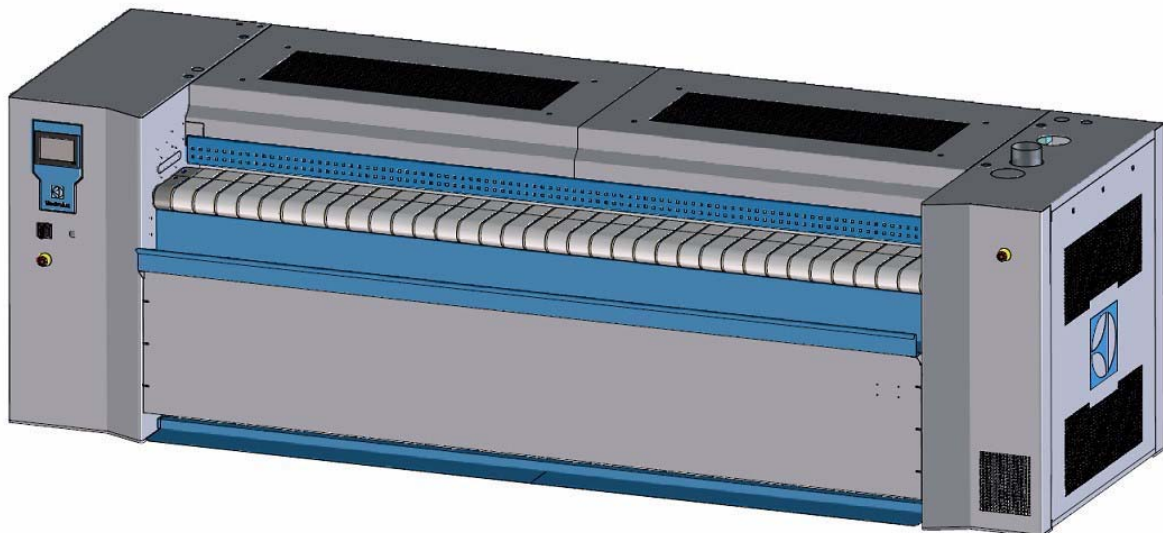


**ART 1:**

**INSTALLATION**

Installation  
manual  
Flatwork  
ironers IB5 700

**With Integrated Thermal Oil Boiler**



**Electrolux**

011040xx/GB  
20.2017



# Electrolux

**CUSTOMER:**

**MACHINE NR.:**

**VOLTAGE: 3 x 380V + N + PE**

**MACHINE TYPE: IB5 733 F - G**

**WIRING DIAGRAM NR.:**

**Electrolux Laundry Systems**

15 Rue Pasteur  
10431 Rosières près Troyes  
France

Tel: +33 3 44 62 23 53

Fax: +33 3 44 62 21 13

## FOREWORD

This manual contains information on installation, operation and maintenance.

The operator should read this manual carefully and become familiar with the machine regulations before the machine is commissioned.

In this document we have attempted to answer any questions you may have.

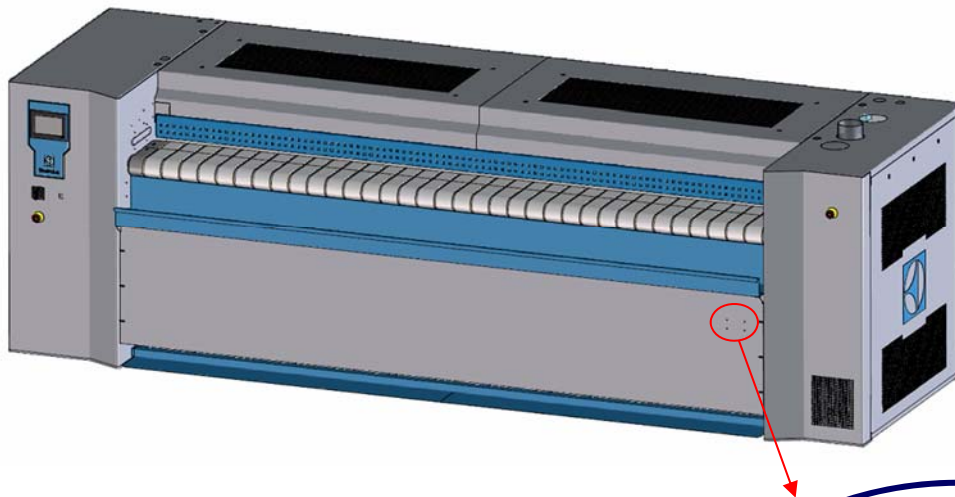
For further information or explanation, please contact our after-sales department.

The illustrations, drawings and text are as accurate as possible. Discrepancies may occur as a result of technical improvements or special options ordered by you. The design explanations in this manual are intended only for the user of the machine and under NO circumstances may they be disclosed to third parties.



This manual will help you get the best out of your machine.

### Location of serial number plate.

Always quote the machine serial number when requesting information or ordering parts.



**Machine serial number plate + CE plate can be found on the front at the bottom right. Here on the right side you see an example from a serial number plate.**

 <b>Electrolux</b> 	
15 Rue Pasteur 10431 Rosières près Troyes France	
CE0085AS0515	
TYPE	IB5 733 F - G
<b>SERIAL NUMBER</b>	<b>16-06-7001</b>
BUILD YEAR	2017
NETWORK TENSION	3 x 380V - 50 Hz
TOTAL INSTALLED POWER	7 kW
ROLL DRIVE MOTOR	2,2 kW
EXTRACTION ROLL	0,75 kW
CIRCULATION PUMP	3 kW
HYDRAULIC PUMP	0,37 kW
MAIN FUSE	16 A
NOMINAL HEAT INPUT	189 kW
APPLIANCES CAT.	II2Er3P
INSTALLATION	B23
NATURE OF GAS	NATURAL GAS
COUNTRY OF DESTINATION	FRANCE

**WE CAN'T GIVE ANY WARRANTY TO THE CONSUMABLE PARTS :**

- The padding
- The feed belts.
- Chains
- Pump seals.
- Oil change.
- Transport damage.
- Components damaged by poor maintenance.
- Spare parts who are placed by a technician who is not trained or schooled by Electrolux.

