Operating Instructions

Shirt Finisher

VEIT 8325

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1 General Information

1.1 Introduction

The Shirt Finisher VEIT 8325 enables an excellent and complete finish for all kinds of shirts either washed, pre-treated or humidly treated garments. Before being finished the shirts are put on hangers and are finished either buttoned or open. The seam tensioning elements, made-to-measure shoulder forms, electrically heated lapel plates for the front shirt pocket and the integrated suction clamp are all standard features. After being finished the garments can be unloaded automatically (option) and be transported to the folding tables or packaging department by a transport system.

1.2 Warnings and Safety Instructions

- **Only use the voltage and type of current shown on the machine plate.**

- **The unit is supplied with a plug. Do not connect without a plug. The plug must be easily accessible and must not be covered by any components.**

- **The main electrical supply is the responsibility of the customer. Take note of the regulations of the local electric suppliers.**

- **Electrical faults must only be repaired by authorized personnel.**

- **Disconnect the power, air and steam supply before opening the machine.**

- **In case of emergency the machine can be stopped by pulling out the main plug by operating the main switch or by operating the STOP button on the control panel.**

- **Don't put your hand into the guides of the seam tensioning elements and into the mechanics of the front sleeve tensioners. - Danger! You may trap your hand!**

- **Don't reach into the area between the button clamp and the form! Danger of burning!**

- **Steam and condensate lines must have a stop valve.**

Hot steam can burn you; take care!

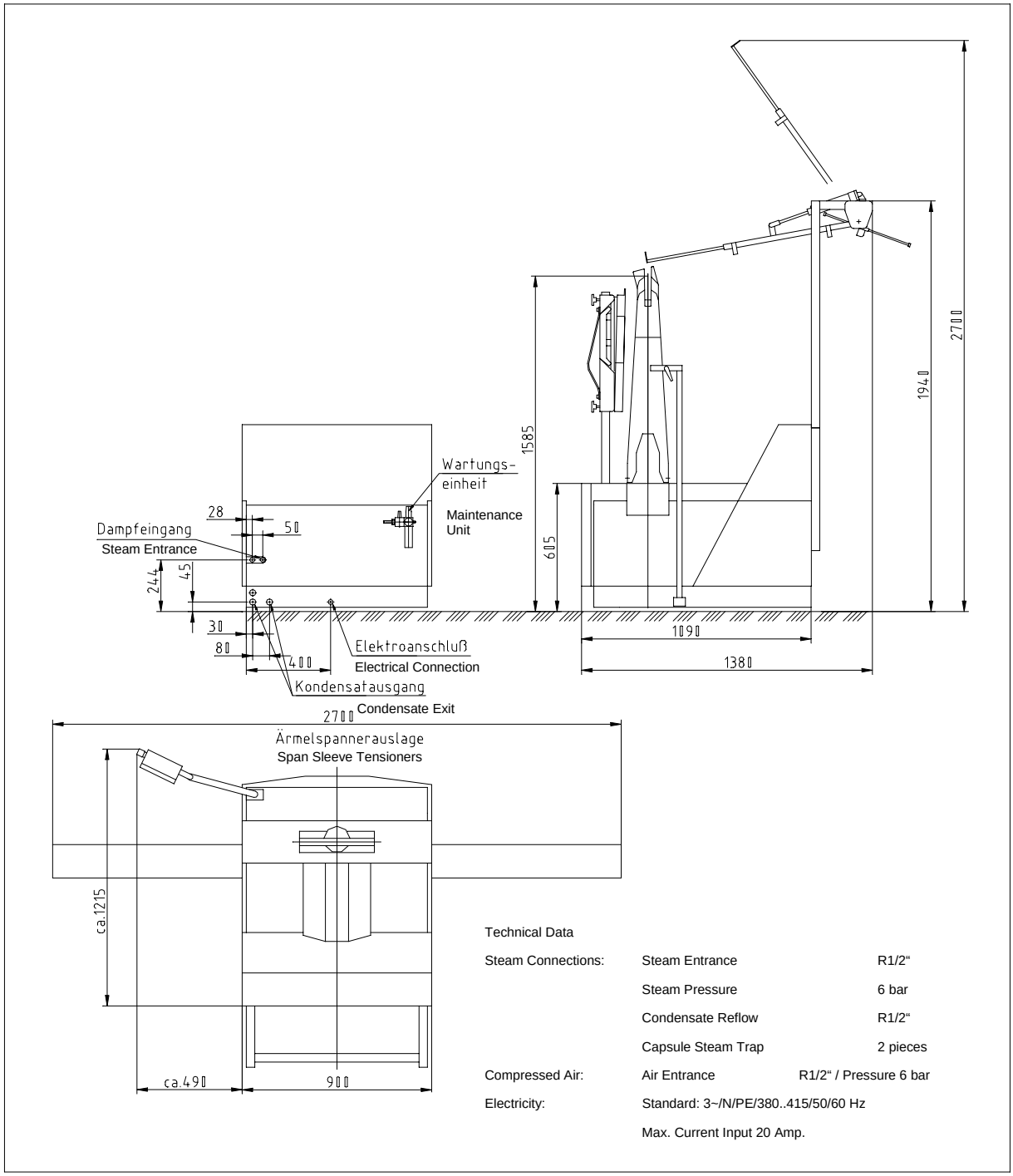
Therefore: You must take special care when testing the steam without using a garment!
Keep a safe distance!

1. **Don't reach into the area below the form!**
2. **Don't touch steam and condensate lines!**

Use only VEIT accessories and Spare Parts.

2 Installation Instructions

2.1 Drawing and Dimensions



Technical Data

Steam Connections:	Steam Entrance	R1/2“
	Steam Pressure	6 bar
	Condensate Reflow	R1/2“
	Capsule Steam Trap	2 pieces
Compressed Air:	Air Entrance	R1/2“ / Pressure 6 bar
Electricity:	Standard: 3~/N/PE/380..415/50/60 Hz	
	Max. Current Input 20 Amp.	

2.2 Installation

The unit should be installed on a level floor. Any unevenness of the floor can be overcome by adjusting the rubber feet.

2.3 Assembly of the Form

The form is fixed with four cylinder screws on the form console.

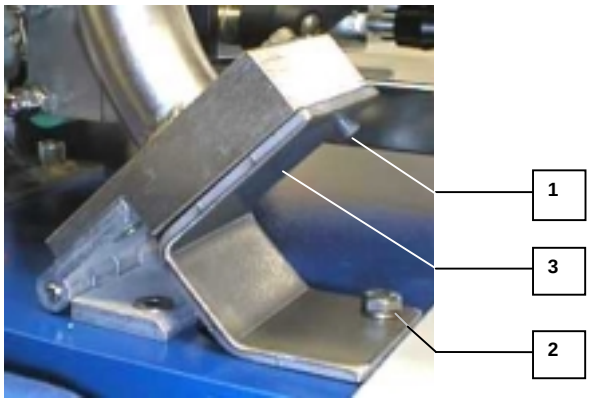
2.4 Assembly of the Sleeve Tensioners

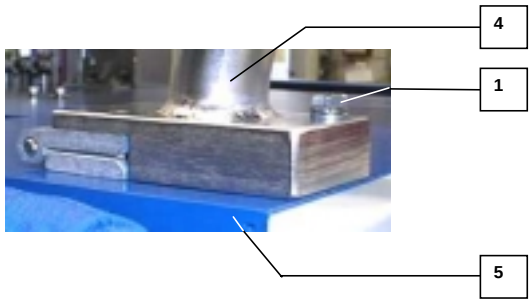
The exact adjustment of the height has to be done with a long sleeved shirt when starting the operation. The correct position is when an optimum tensioning is reached at the position long or short sleeve.

2.5 Assembly of the Control Panel

Open screw (1) and (2) , then take away the transport safety device (3) and move down control panel on machine level.

Fix on basic frame with screw (1).





2.6 Electrical Connection

The unit is already fitted with a Ceecon-plug (400 V) for connection when it is supplied.

Attention: Do not connect without plug.

Install the connection cable so that it will not touch hot steam lines.

2.7 Steam Connection

Have your steam lines connected in accordance with technical principles and regulations. Steam and condensate lines must have a stop valve.

2.8 Compressed Air Connection

Take the maintenance unit out of the packing and screw it to the fastening angle provided at the back of the machine.

Screw the swivelling screw fitting with the eye bolt in the maintenance unit.

Push the compressed air hose over the hose nozzle on the maintenance unit and fasten it with a hose clamp.

Install the compressed air hose so that it will not touch hot steam lines.

The pressure adjustment or the maintenance unit has to be 5.5-6.0 bar.

Attention

When the machine is connected to the compressed air supply, the seam tensioning elements, sleeve tensioners and lapel clamps return to their home position. This also happens when the unit is switched off.

3 Operating

3.1 Commissioning and Start-up

Open condensate return line and steam supply.

Open the compressed air line.

Switch on the main switch on the left side of the machine.

The display on the control panel shows the pre-adjusted values.

All flexible parts of the machine move to their starting position.

Caution: The sleeve tensioners move quickly when opening the compressed air line.

The unit is ready for operation after heating up for approx. 15 minutes.

Carry out some steaming tests without a garment to test the steam quality before operating the machine.

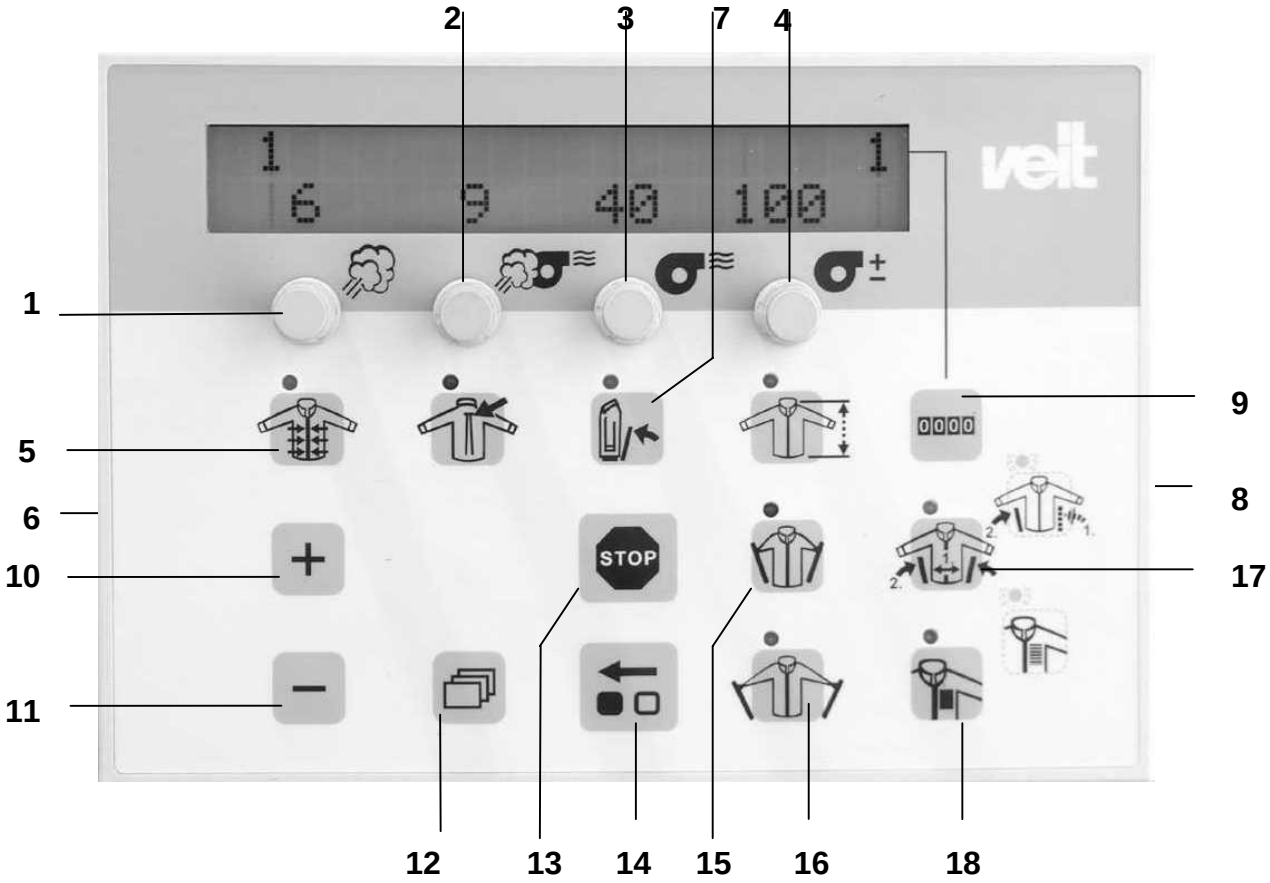
Attention: Danger of burning by hot steam. Keep a safe distance!

