INDUSTRIAL
1000 & 800

User Manual

Revision 3.0

Original Instructions

ADKINS

Preface

Dear User

Welcome to the growing group of the Adkins Industrial Heat Press users. The product you have purchased has been carefully designed and manufactured to ensure that you, the user, will gain the maximum benefit.

All Charterhouse Holdings PLC products are specifically designed to ensure ease of use with particular attention to safety requirements. Should you discover any fault or damage upon receipt of this product, you should immediately contact your supplier.

Contents

1. Introduction Industrial 1000 / 800 Heat Press 1
   - 1.1 What did you receive? 2
   - 1.2 Specifications of the Industrial 1000 / 800 Heat Press 3
   - 1.3 Safety 4
   - 1.4 Safety tips 4

2. Installation 6
   - 2.1 Transport instructions 6
   - 2.2 Installing the machine 6
   - 2.3 Electrical requirements 6
   - 2.4 Pneumatic requirements 7
   - 2.5 Adjusting the pressure 7

3. How to operate the Industrial 1000 / 800 Heat Press 8
   - 3.1 Starting with the Industrial 1000 / 800 Heat Press 8
   - 3.2 Working with heat transfer materials 8
   - 3.3 Pressing pad assembly 9
   - 3.4 Shutting down the machine 9
   - 3.5 Fault diagnosis 9
   - 3.6 Hints and tips 10
   - 3.7 Heat Plate Temperature Measurement 11

4. Maintenance of the Machine 12
   - 4.1 Daily maintenance 12
   - 4.2 Periodic maintenance 12
   - 4.3 General maintenance 12
   - 4.4 Cleaning 12

5. Machine Drawings and Diagrams 13
   - 5.1 Basic machine layout 14
   - 5.2 Control unit operation 15
   - 5.3 Exploded diagram and parts list 17
   - 5.4 Machine - electrical diagram 19
   - 5.5 Pneumatic schematic 20
   - 5.6 Industrial stand assembly 21

6. Design Change 23

7. Warranty & Declaration 24

Declaration of Conformity 25

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1 Introduction Industrial Heat Press

The Industrial 1000 / 800 Heat Press is a pneumatically operated heat press for transfer printing and material fusing. It is ideal for high volume production with low operator fatigue.

The work area of the Industrial 1000 Heat Press is 80 cm x 109.5 cm (31.5 in x 43 in). Industrial 800 heat press is 80 cm x 60 cm (31.5 in x 23.6 in) but machines may have, to special order, optional smaller sized interchangeable worktables of any size and various shapes within this table size.

The Industrial Heat Press has a worktable which pulls out towards the operating position and away from the heat plate for loading and unloading. After loading the work piece, and with the correct settings for temperature, pressure and dwell time, the worktable is pushed back to the operating position with the handle provided. The cycle is started by pressing the green buttons on either the side of the head. The controller operates the timer and the solenoid valve and thus the pneumatic cylinder. When the set time elapses the heat plate is automatically lifted, enabling the worktable to be pulled out. The worktable may then be unloaded and reloaded ready for another cycle.

The Industrial 1000 / 800 Heat Press is produced in one version, nominally 220 - 240 Volts AC for the European market.

1.1 What did you receive?

The Industrial 1000 / 800 Heat Press has been a placed in a shipping crate, and is held in place with bolts for safe transportation. The following articles should have been delivered:

- Industrial 1000 / 800 Heat Press (inc foam pad / Silicone pad / Teflon protection sheet)
- Any extra items ordered

If there is any damage or any article is missing, please contact your supplier immediately.

1.2 Specifications of the Industrial Heat Press

The Industrial 1000 Heat Press

Power consumption	5.8kW Average
Power supply	220-240 Volts AC (Single Phase)
Working temperature	0 - 230oC (32 - 446°F)
Display Timer Range	0 – 999 sec (±0.5%)
Machine height	100 cm (39.4 in)
Machine width	130 cm (51.2 in)
Machine depth, closed	122.8 cm (48.2 in)
Machine depth, open	173 cm (68 in)
Working area	190(W) x 120(H) x 240(D) cm (75(W) x 47(H) x 95(D) in
Size export packed	138(L) x 153(W) x 126(H) cm (54(L) x 61(W) x 49.6(H) in
Net weight (Without stand)	263 kg (580 lbs.)
Gross weight	350 kg (771.6 lbs.)
Heat plate dimensions Maximum	112 cm x 83 cm (44in x 34 in) 6 bar
compressed air supply Suggested	(87 Psi)
compressed air supply	3.5 – 5.0 bar (51 – 65 Psi)
Fuse	32A

The Industrial 800 Heat Press

Power consumption	5kW Average
Power supply	220-240 Volts AC (Single Phase)
Working temperature	0 - 230oC (32 - 446°F)
Display Timer Range	0 – 999 sec (±0.5%)
Machine height	100 cm (39.4 in)
Machine width	82 cm (32.2 in)
Machine depth, closed Machine	122.8 cm (48.2 in)
depth, open	173 cm (68 in)
Working area	142(W) x 120(H) x 240(D) cm (56(W) x 47(H) x 95(D) in
Size export packed	119(L) x 135(W) x 121(H) cm 47(L) x 53(W) x 47.6(H) in
Net weight (Without stand)	183 kg (403.4 lbs.)
Gross weight	314 kg (692 lbs.)
Heat plate dimensions Maximum	80 cm x 60 cm (31.5 in x 23.6) 6 bar
compressed air supply Suggested	(87 Psi)
compressed air supply	3.5 – 5.0 bar (51 – 65 Psi)
Compressed air consumption	5 – 40 litres/min (0.17 – 1.41 cu. ft./
A-weighted noise level	min) <70dB(A)
Fuse	25 A
Both machines height on the stand	164 cm (64.5 in)
Stand dimensions	79(W) x 64-68(H) x 87.5(D) (31.1(W) x 25-26.7(H) x 34.5(D) in
Stand box dimensions	91(W) x 67.5(D) x 16.5(H) (35.8(W) x26.5(D) x 6.5(H)

1.3 Safety

The Industrial 1000 / 800 Heat Press has been equipped with various safety features to ensure operator safety.

a. **The time / temperature** controller has a built in facility giving error messages in the event of faults with the element heating and control system.

b. **Emergency stop button** will release the pressure in the bed and also cut the power to the machine.

c. **The machine table** will only set to pressing position when the heat plate is aligned with it due to a micro switch safety interlock.

1.4 Safety Tips

If required, our customer service team can arrange maintenance service.

The Industrial 1000 / 800 Heat Press meets the European Legislation standard. Under normal conditions accidents are rare. However, listed below are some practical points to ensure your safety.

Always switch off and isolate the mains supply (i.e. Remove plug) before undertaking any maintenance work or cleaning the machine, or when not in use.

Keep other people away from the machine during use.

Ensure that there is sufficient space around the machine. Cables and connections must not get jammed. Although the heat radiation of the press is low, there should be enough space for cooling down.

