

PR-210 PRENSA PARA DVH LÍNEA ALTA PRODUCCIÓN

Fabrique sus propios DVH con el sistema Panaspacer.

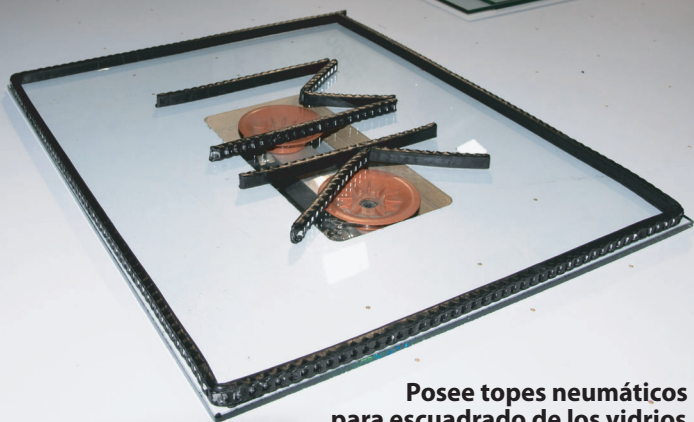
El sistema más simple, ágil, eficiente y económico para la fabricación de vidrios dobles actualmente disponible en el mundo.



DVH

- Con 1 mesa basculante (estándar según fotos):
70/80 paneles con 2 operarios en 8hs.
- Posee topes neumáticos para escuadrado de los vidrios.
- Mesa de apoyo microperforada con colchón de aire para fácil desplazamiento de los paños de vidrio.
- Posibilidad de agregar más de una mesa basculante.
- Trabaja mediante pedales.
- Utiliza espaciadores de medidas desde 6mm hasta 20mm.
- Posibilidad de fabricar triple vidriado hermético.
- Prensa de alta producción para la fabricación de DVH.
- Prensado de todos los bordes con sistema de alimentación continua.
- Fabricación bajo normas de calidad ISO 9001

Muestra realizada en
Batev 2018.



Posee topes neumáticos
para escuadrado de los vidrios.

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1. GENERAL INFORMATION

1.1. INTRODUCTION

The user's manual given by the manufacturer contains necessary information about the machine parts. Each machine operator should read these instructions carefully, and the machine should be operated after fully understanding them.

Safe and efficient use of the machine for long term depends on understanding and following the instructions contained in this manual. The technical drawing and details contained in this manual constitute a guide for the operator.

*In case of any technical problem please contact your nearest OK INDUSTRIAL dealer, or OK INDUSTRIAL head office through the above mentioned phone fax or e-mail address

* Technical labels with the model description of the machine are fixed onto the front side of each machine.

*The machine's serial number and manufacturing year are stipulated on the technical label.

Average life usage of production is 10 years. If you have any further failure and complaint, please inform to our below mentioned technical service by verbal or written

AUTHORIZED TECHNICAL SERVICE CENTER ADDRESS ;

For minimize the documentation, It is very necessary to mention below details at the agreements signed with suppliers and dealers of the purchased machines..

OK INDUSTRIAL SRL

Moreno (148) N° 1900 esquina Italia (41)

CP: 1653 Villa Ballester

Bs. As. Argentina

T: 0054 9 11 4738-2500 rotativas

info@okindustrial.com.ar

www.okindustrial.com.ar

*Machine's serial number

*Machine model

*Voltage and frequency

*Name of dealer where machine was purchased

*Date of purchase

*Average daily operation period

*Description of the machine fault



CERTIFICADO DE GARANTIA

Los productos OK INDUSTRIAL tienen garantía total contra eventuales defectos de fabricación, evidenciados en condiciones de uso y manejos normales, por el término de 12 meses contados a partir de su entrega. Si OK INDUSTRIAL recibiera aviso de algún defecto bajo las circunstancias anteriormente detalladas podrá, discrecionalmente, reparar o sustituir el producto defectuoso sin costo para el cliente.

En caso de reclamo justificado, la responsabilidad máxima de la empresa para con el cliente quedará limitada al precio de compra pagado a OK INDUSTRIAL o al canal de venta autorizado y no incluye compensación o indemnización alguna por otros conceptos.

Limitaciones y Exclusiones

La garantía no será aplicable en los siguientes casos:

- 1) Cuando el producto haya sufrido mal uso; modificaciones no autorizadas, funcionamiento o almacenamiento, desplazamientos, instalación, mantenimiento y transporte en condiciones inadecuadas.
- 2) Daños causados por desastres naturales o provocados (inundaciones, rayos, terremotos, etc), fluctuaciones de la corriente eléctrica, interacción con otros productos de otras marcas.
- 3) Derrame de sustancias corrosivas o deteriorantes sobre el producto.
- 4) Cuando se detecte que el producto fue desarmado total o parcialmente, o sufrió algún intento de reparación por personal no autorizado por el fabricante.
- 5) Daños ocasionados por pruebas, instalación, mantenimiento o ajustes inapropiados.
- 6) Desgaste generado por el uso inherente a la propia naturaleza del material.
- 7) La garantía se rige por la ley del lugar de fabricación del producto.

Las garantías de componentes y/o accesorios de otras marcas que formen parte de nuestros equipos tales como motores, mandos neumáticos, hidráulicos y/o eléctricos, fresas, freselines, hojas de corte, etc, corren por cuenta de su respectivo fabricante.

OK INDUSTRIAL garantiza el aprovisionamiento de todos los componentes que puedan haber sufrido accidentes y/o desgaste natural cobrando su costo de lista y los gastos de envío.

Para obtener el servicio de garantía, el cliente debe acudir al establecimiento de OK INDUSTRIAL con una copia de su factura de compra ó a su distribuidor autorizado que le proveyó del equipo.

Si el cliente prefiere usar servicios de transporte para enviar su equipo a reparación, deberá llamar con anterioridad a los teléfonos de OK INDUSTRIAL donde se le darán instrucciones de seguridad y embalaje para su equipo. Los gastos de envío, transporte y embalaje, estarán a cargo del cliente.

OK INDUSTRIAL SRL no se responsabiliza de los accidentes que se puedan ocasionar por el uso de sus productos o de modificaciones ajenas al fabricante.

OK INDUSTRIAL SRL



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2. MACHINE'S DESCRIPTION AND USER FEATURES


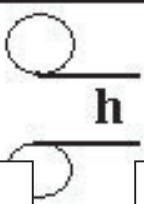


2.1. MACHINE'S DESCRIPTION

The spacers placed between two glass (glazing strip) heating and double glazing presses the machine. There are glass table and glass spacer for installation.