3.2 Description of Control Elements Controls

3.2.1 Control Panel

The control panel is equipped with all elements necessary to operate the unit.

The red light emitting diode (called LED) on the optional keys signalize if the respective option is switched on.



1. Rotary button **Steam time**

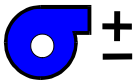
To set the steam time between 0-30 seconds. The adjusted time is shown on the display above the rotary button.

2. Rotary button **Steam-Air Time**

To adjust the steam-air mixture between 0-30 seconds. The adjusted time is shown on the display above the rotary button.

3. Rotary button **Air Time**

To adjust the air time between 0-180 seconds. The adjusted time is shown on the display above the rotary button.



4. Rotary button **Air Quantity** (Option)

To adjust in steps the air quantity to dry the garments. The adjusted quantity is indicated on the display above the rotary button.

5. Press key **Suction Button Tape**

To activate the suction of the button tape.

If this option is activated (LED on) the button tape will be suctioned first, then the button pressure clamp is pressed down manually and the lower end of the button tape is being pressed down automatically by the button tape tensioner.

If this option is deactivated (LED off), the button pressure clamp is pressed down manually first, the button tape will not be suctioned.

When LED flashes, suction, the button pressure clamp and the breast pocket are deactivated. The first step is determined by other optional keys.

6. Press key **Back Pleat** (Option)

If this option is activated (LED on), the back pleat is pressed.

7. Press key **Back Clamp**

If this option is activated (LED on), the back clamp is switched together with the last side clamp.

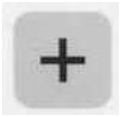
8. Press key **Retensioning Side Back**

If this option is activated (LED on), the sides and the back of the shirt are retensioned during the steam phases. For pressure adjustment refer to 3.2.3.

9. Press key **Pieces Counter**

To set the pieces counter on the right side of the display to zero the key is pressed longer than 3 seconds.

10. Press key **Plus**



To activate the **next** programme.

11. Press key **Minus**

To activate the **previous** programme.

12. Press key **Menu**

To get into another menu.

If there is no input after 10 seconds the menu returns to the last position.

13. Press key **Stop**

To move the machine back to the neutral position from any operating position.

Attention: **All flexible parts move back to their starting position!**

14. Press key **Step back**

To go back to the last control step.

15. Press key **Short Arm**

If this option is activated (LED on), the side tensioners are under permanent pressure. The shirt is continuously tensioned during the finishing cycle.

If the option short arm is activated, the option long arm is automatically deactivated.

16. Press key **Long Arm**

To move the sleeve tensioners to the long-arm position. The LED has to show long-arm position (LED on).

The sleeves are now tensioned by the pneumatic sleeve clamps for one second.

If the option long arm is activated, the option short arm is automatically deactivated.

If none of both sleeve tensioning options is activated (LED off), the sleeve tensioners move totally outwards to inoperative position. The sleeves are not tensioned.

To activate the tensioning function again, one of both keys has just to be pressed and the sleeve tensioners are adjusted to the selected operation mode.

17. Press key **Side Clamp**

If this option is activated (LED on), the side clamps are activated after side tensioning.

With flashing LED the side clamps are activated in sequence during the tensioning process, i.e. first the right and then the left side clamp moves in. Then the side tensioners move out.

18. Press key **Breast Pocket**

If this option is activated (LED on), the breast pocket is pressed during the finishing cycle.

If the LED is flashing, a finishing cycle is activated. The breast pocket is pressed after 1 –2 seconds time-lag, then it is pressed down again for 2 seconds, now the breast pocket remains in neutral position for approx. 2 seconds before being pressed again until the end of the finishing cycle.

3.2.2 Pedal Switch

The right pedal switch activates the tensioning elements step by step.

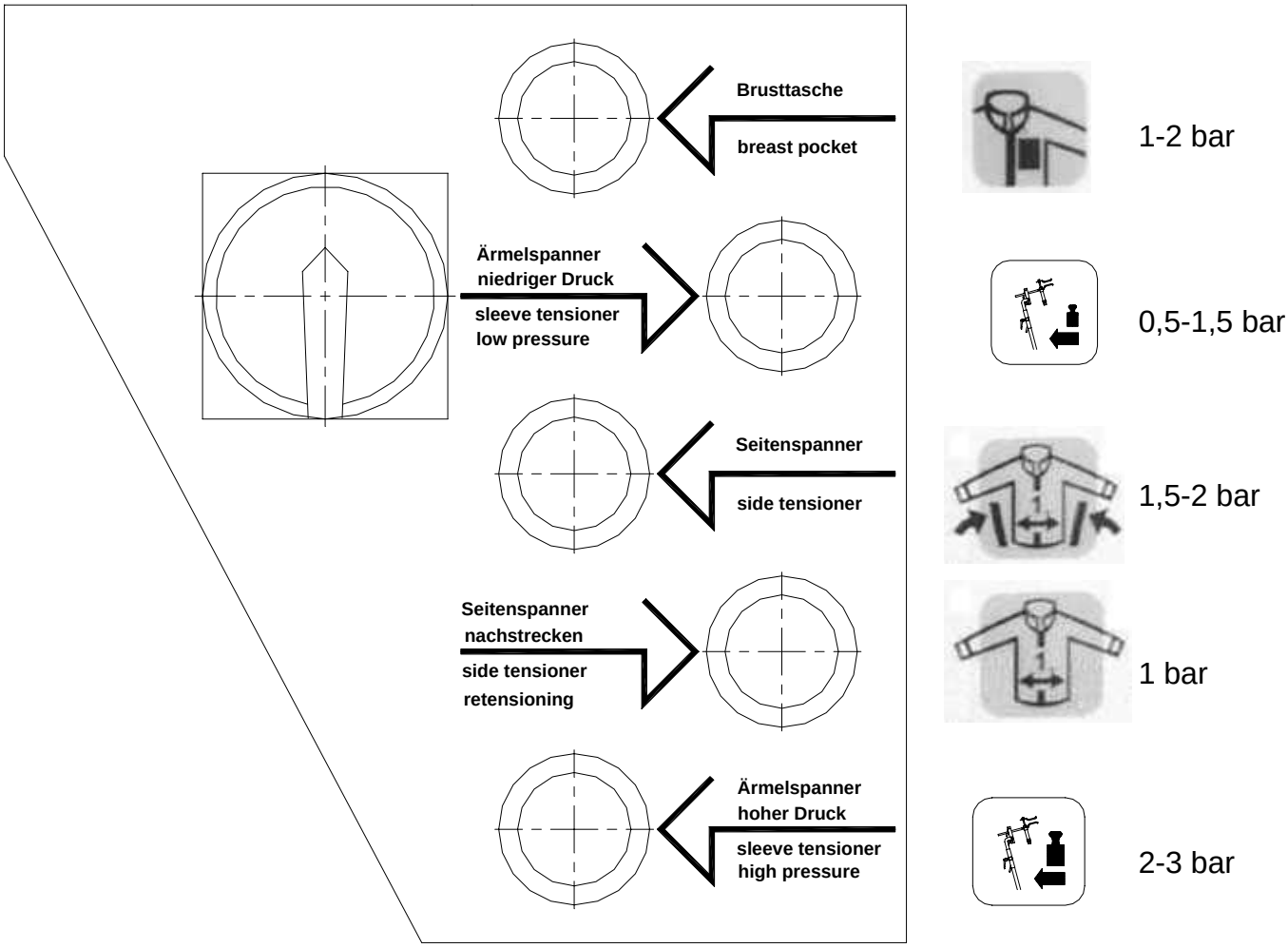
The left pedal switch sets the tensioning elements back step by step.

3.2.3 Pressure Controllers

Five pressure controllers on the left side of the machine make it possible to adjust the pressures for the following functions:

Attention: When the option “Anti-Stretch” is actived, the pressure for “side tensioner retensioning” has to be adjusted to 0.

recommended values



Attention: If the pressure is too high it can damage the fabric of the garment to be finished. Please check correct setting before starting!

3.3 Operation Procedure

After setting all parameters and requested functions the finishing cycle can be started:

Position the garment and check collar position

Adjust the position of the button tape

1. Activate the right foot pedal – vacuum is activated.

   Button tape of the garment must be adjusted.

2. Activate the right foot pedal – the sleeve clamps move inwards; the button tape tensioner moves out.

3. Manually push the button pressure clamp.

   Suction function will be switched off.

4. Position the right sleeve into the right clamping device and then activate the right foot pedal – the right sleeve is being clamped.

5. Position the left sleeve into the left clamping device and then activate the left foot pedal – the left sleeve is being clamped.

6. Both sleeves are being tensioned and the automatic finishing cycle starts.

7. At the end of the finishing procedure the lapel clamps and sleeve tensioners move back to their home position. The garment can be taken off.

Caution: Do not put your hands into the moving parts and into the mechanics of the lapel clamps and sleeve tensioners!

If the step back key is pushed during the automatic finishing procedure, the procedure is stopped by the programme, the left sleeve tensioner moves inwards and the tensioning mechanics of the cuff open.

3.4 Menu Structure

User levels:

A: not authorized, machine is blocked
B: authorized to select programmes, not to change any parameters
C: full authorization for use

- The menu key is blocked during the tensioning and finishing process. The machine is only operable on the operation level.

Menu structure									
	Menu key	Step-back key	Plus key	Minus key	Rotary button “steam time”	Rotary button “steam-air time”	Rotary button “air time”	Rotary button “air quantity”	Au-thori-za-tion
M 1: „Programme selection“ =user level (for user B and C only)	Step to next higher level, if C, or change to password entry (A, B)	Step back (during tensioning or finishing cycle)	Selection of pro-gramme number	Selection of pro-gramme number	Input of para-meters [0-20sec.]	Input of para-meters [0-20sec.]	Input of para-meters [0-180 sec.]	Input of para-meters [0-100% / 5%]	B, C
M 2: „Entry of password“	Step to user level	Step to user level	Confirm and step to next higher level	Step to user level	Password Pos. 4 (alpha-numbers)	Password Pos. 3	Password Pos. 2	Password Pos. 1	A-C
M 2.1: „Password invalid“	Step to user level	Step to user level	Step to user level	Step to user level					
M 3: „Storing“	Step to next higher level	Step to user level	Confirm and step to user level	Refuse, step to user level				Selection of pro-gramme number by over-writing [1-10]	C
M 4: „Change user level“	Step to next higher level	Step to next lower level	Confirm and step to user level	Refuse, step to user level				Select user level [A-C]	C

	Menu key	Step-back key	Plus key	Minus key	Rotary button “steam time”	Rotary button “steam-air time”	Rotary button “air time”	Rotary button “air quantity”	Au-thori-za-tion
M 5: „Parameters breast pocket“	Step to next higher level	Step to next lower level	Confirm and step to user level	Refuse, step to user level			Period of first pressing [in 1/10 sec., 0...25], default 3,0 sec.	Period of pause [in 1/10 sec., 0...25], default 1,0 sec.	C
M 6: Parameter „unloading“	Step to next higher level	Step to next lower level	Confirm and step to user level	Refuse, step to user level			Period of unloading [in 1/10 sec., 0...25,0 sec], default 5,0 sec.	Period of time-lag until unloading [in 1/10 sec., 0...5,0 sec], default 1,5 sec.	C
M 7:	Step to next higher level	Step to next lower level	Confirm and step to user level	Refuse, step to user level				Time-lag between tensioning and steaming [in 1/10 sec., 0...5,0 sec], default 1,0 sec.	C
M 8: Parameter „antistretch“								Period of moving inwards after side tensioning [in 1/10 sec., 0...2,0 sec], default 0,5 sec.	C

	Menu key	Step-back key	Plus key	Minus key	Rotary button “steam time”	Rotary button “steam-air time”	Rotary button “air time”	Rotary button “air quantity”	Au-thori-za-tion
M 9: Parameter „antistretch“							Period of moving out, between side tensioning [in 1/10 sec., 0,5...1,5 sec], default 1,0 sec.	Period of pause between side tensioning and untension-ing [in 1/10 sec., 0,2...1,5 sec], default 0,3 sec.	C
M 10: Display „Change password“	Step to next higher level	Step to next lower level	Confirm and step to next sublevel	Refuse, step to user level					C
M 10.1: „Enter old password“	Step to next higher level	Step to next lower level	Confirm and step to next sublevel	Break off, step to user level	Password Pos. 4 (alpha-numbers)	Password Pos. 3	Password Pos. 2	Password Pos. 1	
M 10.1.1: „Password invalid“	Break off, step to user level	Step to next lower level	Break off, step to user level	Break off, step to user level					
M 10.2: „Enter new password“	Step to next higher level	Step to next lower level	Confirm and step to user level	Break off, step to user level	Password Pos. 4 (alpha-numbers)	Password Pos. 3	Password Pos. 2	Password Pos. 1	
M 10.3: „Confirm new password“	Step to next higher level	Step to next lower level	Confirm and step to user level (=new password is active)	Break off, step to user level	Password Pos. 4 (alpha-numbers)	Password Pos. 3	Password Pos. 2	Password Pos. 1	
M 10.31: „Password invalid“	Break off, step to user level	Step to next lower level	Step to “enter new pass-word”	Break off, step to user level					
M 11: „Restore preset values“	Step to next higher level	Step to next lower level	Confirm and step to user level	Refuse, step to user level					C

User A: not authorized to make any modifications, password is only requested when pressing the menu key.