Avoid contact with the press element.

DO NOT REMOVE THE TOP COVER UNLESS QUALIFIED TO DO SO - touching internal parts is dangerous and may cause shock hazard.
PROTECT THE MAINS CABLE - damage to the mains cable may cause fire or shock hazard. When unplugging, hold by the plug only and remove carefully. Take care that the mains cable does not come into contact with the heat plate (or moving parts of the mechanism) during operation of the machine.
FOR SAFETY REASONS - please ensure that when the machine is not in use the table is fully closed.
OPERATING AMBIENT TEMPERATURE RANGE – the operating ambient temperature range is 0°C –35°C, (32°F-104°F) and humidity of 20 - 80%.

1.4 Safety Tips (continued)

MACHINE FUSES - type: ultra-rapid (FF) fuses 1¼". (230 Vac Max. 32 Amps / 25 Amps)

WARNING - THIS APPARATUS MUST BE EARTHED (GROUNDED).

CAUTION

This machine gets hot whilst operating. Take care not to touch any surfaces that are labelled with the international standard hot surface warnings

MACHINE OPERATION

Only suitably trained personnel should operate this machine.
This machine is designed to be operated by one operator only.

CAUTION

Please ensure the table is fully engaged before pressing the green cycle start buttons.
For operator safety this machine is fitted with a non-return valve that prevents the table from lowering if the air supply is lost.
Contact your print media suppliers to ascertain whether fumes are given off during the process, and if so what precautions are needed for operator safety. These may include air extraction and/or masks for personnel.

Please refer to section 5.1 for a basic illustration of the Industrial 1000 / 800 Heat Press.

2 Installation

2.1 Transport Instructions

The machine comes to you, in a shipping crate, and is held in place with bolts, for safe transportation. If you have to transport the machine at any time it is recommended that you use a similar box and packing method. Please let the machine cool down fully before attempting to pack.

2.2 Transport Instructions

Take the machine out of the crate,due to the weight of the machine we recommend that a fork lift truck or high lift pallet truck is used. After assembling the industrial stand put the machine onto the stand close to a suitable electric socket and compressed air supply connection point, within easy reach of the operator. There must be sufficient space for the machine's table to be pulled out until it hits the built in stops and back to the pressing position without creating trapping points against adjacent articles. Ensure that no items vulnerable to heat radiation are too close to the machine.

2.3 Electrical Requirements

The Industrial 1000 / 800 Heat Press should be connected to the mains supply (nominally 220-240 Volts AC for the European Market) using either a commando plug and socket or an isolator box.

The press is designed for 220-240 Volts AC 50/60 hertz and requires exclusive use of a power outlet rated for at least 32 amps.

Ensure that the supply rating on the machine specification plate corresponds with your local supply and that the correct plug is fitted.

MAINS LEAD

The wires in this mains lead are coloured in accordance with the following code:

230 VAC	**Green & Yellow:**	**EARTH**
	Blue:	**NEUTRAL**
	Brown:	**LIVE**

Wiring the plug for a 220-240 VAC machine.

As the colours of the wires in the mains lead of this apparatus may not correspond with the coloured markings identifying the terminals in your plug, proceed as follows:-

2.3 Electrical Requirements

1. **The wire,** which is, coloured green and yellow must be connected to the terminal in the plug, which is marked by the letter E, or by the safety earth symbol coloured green, or green and yellow.
2. **The wire** coloured blue must be connected to the terminal, which is marked with the letter N, (Neutral connector).
3. **The wire,** coloured brown must be connected to the terminal, which is marked with the letter L, (Live connector).

NOTE: Replacement of the mains cable must be undertaken by a competent service engineer.

2.4 Pneumatic Requirements

The Industrial 1000 / 800 Heat Press should be connected through a filter regulator to a compressed air supply capable of delivering 30 litres/min at a pressure of 3.5 - 5 bar. max. (1.06 cu.ft./min at 14.5 - 72.5 Psi). The press will not operate if the pressure drops below 1 bar. (14.5 Psi) Double hose clips should be used on the delivery hose.
We would advise that when setting up the machine you check that sufficient pressure is maintained into the regulator valve. When the desired pressure is achieved the regulator is locked by pushing the knob back down. We recommend that this should be set between 3.5 to 5 bar.

The Pressure Adjustment Gauge on the left hand side of the machine should only be used to control the settings required for heat transfer and garments.

*Operator is required to source a suitable connection for there compressor as there is not a connector supplied on the end of the hose.

2.5 Adjusting The Pressure

This press is fitted with a manually adjustable pneumatic pressure regulator on the left hand side of the machine. To adjust the operating air pressure, and therefore the pressure exerted by the press on the work, the regulator is unlocked by pulling upwards on the black plastic knob. Turning the regulator knob clockwise will increase the air pressure; turning anticlockwise will decrease the pressure. When the desired pressure is achieved the regulator is locked by pushing the knob back down.

3 How to Operate the Industrial 1000 / 800 Heat Press

3.1 Starting the Heat Press

Turn on the Industrial 1000 / 800 Heat Press; the on/off switch on the front of the machine head. Make sure the fuse on the right hand side is on. Set the machine controls as necessary. See instructions for adjusting the pressure, section 2.5, and the operation of the time temperature unit, section 5.2. When the set temperature is steady in the display the machine is ready to use.

3.2 Working with Heat Transfer Materials

Ascertain from the supplier of the transfer paper and/or the suppliers of the material, that the material to be used is suitable and has been prepared for transfer printing.

Obtain from the supplier of the transfer paper, or material to be used, the recommended temperature, time and pressure settings for the material to be worked on.

Approximate settings are usually within the following:-

180°C - 200°C (350oF - 400oF)	Heat Setting
100 - 300 sec	Time Dwell Setting

Wait until the set temperature has been reached, signalled by the temperature on the controller display becoming steady at the desired figure. Pull the table assembly from beneath the heat plate using the handle on the front of the machine. Place the work piece on the pressure pad, removing all wrinkles. Place the transfer in the desired position. Push the table assembly back into the pressing position, until it stops. This will 'trigger' the micro switch which will enable the machine to perform a heat transfer cycle.

Start the sequence by pressing the green buttons located on either side of the machine head. The heat plate will automatically lower to the table. (The process can be stopped at any time by using the "EMERGENCY STOP" button on the front of the machine head or by pressing the same green buttons used to start pressing this will automatically raise the heat plate away from the table). Emergency stop only to be used in an emergency. **CAUTION** Please ensure the table is fully engaged before pressing the green cycle start buttons.

At the end of the set time, the heat plate rises, allowing the table to be pulled out to permit unloading.

3.3 Pressing Pad Assembly

The pressing pad supplied with this machine is made of heat proof foam a silicone pad and has a Teflon sheet and although they are extremely durable they must be maintained in good condition at all times and replaced when showing signs of wear. A worn pressing pad will always affect the quality of printing/fusing.

CAUTION: Do not insert items into the machine, which would tend to cut the pressing pad, i.e. buttons, pins, press-studs or zips.