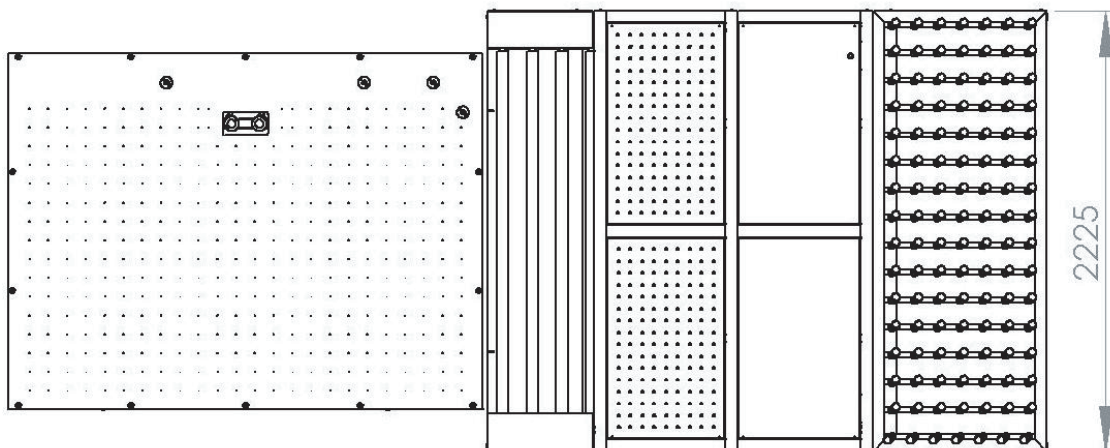
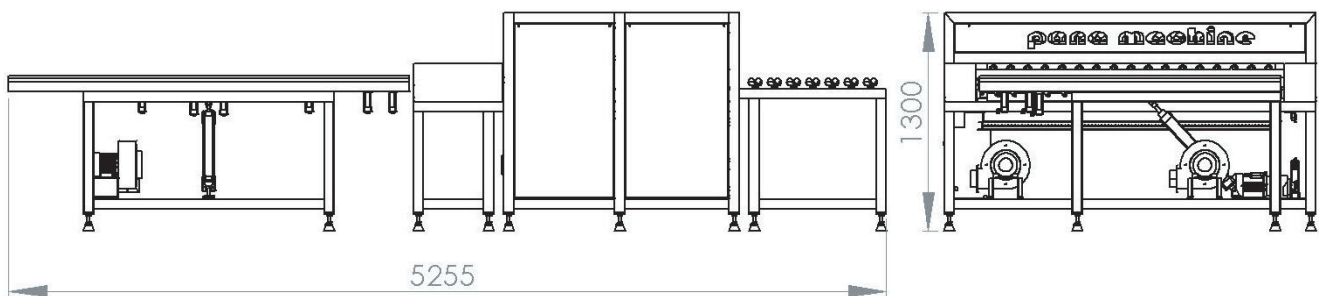
2.2 DIFFERENCES BETWEEN WELDING MACHINES

- * Adjusted to the desired glass and spacer thickness.
- * There are temperature control according to the climatic conditions.
- * There are speed settings for ease of manufacture.
- * There is help in the introduction of the machine mounting stand.
- * The machine complies with CE standards.

2.2. TECHNICAL FEATURES

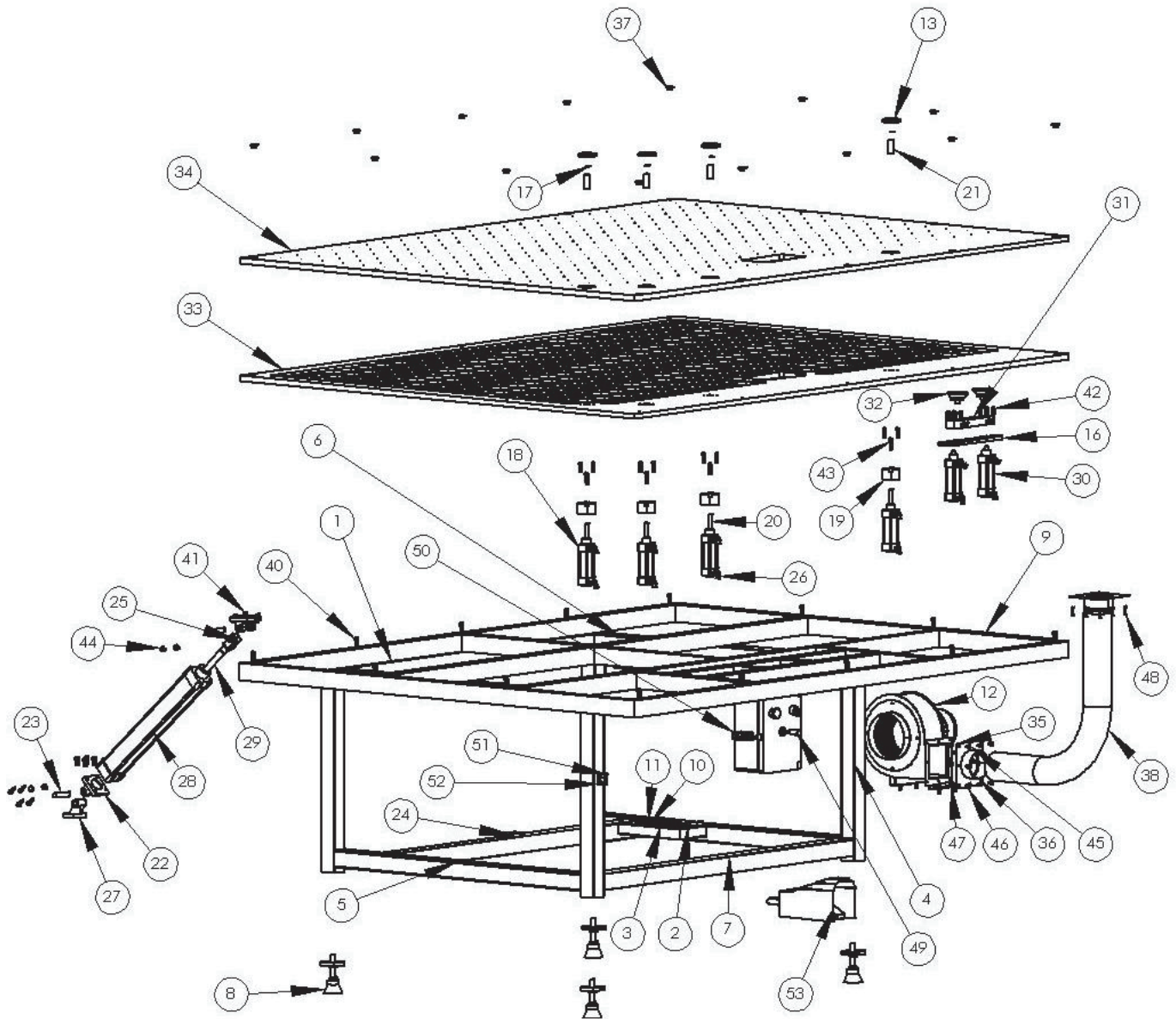
TEKNIK ÖZELLİKLER TECHNICAL FEATURES			 Hava tüke	
PR-210	34 KW 380V 50Hz	Min: 0 mm Max: 50mm	20 Lt./dak Lt/min	5255x2225x1300 1450 kg