The parameters adjusted in the menu are independent from any programme, options, however, are integrated in the programme. The counter is independent from the programme.

„Restore preset values“: All parameters adjusted in the menu are set back to the standard values, the values preset in the configuration menu are not affected.

If there is no new input after approx. 10 seconds, the programme goes back to the user level.

3.5 Configuration of the machine

Key combinations (Activation during start-up):

1. **„Stop“+“Step back“:** Set back password (standard: VEIT)
2. **„Plus“+“Minus“:** Primary initialization, configuration of all standard values
3. **„Step back“+„Minus“:** Configuration menu

Configuration menu:

- to be opened by starting up and pressing the keys “step back” and “minus” at the same time.

	Description	Contents	Value after primary initialization
1. Para-meter	Software configuration	1: Standard	1
2. Para-meter	Unloader	0: inactive 1: active	1
3. Para-meter	Configuration of air quantity adjustable	0: off 1: on	0
4. Para-meter	Maximum value air quantity	Configurate analog value	210
5. Para-meter	Antistretch activated	0: inactive 1: active	0
6. Para-meter	Time, move out sleeves, long arms	in 1/10 sec.	1.5 sec.
7. Para-meter	Time, move out side tensioners	in 1/10 sec.	1.0 sec.

Use the Plus-key to confirm and store new configurations immediately.
Use the Stop-key to break off. The actual parameter will not be stored.

4 Maintenance and Service

Pneumatic-maintenance unit: Drain off the water trap periodically and clean the filter element.

Clean the right and left fluff filters regularly.

Clean the impeller every 8 weeks.

Whenever necessary, clean, wash or replace the covers of the form, the lapel clamps and the sleeve clamps, to maintain good finishing and drying.

5 Malfunction and Troubleshooting

5.1 General

Problem	Cause	Solution
Insufficient suction and blowing effect	Fan works in the wrong direction	1. Switch off unit 2. Pull out main plug **Caution!** **Danger by electric shock!** Open unit plug, change phases L1 and L3
Insufficient suction and blowing effect	Cover is dirty or clogged	Replace the cover
Loud fan noise	Dirty impeller and therefore out-of-balance	1. Switch off the unit 2. Pull out main plug Clean the impeller
No indication on the display when switching on	No input voltage Fuses F1/F2/F3 on the mounting plate are defective	Check the unit plug and the main fuse Check the fuse, replace if necessary
The movable components do not react	Input pressure is too low	Set the input pressure at 6 bar
The pedal switch does not operate the machine	Foot switches (S2, S3)are defective or cables are damaged	Check the switches and the cabling (see LED-I/O card)
Anti-Stretch without effect	“Side tensioner retensioning” impressed with pressure	Adjust pressure of “side tensioner retensioning” to 0 bar

5.2 Error Messages on the Display

Error 10	Error of internal storage (EPROM)
Error 20	Short circuit of card 1
Error 21	Short circuit of card 2
Error 22	Short circuit of card 3
Error 23 and Error 26	Transmission error of card 1
Error 24 and Error 27	Transmission error of card 2
Error 25 and Error 28	Transmission error of card 3

Errors cause a stop of system, the machine stops, the error has to be corrected by the Stop key.

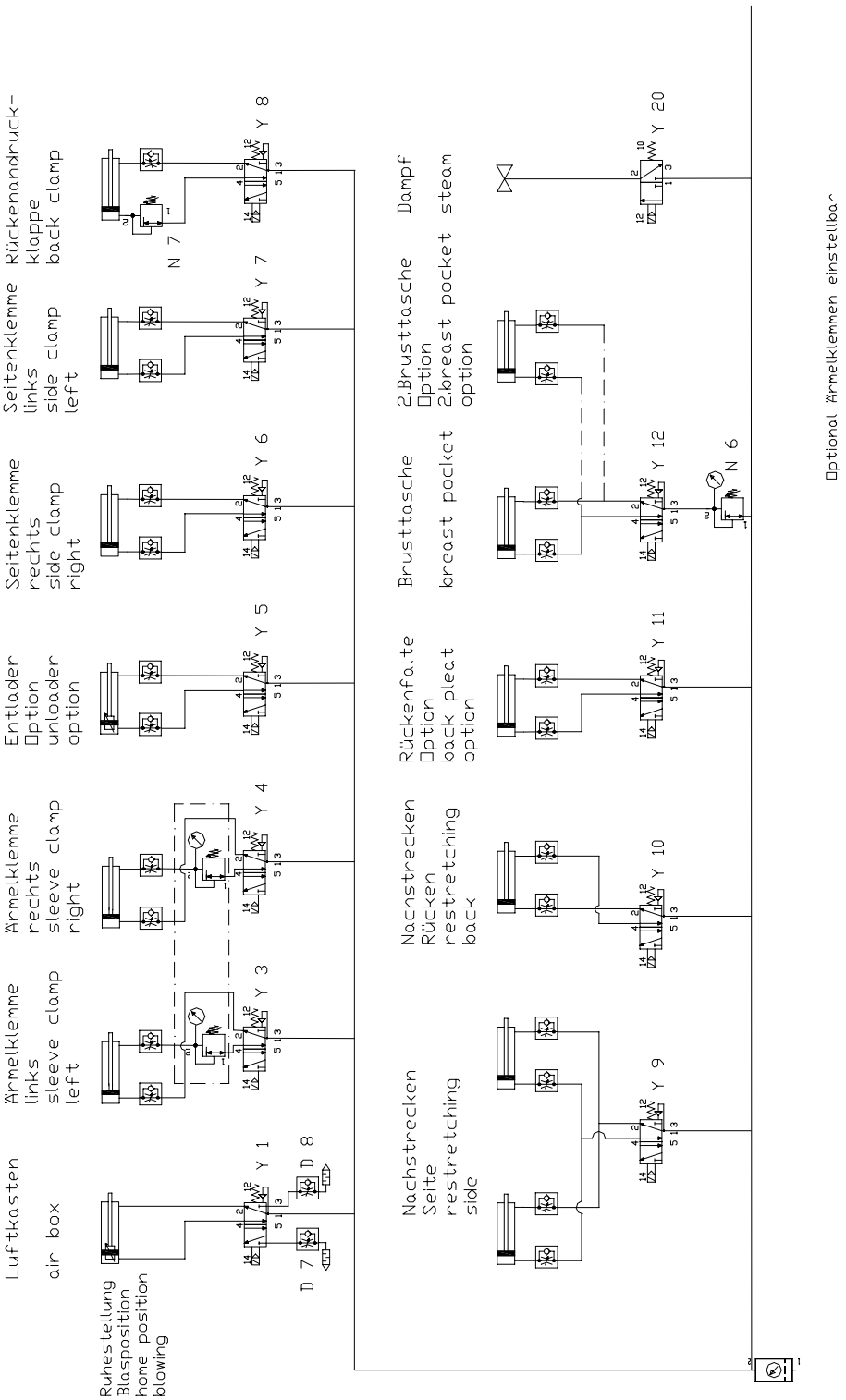
Once an error is confirmed, it is not indicated any more until the machine is started again.

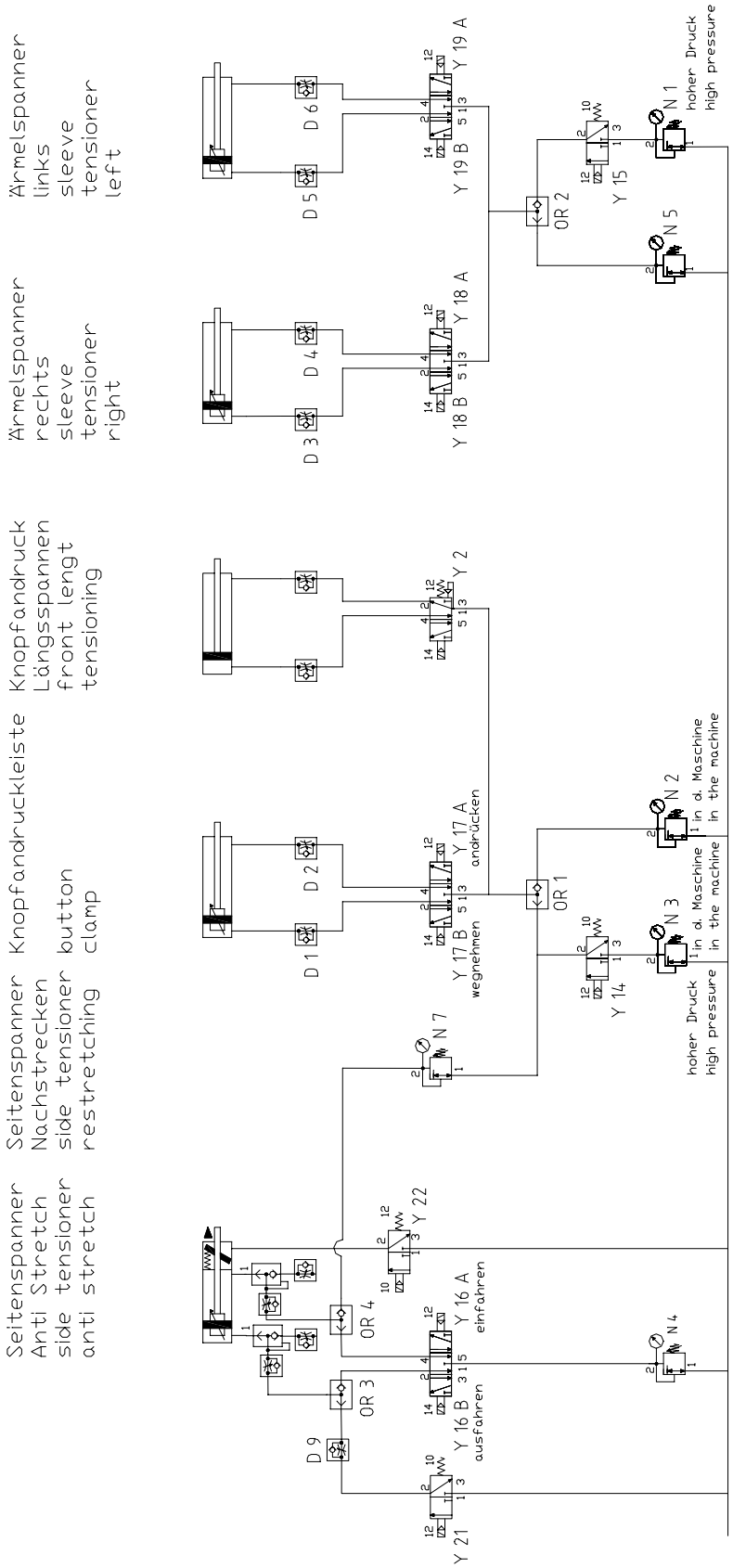
6 Technical Data

Steam connection:	1/2", max. 6 bar
Condensate connection:	1/2"
Compressed air connection:	NW 6; 5.5 - 10 bar
Compressed air consumption:	12 l/min.
Electrical connection:	400 V three-phase current/ neutral wire and earthed conductor separated according to the VDE-regulations
Electrical power:	2.2 kW
Fuse protection:	20 A
Year of construction:	see machine plate
Measurements: Height:	1585 mm (incl. assembled form)
Width:	900 mm (when sleeve tensioners are not moved out)
Depth:	1090 mm
Weight:	290 kg