IMPORTANT NOTE:

The pressing pad supplied with the machine is of the correct thickness. Using a thicker pad may invalidate your warranty.

3.4 Shutting Down

To shut down the machine when a cycle is finished, turn off the red illuminated rocker switch on the front of the machine head.

To temporarily interrupt the pressing cycle, press the emergency stop button on the front of the machine head or pressing both green push buttons.

3.5 Fault Diagnosis

This Industrial 1000 / 800 Heat Press has built in fault diagnosis. The display may show the following:

1. **No. 1 Thermocouple Break**
   If the 1st thermocouple breaks, the display will show “1# Thermocouple break” immediately. Contact your machine supplier immediately.
2. **No. 2 Thermocouple Break**
   If the 2nd thermocouple breaks, the display will show “2# Thermocouple break” immediately. Contact your machine supplier immediately.
3. **“Engineering Mode”**
   If the machine temperature on the controller display does not match the actual heat plate temperature, there is an “Engineering mode” that allows the operator to compensate for the discrepancy in temperature.
   (Please contact Charterhouse Holdings PLC before using Engineering mode).

CAUTION

In all fault conditions switch off the power to the machine and unplug the machine from the electrical supply before contacting your machine supplier.

3.6 Hints & Tips

TRANSFER PRINTING

Extra care should always be taken to ensure that transfer paper is placed print down onto the article, as mistakes will result in the heat plate becoming soiled with ink and spoiling following work.

When transfer printing, it may be found advantageous to cover the press pad with paper or P.T.F.E. to prevent strike-through of surplus ink, particularly when printing thin material as surplus print on the pressing pad cover can also strike back on the following work.

Transfer Paper/Motifs Fail to Print Out Correctly
Check:-

1. **Heat and time** dwell settings are correct.
2. **Article** having transfers applied is locked in contact between pressing pad and heat plate.
3. **Pressing pad** is in good condition, is flat and making complete contact over the whole area of the heat plate. See Pressing Pad details.

"Ghosting" (Double Image) of Transfer Prints
Check:-

1. **Material being used** has been correctly heat set for transfer printing.
2. **Material being used** does not shrink during printing process, i.e. measure material before and after printing.
3. **Transfer paper** does not move after printing process upon lift off of the heat plate.
4. **If possible,** use adhesive coated paper, particularly to overcome fabric shrinkage.
5. **By pre-shrinking** of material in press before transfer printing.

3.7 Heat Plate Temperature Measurement

Testing of the Heat Plate for temperature consistency or fault condition should only be undertaken after consulting Charterhouse Holdings PLC, and then only using a wired Digital Thermometer (***please see note below**).

∗Please note:

The Digital Thermometer with external probe is suitable for surface, air and immersion/penetration measurement, which is required for all Adkins heat presses.

Laser Thermometers only measure air surfaces which can be misleading due to currents of hot air floating on the surface of the heat plate.

4 Maintenance of the Machine

4.1 Daily Maintenance

For good press results it is important to keep the press surfaces clean. Wipe the surface of the heat plate with a dry non-abrasive cloth before use when the plate is cold.
When heat plates are hot and not in use, keep in the open position away from the foam pad.

4.2 Periodic Maintenance

Periodically clean the TEFLON® coated heat plate with a non-abrasive piece of cloth. Stubborn stains may be cleaned, when heat plate is cool, with mineral spirits.

4.3 General Maintenance

The following checks should be carried out at regular intervals by a qualified and competent person:-

- Pneumatic system for air leaks
- Pneumatic system for lubrication
- Electrical connections
- Mechanical moving parts

Any enquiries to: support@adkinsmachines.com

4.4 Cleaning

First unplug the machine. Clean the outside of the machine frequently with a clean, moist cloth. This may conveniently be carried out when the machine is cold.

To prevent soiling of the substrate, periodic wiping of the entire exterior of the machine, including heat plate, with a clean rag is recommended. If necessary, use mineral spirits for cleaning a cold machine. Since mineral spirits are flammable, use precautions at all times and keep away from sparks, flames or hot heat plate.

5 Machine Drawings and Diagrams

On the following pages are the schematic diagrams for the Industrial 1000 / 800 Heat Press.

5.1 Basic Machine Layout **Page 14**

5.2 Control Unit-Operation
Industrial 1000 **Page 15**
Industrial 800 **Page 16**

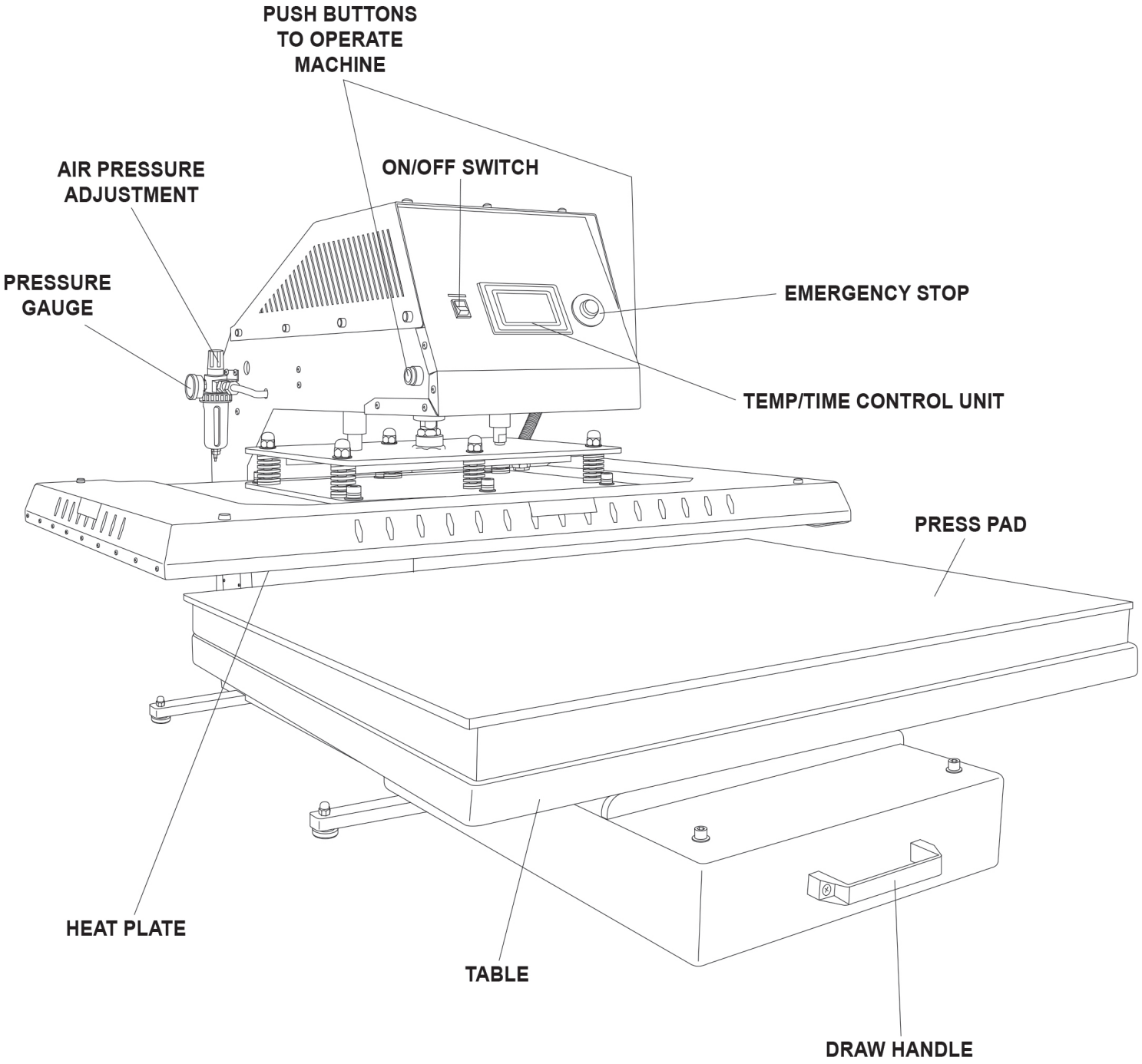
5.3 Exploded Diagram and Parts List
Industrial 1000 **Page 17**
Industrial 800 **Page 18**