2.3. DIMMENSIONS



2.4 PART LIST AND TECHNICAL DRAWINGS

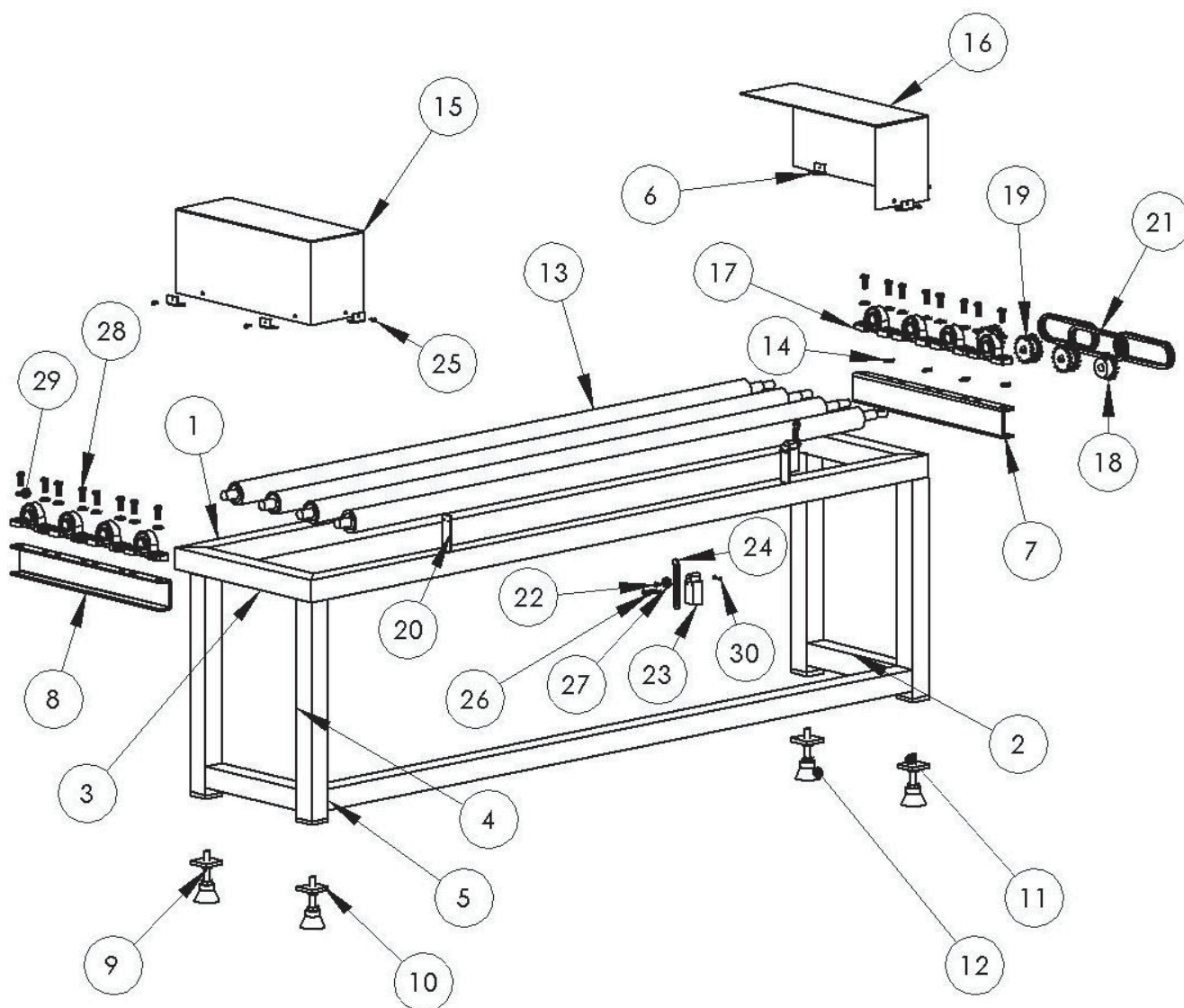
2.4.1 PR-210 HEAT GLASS PREPARATION TABLE



PR-210 HEAT GLASS PREP TABLE PARTS LIST

PART NO	PART LIST	PCS
1	PR-180-1500x60x60	2
2	PR-180-145x60x40x3	1
3	PR-180-280x60x40x3	1
4	PR-180-660x60x60x3	4
5	PR-180-1125x60x60x3	2
6	PR-180-1245x60x60	2
7	PR-180-1380x60x60x3	2
8	M16x2 PLASTIC LEGS	4
9	PR-180-TOP CARCASS	1
10	PR-180-85x60x40x2	1
11	PR-180-SNAIL CONNECTION MOTOR LAM	4
12	SNAIL MOTOR	1
13	32 PISTON TOP COVER	4
14	50x10x40 LAMA	2
15	63x500 CONNECTION FOR RISTON LAMA	1
16	VACUUM LAMA	1
17	Ø 12 OUTER RING	8
18	Ø32x40 PISTON	4
19	Ø32x50 FIND SUPPORT	4
20	Ø32x50 SHAFT	4
21	Ø32x50 PLASTIC	4
22	Ø63 - EB FASTENER	2
23	Ø63 - EB SHAFT	2
24	Ø63 - YB- FITTINGS TO BOTTOM FLANGE	1
25	Ø63 CB-CLIP YOKE	1
26	1/8 ELBOW FITTING	14
27	Ø63 - YB- FASTENER	1
28	Ø63x500 PISTON	1
29	Ø63x500 PISTON SHAFT	1
30	32x10-44 PISTON	2
31	VACUUM ALUMINUM FLAT	1
32	SUCKER	2
33	PR-180-LOWER MDF	1
34	PR-180-TOP MDF	1
35	SPIRAL PIPE STRAIGHT HAIR	2
36	ROUND STEEL SPIRAL PIPE	2
37	TABLE CLAMPING FLANGE	14
38	PR-180- SPIRAL PIPE	1
39	M8x40 IMBUS	14
40	M8x20 IMBUS	20
41	M6x25 IMBUS	8
42	M6x35 IMBUS	16
43	Q16 DIAMETER RING	4
44	M6x15 HEXAGONAL	8
45	6.5- SMALL STAMP	8
46	m6 NUT	8
47	M5- STAR END BOLT	8
48	PLASTIC PANEL	1
49	1/8 5-2 Operated Check Valves	1
50	Air evacuation aluminum	1
51	Air vent connection plate	1
52	PEDAL	1