7 Circuit Diagrams

7.1 Pneumatic Plan




Seitenspanner
Anti Stretch
side tensioner
anti stretch
Seitenspanner
Nachstrecken
side tensioner
restretching
Knopfandruckleiste
button
clamp
Knopfandruck
Längsspannen
front lengt
tensioning
Ärmelspanner
rechts
sleeve
tensioner
right
Ärmelspanner
links
sleeve
tensioner
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Y 16 B
ausfahren
Y 16 A
einfahren
Y 22
Y 17 B
wegnehmen
Y 17 A
andrücken
Y 2
Y 18 B
Y 18 A
Y 19 B
Y 19 A
Y 14
Y 15
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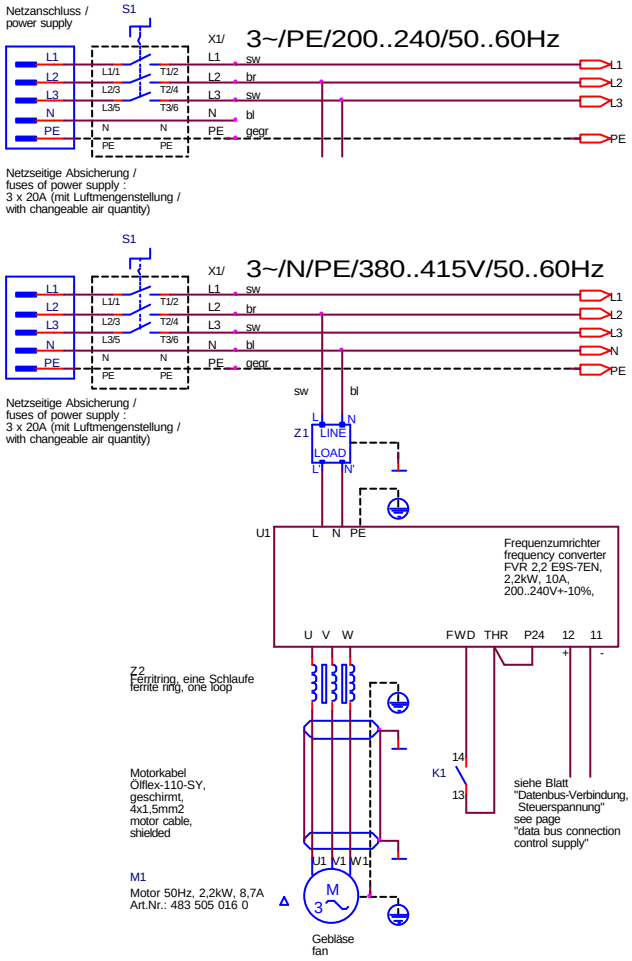
high pressure
in d. Maschine
in the machine

