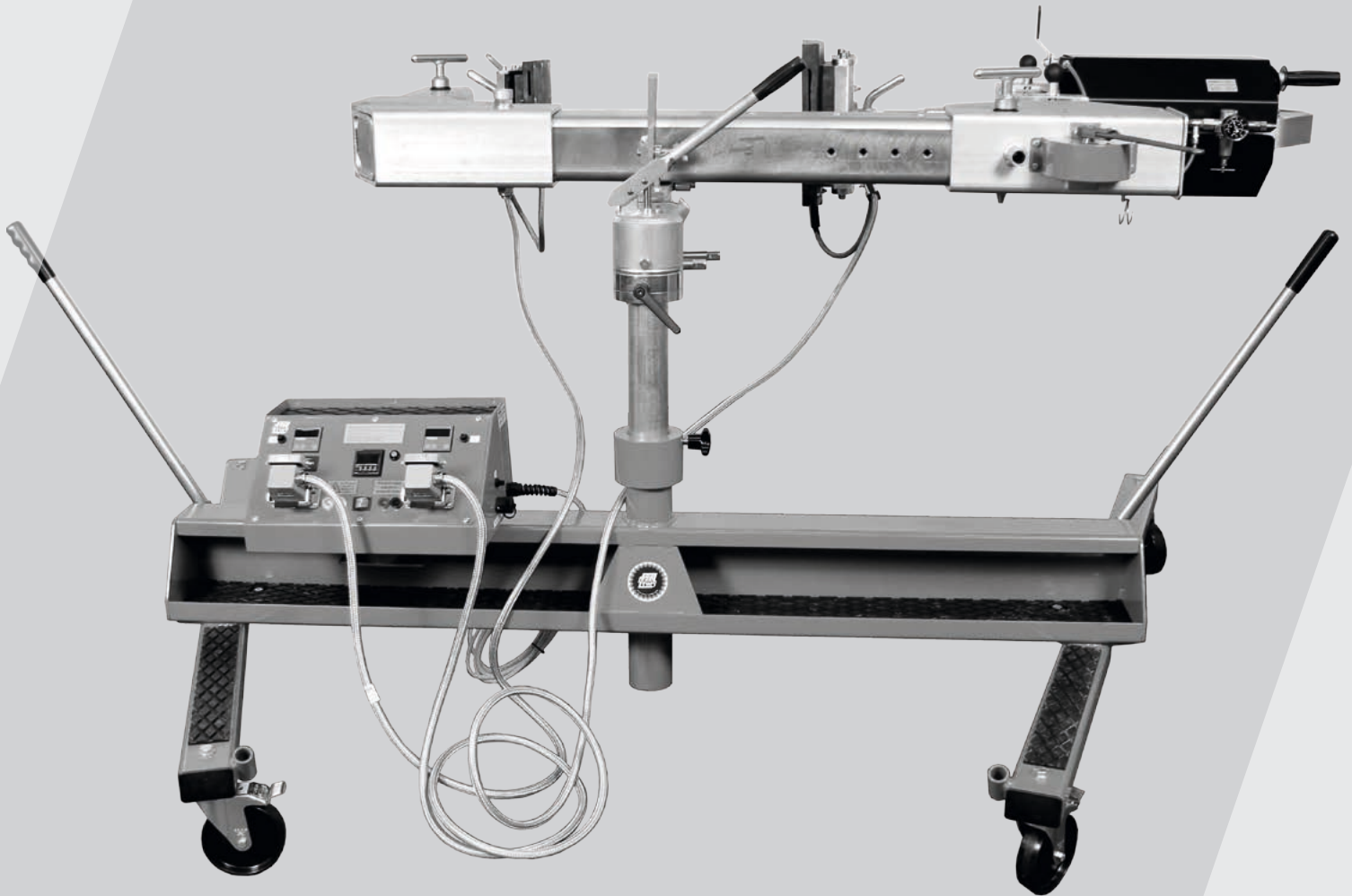




// ONE BRAND // ONE SOURCE // ONE SYSTEM



THERMOPRESS EM I, EM II, EM III

Maintaining REMA TIP TOP vulcanising machines

Service manual

For initial start-up

Thermopress vulcanizing machine

EM 1

EM 2

EM 3

Series number TP EM machine

Series number supply unit
(elect. control box)

Operating hours

Date _____

Signature / Stamp _____

Component exchange (electrical supply unit / hydraulic unit)

Exchanging components

elektrische Versorgungseinheit

Hydraulikeinheit

Series number

OLD _____

NEW _____

Operating hours

OLD _____

NEW _____

Reason for replacement

Exchanged on

Date / Signature

Subsequent introduction of the service handbook to an existing machine:

_____ Operating hours during introduction

Machine handover to a new owner (service handbook must be passed on):

Owner 2:

_____ Name / Company

_____ Handover date

_____ Signature

_____ Operating hours during handover

Owner 3:

_____ Name / Company

_____ Handover date

_____ Signature

_____ Operating hours during handover

Explanation

With this declaration, the machine manufacturer responsible confirms that the following components being used function correctly.

Responsibility	Component	Date / Signature	Company stamp
Fa. Horn	Ground fault circuit interrupter		
Fa. Horn	Ground wire		
Fa. Horn	Overheating cut out		
Fa. Horn	Frame construction		

EN

In order to guarantee the proper and correct handover of the machine to clients, the following machine parameters must be checked during machine acceptance testing and confirmed with a signature!

