



IRONING PRESSING MACHINERIES – FUSING PRESSES

Operating Manual
Perfect PD & Perfect PD S+B



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1. ATTENTION!!!

Please read this instruction manual very carefully before you start using your new Ironing Table.

The customer by purchasing this product declares that he is fully aware, and accepts everything mentioned in this operating manual.

Primula SA assumes neither responsibility for any errors herein, nor for incidental nor for resulting damage in connection with the performance or use of this operating manual.

You may not copy, reproduce, or translate this operating manual, or parts of it, to another language without prior written consent of Primula SA

Any information in this manual may be subject to change without any prior notice.

CAUTION! PLEASE READ CAREFULLY THE INSTRUCTION MANUAL BEFORE INSTALLING THE IRONING TABLE!!!

2nd edition – July 2017

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2. Technical Details

2.1 Identification Data

The Ironing Table, that you have purchased, is a machine of high advanced technology with many advantages, unique in its kind. It is manufactured according to International and European safety standards by a company with experience, since 1969, in this sector. Congratulations for your choice!

Regarding its characteristics, the Ironing Table includes a serial number plate (see below) where all its specifications are displayed. Every warning and symbol that is placed on the Ironing Table is in accordance with the specifications of the European standards.

The serial number plate has been placed in a visible place on the Ironing Table and is made from fadeless material.

Amongst others, the Serial Number plate displays the following:

- Company Logo
- Manufacturer Information
- Model
- Serial Number
- Rated Voltage of Use
- Rated Frequency of Use
- Year of manufacturing
- Accumulated Installed Wattage



Picture 1: Serial Number Plate

2.2 Use of the Instruction Manual

The correct assembly and adjustment of the machine is vital to the safety of the user and the machine’s life span. For this reason, the installation, alteration, replacement or extension of the machine should only be performed by qualified personnel.

Under no circumstances is interventions allowed in the machine, unless it’s for the planned maintenance by an unauthorized engineer.

If you remain uncertain regarding the correct assembly of the machine even after reading the instructions, contact the manufacturer or an authorized representative before starting the operation of the machine.

2.3 Technical Characteristics

Ironing Table with heating, adjustable suction and blowing through a lever with 0-100% suction indicator.

For ironing readymade ladies’/children’s garments. Suitable for garment industries,

2.4 Technical Description

Model	PD	PD S+B
Height adjustment	78-91cm with amortisseur	78-91cm with amortisseur
Heating	1kW	1kW
Blowing	NO	0,75HP
Suction	0.75HP	0.75HP
Power supply	230V-1ph-50Hz or 400V-3ph-50Hz	230V-1ph-50Hz or 400V-3ph-50Hz

3. General Rules and Warnings

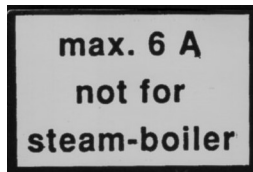
3.1 General rules of using the Ironing Table

For the safe usage of your Ironing Table, please read the following operating instructions carefully, as listed below:

- Install, use and maintain the Ironing Table according to the instructions in this manual. Otherwise, the manufacturer has no responsibility for the possible failed operation or safety.
- Before connecting the power supply, check that the voltage corresponds to the voltage indicated on the technical specifications.
- Connect the machine only to a power supply that meets the minimum required frequency and is properly grounded. Do not leave the Ironing Table while it is operating and is on power without supervision.
- Use the Ironing Table **ONLY** for the intended purpose in accordance with the current instruction manual and only with the accessories that are provided or that are intended for this specific Ironing Table. The manufacturer is not liable for any damages resulting from misuse or wrong use of the Ironing Table.
- **DO NOT** touch the power supply with wet hands.
- Do not clean the Ironing Table with corrosive or other damaging materials/chemicals.
- Never use the Ironing Table to support any other machine or structure.
- **It is strictly prohibited to do any kind of welding or alterations on the Ironing Table or its parts.**
- **It is strictly prohibited to remove any protective device/guards.**
- **It is strictly prohibited to intervene in the control units/circuit boards of the Ironing Table.**
- **It is strictly forbidden to do any modification to the technical specifications of the machine (electrical or mechanical) by third persons.**
- Please contact your dealer or the manufacturer for any malfunction or further information requests.

3.2 Warning marks placed on the Ironing Table

Each ironing board has the following attention marking



The operator of the system has the obligation to be informed himself regarding the dangers which may occur during usage, so that he/she can avoid them or minimize their occurrence as best as he/she is able to.