7.2 Electrical Circuit Diagram



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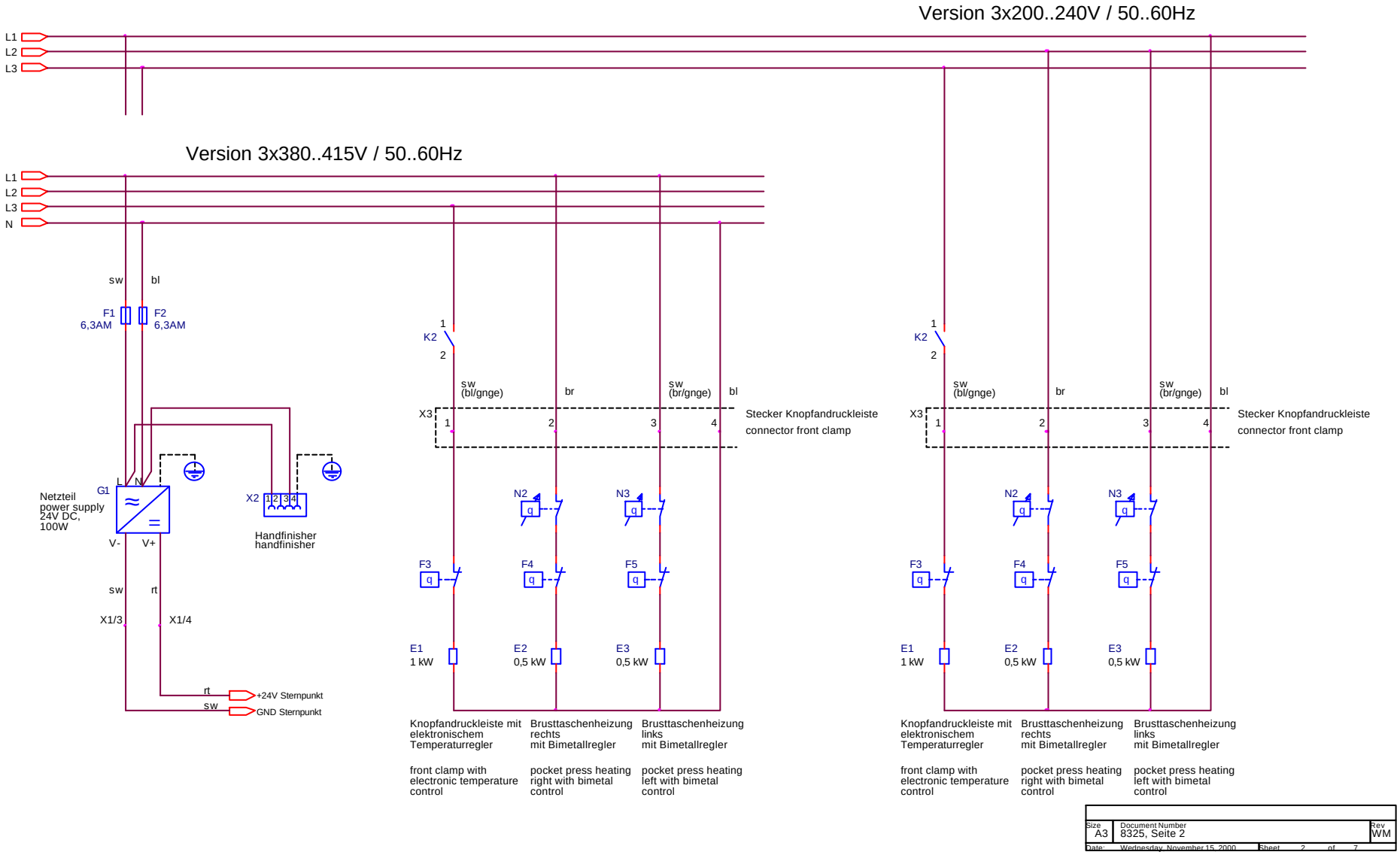
Version 3x200..240V / 50..60Hz
L1
L2
L3
Version 3x380..415V / 50..60Hz
L1
L2
L3
N
sw
bl
F1
6,3AM
F2
6,3AM
Netzteil
power supply
24V DC,
100W
G1
L
N
V-
V+
X2
1 2 3 4
Handfinisher
handfinisher
sw
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X1/3
X1/4
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+24V Sternpunkt
sw
GND Sternpunkt
1
K2
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(bl/gnge)
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(br/gnge)
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X3
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3
4
Stecker Knopfandruckleiste
connector front clamp
N2
N3
F3
F4
F5
E1
1 kW
E2
0,5 kW
E3
0,5 kW
Knopfandruckleiste mit elektronischem Temperaturregler
front clamp with electronic temperature control
Brusttaschenheizung rechts mit Bimetallregler
pocket press heating right with bimetal control
Brusttaschenheizung links mit Bimetallregler
pocket press heating left with bimetal control
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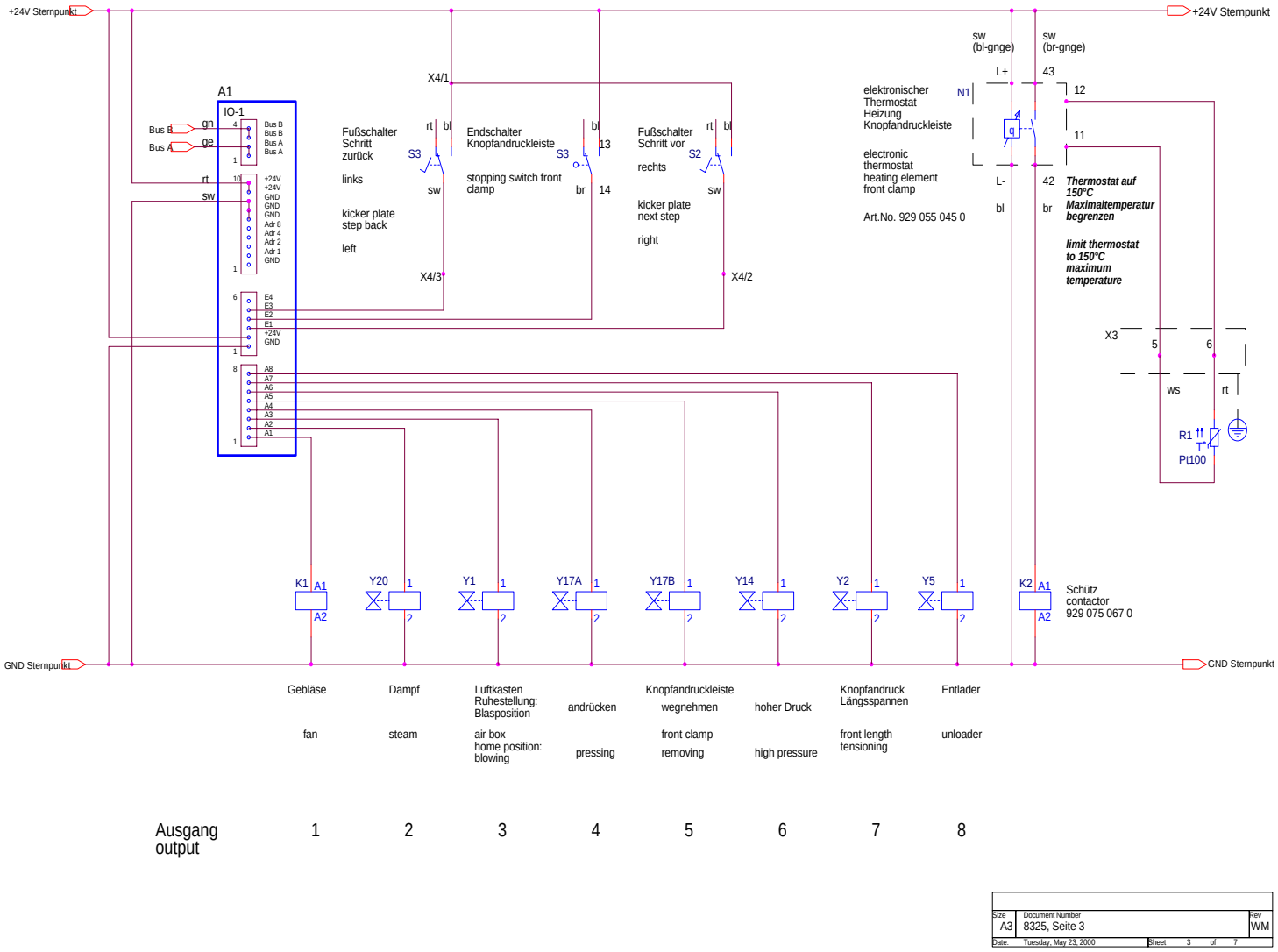
+24V Sternpunkt
GND Sternpunkt
A1
IO-1
Bus B
Bus A
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ge
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sw
Fußschalter Schritt zurück
links
kicker plate step back
left
S3
X4/1
X4/3
Endschalter Knopfandruckleiste
stopping switch front clamp
Fußschalter Schritt vor
rechts
kicker plate next step
right
S2
X4/2
elektronischer Thermostat Heizung Knopfandruckleiste
electronic thermostat heating element front clamp
Art.No. 929 055 045 0
N1
L+
L-
sw (bl-gnge)
sw (br-gnge)
Thermostat auf 150°C Maximaltemperatur begrenzen
limit thermostat to 150°C maximum temperature
X3
ws
R1
Pt100
K1
K2
Schütz contactor 929 075 067 0
Y20
Y1
Y17A
Y17B
Y14
Y2
Y5
Gebläse
fan
Dampf
steam
Luftkasten Ruhestellung: Blasposition
air box home position: blowing
andrücken
pressing
Knopfandruckleiste
wegnehmen
front clamp removing
hoher Druck
high pressure
Knopfandruck Längsspannen
front length tensioning
Entlader
unloader
Ausgang
output
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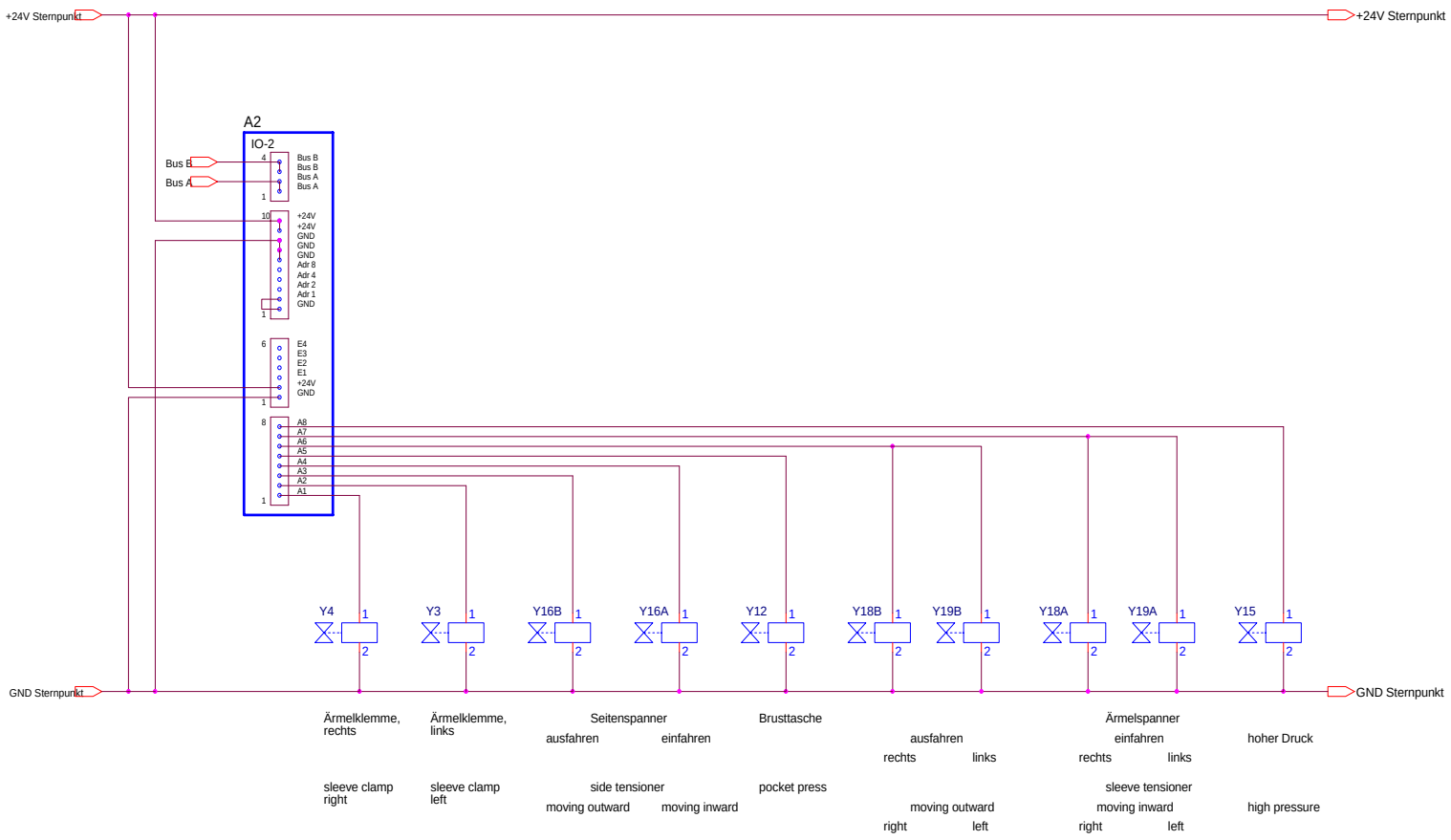
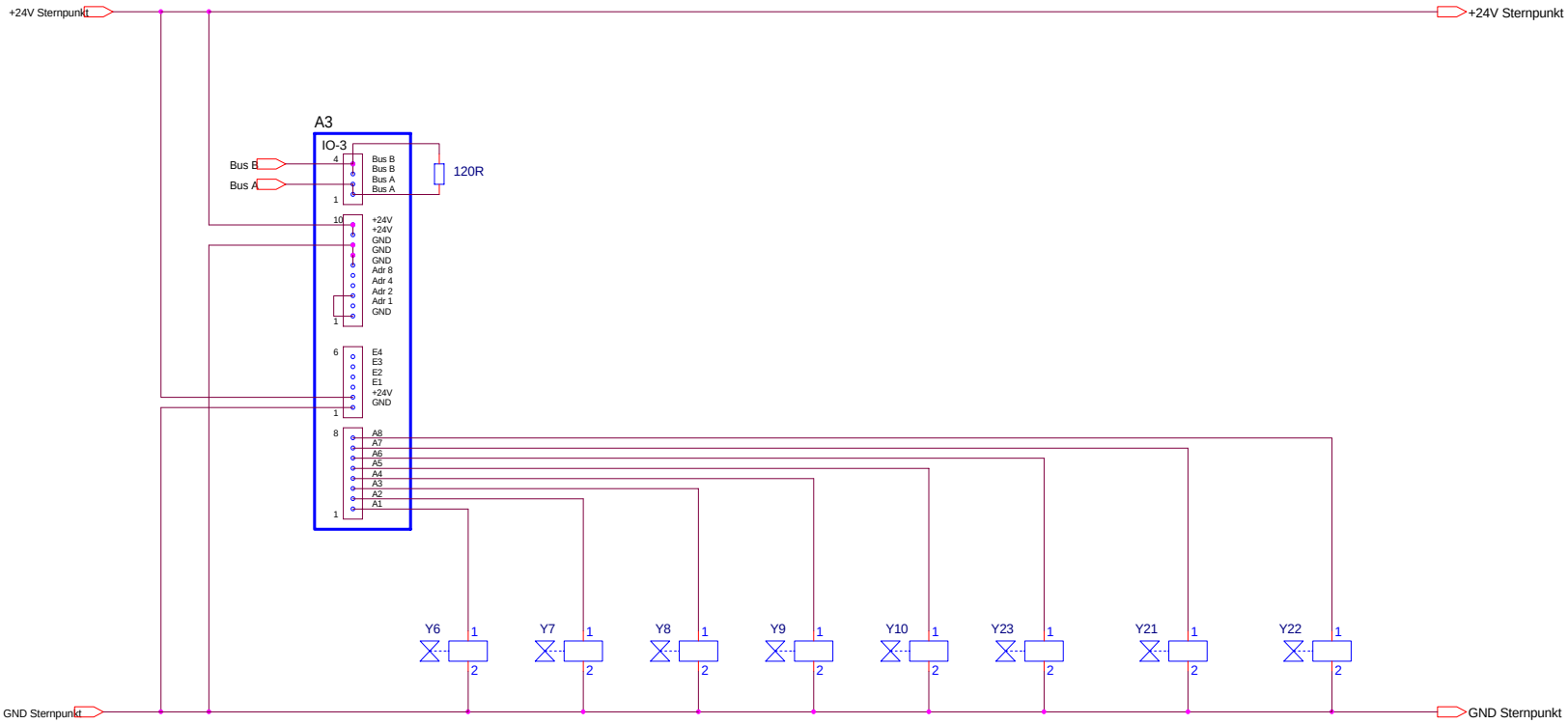
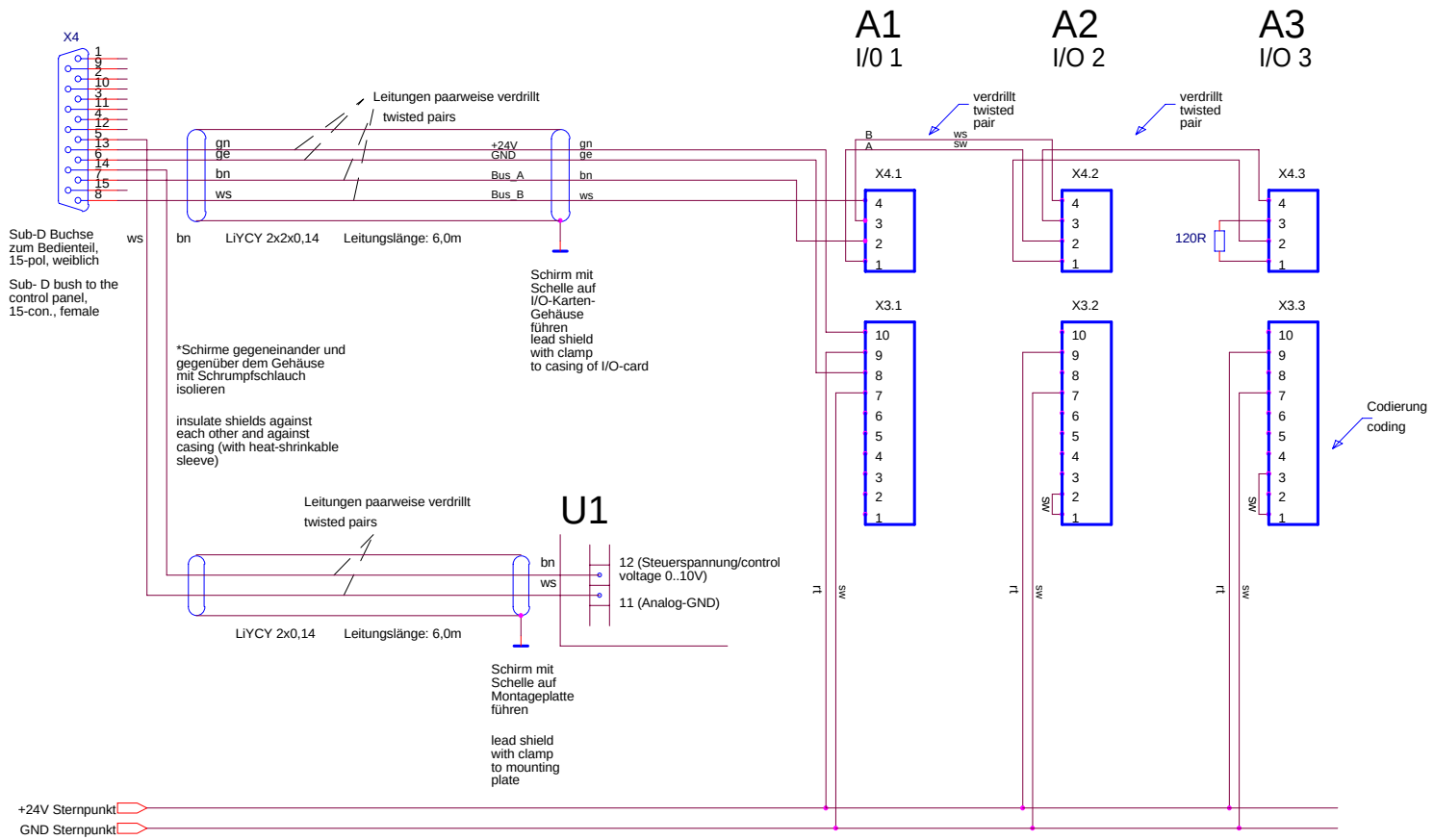