5.4 Machine - Electrical Diagram
Industrial 1000 **Page 19**
Industrial 800 **Page 19**

5.5 Pneumatic Schematic **Page 20**

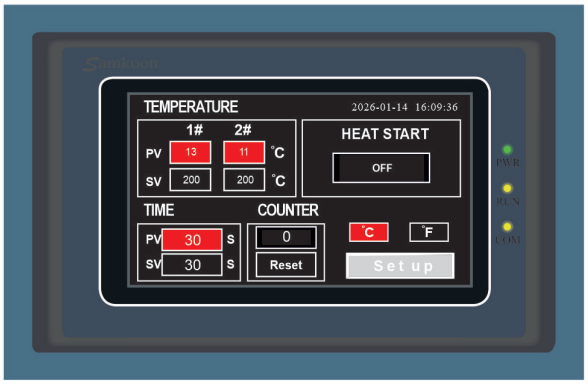
5.6 Industrial Stand Assembly **Page 20**

5.1 Basic Machine Layout



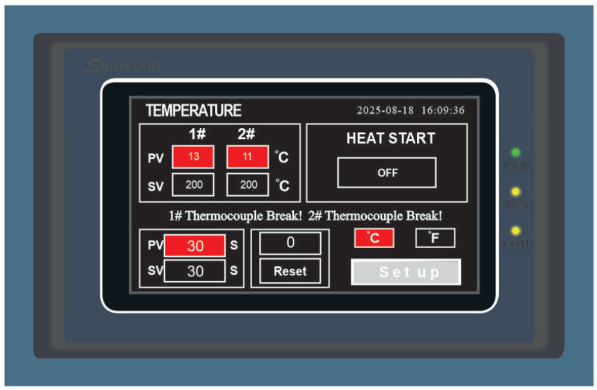
5.2 Operation of PLC Control Unit,1000 setting time and temperature

(The Heat plate must always be in the down position before the Controller is set)

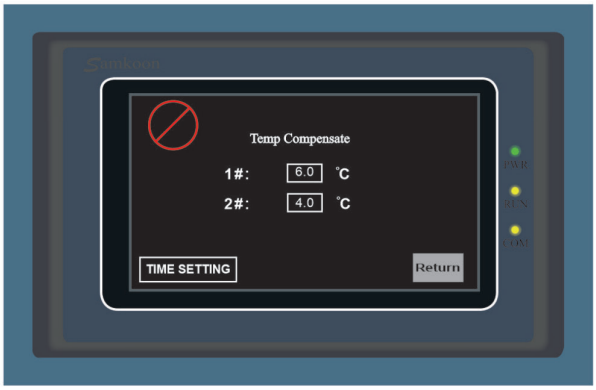


Main interface screen

Value entry screen



Thermocouple malfunction screen



Engineering mode screen

PLC Controller interface description

When you turn on the press, the Controller will initially show the main interface screen.

'PV 1#' and 'PV 2#' on the upper row represents the actual temperature, while SV below is the setting temperature. The 'HEAT START' 'OFF' and 'ON' switch is to the right. On the next row, you can set the 'TIME', 'COUNTER' reset and Celsius and Fahrenheit settings, which are to the right. The 'Set up' button to the right enters 'Engineering mode' [see below]

Setting the PLC Controller

Press '1#' value of 'SV' to set the heating temperature. When in the 'Value entry screen' enter your value, and press 'Enter' to save and exit. If you make a mistake you can press 'Clr' to clear the setting. Pressing 'Esc' also returns you to the main interface screen without altering any values.

Set '2#' value in the same way.

Then select either ˚C or ˚F and finally press 'HEAT START' to 'ON'.

The dwell time is set by pressing the 'SV' value of the 'TIME' setting, using the same procedure as above.

Starting the transfer cycle

When the actual press temperature reaches the setting temperature, press the start buttons at either side of the machine head simultaneously, this will then start the transfer cycle. The heat plate will then lower and the controller will begin to countdown. 3 seconds before the end of the transfer cycle, the buzzer will sound, and finally when the counter reaches 0 the heat plate will raise, thereby completing the transfer cycle.

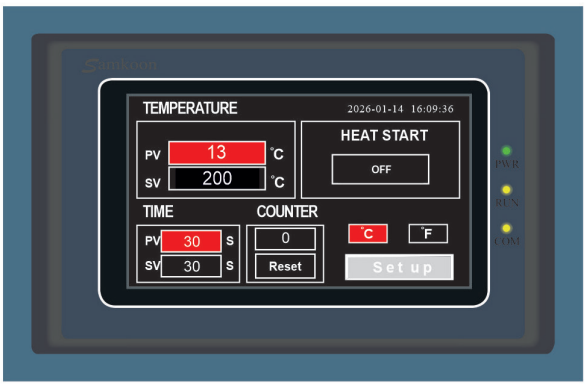
Other features

- Pressing Reset will set the counter value to 0.
- For Safety, in the event of the 1# Thermocouple malfunction, it will show '1# Thermocouple Break!' in red beside 'TIME'. Likewise if 2# Thermocouple breaks, it will show '2# Thermocouple Break!' underneath the ON-OFF switch, and immediately stop the heating process.
- You will have to restart the heating switch to resume heating.
- Click Set up to enter *'Engineering mode' to adjust 1# and 2 # thermocouple temperature correction values. Click Return, to return to the main interface.

N.B. Please contact Charterhouse Holdings PLC before using 'Engineering mode'.