**PART 1: INSTALLATION.....1**

**1.1 HANDLING OF THE MACHINE. .... 6**

**1.2 LAYOUT AND CONNECTIONS ..... 9**

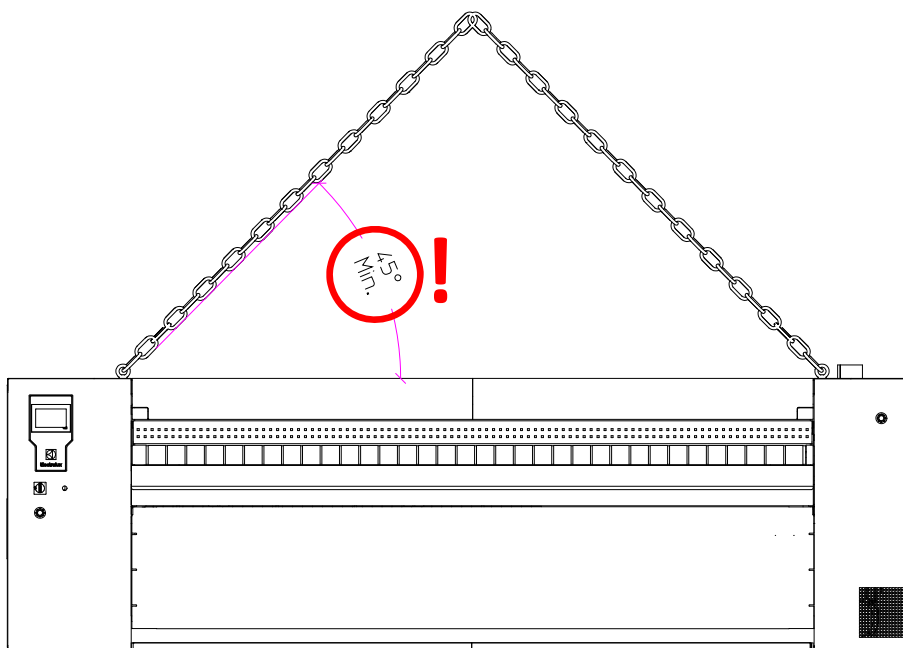
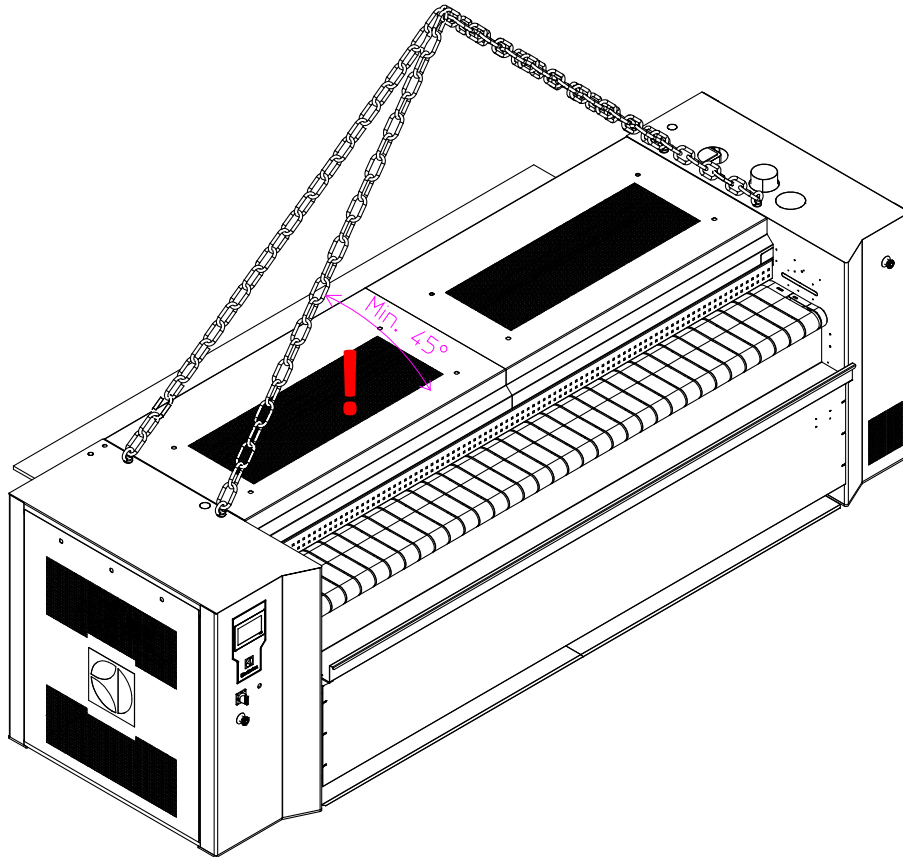
**1.3 TECHNICAL DATA AND DIMENSIONS. .... 13**

**1.4. INSTALLATION..... 17**

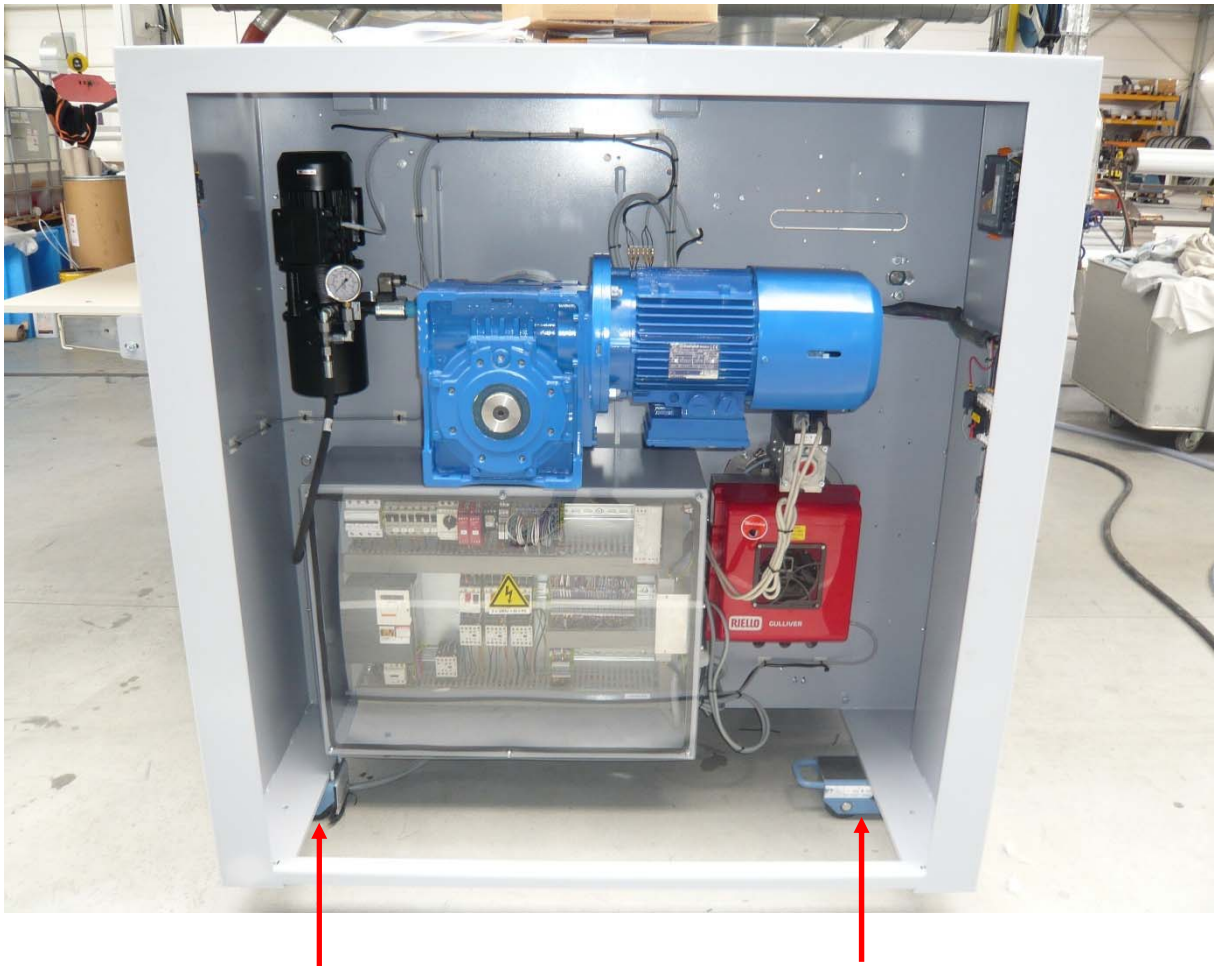
**1.5 GENERAL. .... 33**

## 1.1 Handling of the machine.

- Remove any obstacles under machine placement area.
- Fasten the lifting cables to the supplied lifting eye bolts on the top.