+24V Sternpunkt
+24V Sternpunkt
A2
IO-2
Bus B
Bus A
Bus B
Bus B
Bus A
Bus A
+24V
+24V
GND
GND
GND
Adr 8
Adr 4
Adr 2
Adr 1
GND
E4
E3
E2
E1
+24V
GND
A8
A7
A6
A5
A4
A3
A2
A1
Y4
Y3
Y16B
Y16A
Y12
Y18B
Y19B
Y18A
Y19A
Y15
GND Sternpunkt
GND Sternpunkt
Ärmelklemme, rechts
sleeve clamp right
Ärmelklemme, links
sleeve clamp left
Seitenspanner
ausfahren
einfahren
side tensioner
moving outward
moving inward
Brusttasche
pocket press
ausfahren
rechts
links
moving outward
right
left
Ärmelspanner
einfahren
rechts
links
sleeve tensioner
moving inward
right
left
hoher Druck
high pressure
opt.
Ausgang
1
2
3
4
5
6
7
8
Size
A3
Document Number
8325, Seite 4
Rev
WM
Date:
Tuesday, May 23, 2000
Sheet
4
of
7



Ausgang	1	2	3	4	5	6	7	8
	Seitenklemme, rechts side clamp right	Seitenklemme, links side clamp left	Rückenandruckklappe rear clamp	Nachstrecken, Länge restretching length	Nachstrecken, Rücken restreching rear clamp	Rückenfalte back pleat press	0:gewöhnliche Funktion 1:Seiten langsam ausfahren 0:normal function 1:move side sections slow out	0:Seiten beweglich 1:Seiten blockiert 0:free side sections 1:fixed side sections
						opt.	Option Antistretch	

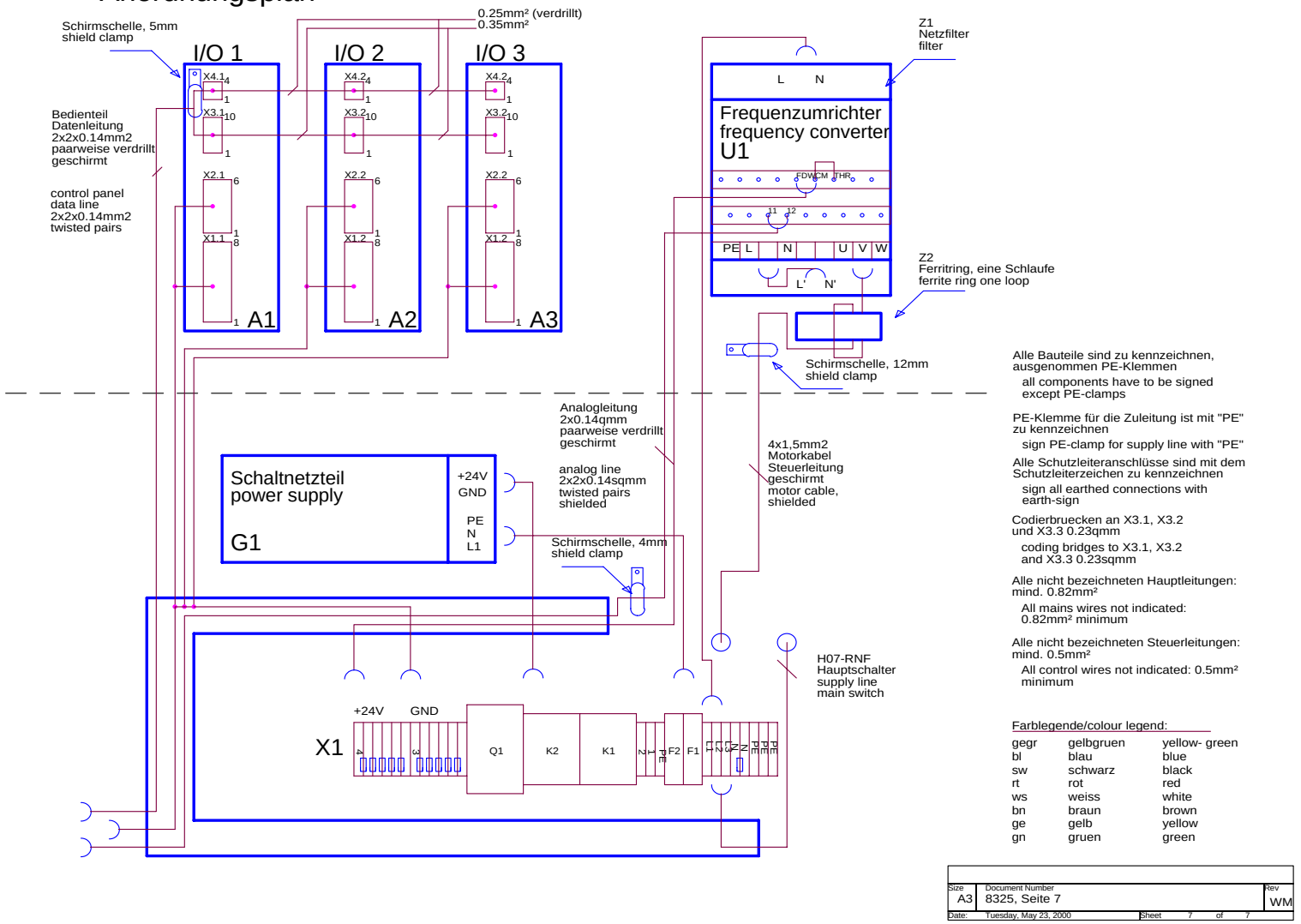
Size	Document Number	Rev
A3	8325, Seite 5	WM
Date: Tuesday, May 23, 2000	Sheet 5 of 7	

Datenbus-Verbindung, Steuerspannung
Data bus connection, control supply

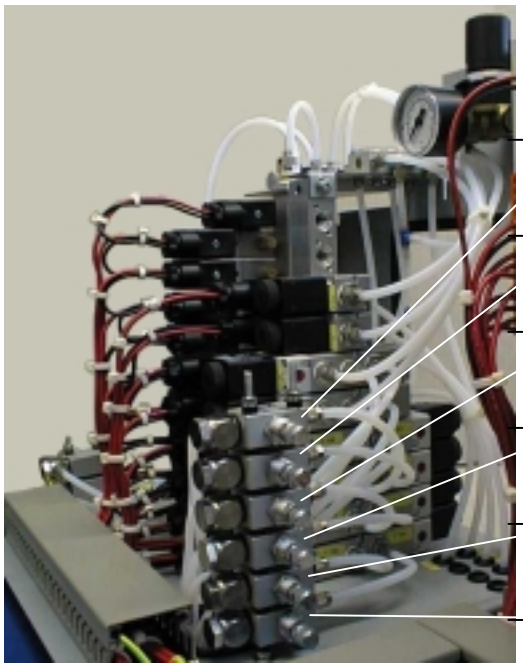


Size	Document Number	Rev
A3	8325, Seite 6	WM
Date: Tuesday, May 23, 2000	Sheet 6 of 7	

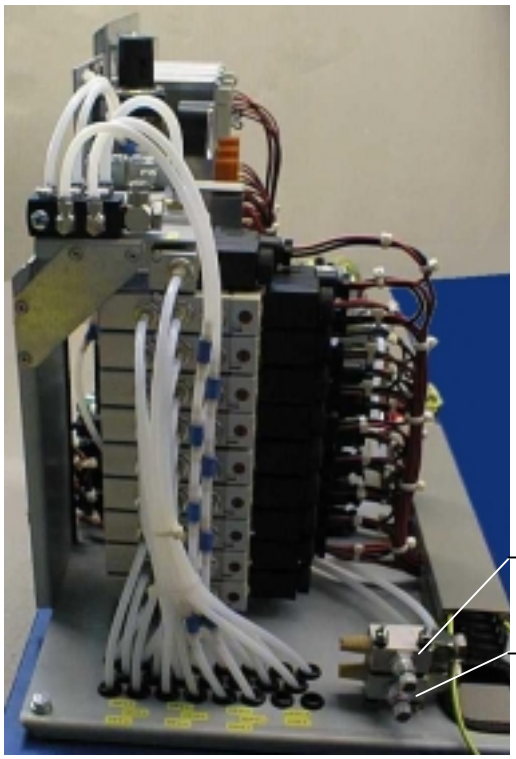
Anordnungsplan



8 Position of Throttles

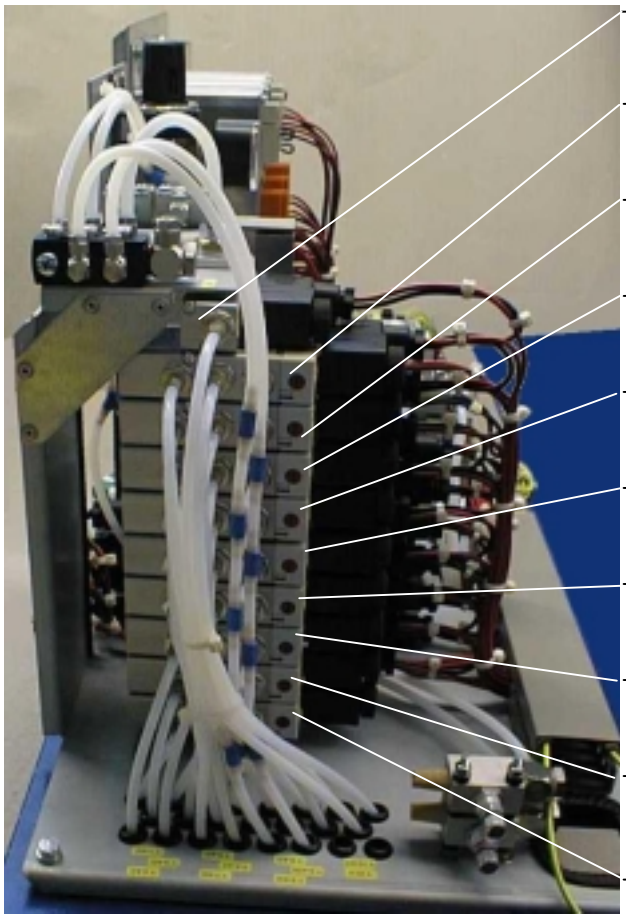


D 1	Moving inwards button clamp
D 2	Moving outwards button clamp
D 3	Moving inwards sleeve tensioner right
D 4	Moving outwards sleeve tensioner right
D 5	Moving inwards sleeve tensioner left
D 6	Moving outwards sleeve tensioner left

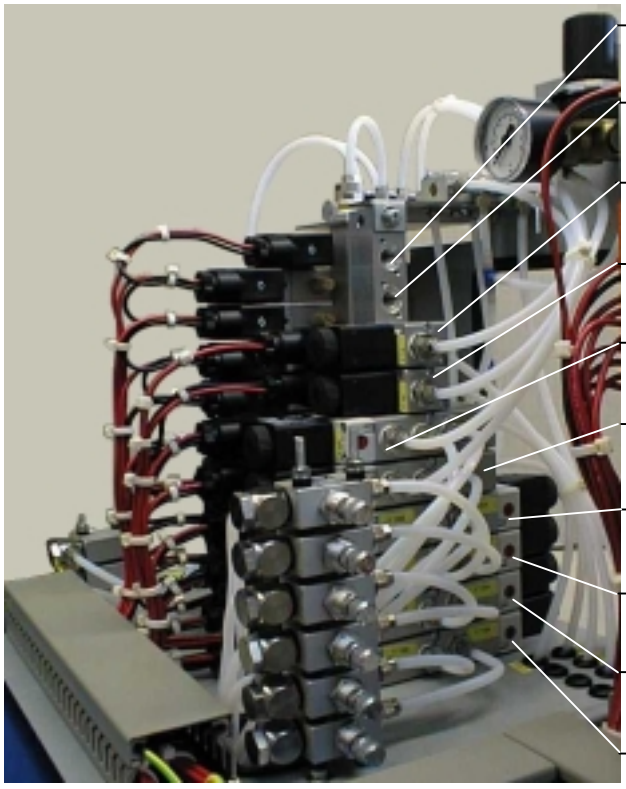


D 7	Suction position air box
D 8	Blowing position air box

9 Types of Valves



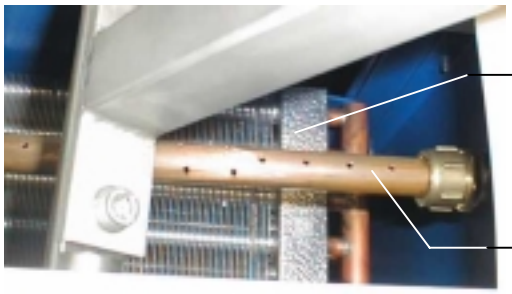
Y20	Steam valve
Y10	Restretching back
Y 9	Restretching side
Y 8	Back clamp
Y 7	Side clamp left
Y 6	Side clamp right
Y 5	Unloader
Y 4	Sleeve clamp right
Y 3	Sleeve clamp left
Y 1	Air box