2.4.2 PR-210 HEAT GLASS EXTENSION GROUP



PR-210 HEAT GLASS EXTENSION GROUP PART LIST

PART NO	PART LIST	PCS
1	2225x60x60x2 PROFILE	2
2	420x60x60x2 PROFILE	2
3	540x60x60x2 PROFILE	2
4	710x60x60x2 PROFILE	4
5	2105x60x60x2 PROFILE	1
6	Hair Connection Lama	6
7	U-G- U LEFT PROFILE	1
8	U-G- U RIGHT PROFILE	1
9	M16x2 NUT	16
10	FLAT FOOT CONECTION	8
11	M16x2 THE WHEEL	8
12	PLASTIC FOOT	8
13	U-G- REEL SHAFT	4
14	6mm KAMA	4
15	U-G FRONT COVER SHEET	1
16	U-G REAR COVER SHEET	1
17	P-205 BEARING	8
18	1-2 I 17 SINGLE ROW SPROCKET	1
19	1-2 II 17 DOUBLE ROW SPROCKET	3
20	SWITCH CONNECTION LAM	2
21	08 -B1 CHAIN	3
22	M5x15 BOLT	6
23	L5K13MEP123 14613863 SWITCH	2
24	L5K13MEP123 14613863 SWITCH END	2
25	M5x10 BOLT	4
26	M5X40 BOLT	2
27	SPIN WASHER	2
28	M10x30 HEXAGON	16
29	M10 THICK WASHER	16
30	M5 NUT	4

PR-210 HEAT GLASS HEATER GROUP PART LIST

PART NO	PART LIST	PCS
1	HEATER GROUP PROFILE CASE	
2	SHEET QUILTED TOP	2
3	TOP COVER SHEET	
4	UPPER FRONT COVER SHEET	
5	1/2-I-17 TENSIONING GEAR	5
6	TENSIONING U LAMA	
7	ANGLE ELBOW	34
8	SIDE COVER SHEET	
9	FRONT COVER SHEET	
10	BACK COVER SHEET	
11	M16x2 FOOT	6
12	SNAIL CONNECTION MOTOR LAMA	4
13	ANGLE AIR PIPE	2
14	M8x20 IMBUS NUT	8
15	SNAIL MOTOR	
16	GEAR MOTOR CONNECTION SHEET	
17	1/2-I-17 CHAIN TENSIONING GEAR	
18	6203 ZZ BEARING	5
19	M8x60 IMBUS NUT	
20	M8x30 IMBUS NUT	4
21	1/2-I-17 SINGLE LINE GEAR	10
22	M8 WASHER	
23	GEAR MOTORS	
24	U TENSIONING LAMA	
25	TENSIONING SPRING	
26	M8 NUT	15
27	M10x45 MOUTH KEY BOLT	16
28	LAMA IS LIFT ACCESS	
29	LIFT SHAFT SET SCREW	
30	LIFT CARRIER LAMA	
31	LIFT SCREW SHAFT ENCODER	
32	M10x35 MOUTH KEY BOLT	54
33	M10 THICK WASHER	54
34	U CONNECTION	



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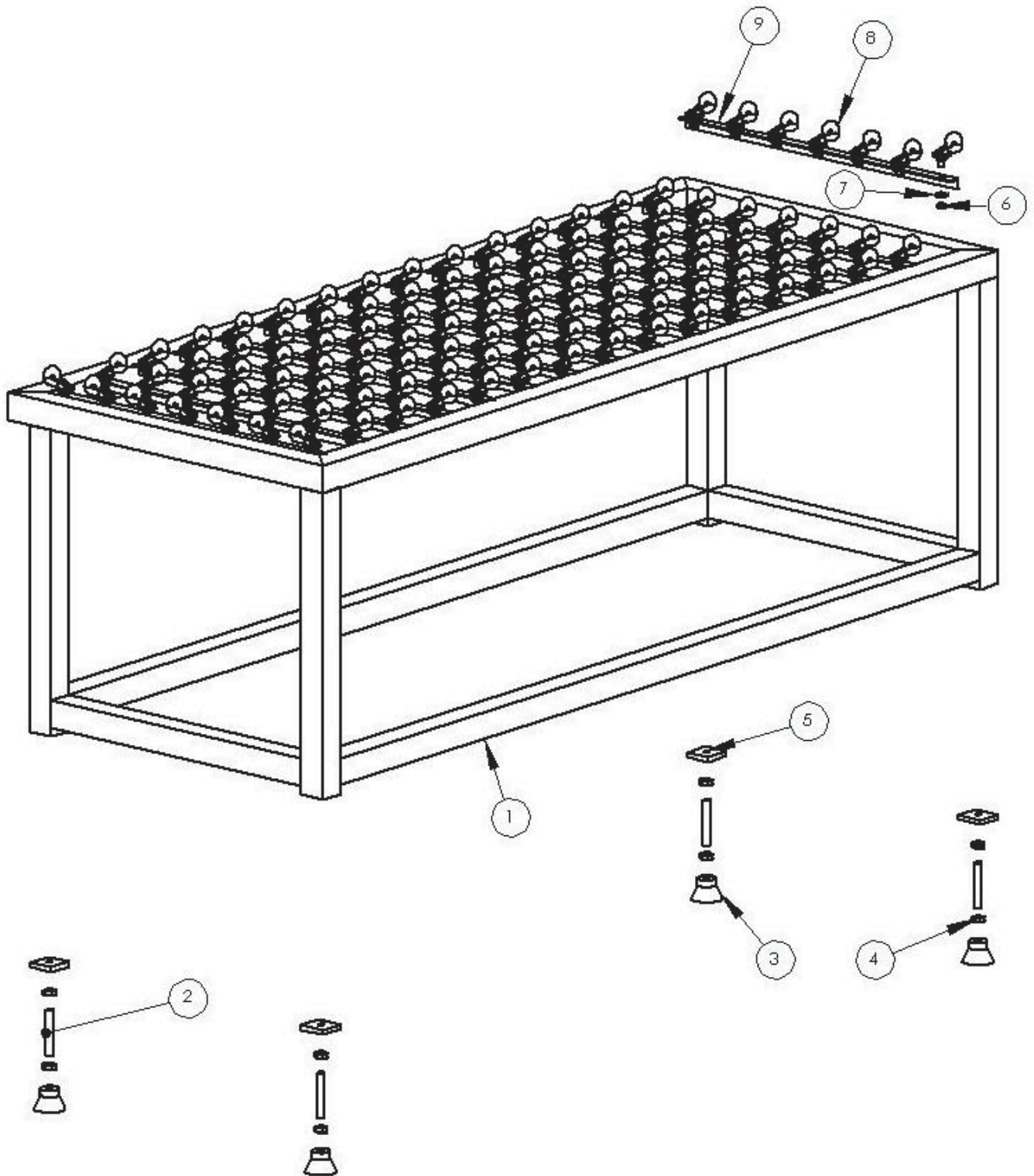
35	U CALL RIGHT-LEFT CONNECTION	
36	U RIGHT-LEFT CONNECTION	
37	Q60 REEL SHAFT	2
38	Q120 REEL SHAFT	6
39	UPPER HOOD LONG PIPE	
40	HALOGEN LAMP UPPER RIGHT-LEFT SHEET	
41	HOOD TOP SHORT PIPE	
42	750 W HALOGEN LAMP	34
43	UPPER HOOD	
44	SCREW LIFT SHAFT	2
45	1/2-II-17-34 DOUBLE ROW GEAR	2
46	1/2-II-17 DOUBLE ROW GEAR	4
47	LEFT REAR COVER SHEET	
48	RIGHT REAR COVER SHEET	
49	P205 BEARING BEARING	27
50	LEAD ROLLER SHAFT	4
51	HALOGEN LAMP LOWER RIGHT-LEFT SHEET	
52	HOOD STRAIGHT HAIR	2
53	SUB HOOD	
54	HOOD CONNECTION LAMA	
55	CABLE CHANNELS	
56	Q90x3 SHORT PIPE	
57	ELECTRICAL PANEL	
58	DOOR LOCK	2
59	WINTER SUMMER KEY	
60	OFF-ON SWITCH	
61	START-STOP SWITCH	
62	SET SPEED SWITCH	
63	THICKNESS SET SWITCH	
64	EMERGENCY STOP SWITCH	
65	08 B1 CHAIN	