- Lift the machine.
- Make sure the cables are positioned correctly so that machine hangs horizontally.
- Make sure nobody walks under the load.
- Lift and relocate machine carefully, without sudden shocks or movements.
- Place the machine on the ground, as close to the permanent location as possible.
- If the machine needs further moving, use rollers.  
**Important:** To use rollers, place rollers in four corners, distributing the weight evenly.



To place the rollers under the machine, the machine can be lifted with a hydraulic jack on these 4 supports.





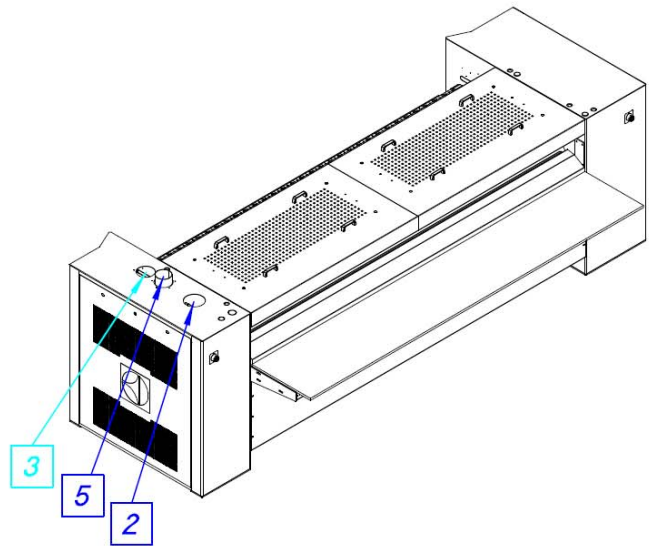
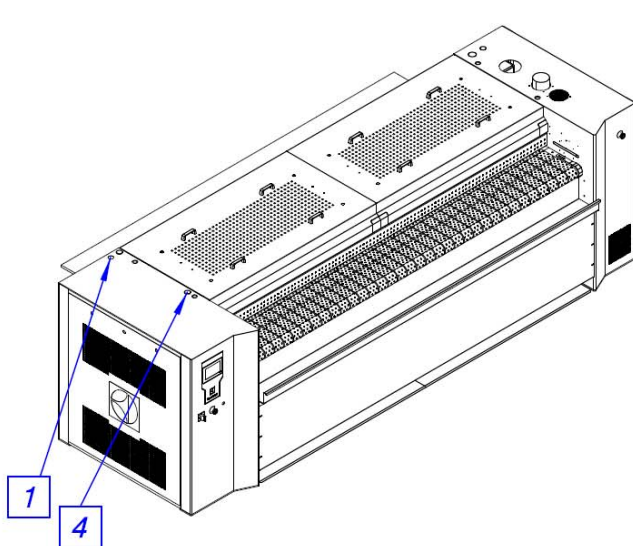
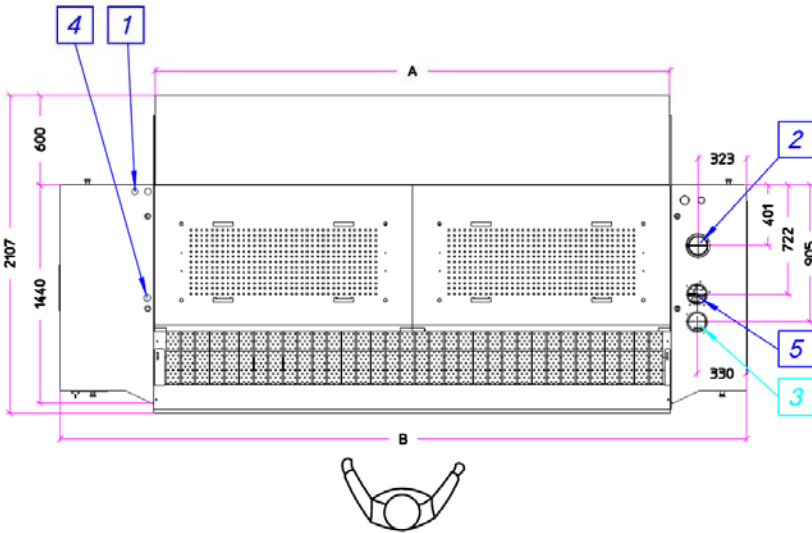
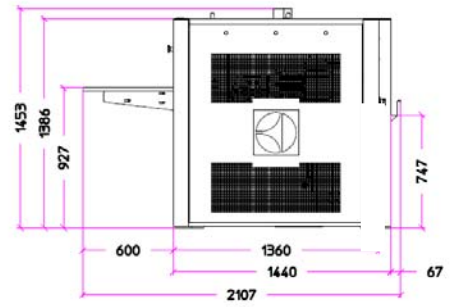
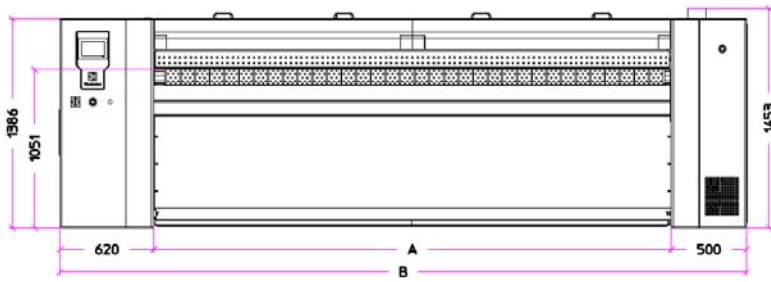
- Once machine is in final position, remove the wooden bars. They are screwed underneath the ironer foot plates.
- Remove all packing materials.
- Level machine.
- If there is also a length folder supplied, then place the length folder behind the ironer as described in the manual from the length folder.