4 Instructions for Installation

4.1 Installation

- Put the Ironing Table in the designated area of your choice and align the machine by increasing/decreasing the height of its feet **No 31 (see the drawing on page 10)**. Make sure that the ironing Table is stable and the ironing surface flat.
- Adjust top-flat height according to the height of each operator. Make sure that after the adjustment the knob is tightly blocked.

4.2 Electrical Connection

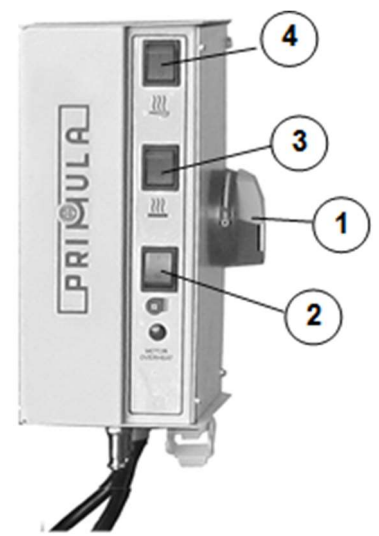
For the electrical connection and above all for the power supply, please follow carefully the instructions of the wiring diagram (enclosed) as well the warning signs symbols attached on the machine. In case you have purchased a single phase machine 230V, connect the machine to the power into the socket 230V/16A. The connection should be done with 3-phase 3X1,5 mm (1 phase, 1 neutral, 1 grounded). The power should be provided with a fuse 10A. If the machine is 400V/3 phase, the connection should be made to a 5-poles cable 5X1,5 mm (3 phase, 1 neutral, 1 grounding). The power should be secured with a 3-poles safety switch (3X10A).

For any device that is connected to a 3-phased current, make sure that the rotation of the motor is done clockwise.

CAUTION! For your own safety, pay attention to all the warning labels (yellow colored) that are placed on the machine. The manufacturer bears no liability for any damages or accidents due to faulty supplying network or to not specified personnel.

5. Operating Instructions

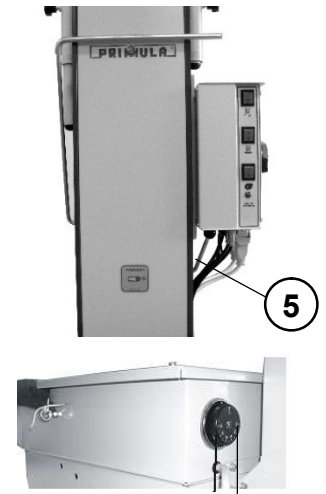
For the instructions mentioned in the current section please see the below image (picture 2).



5.1 Activation Instructions

- Turn on the main switch **No 01**
- Turn on the switch **No 02** to activate the suction.
- Turn on the switch **No 03** to activate the heating on the ironing surface.
- Switch the thermostat **No 06** that is placed below the buck to temperature 110°C during the winter and to 90°C during the summer.
- Turn on the switch **No 04** to activate the heating of the ironing bucks.
- Whenever you want to activate the suction, step lightly on the foot pedal.
- Adjust the intensity of the suction through the lever **No 05**, which is located on the chimney. From 0% - 100% depending on the fabric (weight, quality etc.).
- Adjust the amount of steam from the steam generator in proportion to the intensity of the suction to avoid the liquidification of the steam on the ironing surface. Thinner fabric requires smaller amounts of steam, while thicker fabric requires larger amounts.

Picture 2: Switches



5.2 Additional instructions

***In case the ironing table disposes a Vario iron system (optional):**

- Hook the steam iron from the balancer and adjust the distance of the steam iron from the working surface (approximately 5cm). After you have finished ironing, unhook the steam iron from the balancer and put it on the iron rest mat.

**** In case the ironing table disposes blowing system of air:**

- Adjust the pressure of the blowing based on the fabric at hand (weight, quality etc.) from the lever located on the body of the ironing surface.
- To use the blowing step lightly on the foot pedal.

***** Interchange Suction and Blowing air to and from the bucks**

If you want to interchange the suction/blowing air from the ironing surface to the bucks, then pull the buck over the ironing surface and automatically the air will switch from the ironing surface to the bucks and vice versa.