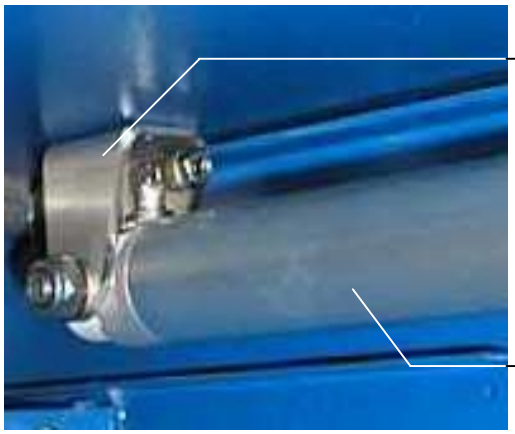
	Option
	Option
Y14	High pressure front clamp
Y15	High pressure Y18/Y19
Y12	Breast pocket
Y 2	Revers
Y16	Side tensioner
Y17	Front clamp
Y18	Sleeve tensioner right
Y19	Sleeve tensioner left

10 Spare Parts

1	585 201 068 0	Sound absorber 1/8“ (2x)
2	929 065 078 0	Quick vent valve (2x)
3	929 065 095 0	Inhibit cylinder AZS5040/100
5	485 105 020 0	End switch AT 11
4	483 153 018 0	Throttle check valve (4x)

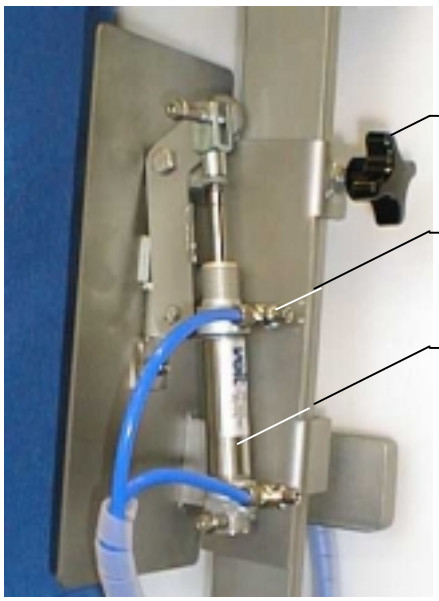


6	483 451 021 0	Heating element 8345
7	483 251 142 0	Spray tube

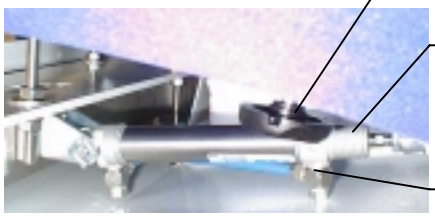


Installation position of the bearing bottom must not be changed!

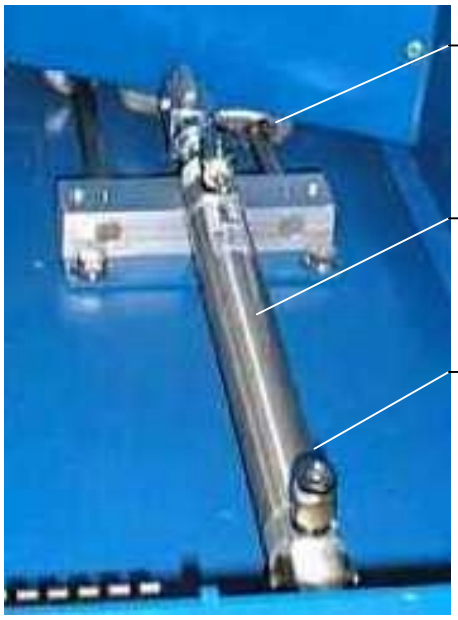
8	483 453 028 0	Compressed air cylinder dia inside 32 - 200



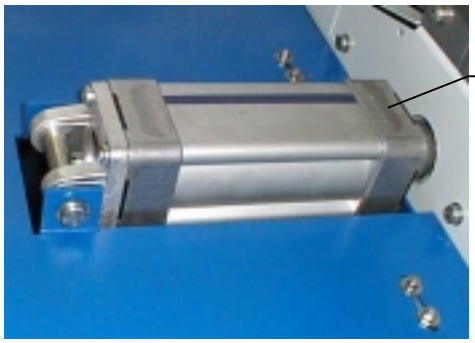
9	923 063 002 0	Star grip screw M 6x20
10	483 303 015 0	Swivel throttle valve 5/3-M5
11	483 803 008 0	Cylinder dia inside 16 - 25



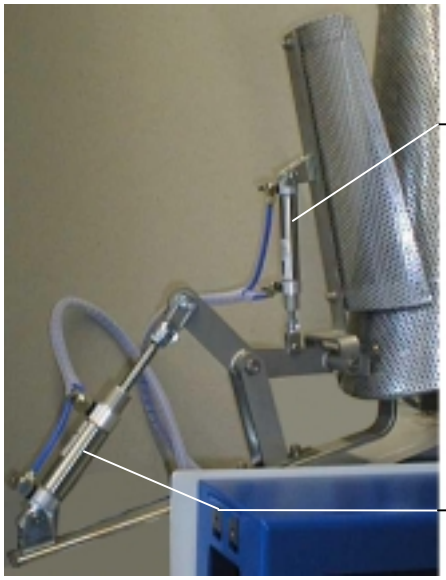
12	421 282 006 0	Thermostat cpl.
13	483 453 032 0	Cylinder dia inside 16 - 50
14	483 303 015 0	Swivel throttle valve 5/3-M5



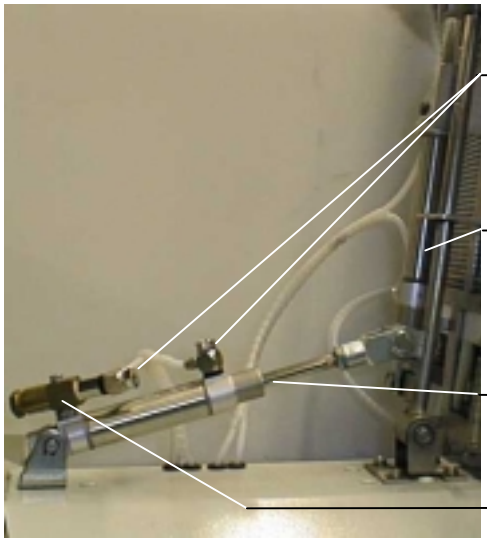
15	929 025 002 0	Ball bushing dia 12 corr.-resist.
16	483 453 010 0	Cylinder dia inside 25-160
17	941 201 086 0	Quick screwing swivelling 5/3-1/8“



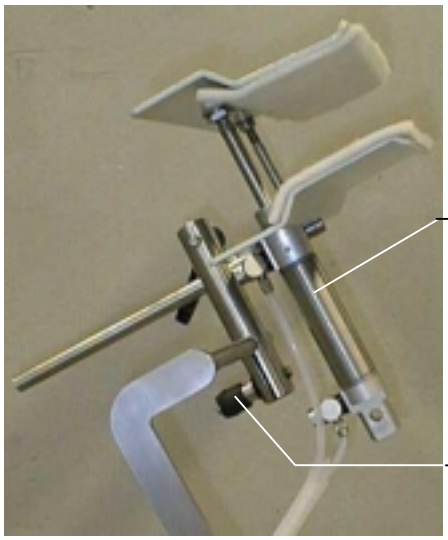
18	929 065 079 0	Compressed air cylinder dia inside 63-80



19	483 303 004 0	Compressed air cylinder dia inside 16 - 50
20	929 065 073 0	Compressed air cylinder dia inside 25 - 40



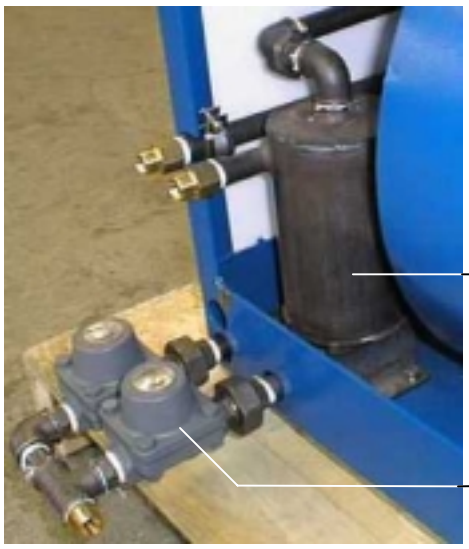
22	929 065 010 0	Throttle check valve 1/8“-5/3
21	483 453 014 0	Compressed air cylinder dia. inside 20 - 80
23	583 801 001 0	Compressed air cylinder dia. inside 25 - 50
24	929 065 089 0	Mini-pressure regulator 115/115/1/8“



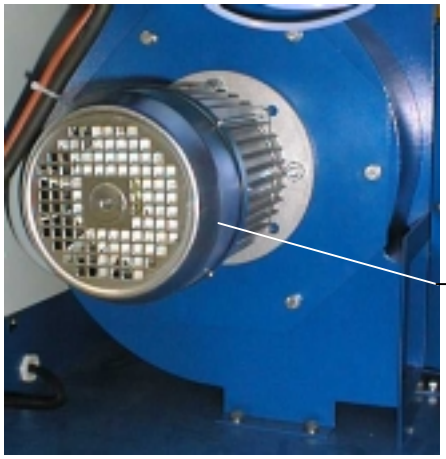
25	929 065 075 0	Compressed air cylinder dia inside 20 - 40
26	923 063 003 0	Clamping lever M 8x25 Nirosta

27	935 081 015 0	Tension spring

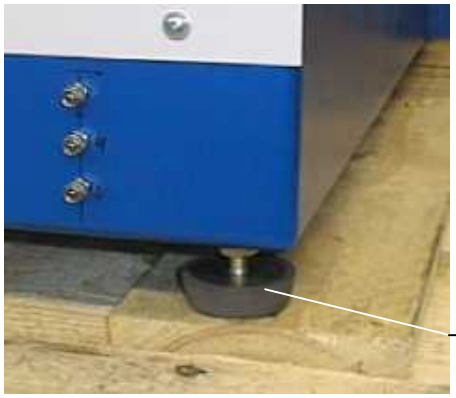
28	929 055 045 0	Electro thermostat 0-150°C
29	483 153 013 0	Manometer 0 – 10 bar 1/8“
30	483 153 012 0	Pressure regulator 1/8“ 7 bar
31	585 201 065 0	Main switch 380/440 V



32	483 452 006 0	Steam drier cpl.
33	483 074 001 0	Capsule steam trap ½“



34	483 505 016 0	Motor 2,2 kW

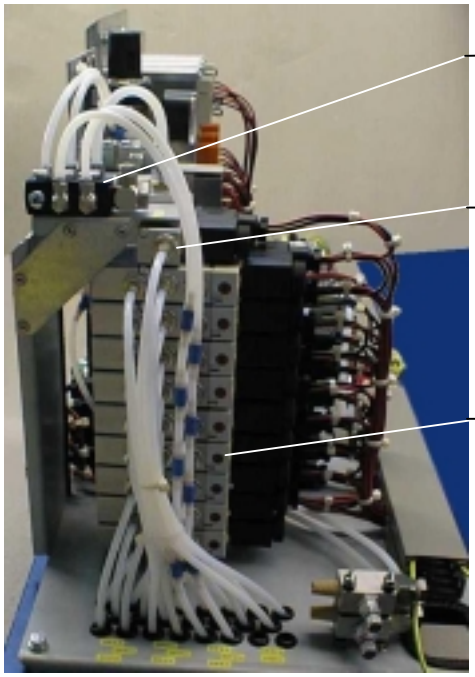


35	926 026 002 0	Rubber foot

36	483 083 000 0	Steam valve

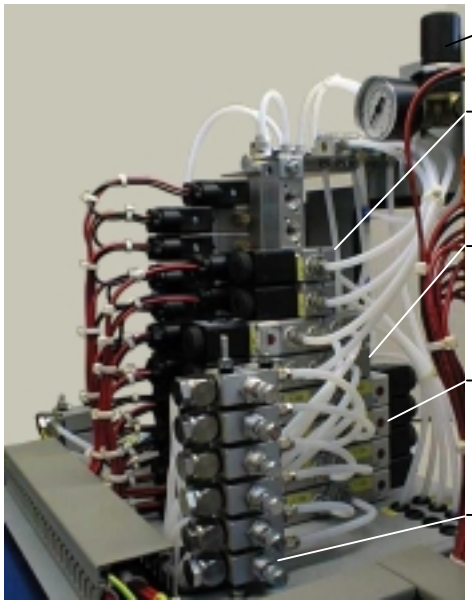
37	483 153 011 0	Filter control
	483 151 162 0	Absorbtion glass for filter control