## 1.2 Layout and connections

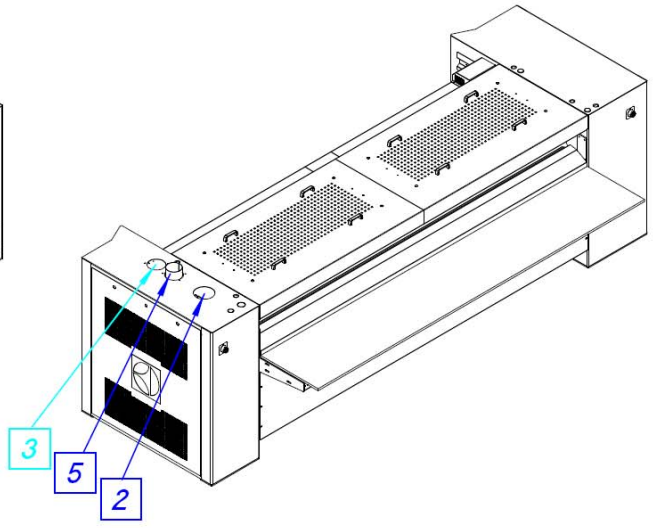
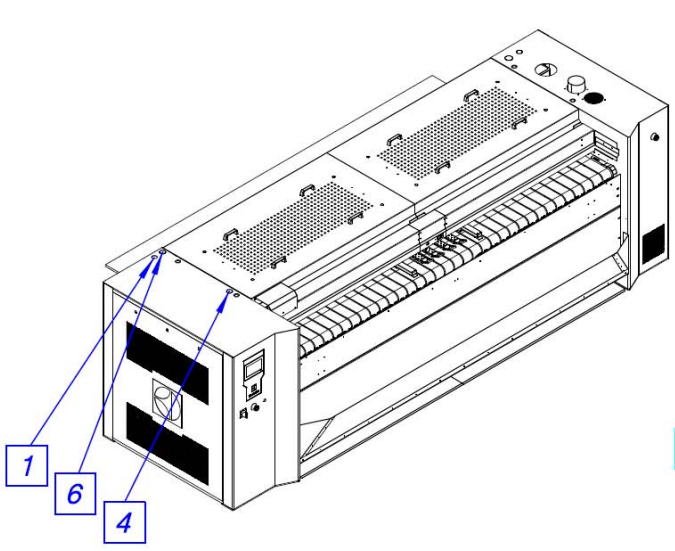
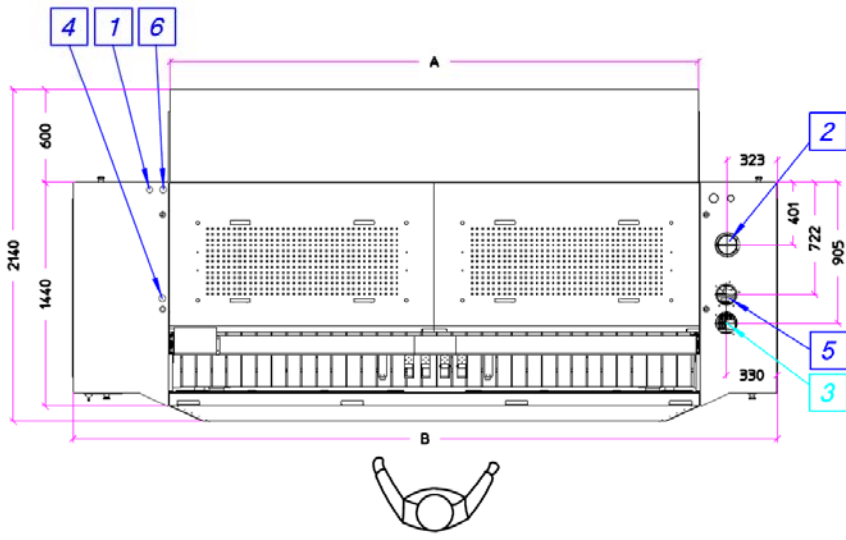
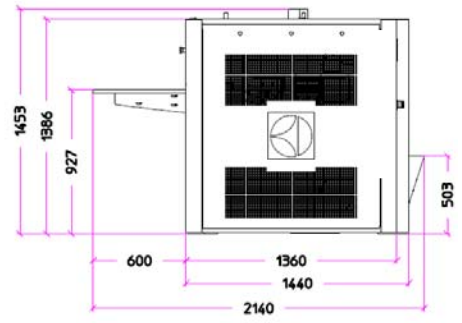
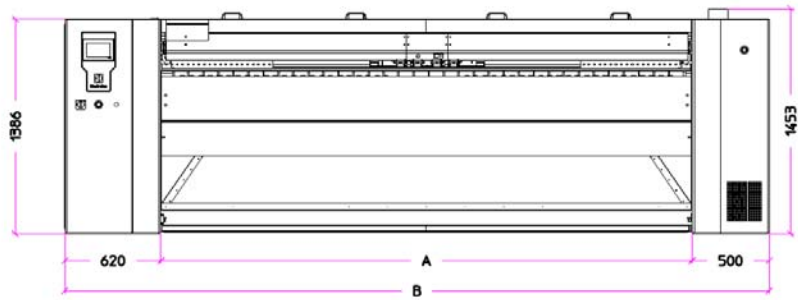
	052.750.0002B	IB5 700 G	IB5 700 E
Rolsnelheid – Vitesse repassage Ironing speed – Mangelgeschwindigkeit		3 – 12 m/min. *4 – 16 m/min.	3 – 12 m/min. *4 – 16 m/min.
Rol aandrijfmotor – Moteur entrainement Roll drive motor – Walzenantriebmotor		2.2 kW – 1500 rpm *4 kW – 1500 rpm	2.2 kW – 1500 rpm *4 kW – 1500 rpm
Rol afzuigmotor – Moteur aspiration Exhaust motor – Absaugmotor		1.1 kW – 3000 rpm	1.1 kW – 3000 rpm
* Option Afzuiging door invoerbanden Aspiration par bandes d'engagement* Suction by feedbands Absaugung durch Eingabebanden		0.75 kW – 3000 rpm	0.75 kW – 3000 rpm
Motor hydr. pomp – Moteur pompe hydr. Motor hydr. pump – Motor hydr. Pumpe		0.37 kW – 1500 rpm	0.37 kW – 1500 rpm
Circulatiepomp – Pompe de circulation Circulation pump – Umwalzpumpe		3 kW – 3000 rpm	3 kW – 3000 rpm
Verwarming – Chauffage Heating – Heizung		IB5 725 G 116 kW IB5 730 G 140 kW IB5 733 G 140 kW	IB5 725 E 75 kW IB5 730 E 90 kW IB5 733 E 90 kW
1 Elektrische aansluiting Connection électrique Strom Anschluss Electrical connection		230V : 3 x 6mm <sup>2</sup> + PE (25A)  400V : 3 x 4mm <sup>2</sup> + N + PE (16A)	IB5 725 E 400V : 3 x 32mm <sup>2</sup> + N + PE (125A)
			IB5 730 E / IB5 733 E 400V : 3 x 50mm <sup>2</sup> + N + PE (160A)
2 Afzuiging dampen – Sortie buées Vapour outlet – Wrasenausgang		Ø125	Ø125
3 * Option Afzuiging door invoerbanden Aspiration par bandes d'engagement* Suction by feedbands Absaugung durch Eingabebanden		Ø125	Ø125
4 Gasinlaat – Entrée gaz Gasanschluss – Gas inlet		5/4" Min. 20mBar – Max. 36mBar	/
5 Gasuitlaat – Sortie gaz Gasausgang – Gas outlet		Ø125	/

Model	werkbreedte largeur de travail working width Arbeitsbreite	A	B	Weight 	Packed dimensions (L x D x H)	Packed weight 
IB5 725 G IB5 725 E	2500	2630	3750	.... kg	3.8m x 1.9m x 1.8m	.... kg
IB5 730 G IB5 730 E	3000	3130	4250	.... kg	4.3m x 1.9m x 1.8m	.... kg
IB5 733 G IB5 733 E	3300	3430	4550	.... kg	4.6m x 1.9m x 1.8m	.... kg