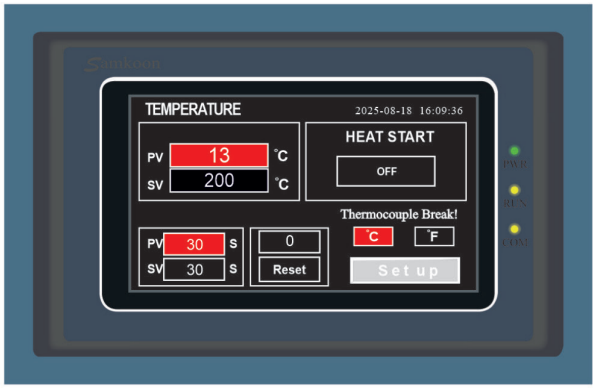
5.2 Operation of PLC Control Unit,800 setting time and temperature

(The Heat plate must always be in the down position before the Controller is set)



Main interface screen

Value entry screen



Thermocouple malfunction screen

Engineering mode screen

PLC Controller interface description

When you turn on the press, the Controller will initially show the main interface screen.

'PV on the upper row represents the actual temperature, while SV below is the setting temperature. The 'HEAT START' 'OFF' and 'ON' switch is to the right. On the next row, you can set the 'TIME', 'COUNTER' reset and Celsius and Fahrenheit settings, which are to the right. The 'Set up' button to the right enters 'Engineering mode' [see below]

Setting the PLC Controller

Press PV value of 'SV' to set the heating temperature. When in the 'Value entry screen' enter your value, and press 'Enter' to save and exit. If you make a mistake you can press 'Clr' to clear the setting. Pressing 'Esc' also returns you to the main interface screen without altering any values.

Set '2#' value in the same way.

Then select either ˚C or ˚F and finally press 'HEAT START' to 'ON'.

The dwell time is set by pressing the 'SV' value of the 'TIME' setting, using the same procedure as above.

Starting the transfer cycle

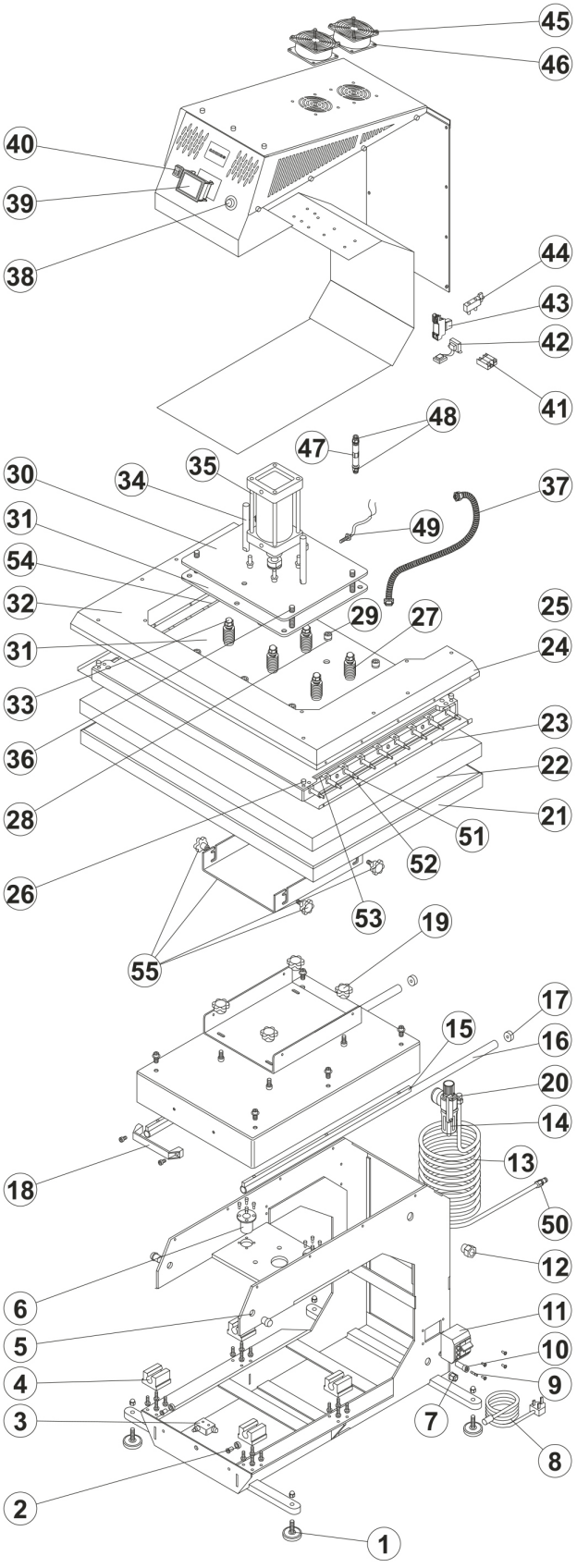
When the actual press temperature reaches the setting temperature, press the start buttons at either side of the machine head simultaneously, this will then start the transfer cycle. The heat plate will then lower and the controller will begin to countdown. 3 seconds before the end of the transfer cycle, the buzzer will sound, and finally when the counter reaches 0 the heat plate will raise, thereby completing the transfer cycle.

Other features

- Pressing Reset will set the counter value to 0.
- For Safety, in the event of the Thermocouple malfunction, it will show '1# Thermocouple Break!' in red beside 'TIME'. underneath the ON-OFF switch, and immediately stop the heating process.
- You will have to restart the heating switch to resume heating.
- Click Set up to enter *'Engineering mode' to adjust thermocouple temperature correction values. Click Return, to return to the main interface.

