■ Cylinder Z3, Z3.1 leak ■ 5/2 directional control valve Y9 defective ■ Pedal S12 defective	■ Check of tightness and replace if necessary ■ Check and replace if necessary ■ Check and replace if necessary
Stretching device does not swivel to the front / back properly(option)	■ Throttle V6, V7, V8, V9 set incorrectly	■ Check and reset or replace if necessary
Stretching device is not lowered/raised (option)	■ Cylinder Z4, Z4.1 leak ■ 5/2 directional control valve Y10, Y11 defective	■ Check of tightness and replace if necessary ■ Check and replace if necessary
Stretching device is not lowered/raised properly (option)	■ Throttle D8, V11, V18, V20, V21 set incorrectly	■ Check and reset or replace if necessary
Stretching device does not swivel to home position	■ 3/2 directional control valve V13 defective ■ 5/2 directional control valve Y9 defective ■ Magnetic switch S15 set incorrectly or defective	■ Check and replace if necessary ■ Check and replace if necessary ■ Check of tightness and replace if necessary
Head buck does not move back and forth	■ Throttle V16 set incorrectly ■ Magnetic switch S15, S17, S18, S19 defective ■ 2/2 directional control valve Y22.1 defective ■ 3/2 directional control valve Y22 defective ■ 5/2 directional control valve Y3 defective	■ Check of tightness and replace if necessary ■ Check and replace if necessary ■ Check and replace if necessary ■ Check and replace if necessary ■ Check and replace if necessary

Defect	Cause	Elimination
Head buck does not move back and forth properly	■ Insufficient compressed-air supply ■ End-of-travel damping set incorrectly ■ Throttle D1, D2 set incorrectly ■ Shock absorber defective	■ Check compressed-air supply provided by customer ■ Readjust end-of-travel damping of cylinder Z1 ■ Check and reset or replace if necessary ■ Check and replace if necessary
Head buck is not raised/lowered	■ Cylinder Z2 leak ■ Cylinder Z0 defective ■ 5/2 directional control valve Y6, Y7 defective ■ Magnetic switch S16 defective	■ Check of tightness and replace if necessary ■ Check and replace if necessary ■ Check and replace if necessary ■ Check and replace if necessary
Head buck is not raised/lowered properly	■ Insufficient compressed-air supply ■ Pressure controller Y28 defective ■ Cylinder Z2 leak	■ Check compressed-air supply provided by customer ■ Check and replace if necessary ■ Check of tightness and replace if necessary
Programme does not start	■ Magnetic switch S20 defective	■ Check and replace if necessary
No pressing pressure head buck	■ Pressure controller Y28 defective ■ Pressure levels not programmed ■ 5/2 directional control valve Y6 defective	■ Check and reset or replace if necessary ■ Check pressing programme ■ Check and replace if necessary

Defect	Cause	Elimination
No steam in head buck	■ No or not enough steam supply ■ Steam valve Y1, Y1.1, Y1.2, Y1.3 set incorrectly or defective ■ Relay K2, K3 defective	■ Check steam supply provided by customer ■ Check and reset or replace if necessary ■ Check and replace if necessary
No steam in lower bucks	■ No or not enough steam supply ■ Steam valve Y2, Y2.1, Y2.2, Y2.3 set incorrectly or defective ■ Relaiy K4, K5 defective	■ Check steam supply provided by customer ■ Check and reset or replace if necessary ■ Check and replace if necessary
Stretching / additional stretching head buck does not work	■ Pressure control V14 set incorrectly or defective ■ 5/2 directional control valve Y11, Y20 defective	■ Check and reset or replace if necessary ■ Check and replace if necessary
Stretching / additional stretching lower buck does not work	■ Pressure control V15 set incorrectly or defective ■ 5/2 directional control valve Y12, Y13 defective	■ Check and reset or replace if necessary ■ Check and replace if necessary
Stretching device head buck and lower buck move into home position before removal of trousers	■ Photoelectric barrier S10 defective	■ Check and replace if necessary
Suction lower bucks does not work	■ No low pressure ■ Suction valve Z6, Z7 defective ■ 5/2 directional control valve Y4, Y8 defective ■ Pedal S11, S13 defective	■ Check suction provided by customer ■ Check and replace sealing or valve if necessary ■ Check and replace if necessary ■ Check and replace if necessary