	052.750.0001B	IB5 700 F – G	IB5 700 F – E
Rolsnelheid – Vitesse repassage Ironing speed – Mangelgeschwindigkeit		3 – 12 m/min. *4 – 16 m/min.	3 – 12 m/min. *4 – 16 m/min.
Rol aandrijfmotor – Moteur entrainement Roll drive motor – Walzenantriebmotor		2.2 kW – 1500 rpm *4 kW – 1500 rpm	2.2 kW – 1500 rpm *4 kW – 1500 rpm
Rol afzuigmotor – Moteur aspiration Exhaust motor – Absaugmotor		1.1 kW – 3000 rpm	1.1 kW – 3000 rpm
* Option Afzuiging door invoerbanden Aspiration par bandes d'engagement* Suction by feedbands Absaugung durch Eingabebanden		0.75 kW – 3000 rpm	0.75 kW – 3000 rpm
Motor hydr. pomp – Moteur pompe hydr. Motor hydr. pump – Motor hydr. Pumpe		0.37 kW – 1500 rpm	0.37 kW – 1500 rpm
Circulatiepomp – Pompe de circulation Circulation pump – Umwalzpumpe		3 kW – 3000 rpm	3 kW – 3000 rpm
Verwarming – Chauffage Heating – Heizung		IB5 725 F – G 116 kW IB5 730 F – G 140 kW IB5 733 F – G 140 kW	IB5 725 F – E 75 kW IB5 730 F – E 90 kW IB5 733 F – E 90 kW
<b>1</b> Elektrische aansluiting Connection électrique Strom Anschluss Electrical connection		230V : 3 x 6mm <sup>2</sup> + PE (25A)  400V : 3 x 4mm <sup>2</sup> + N + PE (16A)	IB5 725 F – E 400V : 3 x 32mm <sup>2</sup> + N + PE (125A)  IB5 730 F – E / IB5 733 F – E 400V : 3 x 50mm <sup>2</sup> + N + PE (160A)
<b>2</b> Afzuiging dampen – Sortie buëes Vapour outlet – Wrasenausgang		Ø125	Ø125
<b>3</b> * Option Afzuiging door invoerbanden Aspiration par bandes d'engagement* Suction by feedbands Absaugung durch Eingabebanden		Ø125	Ø125
<b>4</b> Gasinlaat – Entrëe gaz Gasanschluss – Gas inlet		5/4" Min. 20mBar – Max. 36mBar	/
<b>5</b> Gasuittlaat – Sortie gaz Gasausgang – Gas outlet		Ø125	/
<b>6</b> Luchtinlaat – Entrëe d'air Lufteinlass – Air intake		15l/min. – 6 Bar – Ø10mm	15l/min. – 6 Bar – Ø10mm

Model	werkbreedte largeur de travail working width Arbeitsbreite		A	B	Weight 	Packed dimensions (L x D x H)	Packed weight 
IB5 725 F – G IB5 725 F – E	2500		2630	3750	.... kg	3.8m x 1.9m x 1.8m	.... kg
IB5 730 F – G IB5 730 F – E	3000		3130	4250	.... kg	4.3m x 1.9m x 1.8m	.... kg
IB5 733 F – G IB5 733 F – E	3300		3430	4550	.... kg	4.6m x 1.9m x 1.8m	.... kg



### 1.3 Technical data and dimensions.

		IB5 725 G	IB5 730 G	IB5 733 G
Roll	Diameter	700 mm	700 mm	700 mm
	Length	2500 mm	3000 mm	3300 mm
Dimensions	Length	3750 mm	4250 mm	4550 mm
	Depth	2036mm	2036mm	2036mm
	Height	1453mm	1453mm	1453mm
Speed	Minimum – Maximum (*option)	3 – 12m/min. *4 – 16 m/min	3 – 12m/min. *4 – 16 m/min	3 – 12m/min. *4 – 16 m/min
Temperature	Minimum – Maximum (*option)	150°C - 175°C 190°C*	150°C - 175°C 190°C*	150°C - 175°C 190°C*
Motors	Roll (*option)	2.2 / *4 kW	2.2 / *4 kW	2.2 / *4 kW
	Fan	1.1 kW	1.1 kW	1.1 kW
	Hydr. pump	0.37 kW	0.37 kW	0.37 kW
	Circulation pump	3 kW	3 kW	3 kW
Electr. Connection (D curve)	3 x 230 V 50 Hz	25 A	25 A	25 A
	3 x 400 V 50 Hz	16 A	16 A	16 A
Cable section	3 x 230 V	3 x 6 mm <sup>2</sup> + PE	3 x 6 mm <sup>2</sup> + PE	3 x 6 mm <sup>2</sup> + PE
	3 x 400 V	3 x 4 mm <sup>2</sup> + PE + N	3 x 4 mm <sup>2</sup> + PE + N	3 x 4 mm <sup>2</sup> + PE + N
Weight	kg	kg	2260 kg	kg
Packaging	L x D x H	3.8m x 1.9m x 1.8 m	4.3m x 1.9m x 1.8 m	4.6m x 1.9m x 1.8 m
Noise	Decibels	71 dB	71 dB	71 dB
Capacity burner	kW	189	189	189
Gas inlet	Pressure	Min. 20 mBar Max. 36 mBar	Min. 20 mBar Max. 36 mBar	Min. 20 mBar Max. 36 mBar
	Diameter	5/4"	5/4"	5/4"
Gas outlet	m <sup>3</sup> /h	280	280	280
	°C	260	260	260
	Throughput Diameter	Ø125 mm	Ø125 mm	Ø125 mm
Gas consumption	m <sup>3</sup> /h	4,44 – 18,03	4,44 – 18,03	4,44 – 18,03
Gas setting	kcal/h	41300 - 167700	41300 - 167700	41300 - 167700
Roll suction outlet	m <sup>3</sup> /h	1400	1400	1400
	°C (ironing temp. 180°C)	100°C	100°C	100°C
	Diameter (Heat resistance pipe)	Ø125 mm	Ø125 mm	Ø125 mm
	Fan max. flow rate with no pressure in m <sup>3</sup> /h	1800	1800	1800
	Fan total pressure with no flow	105 mm H <sub>2</sub> O	105 mm H <sub>2</sub> O	105 mm H <sub>2</sub> O
Fresh air supply in the working room.	m <sup>3</sup> /h	4500	4500	4500
Ironing capacity	Residual moisture 50% (ironing temp. 180°C)	200 kg/h	230 kg/h	250 kg/h

\* All gas calculations are with a gas type with a calorific value of 9300 kcal/h.

Example: gas consumption = 41300 / 9300  
= 4,44m<sup>3</sup>/h

\*Max. temperature for polyester is 175°C  
Max. temperature for nomex is 190°C

When there is a **modulating burner (BS3/M)** installed, the **lowest possible power output must be regulated below 60kW !!!**  
This to ensure that the CO value will not be too high. (for safety reasons).

		<b>IB5 725 E</b>	<b>IB5 730 E</b>	<b>IB5 733 E</b>
Roll	Diameter	700 mm	700 mm	700 mm
	Length	2500 mm	3000 mm	3300 mm
Dimensions	Length	3750 mm	4250 mm	4550 mm
	Depth	2036mm	2036mm	2036mm
	Height	1453mm	1453mm	1453mm
Speed	Minimum – Maximum (*option)	3 – 12m/min. *4 – 16 m/min	3 – 12m/min. *4 – 16 m/min	3 – 12m/min. *4 – 16 m/min
Temperature	Minimum – Maximum (*option)	150°C - 175°C 190°C*	150°C - 175°C 190°C*	150°C - 175°C 190°C*
Motors	Roll (*option)	2.2 / *4 kW	2.2 / *4 kW	2.2 / *4 kW
	Fan	1.1 kW	1.1 kW	1.1 kW
	Hydr. pump	0.37 kW	0.37 kW	0.37 kW
	Circulation pump	3 kW	3 kW	3 kW
Electr. Connection (D curve)	3 x 230 V 50 Hz	50 A	25 A	25 A
	3 x 400 V 50 Hz	125 A	160 A	160 A
Cable section	3 x 230 V	3 x 6 mm <sup>2</sup> + PE	3 x 6 mm <sup>2</sup> + PE	3 x 6 mm <sup>2</sup> + PE
	3 x 400 V	3 x 32 mm <sup>2</sup> + PE + N	3 x 50 mm <sup>2</sup> + PE + N	3 x 50 mm <sup>2</sup> + PE + N
Weight	kg	kg	kg	kg
Packaging	L x D x H	3.8m x 1.9m x 1.8 m	4.3m x 1.9m x 1.8 m	4.6m x 1.9m x 1.8 m
Noise	Decibels	71 dB	71 dB	71 dB
Capacity heating elements	kW	75	90	90
Vapour outlet	m <sup>3</sup> /h	1400	1400	1400
	°C (ironing temp. 180°C)	100°C	100°C	100°C
	Diameter (Heat resistance pipe)	Ø125 mm	Ø125 mm	Ø125 mm
Fresh air supply in the working room.	m <sup>3</sup> /h	4500	4500	4500
Ironing capacity	Residual moisture	200 kg/h	230 kg/h	250 kg/h
	50% (ironing temp. 180°C)			