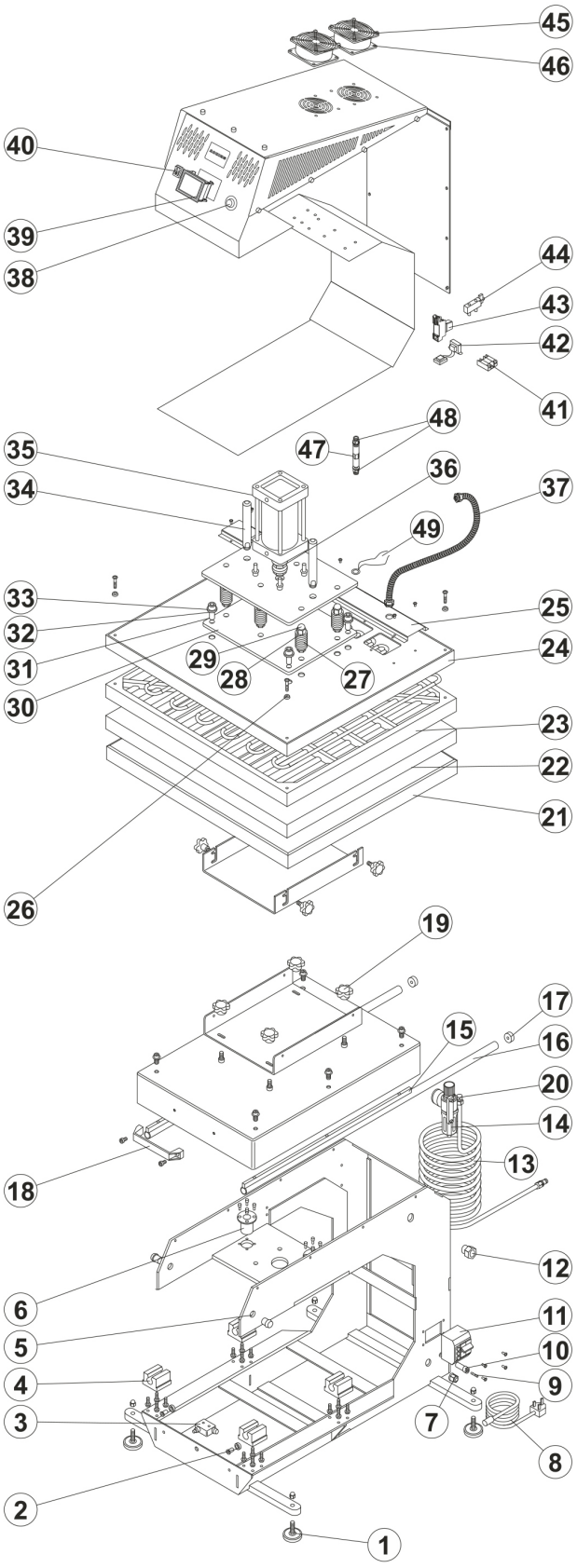
N.B. Please contact Charterhouse Holdings PLC before using 'Engineering mode'.

5.3 Exploded Diagram and Parts List
Industrial 1000



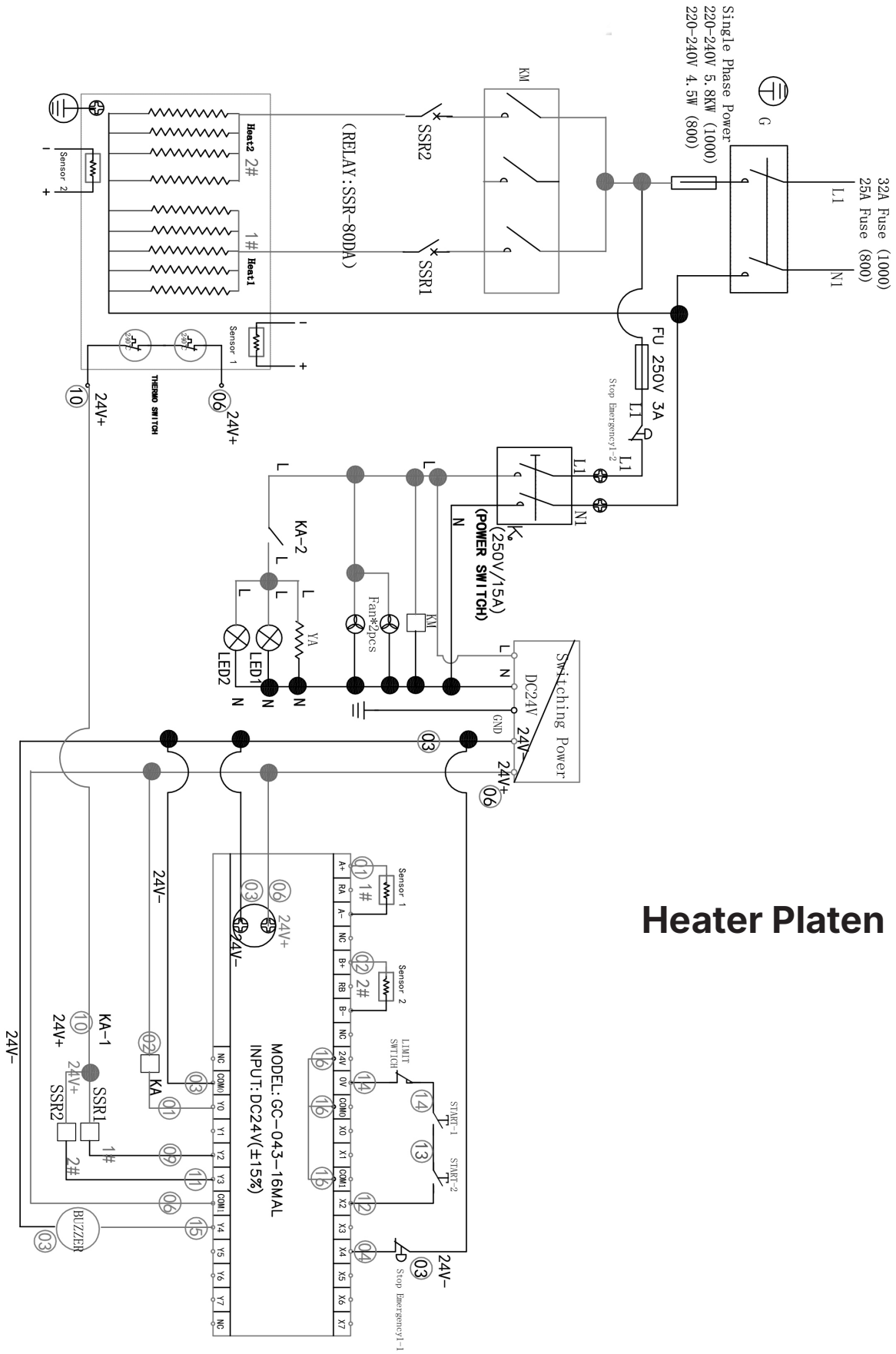
No.	Part Description	Qu
1	Machine foot	4
2	Magnet	1
3	Micro switch	1
4	Bearing (LM 25UU-OP)	4
5	Start-up button	2
6	Linear bearing	2
7	Plug connector	1
8	Power cord	1
9	Fuse 6 amps	1
10	Fuse holder	1
11	Circuit breaker	1
12	3/4″ Coiler joint	1
13	012mm Air pipe (5m)	1
14	Filter regulator/ Pressure gauge	1
15	Glide rail filler strip	2
16	Glide rail	2
17	Crashproof spacer	2
18	Draw handle	1
19	Straight line handle	4
20	C-tape quick coupling	1
21	Table	1
22	Foam pad (80 × 110 × 5cm)	1
	Silicone pad (80 × 110)	1
	Teflon protection sheet	1
23	Heat plate	1
24	Heat plate cover	1
25	Wire slot	1
26	Heat resistant gasket	4
27	Spring	6
28	M16 Spring Washer	6
29	Cap nut	6
30	Upper adapter plate	1
31	Lower adapter plate	1
32	Heat shield	1
33	Cap Nut	6
34	Cylinder guide rod	2
35	Air cylinder	1
36	M16×100 Bolt	6
37	Metal conduit cable	1
38	Emergency stop button	1
39	Digital PLC controller	1
40	Power switch	1
41	Solid state relay	2
42	Transformer	1
43	Relay and Base 12V	1
44	Electromagnetic valve	1
45	Fan protective cover	2
46	Fan	2
47	Non return valve	1
48	Straight connector 12 mm	2
49	Thermocouple probe 1.5 m	1
50	Compressor pipe fitting	1
51	Plate electrode	16
52	Element pipe	9
53	Sealing plate	2
54	Rear cover	1
55	Threaded Knob M10	4