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2.4.4 PR-210 HEAT GLASS CARRIAGE GROUP





PR-210 HEAT GLASS CARRIAGE GROUP PART LIST

PART NO	PART LIST	PCS
1	CARRIER PROFILE CASE	1
2	M16x2 THE WHEEL	4
3	PLASTIC FOOT	4
4	M16x2 NUT	8
5	FOOT CONNECTION LAM	4
6	WHEELS (1501-MTB)	112
7	25x25x3 ANGLE	16
8	M10-1.5 NUT	112
9	M10 THICK WASHER	112

3. SAFETY



3.1 SAFETY INFORMATION

The symbols shown hereunder are necessary to be read with special attention. Not reading or observing of them may cause damage to the equipment or personal injury.

IMPORTANT

The IMPORTANT symbol above is one telling to apply special care and to be careful at carrying out the specific operation.

CAUTION!

The CAUTION! Symbol above warns you against specific dangers, and requires to read the text. Not observing may cause damage to the equipment.



DANGER WARNING

The above symbol DANGER WARNING, warns you against specific dangers, and you have definitely to read them. Negligence may cause damage to the equipment and bodily injury.

Read the user's manual carefully before using the machine or carrying out maintenance works.



3.2. ACCIDENT PREVENTION

3.2.1. Our machines are manufactured in accordance with EN 60204-1 and EN 292-2 CE safety directives, which cover national and international safety directives.

3.2.2. It is the task of the employer to warn his staff against accident risks, to train them on prevention of accidents, to provide for necessary safety equipment and devices for the operator's safety.

3.2.3. Before starting to work with the machine, the operator should check the features of the machine, learn all details of the machine's operation.

3.2.4. Machine should be operated only by staff members, who have read and understood the contents of this manual.

3.2.5. All directives, recommendations and general safety rules contained in this manual have to be observed fully. The machine cannot be operated in any way for purposes other than those described herein. Otherwise, the manufacturer shall not be deemed responsible for any damages or injuries. And such circumstances would lead to the termination of the warranty.

3.3. GENERAL SAFETY INFORMATION

3.3.1. The power cable should be led in such a way that nobody can step on it or nothing can be placed on it. Special care has to be taken regarding the and outlet sockets.



For example  1 sec put 10 value.

3.3.2. If the power cable should be damaged operation, don't touch and unplug it. Never use damaged power cables

3.3.3. Don't overload machines for drilling and cutting. Your machine will operate more safely with power supply in accordance with the stipulated value.

3.3.4. Don't place your hands between parts in motion



3.3.5. Use correct illumination for the safety of the operator. (ISO 8995-89 Standard The lighting of indoor work system)

3.3.6. Use protective eye glasses and earplugs. Don't wear oversized clothes and jewelry. These can be caught by moving parts



3.3.7. Don't use any materials other than those recommended by the manufacturer for welding operations on the machine



3.3.8. Ensure that the work piece is clamped appropriately by the machine's clamp or vice.

3.3.9. Ensure safe working position, always keep your balance

3.3.10. Don't leave anything on the machine



3.3.11. Keep your working place always clean, dry and tidy for accident prevention and operation

3.3.12. Keep your machine always clean for safe operation. Follow the instructions at maintenance and replacement of accessories. Check the plug and cable regularly. If damaged, let replace by a qualified electrician. Keep handles and grips free of any oil and grease.

3.3.13. Unplug first, before conducting and maintenance works

3.3.14. Ensure that any keys or adjustment tools have been removed before operating the machine.

3.3.15. If you are required to operate the machine outside, use only appropriate extension cables.

3.3.16. Repairs should be carried out by qualified technicians only. Otherwise, accidents may occur

3.3.17. Before starting a new operation, check the appropriate function of protective devices and tools, ensure that they work properly. All conditions have to be fulfilled in order to ensure proper



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operation of your machine. Damaged protective parts and equipment have to be replaced or repaired properly (by the manufacturer or dealer)..