\* speed option: 4 kw motor

\* temperature option: nomex padding

\*roll option: 4 kw motor

\*suction feeding belts: 0.75 kw motor

		<b>IB5 725 F - G</b>	<b>IB5 730 F - G</b>	<b>IB5 733 F - G</b>
Roll	Diameter	700 mm	700 mm	700 mm
	Length	2500 mm	3000 mm	3300 mm
Dimensions	Length	3750 mm	4250 mm	4550 mm
	Depth	2140mm	2140mm	2140mm
	Height	1453mm	1453mm	1453mm
Speed	Minimum – Maximum (*option)	3 – 12m/min. *4 – 16 m/min	3 – 12m/min. *4 – 16 m/min	3 – 12m/min. *4 – 16 m/min
Temperature	Minimum – Maximum (*option)	150°C - 175°C 190°C*	150°C - 175°C 190°C*	150°C - 175°C 190°C*
Motors	Roll (*option)	2.2 / *4 kW	2.2 / *4 kW	2.2 / *4 kW
	Fan	0.75 kW	0.75 kW	0.75 kW
	Hydr. pump	0.37 kW	0.37 kW	0.37 kW
	Circulation pump	3 kW	3 kW	3 kW
	Suction feeding belts (*option)	0.75 kW	0.75 kW	0.75 kW
Electr. Connection (D curve)	3 x 230 V 50 Hz	25 A	25 A	25 A
	3 x 400 V 50 Hz	16 A	16 A	16 A
Cable section	3 x 230 V	3 x 6 mm <sup>2</sup> + PE	3 x 6 mm <sup>2</sup> + PE	3 x 6 mm <sup>2</sup> + PE
	3 x 400 V	3 x 4 mm <sup>2</sup> + PE + N	3 x 4 mm <sup>2</sup> + PE + N	3 x 4 mm <sup>2</sup> + PE + N
Weight	kg	kg	kg	2384 kg
Packaging	L x D x H	3.8m x 1.9m x 1.8 m	4.3m x 1.9m x 1.8 m	4.6m x 1.9m x 1.8 m
Noise	Decibels	71 dB	71 dB	71 dB
Capacity burner	kW	189	189	189
Gas inlet	Pressure	Min. 20 mBar Max. 36 mBar	Min. 20 mBar Max. 36 mBar	Min. 20 mBar Max. 36 mBar
	Diameter	5/4"	5/4"	5/4"
Gas outlet	m <sup>3</sup> /h	280	280	280
	°C	260	260	260
	Throughput Diameter	Ø125 mm	Ø125 mm	Ø125 mm
Gas consumption	m <sup>3</sup> /h	4,44 – 18,03	4,44 – 18,03	4,44 – 18,03
Gas setting	kcal/h	41300 - 167700	41300 - 167700	41300 - 167700
Roll suction outlet	m <sup>3</sup> /h	1400	1400	1400
	°C (ironing temp. 180°C)	100°C	100°C	100°C
	Diameter (Heat resistance pipe)	Ø125 mm	Ø125 mm	Ø125 mm
	Fan max. flow rate with no pressure in m <sup>3</sup> /h	1800	1800	1800
	Fan total pressure with no flow	105 mm H <sub>2</sub> O	105 mm H <sub>2</sub> O	105 mm H <sub>2</sub> O
Air intake (100% dry air! )	l/min.	450	450	450
	Pressure	Min. 6 Bar	Min. 6 Bar	Min. 6 Bar
	Diameter	½"	½"	½"
Fresh air supply in the working room.	m <sup>3</sup> /h	4500	4500	4500
Ironing capacity	Residual moisture	200 kg/h	230 kg/h	250 kg/h
	50% (ironing temp. 180°C)			

\* All gas calculations are with a gas type with a calorific value of 9300 kcal/h.

$$\begin{aligned} \text{Example: gas consumption} &= 41300 / 9300 \\ &= 4,44\text{m}^3/\text{h} \end{aligned}$$

\*Max. temperature for polyester is 175°C  
Max. temperature for nomex is 190°C

When there is a **modulating burner (BS3/M)** installed, the **lowest possible power output must be regulated below 60kW !!!**

This to ensure that the CO value will not be too high. (for safety reasons).

		<b>IB5 725 F - E</b>	<b>IB5 730 F - E</b>	<b>IB5 733 F - E</b>
Roll	Diameter	700 mm	700 mm	700 mm
	Length	2500 mm	3000 mm	3300 mm
Dimensions	Length	3750 mm	4250 mm	4550 mm
	Depth	2140mm	2140mm	2140mm
	Height	1453mm	1453mm	1453mm
Speed	Minimum – Maximum (*option)	3 – 12m/min. *4 – 16 m/min	3 – 12m/min. *4 – 16 m/min	3 – 12m/min. *4 – 16 m/min
Temperature	Minimum – Maximum (*option)	150°C - 175°C 190°C*	150°C - 175°C 190°C*	150°C - 175°C 190°C*
Motors	Roll (*option)	2.2 / *4 kW	2.2 / *4 kW	2.2 / *4 kW
	Fan	0.75 kW	0.75 kW	0.75 kW
	Hydr. pump	0.37 kW	0.37 kW	0.37 kW
	Circulation pump	3 kW	3 kW	3 kW
	Suction feeding belts (*option)	0.75 kW	0.75 kW	0.75 kW
Electr. Connection (D curve)	3 x 230 V 50 Hz	50 A	25 A	25 A
	3 x 400 V 50 Hz	125 A	160 A	160 A
Cable section	3 x 230 V	3 x 6 mm <sup>2</sup> + PE	3 x 6 mm <sup>2</sup> + PE	3 x 6 mm <sup>2</sup> + PE
	3 x 400 V	3 x 32 mm <sup>2</sup> + PE + N	3 x 50 mm <sup>2</sup> + PE + N	3 x 50 mm <sup>2</sup> + PE + N
Weight	kg	kg	kg	kg
Packaging	L x D x H	3.8m x 1.9m x 1.8 m	4.3m x 1.9m x 1.8 m	4.6m x 1.9m x 1.8 m
Noise	Decibels	71 dB	71 dB	71 dB
Capacity heating elements	kW	75	90	90
Vapour outlet	m <sup>3</sup> /h	1400	1400	1400
	°C (ironing temp. 180°C)	100°C	100°C	100°C
	Diameter (Heat resistance pipe)	Ø125 mm	Ø125 mm	Ø125 mm
Air intake (100% dry air! )	l/min.	450	450	450
	Pressure	Min. 6 Bar	Min. 6 Bar	Min. 6 Bar
	Diameter	½"	½"	½"
Fresh air supply in the working room.	m <sup>3</sup> /h	4500	4500	4500
Ironing capacity	Residual moisture 50% (ironing temp. 180°C)	200 kg/h	230 kg/h	250 kg/h

\* speed option: 4 kw motor

\* temperature option: nomex padding

\*roll option: 4 kw motor

\*suction feeding belts: 0.75 kw motor



## **1.4. Installation.**

### **1. Unload the machine as described. ( See: 1. Handling of the machine )**

The ironing machine is best moved with rollers.