38	928 015 202 0	Cable box
39	928 015 200 0	Contact inset / pin
40	928 015 203 0	Attached box
41	928 015 201 0	Contact plug / bushing

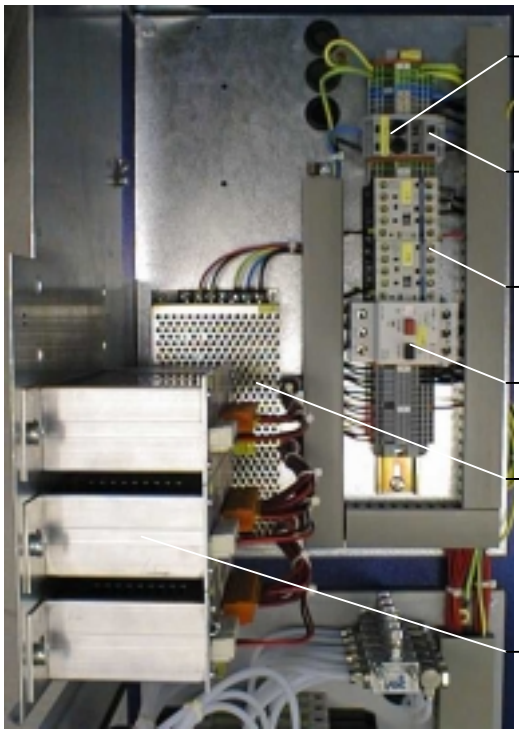


42	483 703 003 0	Distributor block
43	483 603 000 0	Way valve 3/2 – G 1/8“
44	483 603 001 0	Way valve 5/2 – G 1/8“

Pressure regulator for safety-pressure adjustment of 1,8 bar



45	483 603 000 0	Way valve 3/2 – G 1/8“
46	483 603 001 0	Way valve 5/2 – G 1/8“
47	929 065 077 0	Way valve 5/3 – G 1/8“ *Locking middle position evacuated (4x)*
48	483 153 018 0	Throttle check valve 1/8“



49	929 055 006 0	Fuse 6,3 A mtr.
50	923 035 000 0	Fuse clamp f. mounting f.TS35.
51	929 075 063 0	Power contactor 415V 4kW
52	929 075 023 0	Motor power contactor 1-16
53	483 453 018 0	Power supply S-100-24
54	483 453 019 0	I/O- card box cpl.

Article-No.	Description	Piece
383 251 000 0	Cover / chest	1
383 251 001 0	Felt / chest	1
383 251 002 0	Air bag right	1
383 251 003 0	Air bag left	1
383 251 004 0	Foam cutting / button clamp	1
383 251 005 0	Cover / button clamp	1
383 251 006 0	Needle felt / side tensioner clamp	2
383 251 007 0	Needle felt / button tape tensioner	1
383 251 008 0	Felt / back clamp	1
383 251 009 0	Felt / sleeve tensioner	4
483 251 342 0	Heating / breast pocket	1
483 251 343 0	Heating / button tape	1
928 015 303 0	Double foot switch red/black	1
929 055 048 0	Miniclick temperature fuse heating button clamp (S2, S3)	2
929 055 044 0	Temperature sensor PT 100	1
483 252 620 0	Operation panel cpl.	1

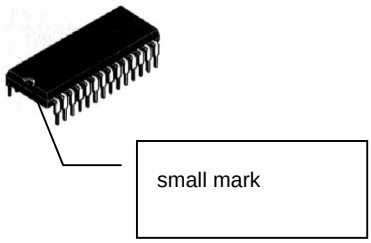
11 Information Leaflet

Replacement of the EPROM

Operation panel

1. Disassemble the operation panel
2. Open the operation panel
3. Remove the assembled EPROM carefully with a special tool or with a screw driver
4. Insert the new EPROM (label „XXXX_XX“) in the base, but please note:
   - the **small mark** at the EPROM must exactly be positioned onto the mark of the base
   - all the PINs must properly be set in the base, they must not be bent or buckled

position of small mark



Parameterizing of the frequency converter

Change the parameterization

1. Actuate the "PRG/Reset"-key (the display shows "F000")
2. Select the parameter to be changed with the arrow-keys ("F???")
3. Activate the corresponding value by the "Func/Data"-key
4. Change the value by the arrow-keys
5. Confirm the input by the "Func/Data"-key (use the "PRG/Reset"-key to leave the parameterizing mode without changing the parameter)

Inquiry of parameterizing

- Do the steps 1-3 and 5

Deactivate/activate the parameter protection

- Set the parameter "F000" to 0 (to deactivate) / 1 (to activate). (Use the "Stop"-key and the arrow-keys to change the parameter)

Parameters of the frequency converter

Para-meter	Adjustment of VEIT	Meaning of the parameters	Remarks
F00	**1**	Blocking of input	Changes only by using the "Stop"- and "arrow"-keys.
F01	**1**	analog nominal value	
F02	**1**	Operating via terminal strip	
F03	**50**	max. frequency	
F04	**50**	corner frequency	
F05	**230**	rated voltage (max. output voltage)	
F06	**0.80**	acceleration time	
F07	**2.00**	deceleration time	
F08	**0**	automatic torque boost	
F09	**85**	FMA voltage adjustment	
F10	**4**	motor poles: 4	
F11	**0.02**	speed display coefficient	
F12	**15**	motor operating sound adjustment (carrier frequency) (kHz)	
F13	**5**	No. of retries	
F14	**2**	active restart after momenttary power failure (operation selection)	
F15	**1**	electronic thermal overload relay 1 (operation selection) active (standard motor)	
F16	**9.20**	electronic thermal overload relay 1 (operating level) (A)	
F17	**1**	active DC brake (operation selection)	
F18	**20**	DC brake (starting frequency)	

F19	**50**	DC brake (braking level)	
F20	**0.50**	DC brake (braking time)	
F21	**0.00**	multistep frequency setting 1 /Hz)	
F22	**0.00**	multistep frequency setting 2 (Hz)	
F23	**0.00**	multistep frequency setting 3 (Hz)	
F24	**0.00**	multistep frequency setting 4 (Hz)	
F25	**0.00**	multistep frequency setting 5 (Hz)	
F26	**0.00**	multistep frequency setting 6 (Hz)	
F27	**0.00**	multistep frequency setting 7 (Hz)	
F28	**0**	inactive (linear acceleration/deceleration) of S-curve acceleration/deceleration (operation selection)	
F29	**-**	protection history (last 4 protection operations are displayed in order)	
F30	**10**	starting frequency (Hz)	
F31	**120**	torque limit active (during acceleration/deceleration)	
F32	**100**	torque limit active (at constant speed)	
F33	**0**	braking torque selection low (no DB option)	
F34	**6**	bias frequency	
F35	**100.0**	gain for frequency setting signal	
F36	**50**	frequency limiter (high)	
F37	**10**	frequency limiter (low)	
F38	**5**	motor characteristics	
F39	**0**	manual setting	
F40	**0**	analog signal output from FMA terminal	
F41	**0**	output frequency	
F42	**24**	FMP terminal (Pulse rate multiplier)	
F43	**0**	X4 terminal function: RT1	
F44	**0.00**	multistep frequency setting 8	
F45	**0.00**	multistep frequency setting 9	
F46	**0.00**	multistep frequency setting 10	
F47	**0.00**	multistep frequency setting 11	
F48	**0.00**	multistep frequency setting 12	
F49	**0.00**	multistep frequency setting 13	
F50	**0.00**	multistep frequency setting 14	
F51	**0.00**	multistep frequency setting 15	
F52	**0.06**	frequency setting signal filter	
F53	**0.00**	timer	
F54	**1**	Y1E terminal (function selection): frequency level detection (FDT)	
F55	**50.00**	frequency level detection (FDT operation level)	
F56	**10**	hysteresis width (FDT or FAR)	
F57	**0**	THR function	
F58	**3**	jump frequency (hysteresis width)	
F59	**0**	jump frequency 1	
F60	**0**	jump frequency 2	
F61	**0**	jump frequency 3	
F62	**50**	base frequency 2	

F63	**10.0**	acceleration time 2	
F64	**10.0**	deceleration time 2	
F65	**13**	torque boost 2	
F66	**1**	electronic thermal overload relay 2 (operation selection) (active Standard motor)	
F67	**10.5**	electronic thermal overload relay 2 (operating level)	
F68	**0.0**	slip compensation inactive	
F69	**0**	torque vector control inactive	
F70	**1**	motor capacity standard	
F71	**9.20**	motor 1/rated current	
F72	**4.85**	motor 1/mo-load current	
F73	**9.20**	motor 2/rated current	
F74	**1**	automatic tuning inactive	
F75	**(18.56)**	motor 1 (%R1 setting)	
F76	**(33.14)**	motor 1(%X setting)	
F77	**390**	torque limiter response (at constant speed)	
F78	**394**	torque limiter response (during acceleration/deceleration)	
F79	**0**	option selection (no options)	

12 EC Declaration of Conformity

EG-Konformitätserklärung/ EC declaration of conformity / Déclaration "CE" de conformité
EF-overensstemmelseserklæring/ EG-verklaring van overeenstemming
Declaración CE de conformidad / Dichiarazione CE di conformità / Declaraçao CE de conformidade

Hemdenfinisher / Shirt Finisher VEIT 8325 Seriennummer: _____

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 correspond aux dispositions pertinentes suivantes

Hermed erklæres, at produkttypen er i overensstemmelse med fÝlgende bestemmelser

Hiermede verklaren wij, dat de in de handel gebrachte machine voldoet ann de eisen van de in het vervolg genoemde bepalingen

Por la presente, declaramos que el modelo suministrado satisface las disposiciones pertinentes siguientes Si dichiara che il modello fornito della è conforme alle seguenti disposizioni pertinenti

Com a presente, declaramos que o modelo fornecido da está em conformidade com as disposiçoes pertinentes, a saber

EG-Richtlinie Maschinen 89/392, Elektromagnetische Verträglichkeit 89/336

Angewandte harmonisierte Normen, insbesondere

Applied harmonized standards, in particular

Normes harmonisées utilisées, notamment:

Harmoniserede standarder, der blev anvend, i særdeleshed

Gebruikte geharmoniseerde normen, in het bijzondere

Normas armonizadas utilizadas, particularmente

Norme armonizzate applicate in particolare

Normas harmonizadas utilizadas, em particular

EN 292-1, EN 292-2, EN 50082-2, EN 55011, EN 50081, EN 60204-1

Landsberg, 20.09.2000

D. Töwe
Geschäftsführer / Vice President & Managing Director

VEIT GmbH & Co.
Justus-von-Liebig-Straße 15
D-86899 Landsberg / Lech

To:
VEIT - Service -
Justus-von-Liebig Str. 15
D- 86899 Landsberg / Lech
Germany
Fax: +49 (8191) 479 - 230

Registration

VEIT always tries to improve its products. To do this, we need to be supported by you. We will register your answers which will enable us to inform you directly about any technical improvements.

1.) How did you become aware of the product?

☐ VEIT employee / dealer ☐ Internet
☐ Exhibition _____ ☐ Other _____
☐ Magazine _____

2.) What is your opinion about the following points:

	good				bad
Support at the sales decision	☐	☐	☐	☐	☐
Installation	☐	☐	☐	☐	☐
Instruction	☐	☐	☐	☐	☐
Manual	☐	☐	☐	☐	☐
Operation of the unit	☐	☐	☐	☐	☐
Result of the operation	☐	☐	☐	☐	☐
Quality of the machine	☐	☐	☐	☐	☐

3.) Suggestions for improvement:

_____

_____

_____

Address:

Name: _____
Street: _____
Place/Country:_____
Phone: _____
Fax: _____

Thank for your help!