3.3.18. Don't use machines with improper functioning buttons and switches.

3.3.19. Don't keep flammable, combusive liquids and materials next to the machine and electric connections



4. SAFE TRANSPORT OF THE MACHINE

* The transport should be done by qualified personnel only.

4.1. The machine should be transported by lifting with proper equipment (not touching the ground during the transport).

4.2. The Machine is delivered wrapped in nylon as packaging, unless other form of packing is agreed upon with the customer.

4.3. For the weight and overall dimensions of the machine see Technical Features.

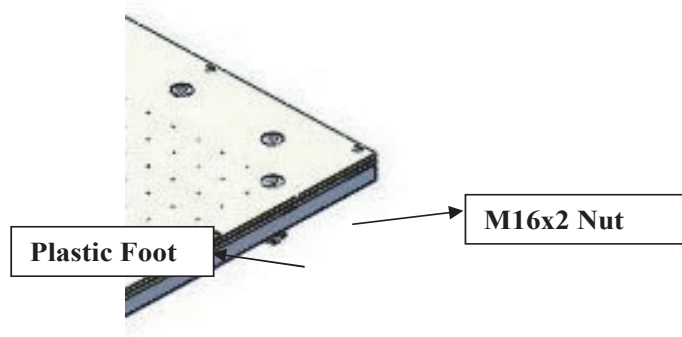
5. INSTALLATION OF THE MACHINE

5.1. Preparation

5.1.1. The machine should be located at least in front of the back wall. The machine is equipped with a burr collection bag connector and power supply socket on the back side (Page no 7)

5.1.2. Position of the rear wall should be approximately 100 cm in the machine

5.1.3. Feet at the bottom of the chassis with the help of the machine can adjust the balance. (Page 1)



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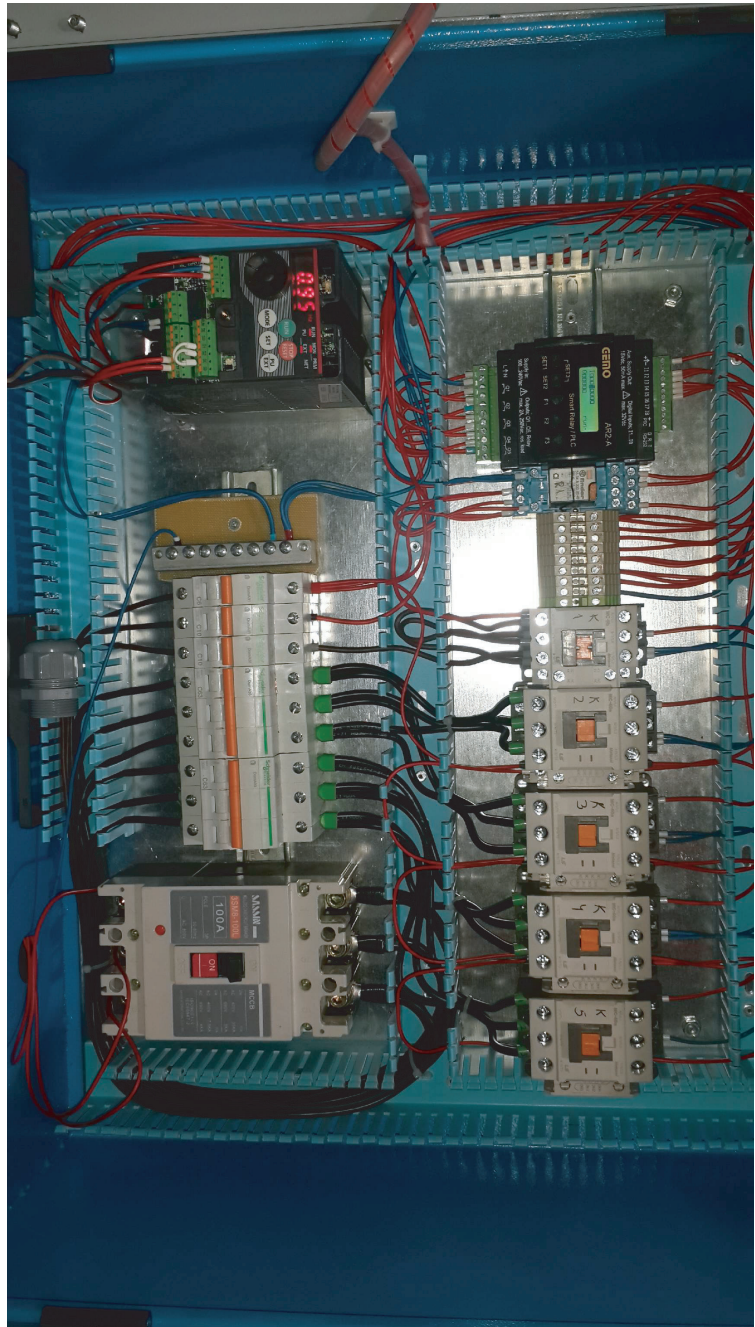
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5.2. ELECTRIC CONNECTION

5.2.1 380V 50 Hz mains voltage is applied.

5.2.2 Apply Plug the machine into a grounded outlet.

PR-180 ELECTRIC PANEL



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6. MACHINE SAFETY INFORMATION

- 6.1. The machine used for removing the protective enclosure.
- 6.2. Remove the machine, place, qualified and authorized personnel should be used for electrical maintenance work.
- 6.3. Routine scheduled maintenance with maintenance work by authorized and qualified personnel should be done after the removal of the electrical power supply circuit.
- 6.4. Cleaning of the machine before working on the machine, ensure that the testing and maintenance made.
- 6.5. Safety equipment and moving parts of the electrical power cord as a routine check. If you see damage to equipment or parts to fulfill the functions of security with a new one without changing the machine operate.
- 6.6. Never change blades for disconnecting electric power.
- 6.7. Holds of foreign bodies in the area where the operation, Do not put your hands in between the moving parts.