Defect	Cause	Elimination
Fine suction does not work (option)	■ No low pressure ■ 5/2 directional control valve Y24 defective ■ Suction valve Z6, Z7 set incorrectly	■ Check suction provided by customer ■ Check and replace if necessary ■ Check and replace sealing or valve if necessary
Suction head buck does not work	■ No low pressure ■ Suction valve Z8, Z8.1 defective ■ 5/2 directional control valve Y19 defective	■ Check suction provided by customer ■ Check and replace sealing or valve if necessary ■ Check and replace if necessary
Aeration head bucks does not work (option)	■ Aeration valve Z10, Z10.1 defective ■ 5/2 directional control valve Y23 defective	■ Check and replace sealing or valve if necessary ■ Check and replace if necessary
Edge suction lower bucks / head buck does not work	■ No low pressure ■ Suction valve Z9 Z9.1, Z9.2 defective ■ 5/2 directional control valve Y18 defective	- Check suction provided by customer ■ Check and replace sealing or valve if necessary ■ Check and replace if necessary

9.4. RECOMMENDATIONS FOR PRESSING OPERATIONS

The facts and indications which are described as **recommendations for pressing operations** in this chapter, are detailed in such a way that they may be understood by the respective person mentioned in the column **Person in charge**, either
- an instructed person
- an authorised person or
- a qualified person.

Pressing result	Cause	Remedy	Person in charge
Creases	Pressing covers do not correspond to the cover composition specified by BRISAY. ⇒ Cover composition is too high – the head buck displaces the garment and creases are pressed in the garment.	Adjust composition of pressing cover to pressing bucks.	**Authorised person**
	Garment has not been placed properly on the lower buck. ⇒ The head buck presses creases.	Observe method	**Instructed person**
Bad pressing work	Steam volume is too low because the steam valve is incorrectly set or defective.	Set steam valve	**Authorised person**
		replace if necessary	**Qualified person**
	Steam volume is too low because covers are dirty and steam is prevented from reaching garment.	Replace covers	**Authorised person**
	Steam volume is too low because steam hose is kinked or defective.	Remove kink	**Authorised person**
		Replace hose	**Qualified person**

Pressing result	Cause	Remedy	Person in charge
Waves	Cover composition is too high or too low.	Readjust cover composition to pressing bucks	**Authorised person**
	Steam distribution is not optimal.	Change covers	**Authorised person**
	Steam volume is too high.	Set steam valve	**Authorised person**
	Pressure is too high.	Set pressure on garment	**Instructed person**
Distortion	Cover composition is too high.	Readjust cover composition to pressing bucks	**Authorised person**
Soiled garment	Covers are dirty.	Change covers	**Authorised person**
	Stains due to oil in the compressed air.	Customer's compressed-air supply defective	**Qualified person**
Marks / Shine	Pressure of the head buck on the garment is too high.	Reset pressing pressure head buck	**Instructed person**
	Pressing covers are pressed flat and no longer have the elastic force to counteract the pressure of the head buck.	Change pressing covers	**Authorised person**
	Covers are dirty and not enough blowing air reaches the garment.	Change pressing covers	**Authorised person**
	Blowing air is insufficient.	Extend hose connection	**Qualified person**
	Suction is too strong.	Install regulating valve	**Qualified person**

10. EMERGENCY

In case of danger, an emergency shut-down must be carried out.

In case of emergency:

- press emergency stop button which is located on the control panel,
- activate the safety frame on the head buck,
- switch off main switch on the switch cabinet,
- remove power plug.