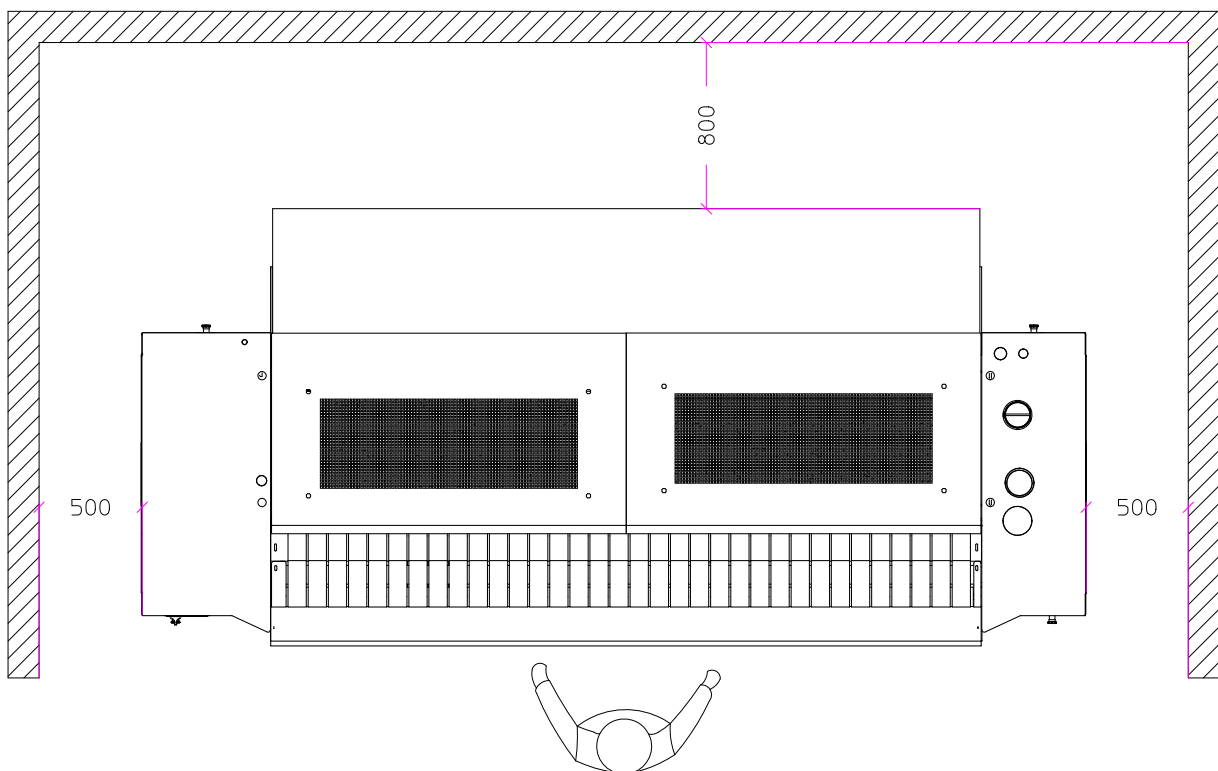
The ironing machine must be positioned perfectly level.

For the purposes of service and maintenance work, a space of at least 50 cm must be left to the right side and left side and 80 cm behind the machine.

The walls through which the air exhaust pipe runs to the outside must be made of a non-flammable material.

The ironing machine must have sufficient air supply (approx. 4500 m<sup>3</sup>/h).

**(Insufficient supply of fresh air can lead to overheating)**



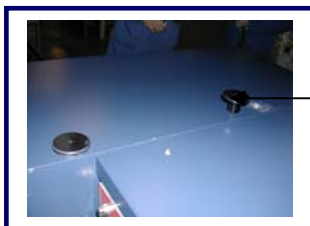
2. Remove all packaging materials such as plastic and cardboard from the machine and clean the ironing roll with a vacuum cleaner before allowing the machine to warm up. Remove all dust from the ironer. Do not use any explosive products.



3. Position the machine so it is level. When the floor isn't flat, place metal plates under the foot plates from the ironer to level the ironer.
4. Remove the lifting eye bolts.



Lifting eye bolts



Screw the supplied plugs into the lifting holes.

## 5. Electrical connection.

Compare the type of main voltage with the data on the machine plate and bear the guidelines in mind.

It is important for the electrical connection to be set up by an qualified or certified technician to ensure that the installation complies with the standards and guidelines that apply where the machine is installed.

The selected main connection must have a nominal cross-section that matches the nominal electrical load specified on the ironing machine.

The ironing machine must be **earthed** to ensure proper operation and safety.

A differential switch must be installed

The connection cable must be fed in via the connector in the frame containing the electrical connection box.

The connection cable can be connected to the main switch (L1-L2-L3-Earth-Neutral) in the left-hand from containing the electrical connection box.



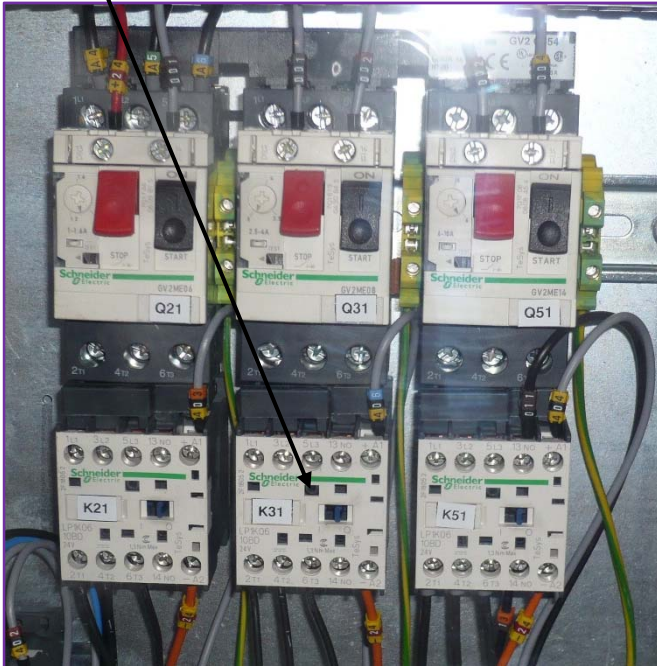
Connection for electrical cable:



When the connection cable is connected, the main switch can be moved to position "1" and the direction of movement of the motors must be checked (to prevent damage).