5.3 Exploded Diagram and Parts List
Industrial 800

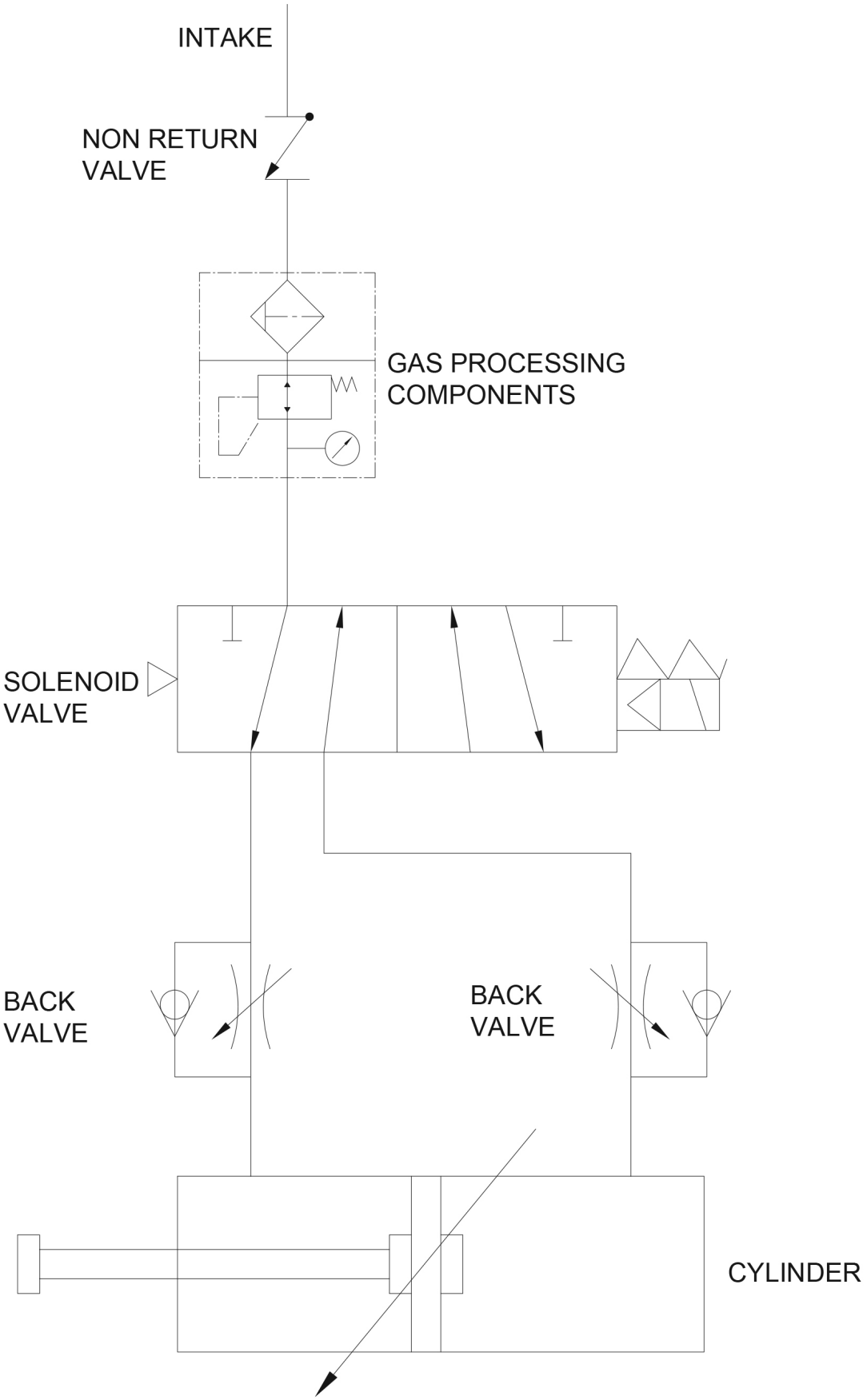


No.	Part Description	Qu
1	Machine foot	4
2	Magnet	1
3	Micro switch	1
4	Bearing (LM 25UU-OP)	4
5	Start-up button	2
6	Linear bearing	2
7	Plug connector	1
8	Power cord	1
9	Fuse 6 amps	1
10	Fuse holder	1
11	Circuit breaker	1
12	3/4″ Coiler joint	1
13	012mm Air pipe (5m)	1
14	Filter regulator/ Pressure gauge	1
15	Glide rail filler strip	2
16	Glide rail	2
17	Crashproof spacer	2
18	Draw handle	1
19	Straight line handle	4
20	C-tape quick coupling	1
21	Table	1
22	Foam pad (60 × 80 × 5cm)	1
	Silicone pad (60 × 80)	1
	Teflon protection sheet	1
23	Heat plate	1
24	Heat plate cover	1
25	Wire slot	1
26	Heat resistant gasket	4
27	Spring	6
28	M16 bolt	6
29	Cap nut	6
30	Adapter plate	1
31	M16×100 Bolt	6
32	M16 spring washer	6
33	M16 gasket	10
34	Cylinder guide rod	2
35	Air cylinder	1
36	Cylinder spacer	1
37	metal conduit cable	1
38	Emergency stop button	1
39	Digital PLC controller	1
40	Power switch	1
41	Solid state relay	1
42	Transformer	1
43	Relay and base 12V	1
44	Electromagnetic valve	1
45	Fan protective cover	2
46	Fan	2
47	Non return valve	1
48	Straight connector 12 mm	2
49	Ring probe	1

5.4 Machine - Electrical Diagram



5.5 Pneumatic Schematic



5.6 Adkins Industrial Stand Assembly

Items needed (included)

The items listed below are included in the packaging of your stand. Please see Figure 1 to see these parts illustrated.

1. Side Panels x2
2. Front and Rear Panels x2
3. Cross Bar Supports x2
4. M10 Feet x4
5. L Shaped Brackets x2
6. M6 Bolts x16

Items needed (not included)

The items listed below are needed for the assembly of this stand. However, they are not included in the packaging of the product.