The following procedure is triggered:

- the head buck moves into home position,
- the stretching device with holding-down function (option) moves into home position,
- steam exhaust is switched off.

The emergency stop button may be released by pulling.

In **case of fire** switch off the machine and remove power plug.

Switch off all energy supplies:

- steam
- compressed air.

Before operating the machine

- find out where the fire extinguisher is located,
- learn how to handle the fire extinguisher,
- inform yourself on how to report fires without delay.

A risk of fire may be caused by inflammable liquids and mixtures of liquids and gases (e.g. oil oxygen mixture).

Fire extinguishers to be used in accordance with fire classification DIN EN 2:

- powder fire extinguisher for class A, B, C fires designed for solid, liquid and gaseous substances,
- powder fire extinguishers for class D fires designed for inflammable metal,
- carbon dioxide fire extinguishers for liquid, gaseous and solid substances.

11. DISMANTLING / DISPOSAL

The double leg pressing machine is mainly built of steel (apart from the electrical equipment) and must be disposed of in accordance with the existing local environmental regulations.

Oil and cleaning agents must be disposed of in accordance with the local regulations as well.

Residues as well as the cover material must be disposed of in accordance with the instructions given by the material manufacturer or the local regulations.

12. SPARE PARTS LISTS

We draw your attention in particular to the fact that we cannot test and release spare parts and accessories which have not been supplied by us. The fitting and/or use of such products may therefore have a negative effect on the designed characteristics of the machine.

BRISAY-Maschinen GmbH shall not be liable for any damage caused due to the use of non-original parts and non-original accessories.

The spare parts with the relevant article numbers are described in this chapter as well as on the supplied CD „Spare parts catalogue“.

When enquiring or ordering in writing or on the phone, please always quote

- type of machine (see cover),
- number of machine (see cover),
- article number of the relevant component.