6. Maintenance

- Make sure that the covers of the table and the ironing buck remain clean, in order to have high performance of suction and blowing air. Wash periodically the blue polyester fabric and the foam blue in the washing machine (30-40 °C). In case you use felt molleton instead of blue foam, do not wash it in the washing machine, but wash it by hand. Replace them regularly, in order to keep high suction and blowing performance.

- Clean the dust of the fan wheel /impeller at least 2-3 times per year.
- Clean periodically and grease the arm's as well as the buck's bearings.
- Clean periodically the internal parts of the table as well as the electronic circuit by using compressed air.
- Keep the machine clean.

The manufacturing company suggests:

- Quick daily optical control of the ironing table (locate loose wires etc.) and every 3 month an optical control of each part inside the ironing table

CAUTION!

Before doing maintenance work, please disconnect the machine from the electrical power supply.

6. Troubleshooting

For the instructions mentioned in the current section please see the **drawing on page 10.**

7.1 The vacuum does not function properly

- Check if there is power supply.
- Check if the power supply cable **No 82** has for some reason cut off.
- Check the circuit fuse F3 2.5A located inside the circuit board.
- Check if the pedal micro switch **No 35** is for some reason faulty.
- Check the relay **No 73**.
- Check electric board **No 74**.
- Check the motor **No 01**.

7.2 The heating of the working surface is not activated

- Check if the safety thermostat **No 40** is faulty. Replace it.
- Check if the thermostat **No 41** is faulty. Replace it.
- Check if the heating element **No 64** is burned out. Replace it.
- Check if the switch **No 70** is faulty. Replace it.
- Check the power supply cable and power plug on the board surface (**No 43**).

7.3 The heating of the ironing buck is not activated

- Check the power supply cable and power plug on the ironing buck.
- Check the heating switch **No 70** of the ironing buck.
- Check the heating element, the safety thermostat or the power supply cable of the ironing buck.

7.4 The machine operates loudly

- Check if the motor ball bearings have been outworn. Replace them.
- Check the impeller to ensure there is no dust or fuzz that could cause its vibration.

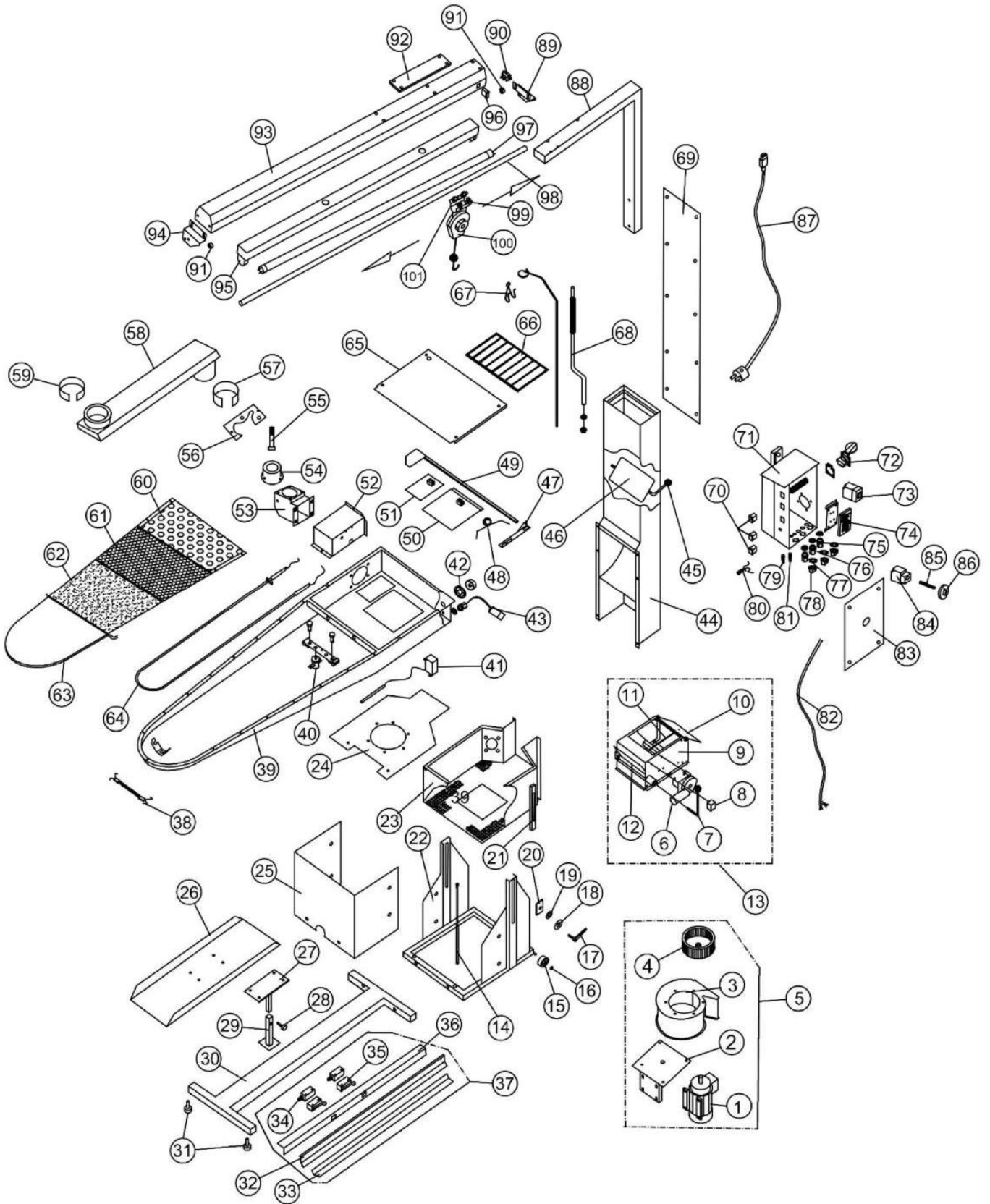
7.5 The blowing of air does not function