1. 17mm Spanner

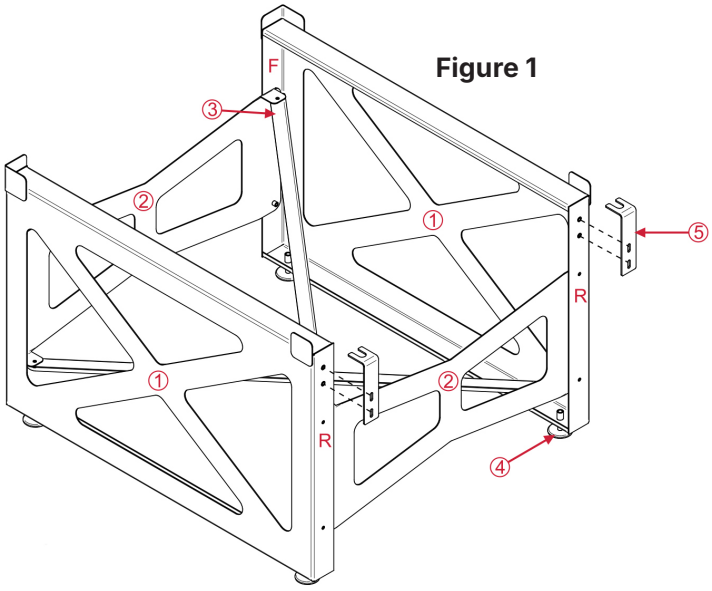


Figure 1

The Assembly Process

1. Secure the front and rear panels to the side panels. These panels are placed on the inside of the stand with the nut-serts facing inwards.

2. Secure the cross bars to the inside of the stand, corner to corner. The bars should be placed below the upper horizontal brackets and above the lower horizontal brackets. The nut-serts on the lower bar should point upwards and those on the upper bar should point downwards.

3. Position the height of the feet so that those at the rear are shorter than those at the front. This will mean that the stand leans slightly backwards. This ensures that the press does not lean forwards and the drawer on the press will not slide open of its own accord. IMPORTANT At this stage it is necessary to correctly locate the front and rear of the stand, this is highlighted by the F and R in Figure 1.

5.6 Adkins Industrial Stand Assembly (continued)

4. Lift the press into place on the stand. It is essential that the feet on the press are located above each corner of the stand before the press is lowered onto the unit. IMPORTANT As with Step 3 above, ensure that the front and rear of the stand have been correctly identified.

5. Once the press is positioned on the stand, remove the domed nuts securing the rear feet to the press. Shown in Figure 2 and Figure 3.

6. Secure the L Shaped brackets to the rear of the stand and above the rear feet, with the cut-out positioned around the bolt. As highlighted in Figure 4 and in Figure 1.

7. Re apply the domed nuts and tighten these to secure the rear of the press.

Figure 2

Figure 3

Figure 4

Figure 5

6 Design Change

With the policy of constant improvement and/or modification to meet changing conditions, the right is reserved to change the design and/or specifications at any time without prior notification, and therefore specifications may vary and not be in accordance with this manual.

Warranty and Declaration

Guarantee (Limited Warranty)

Adkins warrants that the machine is free from defects in material and workmanship for a period of 12 months from the date of supply. The machine comes with a one-year warranty on parts, based on a standard equipment operating schedule of 8 hours per day, i.e. 3000 hours.

This warranty covers all parts to repair the defects, except when damage results from misuse or abuse, accident, alteration or negligence or when a machine has been improperly installed.

If a machine covered by warranty should need to be returned to the factory for examination or repair, where an on-site component replacement is not possible, Adkins will make every effort to repair the customer's machine.
The warranty will only be effective when Adkins authorises the original purchaser to return the machine to the factory and only when the product examination has proven the machine to be defective.

Should any part of the machine be found defective in materials or workmanship, it will be replaced by the supplying dealer, distributor or the manufacturer depending on geographical agreements, provided that the machine has been installed, maintained as per the guidance, operated in the correct manner and not subjected to misuse.
Whilst in warranty, any non-consumable replacement parts will be provided free of charge by Adkins to the supplying dealer/distributor. Additional costs associated with, but not limited to, labour and travel will be at the discretion of the supplying dealer and/or distributor.
For non-mainland UK onsite warranty claims, the manufacturer covers parts and labour as standard. Additional costs such as travel and expenses are not covered by the warranty but will be borne by the customer, with expenses at the discretion of the supplying dealer.

In exceptional circumstances, if Adkins authorise a replacement machine, the warranty of the replacement machine shall expire on the anniversary date of the original machines invoice to the end user or the installation date logged via the 'warranty activation form' by the Adkins dealer.

For the warranty to be effective, no return of machine or parts may be made without prior authorisation. This will exclude any travelling and/or carriage costs which will be charged at our discretion.

Replacements parts purchased, when outside of the original 12 months machine warranty, receive a 6-month parts warranty, provided that the part and machine have been installed, maintained as per the guidance, operated in the correct manner and not subjected to misuse.

This is the sole warranty given by the company; there are no warranties, which extend beyond the description on the face hereof. The seller disclaims any implied warranty of merchantability and/or any implied warranty of fitness for a particular purpose; the buyer agrees that the goods are sold "as is".

The sole purpose of the machine is to be used for its intended use. Outside of this use Adkins does not warrant the machine. The entire risk of use, operation and/or maintenance of the machine lies with the end user.
No claim of any kind shall be greater than the sale price of the product or part to which the claim is made.

In no event will Adkins be liable for any injury, loss or damage, including loss of profits, destruction of goods or any special, incidental, consequential or indirect damages arising from the use of the machine or accompanying materials.
This limitation will apply even if Adkins or its authorised dealer/distributor had been advised of the possibility of such damage.

CHARTERHOUSE HOLDINGS PLC
EU DECLARATION OF CONFORMITY

Application of Council Directives:	European Low Voltage Directive **(LVD)**, European Machinery Directive **(MD)**, Electro Magnetic Conformity **(EMC)**
Standards to which Conformity is Declared:	**(LVD):** **EN 60204-1:2018** **(MD):** **EN ISO 12100:2010 2006/42/EC Annex1** **(EMC):** **EN 61000-6-2:2019**
Manufacturer's Name:	**Charterhouse Holdings Plc**
Manufacturer's Address:	Oakridge Park, Trent Lane, Castle Donington, Derby, DE74 2PY United Kingdom.
Type of Equipment:	Industrial 1000
Standards Compliance:	RoHS COMPLIANT CE
Model Number:	Industrial 1000

I, the undersigned, hereby declare that the equipment specified above conforms to the above directives and standards.

Place: Castle Donington, United Kingdom

Signature: M. S. Carter

Full Name: Miles Carter
Position: Chief Executive

European Union Authorized Representative

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71 Lower Baggot Street
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www.arccompliance,com

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Application of Council Directives:	European Low Voltage Directive **(LVD)**, European Machinery Directive **(MD)**, Electro Magnetic Conformity **(EMC)**
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Manufacturer's Name:	**Charterhouse Holdings Plc**
Manufacturer's Address:	Oakridge Park, Trent Lane, Castle Donington, Derby, DE74 2PY United Kingdom.
Type of Equipment:	Industrial 800
Standards Compliance:	RoHS COMPLIANT CE
Model Number:	Industrial 800

I, the undersigned, hereby declare that the equipment specified above conforms to the above directives and standards.

Place: Castle Donington, United Kingdom

Signature: M. S. Carter

Full Name: Miles Carter
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