Address
BRISAY-Maschinen GmbH

Mittelweg 4

D-63762 Grossostheim-Ringheim, Germany

Phone: ++49 (0) 6026/997-0

Fax: ++49 (0) 6026/997-100

e-mail: info@brisay.com

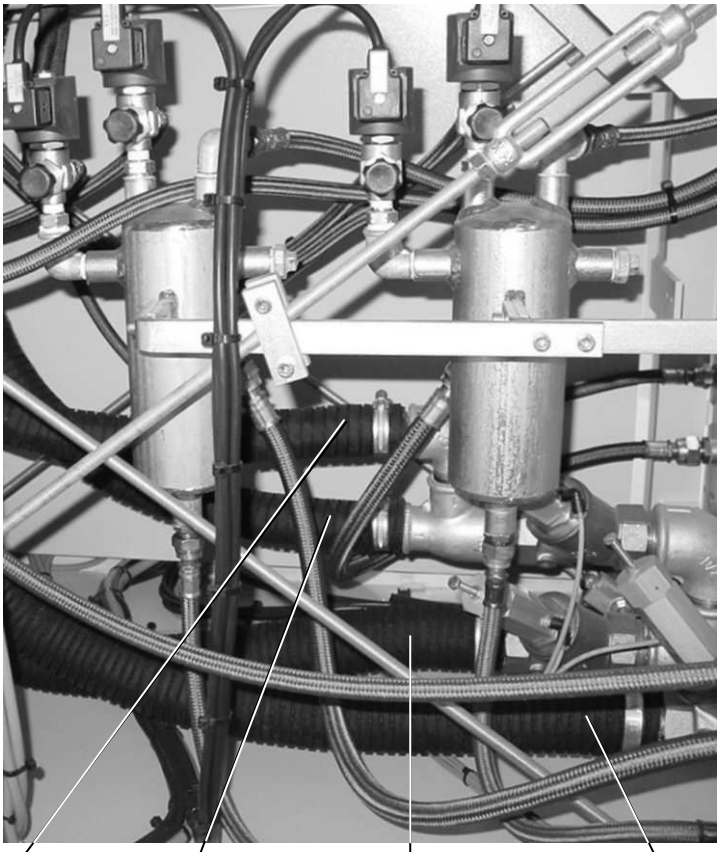
www.brisay.com

Service department: Tel: ++49 (0) 6026/997-0

Fax: ++49 (0) 6026/997-100

e-mail: service@brisay.com