Component	Target setting	Actual setting	Date / Signature
Temperature controller	175 °C		
Pressure regulator	160 bar		
Automatic adjustment			

Service 1

Service 1 concerns checks that must be carried out before the machine is first set up and before each application during regular operating processes.

A separate signed and dated confirmation of the checks is not required. The checks must be carried out independently and responsibly by each user of the machine.

Service 2

Service 2 concerns recurring monthly checks whilst the machine is in operation. Checks carried out are confirmed in the table provided here, specifying date, operating hours and signature.

The checks must be carried out independently and responsibly by each user of the machine.

Service 3

Service 3 concerns the annual (or every 10,000 operating hours) recurring checks whilst the machine is in operation. Checks carried out are confirmed in the table provided here, specifying date, operating hours and signature.

Checks on electrical components may only be carried out by a designated qualified electrician. Checks on hydraulic, pneumatic and mechanical engineering components can be carried out by users.

The service handbook is designed to be used over a period of 10 years. If the machine is operated for more than 10 years, a new service book (Art. no.: 581 4350) can be obtained via REMA TIP TOP.

Service 1 (during initial set-up or before each application)

Before initial set-up, the transport bolts of the height adjusting device and/or the hydraulic pump must be replaced with the necessary screw plugs. The numbers can be taken from the appropriate replacement list (see operating manual) of the machines.

TP EM I:

Replacement of the transport bolt with the plastic vent screw.

TP EM II:

Replacement of transport bolt with plastic vent screw of the hydraulic unit.

Replacement of transport bolt with plastic vent screw of the height adjusting device.


TP EM III:

Replacement of transport bolt with plastic vent screw of the hydraulic unit.

Replacement of transport bolt with plastic vent screw of the height adjusting device.

Assemblies	Machine component	Type of maintenance	Required material	Operator
	Cable and extensions of the heating /mains supply	Check heating system cable for mechanical damage	No material necessary Visual check!	User
	Heating pocket	Before each application	REMA TIP TOP Talcum Art. no.:	User
	Heating mat	1 x weekly or every 50 hrs	593 0649	User

Documentation concerning change of heating mat within the scope of Service 1

Date	Operating hours	Comment	Signature
 18. 04. 2011	3451 hrs	Heating mat size 2 exchanged – replacement heating map size 2 (Series number: 842)	

Service 2 (recurring monthly)

Assembly	Machine component	Type of maintenance	Required material	Operator
	Ground fault circuit interrupter	Check the mechanical function of the ground fault circuit interrupter by pressing the FI switch	No material necessary	User
	Timer (No. 156) Temperature controller (No. 155)	Check for external mechanical damage	Exchange damaged components Temperature controller Art. no.: 557 3972 Overheating cut out Art. no.: 557 3783	User
	Pressure control	Check of the correct pressure (160 bar) with adjusting screws of the hydraulic unit	No material necessary	User
	Hydraulic piping	Check pipes for leaks and proper connection	No material necessary Visual check!	User
	Hydraulic pump EM II / EM III			
	Height adjusting device EM I / EM II / EM III	Oil level check	Hydraulic oil SAE 5-10	User
	Clamping screws (no. 28 and 29) Tilting mechanism	Oil clamping screw threads, check thread quality	Graphite – oil Visual check!	User
	! Attention: Do not oil the clamping device for the tilting and swivelling mechanism!			

EN

Service 3 (annually or after 10,000 operating hours)

Assembly	Machine component	Type of maintenance	Required material	Operator
	Ground fault circuit interrupter	Check trip current of the ground fault circuit interrupter	Measuring device to test the fault current	Qualified electrician
	Ground wire check	Test machine with ground wire tester		Qualified electrician
	Overheating cut out	Test cut out with calibrator for cut out temperature of 190°C, if necessary replace	Exchange damaged components Overheating cut out Art. no.: 557 3783	Qualified electrician
	Temperature controller Overheating cut out	Open machine cover of the electrical supply box and check date of manufacture of the controller or cut out	With more than 40,000 operating hours Temperature controller Art. no.: 557 3972 Overheating cut out Art. no.: 557 3783 replace	Qualified electrician
<p>! Attention: The condenser must always be checked via the temperature controller and must also be checked to ensure there is good contact!</p>				
	Hydraulic pump	Renew hydraulic oil	Hydraulic oil SAE 5-10	User
	Hydraulic cylinder	As part of the oil change, visual check of seals, exchange if necessary	TP EM I / TP EM II Seal kit Art. no.: 557 3154 TP EM III Seal kit for piston compact seal Art. no.: WH 7132 Seal kit rod seal, 'O' rings and wipers Art. no.: WH 7131	User
Pneumatics	Air bellows TP EM I	Visual check of the air bellows, by disassembling the protective cover, for mechanical damage or ageing cracks	In the case of identifiable defects, contact REMA TIP TOP service technicians.	User
	Main frame of the upper part of the machine	Clean frame part and then lubricate	Universal grease	User
	Adjusting device of the right frame part	Slightly lubricate movable parts	Universal grease	User
	Guide tube Height adjusting device	Clean guide tube and then lubricate	Universal grease	User



Your local contact



// ONE BRAND // ONE SOURCE // ONE SYSTEM

REMA TIP TOP AG
Gruber Strasse 65 · 85586 Poing / Germany
Phone: +49 8121 707-100
Fax: +49 8121 707-10222
info@tiptop.de
www.rema-tiptop.com