(If you have purchased PD S+B)

- Check if the pedal button **No 35** is for some reason faulty.
- Check electric board **No 74**.
- Check the relay **No 73**.

- *Check the motor **No 01**.*
- *Check the motor Flap Motor 12V/DC **No 06**.*
- *Check the relay 12V/DC **No 08**.*

Drawing of spare parts



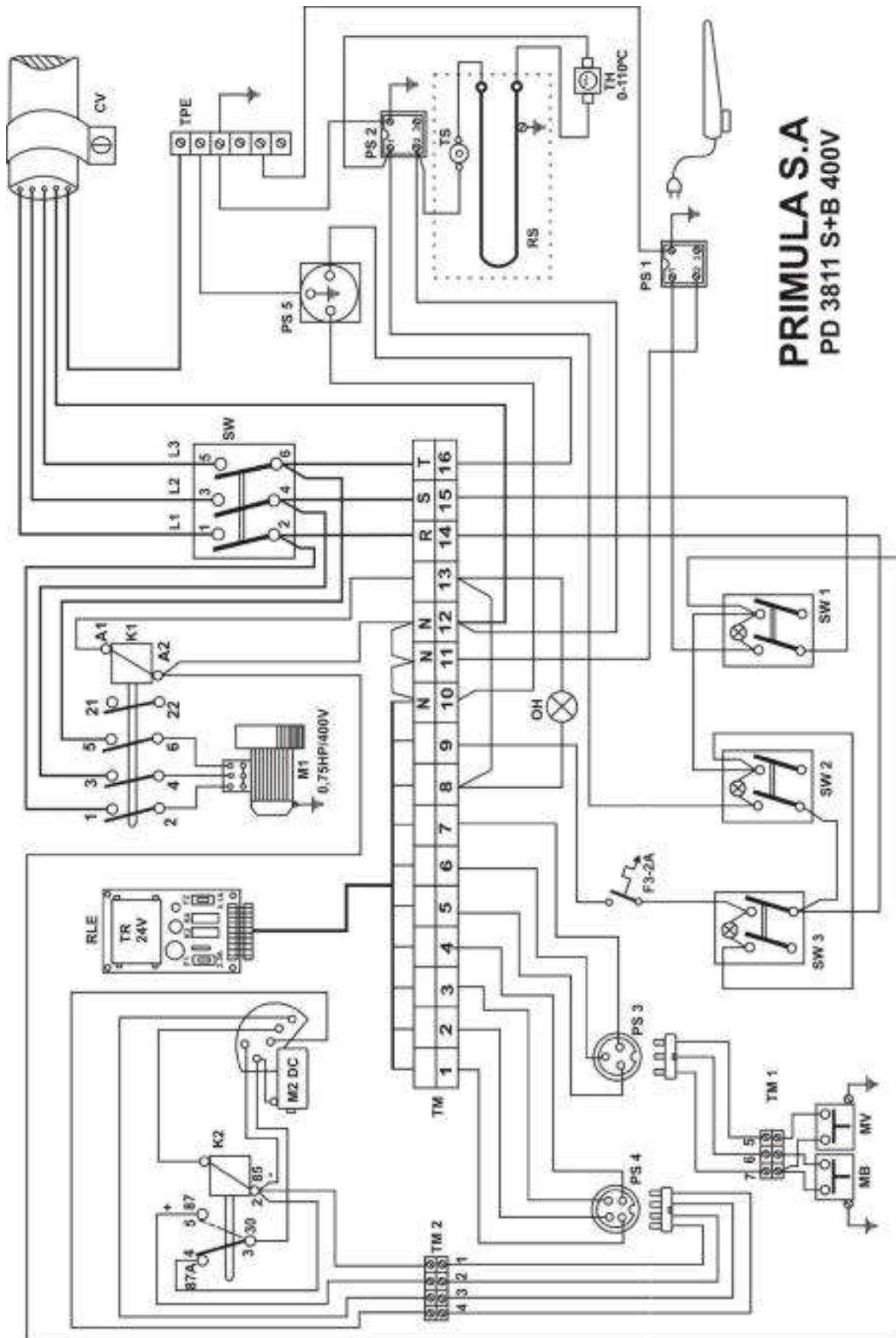
List of spare parts

<u>No</u>	<u>CODE</u>	<u>DESCRIPTION</u>
1	302-00-001-3	Electric Motor 0,75HP/400V/50HZ - 3 N
	302-00-001-1	Electric Motor 0,75HP/230V/50HZ - 1 N
	302-22-001-2	Electric Motor 0,75HP/220V/60HZ - 1 N
	302-22-001-3	Electric Motor 0,75HP/110V/60HZ –1 N
2	192-22-004	Metallic flange of metallic shell vacuum B
3	192-22-002	Metallic shell vacuum
4	302-00-003	Fan wheel Ø180
5	302-22-004	Vacuum 0.75HP complete
6	302-03-006	Flap Motor 12V/DC
7	192-22-017	Regulating lever of Blowing
8	302-21-024	Relay 12V/DC
9	302-03-005	Case of Vacuum and Blowing interchange system
10	192-03-007	Flap of Vacuum and Blowing interchange
11	192-03-085	Rod of blowing mechanism
12	192-03-044	Regulating flap of blowing air quantity
13	102-03-013	Vacuum and Blowing interchange system complete
14	302-04-012	Suspension lift 33/1000N
15	302-01-016	Plastic wheel
16	302-03-023	Safety washer
17	302-03-029	Stopper knob
18	302-03-025	Washer
19	302-03-026	Plastic Washer
20	192-03-025	Metallic holder
21	192-03-027	Metallic Guide
22	192-03-031	Female base
23	192-03-030	Male base
24	302-03-009	Vacuum upper cover with flange
25	192-03-022	Metallic cover of base
26	192-35-084	Metallic spilltray PDL
27	192-03-032	Metallic base of spilltray
28	302-35-010	Knob M8x15mm
29	192-03-033	Female arm of spilltray base
30	192-03-016	Metallic frame of pedals
31	302-02-014	Leg for the regulation of table
32	192-04-018	Blowing pedal
33	192-04-017	Vacuum pedal (only for S+B version)
	302-03-017	Vacuum pedal (only for suction version)
34	302-22-078	Cover of micro switch MV45
35	302-26-026	Vacuum and Blowing micro switch MV45
36	192-35-020	Metallic cover of micro switches