12.1. SUCTION HOSES



KS51033
1 m

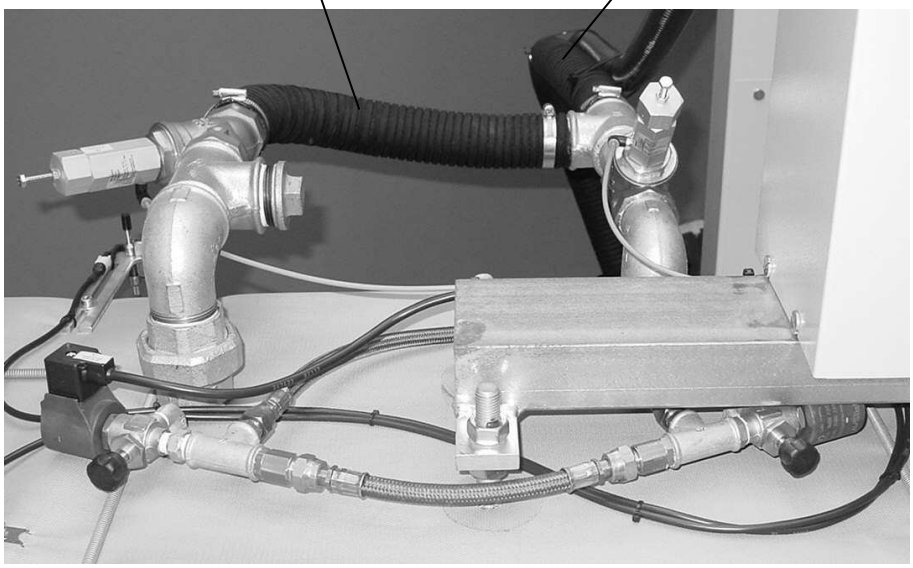
KS51033
1 m

KS51048
1,5 m

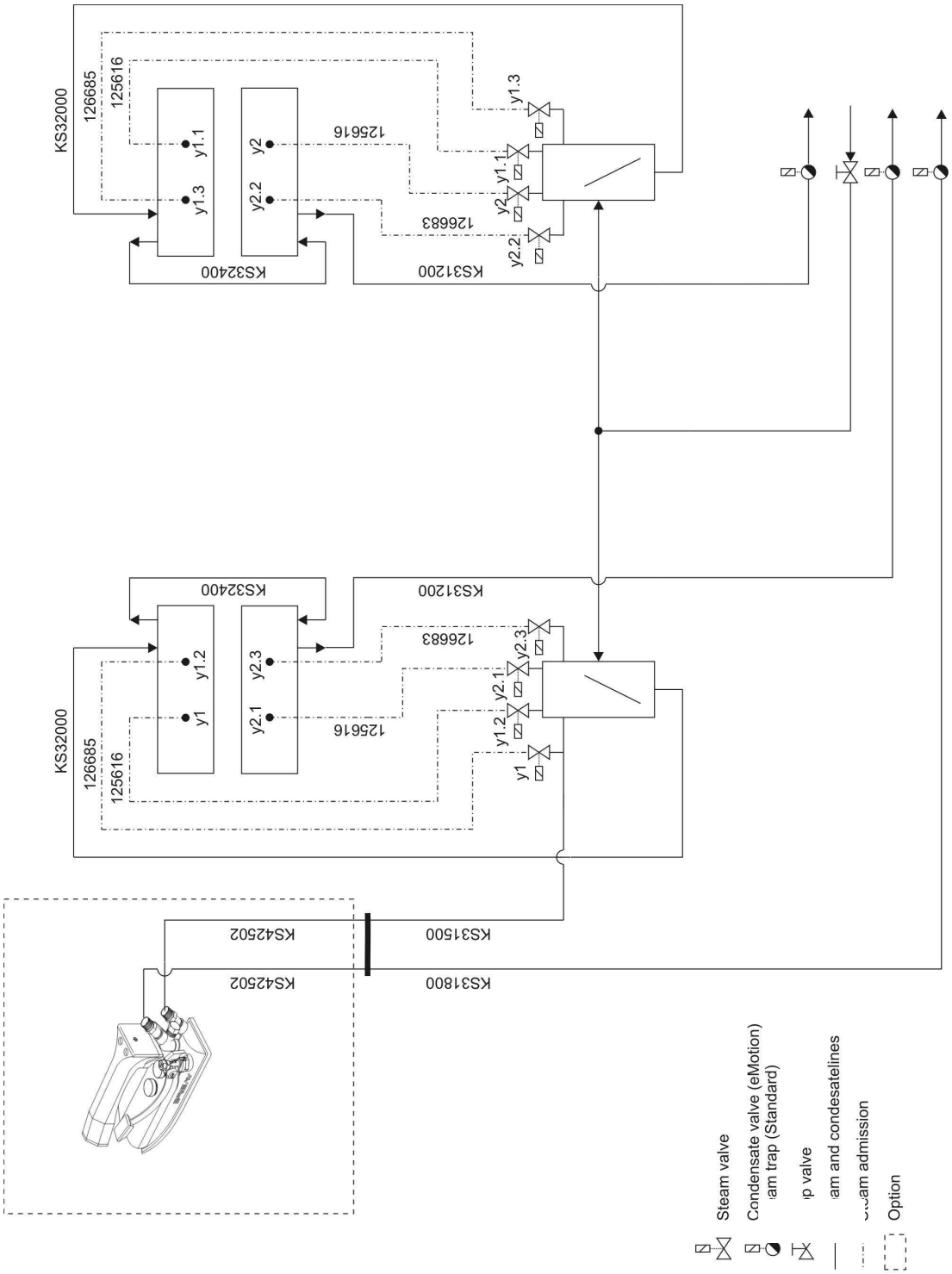
KS51048
1,6 m

KS51048; 0,45 m

KS51048; 1,2 m

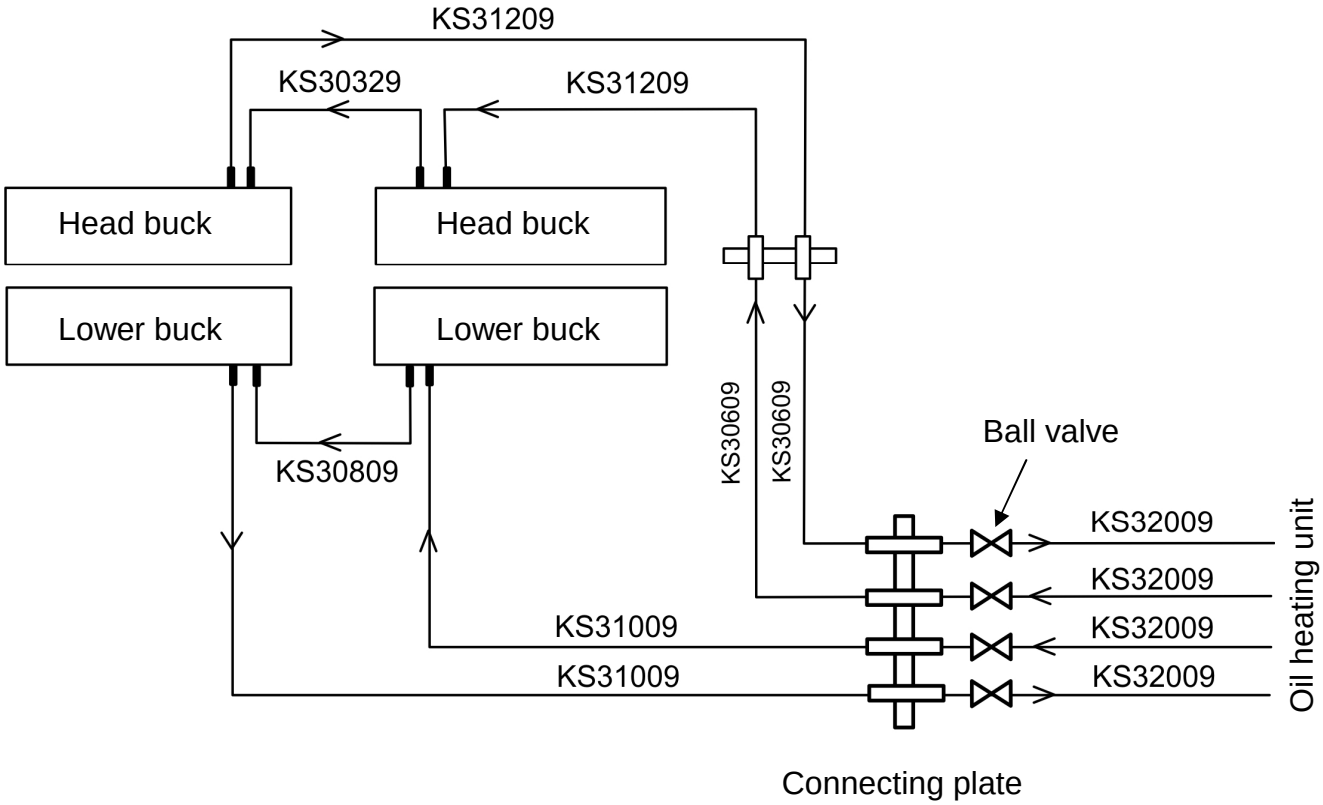


12.2. STEAM AND CONDENSATE PLAN



Steam system plan no.:	24-0222-002 / Page 1