7. PREPARATION OPERATION

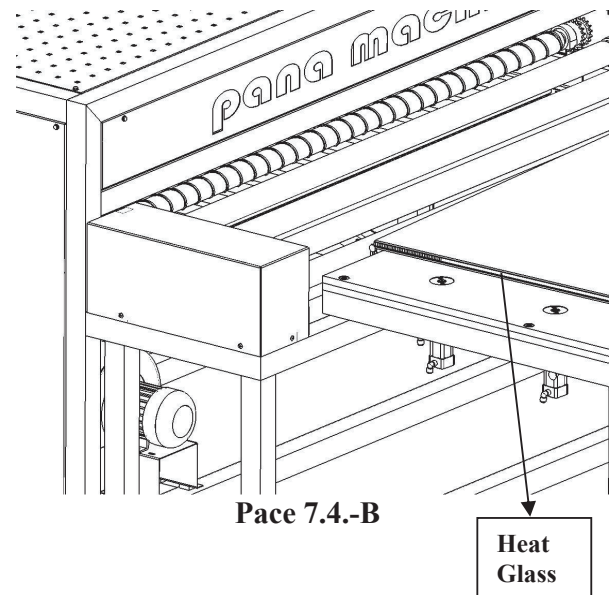
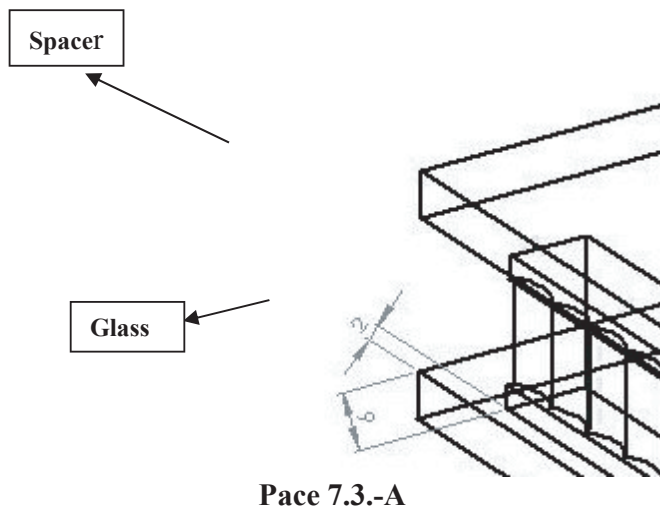
7.1. PRE OPERATION INFORMATION

- 7.1.1. Check that the machine's electrical and air connections made correctly.
- 7.1.2. Adjust the heat setting machine according to climate and weather conditions.
- 7.1.3. Check the air pressure and oil level on the air adjustment unit.
- 7.1.4. Heaters (Halogen) check that the lights of the lamps.

7.2. FINE BINDING AND THICKNESS SET

- 7.2.1. At the exit of the heat insulating glass on the table during the manufacture of insulating glass seal must be at 45 ° C & 48 ° C.
- 7.2.2. The surface for proper adhesion to glass spacers out of the washer must be absolutely dry.
- 7.2.3. The desired temperature should be set to the glass transition speed. **(Potentiometer)**
- 7.2.4. On top of the glass thickness adjustment of the machine should be adjusted by turning the handle ¼ donuts with the right and left.
- 7.2.5. Machine while turning ¼ donuts energized without arm, calibration settings of the machine is broken.

7.3. SPACEr INSTALLATION



7.3.1. Washing of the glass, pressed suction valve is brought to the table.

7.3.2. Spacer (Figure 7.3) as 2-3 mm and the initial part of the adhered surface so as to leave 9-10 mm.

7.4. HEAT GLASS MANUFACTURING

7.4.1. Make the electrical connections of the machine.

7.4.2. Open SARTEL.

7.4.3. Remove from off the emergency stop button.

7.4.4. You choose the summer and winter mode.

7.4.5. Start giving, make sure that the machine.

7.4.6. Make the desired thickness adjustment lever with $\frac{1}{4}$ donuts.

7.4.7. Double glazing which was prepared at the table (Figure 7.4-B) contains the input data of the machine.

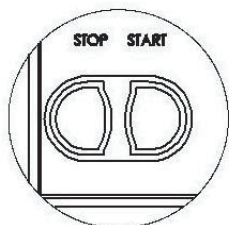


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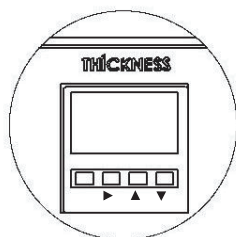
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8- ELECTRONIC DEVICES

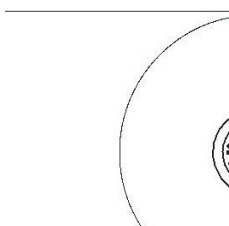
8.1 Introduction to electronic devices



The drive motor start-stop switch.



Heat Glass thickness adjustment counter.



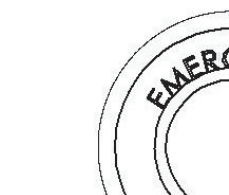
Heat Glass materials used to make fine-tuning the control speed (speed control) key.



Power on-off switch.



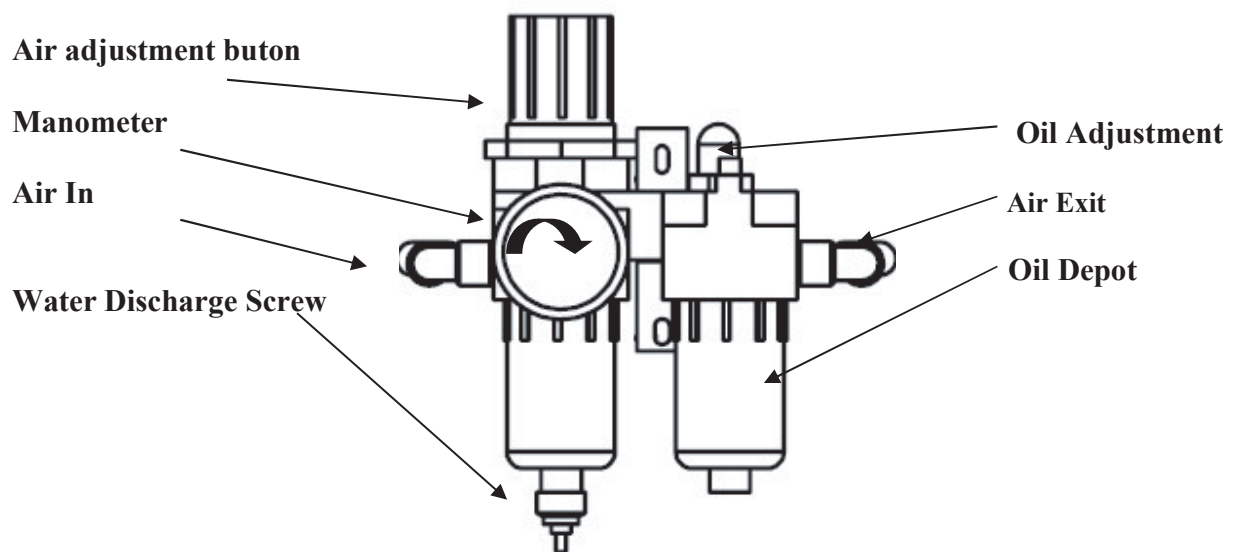
Winter - Summer tuning key.