No	CODE	DESCRIPTION
37	192-35-021	Pedals System
38	302-01-035	Cover's spring with clip
39	192-21-030	Plate of ironing table PD
40	302-01-010	Safety thermostat 145°C
41	302-00-012	Thermostat of table 110C
42	302-26-004	Thermostat knob
43	302-35-078	Power supply cable of heating element with plug
44	102-35-035	Chimney
45	302-00-040	knob of air quantity adjuster lever
46	192-03-043	Regulating flap of vacuum air quantity
47	192-21-034	Bracket axle of corner
48	192-21-074	Spring of Tamper
49	192-21-035	Axle of corner
50	192-35-070	Tamper
51	192-22-041	Tamper of swivelarm
52	192-21-048	Cover of tamper
53	192-22-042	Corner of swivelarm
54	192-22-047	Bearing of corner
55	302-21-046	Screw of arm
56	192-21-073	Metallic holder of screw
57	192-35-056	Brass muff of corner 50x0.4mm
58	102-22-010-1	Swivelarm of buck
59	192-22-043	Brass muff of swivelarm 40x0.4mm
60	192-21-052	Perforated
61	302-21-051	Plastic lattice
62	302-21-050	Foam layer 1242
	302-21-050-1	Vacufix layer 1242
	302-21-050-2	Felt molleton 1242
63	302-35-063	Cover of table
64	302-01-014	Heating element 1KW/230V
65	192-21-068	Base of iron
66	107-03-002	Silicon iron rest mat
67	192-01-027	Hanger of the iron's cables
68	107-01-000	Antenna
69	192-36-117	Metallic cover of chimney
70	308-00-006	Switch ON-OFF 16A
71	192-03-034	Electric box
72	302-02-009	Socket
73	302-00-010	Relay for motor
74	302-22-018	PC Board
75	300-00-008	Gland PG 13.5

<u>No</u>	<u>CODE</u>	<u>DESCRIPTION</u>
76	302-35-045	Gland PG 9
77	300-00-007	Gland PG 11
78	303-03-021	4-pole safety socket
79	302-03-079	Connector 4pole
80	302-22-046	Indicator lamp
81	302-03-081	Connector 3pole
82	302-26-005 302-00-014	Cable of power supply 3X1.5mm with plug Cable of power supply 5X1.5mm
83	192-04-052	Electric box-cover
84	302-03-038	Main power switch 3X25
85	302-03-039	Axel of main switch 3X25
86	303-03-031	Cover of main switch 3X25
87	302-22-057	Cable of lighting power
88	192-22-059	Corner of vario
89	192-22-055-1	Blade of bar support L
90	302-22-056	Lighting's socket
91	302-01-057	Elastic stop
92	192-03-092	Lighting Holder
93	192-22-058	Plate of lighting
94	192-22-055	Blade of bar support S
95	302-22-052	Lighting
96	302-22-054	Lighting's switch
97	302-00-044	Fluorescent lighting
98	192-22-051	Suspension's bar
99	302-22-050	Ball bearing of trolley
100	302-00-051	Iron's balancer
101	302-00-049	Trolley of iron balancer

Wiring Diagram



PRIMULA S.A
PD 3811 S+B 400V

List of spare parts of Wiring Diagram

Symbol	Description
<i>IC</i>	<i>3-poles main switch</i>
<i>I1</i>	<i>1-pole switch for table heating with indicator lamp</i>
<i>I2</i>	<i>Switch for forms heating with indicator lamp</i>
<i>I3</i>	<i>1-pole vacuum switch</i>
<i>RE</i>	<i>Heat.element PU 2x750W, 230V –PD, 1000W</i>
<i>R1</i>	<i>Vacuum motor relay</i>
<i>R2</i>	<i>Flap motor Relay</i>
<i>M</i>	<i>Vacuum motor 1HP/400V-3ph-50Hz with thermostat</i>
<i>MV</i>	<i>Vacuum pedal switch</i>
<i>MB</i>	<i>Blowing pedal switch</i>
<i>TS</i>	<i>Vacuum motor thermal protector</i>
<i>TS1</i>	<i>Thermostat 30-110°C adjustable</i>
<i>TS2</i>	<i>Safety thermostat (heat stop)</i>
<i>PS1</i>	<i>4-poles safety F-plug (for form connection)</i>
<i>PS2</i>	<i>4-poles safety F-plug (for form connection)</i>
<i>PS3</i>	<i>4-poles safety F-plug (for table connection)</i>
<i>PS4</i>	<i>F-plug for pedal switch connection</i>
<i>PS5</i>	<i>F-plug for flap motor connection</i>
<i>PS6</i>	<i>F-plug for iron connection, Max 1kW</i>
<i>TM</i>	<i>Wires terminal block</i>
<i>CV</i>	<i>Flexible power feeding cable 5 x 1,5mm²</i>
<i>RLE</i>	<i>DC feeding, electrical card</i>
<i>MDC</i>	<i>Flap motor DC</i>
<i>LS</i>	<i>Indicating lamp for motor over heating</i>

For any advice about the operation of the machine or the spare parts, please contact the dealer you have purchased the machine from or us directly at:



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All specifications have been made to the best of our knowledge.

Primula S.A preserves the right to make changes to the system and its parts without prior notice.