12.3. SPARE PARTS FOR OIL SUPPLY LINES (ONLY WITH BRI-222/111)



Steam system plan no.:	24-0222-002 / Page 2

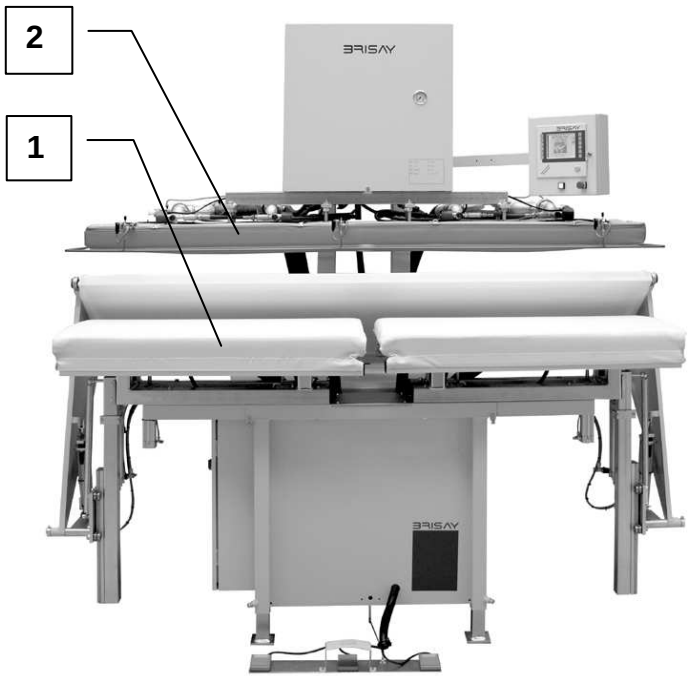
12.4. COVERMATERIAL

BRI-222 Doppelbein-Bügelmaschine

BRI-222 Double Legger Pressing Machine

Bitte geben sie bei jeder Bestellung von Fertigware die Maschinen Nr. und Form Nr. an.