Emergency button.

9. AIR PRESSURE ADJUSTMENT

Pneumatic systems should be 6-8 bar air pressure to function as healthy. Machine to operate at pressures lower than 6 cups. Conditioner to adjust the air pressure to control and read on the manometer. (FIGURE 8)



- 9.1- ncreasing the pressure adjustment knob clockwise direction is flipped, rotated in the opposite direction pressure Decrease
- 9.2- Once you read 6-8 Bar on the manometer, push the adjustment button of the conditioner down and lock it in that position
- 9.3- The conditioner unit collects the water within the air system in a receptacle in order to prevent damage to the pneumatic system components. Discharge this water periodically (at the end of the working day) by pressing or opening the button under the conditioner.
- 9.4 The manufacturer recommends to use the following oils with the conditioner: TELLUS C 10 / BP ENERGOL HLP 10/ MOBIL DTE LIGHT / PETROL OFISI SPINDURA 10



10. MAINTENANCE

10.1. ROUTINE CHECKS

10.1.1. Before any maintenance or cleaning operation, the **emergency stop** button must be in the 0 position and the Location of **sartel**.

10.1.2. Controls the halogen lamp is made.

10.1.3. 3/8 parts consisting of the chain is checked and lubrication is done when needed.

10.1.4. Any foreign material on the rollers (broken glass, remove melted plastic, etc.), if any.

10.1.4. Check the oil level in the air pressure filters and conditioners. If you complete the missing amount of fat. (Figure 8)

10.2. MAINTENANCE AT THE END OF WORKING DAY

10.2.1 Keep working parts as possible, and periodically clean dirt, oil and check against corruption.

10.2.2. Avoid materials that harm the paint cleaning the machine

10.2.3. When cleaning the machine table, avoid material to the surface.

10.2.4. Check the air adjustment unit periodically, to prevent the entrance of water in the air within the system, check the oil level in the conditioner.

10.3. GENERAL LUBRICATION

10.3.1. The machine is equipped with a special lubricant-free bearings do not require lubrication or greasing. Periodically check the oil level in the conditioner pneumatic system. For the oil to be used (see Article 9)

10.4. SPECIAL PRECAUTIONS

10.4.1. Not work beyond a few days in case the machine is non-painted surfaces to prevent oxidation of the grease. Clean layer of fat in case of working again

10.4.2. The machine will stay out of the long-term use;

- Sartel position 0
- Close the pneumatic system
- 1/2 sprocket to pass protective Grease
- 08-B1 Lubricate the chain
- Keep scratches on the glass table



11. TROUBLESHOOTING GUIDE

POSSIBLE ERRORS AND REMOVAL

Emergency proposals to eliminate the problems below. If the fault can not be eliminated or encounter a malfunction other than those recommended below, please consult the technical service

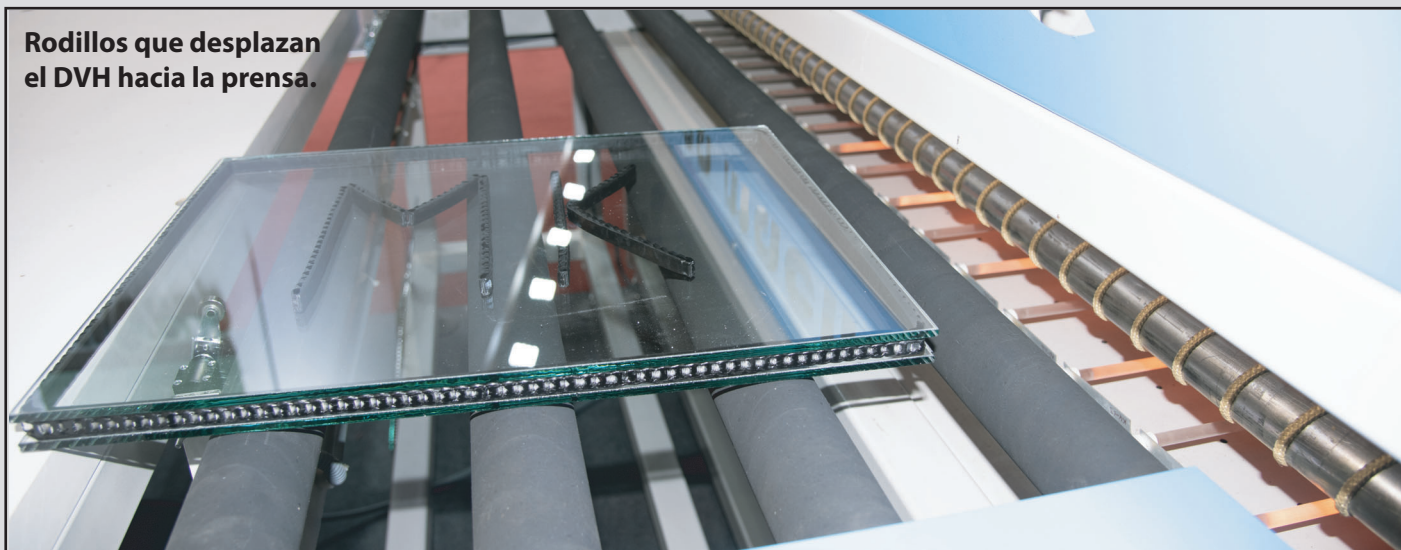
TROUBLES	CAUSES	REMEDY
Thickness error	¼ donuts arm without power have been translated.	Adjustment lever with ¼ donuts to make sure that the necessary adjustments should be made after power on the machine.
Table does not move	Air pressure is insufficient	Check that the air hose into the appropriate machine. Set the air conditioner pressure.
The machine does not work	Emergency stop is active	Emergency stop the machine after the first energy (EMERGENCY) Make sure the button is not active.
	Cards may be problems.	Call technical service.
One of the moving parts of the machine does not work.	Chain 3/8 Lera one or both at the top and front of the machine was broken.	We take 3/8 replace the chain.
The machine is not receiving power.	The power supply light is not lit	Change your power supply Insurance, plugs, sockets and. Check. (Do not connect the machine to the ground.)
	There is a connection error.	
short circuit	Switch for electrical connection with mixing desk snail.	Call technical service.
If the machine has been running for any reason.	-	Call technical service.

DVH

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Rodillos que desplazan el DVH hacia la prensa.



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Mesa de apoyo con rodillos que desplazan los vidrios DVH recién prensados.