Please give us the machine no. and buck no. for every order of ready made parts.



Maschinen Nr. :

Machine no.: _____

Form Nr. :

Buck no.: _____

BRI-222 Doppelbein-Bügelmaschine
BRI-222 Double Legger Pressing Machine

	Artikelbezeichnung der Bezugslagen, beginnend auf der Metall-Bügelform	**description of the layers, starting at the metall-iron buck**	Meterware / yard goods	Fertigware einzeln / ready-made single goods	Fertigware komplett / ready-made complete set	Fertigware Verschleiß Set / ready-made wear and tear kit	Warenbreite / width of material **cm**	Verbrauch lfm. / qty. linear meter. **m**
1					C102XX01	C102XX02		
	1. Kupferdrahtgewebe	1. copper wire	KG20030	L11	•		130	2,00
	2. Nomex Nadelfilz 6 mm	2. nomex needle felt 6mm	KG00105	L12	•	•	180	2,10
	3. Silikonschaum 10 mm	3. silicon foam 10 mm	KG10092	L13	•	•	50	4,00 = 2 Platten
	4. Polyestergewebe mit Bügeltischbezug vernäht	4. polyester wire with pressing table cover	KG00050 KG00015	L14	•	•	160 150	2,10 1,00
	5. Stretch weiß	5. stretch white	KG00020	L15	•	•	130	4,70
2						C102XX03		
	1. Kupferdrahtgewebe	1. copper wire	KG20030	L21	•		130	
	2. Nomex Nadelfilz 6 mm	2. nomex needle felt 6 mm	KG00105	L22	•	•	180	
	3. Silikonschaum 10 mm	3. silicon foam 10 mm	KG10092	L23	•	•	50	
	4. Polyestergewebe mit Bügeltischbezug vernäht	4. polyester wire with pressing table cover	KG00050 KG00015	L24	•	•	160 150	
	5. Stretch weiß	5. stretch white	KG00020	L25	•	•	130	

Bitte geben Sie bei jeder Bestellung von Fertigware die Maschinen Nr. und Form Nr. an.
Please give us the machine no. and buck no. for every order of ready made parts.

13. EC DECLARATION OF CONFORMITY

EG-Konformitätserklärung / EC declaration of conformity /
Declaración CE de conformidad / Dichiarazione CE di conformità / EC Uygunluk sertifikası /
Deklaracja zgodności WE / ЕС Декларация за съответствие / ЕС-Соответсвенное объяснение

Typ: BRI-222 / 101
BRI-222 / 111

Maschinennummer/ Machine number: _____

Hiermit erklären wir, dass die Bauart des genannten Geräts in der gelieferten Ausführung folgenden einschlägigen Richtlinien entspricht:

Herewith we declare that the supplied model complies with the following provisions applying to it:

Por la presente, declaramos que el modelo suministrado satisface las disposiciones pertinentes siguientes:

Con la presente, si dichiara che il modello fornito è conforme alle seguenti disposizioni pertinenti:

Isbu belge ile temin edilen makinanin asagidaki normlara uygun oldugunu teyit ederiz:

Niniejszym oświadczamy, że wymienione urządzenie w dostarczonej wersji odpowiada poniższym wytycznym WE:

С настоящето декларираме, че конструкцията на уреда в доставеното му изпълнение отговаря на следните отнасящи се директиви:

Мы заявляем?что способ постройки названного аппарата в поставляемом исполнении соответствует специальным директивам руководящих принципов

EG-Richtlinie Maschinen 2006/42/EG **EMV-Richtlinie 2004/108/EG**

Angewandte harmonisierte Normen, insbesondere:	Applied harmonized standards, in particular:
Normas armonizadas utilizadas, particolarmente:	Norme armonizzate applicate in particolare:
Asagida belirtilen standartlara uygundur:	Zastosowane, współbrzmiące normy, w szczególności:
Приложени хармонизирани норми, специално:	Прикладные согласованные нормы, в частности:

DIN EN ISO 12100-1 (04/2004) **DIN EN ISO 12100-2 (04/2004)** **DIN EN 60204-1 (06/2007)**
DIN EN 61000-6-2 (03/2006) **DIN EN 61000-6-4 (09/2007)**

Bevollmächtigter für die Zusammenstellung der technischen Unterlagen:

Authorized representative for the compilation of the technical documents:

La persona autorizada para la disposición de los documentos tecnicos:

Delegato per la compilazione dei documenti tecnici:

Teknik dökümanlarin telif hakkina yetkili tek firma:

Jednostka odpowiedzialna za przedstawienie właściwej dokumentacji technicznej:

Упълномощен за окомплектоването на техническата документация:

Уполномоченный для составления технической документации:

Brisay-Maschinen GmbH

Brisay-Maschinen GmbH
Mittelweg 4
D-63762 Grossostheim-Ringheim

Ringheim, 12.01.2010 _____

i.V. Reinhold Erbacher

EG-Konformitätserklärung / EC declaration of conformity / Déclaration "CE" de conformité
Declaraçao CE de conformidade / UE-Declaratie de conformitate / EU-Izjava o sukladnosti /
EU megfelelőségi tanúsítvány

Typ: BRI-222 / 101
BRI-222 / 111

Maschinennummer/ Machine number: _____

Hiermit erklären wir, dass die Bauart des genannten Geräts in der gelieferten Ausführung folgenden einschlägigen Richtlinien entspricht:
Herewith we declare that the supplied model complies with the following provisions applying to it:
Par la présente, nous déclarons, que le modèle fourni correspond aux dispositions pertinentes suivantes:
Com a presente, declaramos que o modelo fornecido da está em conformidade com as disposiçoes pertinentes, a saber:
Prin prezenta declaram ca, tipul de constructie al utilajului, in forma livrata, corespunde urmatoarelor Normative admise:
Ovime izjavljujemo,da oblik gradnje spomenutog uredjaja u isporučenoj izvedbi odgovara slijedećim navedenim smjernicama:
Kijelentjük, hogy az alábbi berendezés a következő biztonsági előírásoknak megfelel:

EG-Richtlinie Maschinen 2006/42/EG

EMV-Richtlinie 2004/108/EG

Angewandte harmonisierte Normen, insbesondere:
Normes harmonisées utilisées, notamment:
Normative armonizate utilizate, in special:
Megfelel az alábbi szabványoknak:

Applied harmonized standards, in particular:
Normas harmonizadas utilizadas, em particular:
Primjenjene harmonizirane norme,osobito:

DIN EN ISO 12100-1 (04/2004)
DIN EN ISO 12100-2 (04/2004)
DIN EN 60204-1 (06/2007)
DIN EN 61000-6-2 (03/2006)
DIN EN 61000-6-4 (09/2007)

Bevollmächtigter für die Zusammenstellung der technischen Unterlagen:
Authorized representative for the compilation of the technical documents:
Fondé de pouvoir pour l'établissement des documents techniques:
Procurador com poderes para a compilação da documentação técnica:
Imputernicitul pentru compunerea documentatiei tehnice:
Opunomoćenik za sastav tehničke dokumentacije:
A technikai dokumentumok összeállításáért felelős felhatalmazott képviselő:

Brisay-Maschinen GmbH

Brisay-Maschinen GmbH
Mittelweg 4
D-63762 Grossostheim-Ringheim

Ringheim, 12.01.2010

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i.V. Reinhold Erbacher

Alphabetical Index

D

E

F

G

H

I

L

M

O

P

T

U

W