How to check the rotation :

Open the electrical cabinet and push on contactor K31 (suction roll )



Check the rotation from the motor

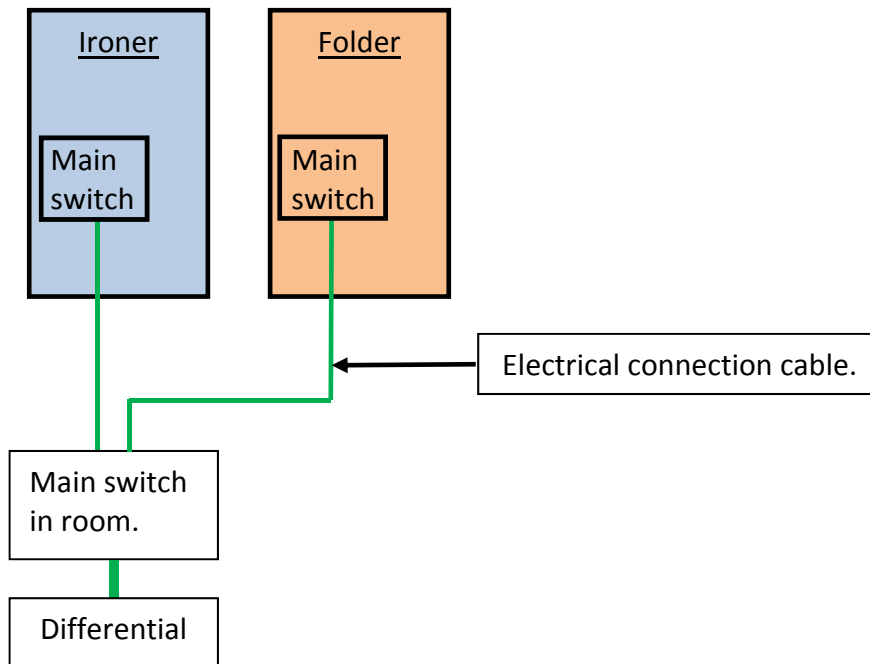


# **ATTENTION !!!**

**Before starting up the machine, check the direction of rotation of:**

- the fan motor***
- the hydraulic pump motor***
- the circulation pump motor***

When the Ironer is installed together with a folder, then both machines must be able to be switched off by 1 main switch.



## 6. Gas connection

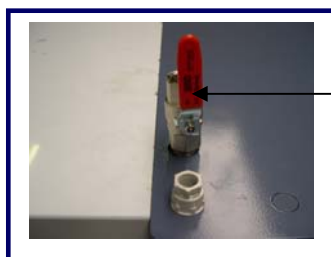
Compare the type of gas (natural gas, propane) with the data on the machine and bear the guidelines in mind.

It is important for the gas connections to be set up by an a qualified or certified technician to ensure that the installation complies with the standards and guidelines that apply where the machine is installed.

The gas connected must correspond to the type of gas specified on the machine plate. The gas pressure for natural gas and propane must be between 20 mbar and 36 mBar. If the pressure exceeds 36 mBar, a gas pressure regulator must be installed upstream of the connection tap. Also consider the diameter of the gas pipe.

The machine connection is 1"1/4.

If the distance between the gas meter and the machine is over 10 meters, the use of a gas pipe with a larger diameter is recommended (example 1"1/2 instead of 1"1/4)



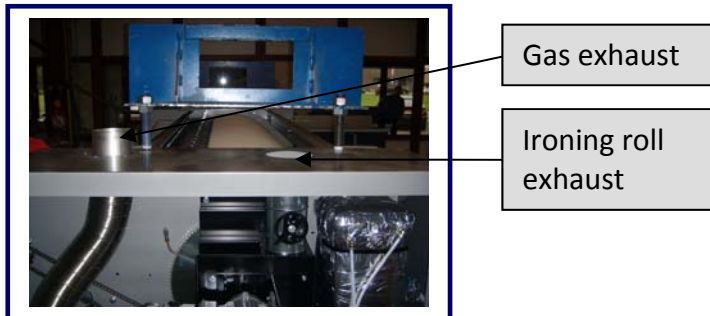
1"1/4  
Gas valve not included, use certified gas valve.

7. Connect the gas and exhaust outlet.

The gas and exhaust outlet are on the right and have the following connections:

Gas outlet: Diameter 125mm

steam outlet: Diameter 125 mm



By law the exhaust outlet must be completely separated from the gas outlet to prevent the risk of fire.

The exhaust outlet should consist of a heat-resistant pipe (150°).

In order to achieve proper operation, this pipe must always be kept as short as possible and must have as few bends as possible.

If an outlet channel joins a main channel, the angle of incidence must not exceed 45°.

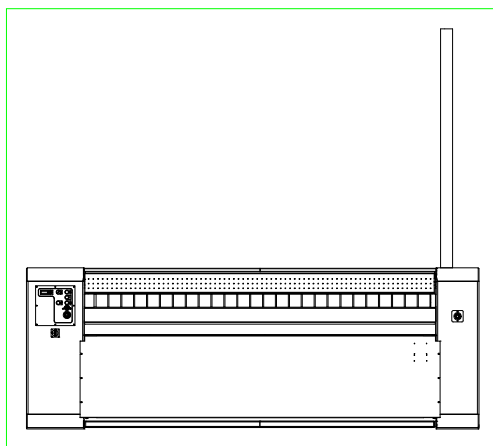
If the distance from the outlet channel is bigger than 5 meters, a series fans must be installed further down the outlet channel or the section of the pipe must be increased! example 150 mm instead of 125 mm.

Insulate both the gas and exhaust outlet pipes to prevent fire.

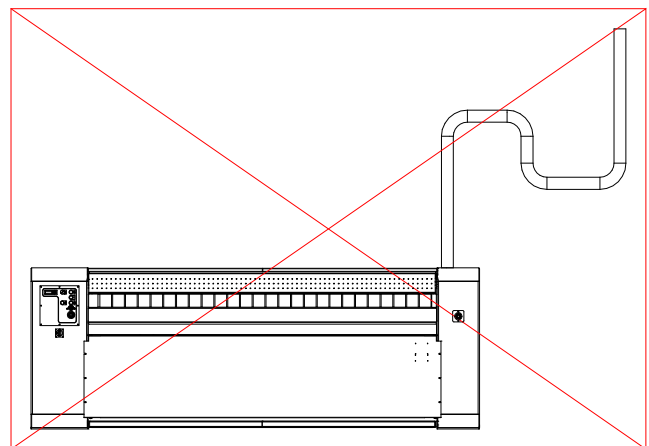
See chapter 1.3 for amount of m<sup>3</sup>/h air for exhaust outlet and gas outlet.

**Note :**

**Failure to comply with the installation guidelines may lead to counter-pressure in the outlet channel which will impair output and quality.**



Good



Wrong

8. When the machine is completely connected, open the gas valve and check the machine for leaks. When starting up on site, the gas burner adjustment should be done again by an approved or authorized person.
  
9. Install the table horizontally at the back of the machine.

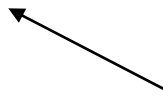
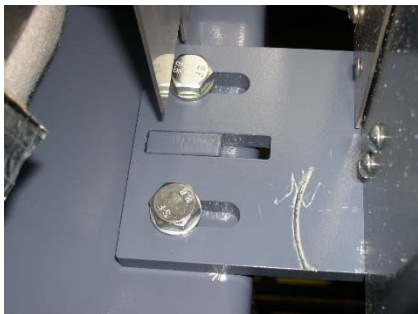
Undo bolts and rotate bench 90° so that you can screw the same bolt back in and place the bench flat (spirit level). Then tighten both bolts well.



Dismantle the protective plate at the back.



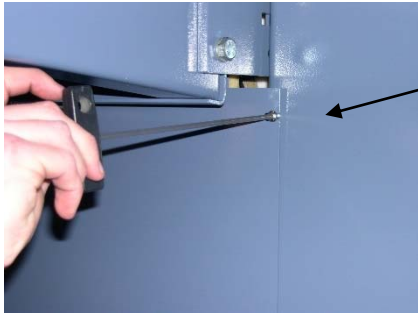
Allow the machine to warm up (adjust the temperature setting to 175°) and press start and at the same time press against the finger guard so that the bed closes and the roll does not turn. Loosen the tensioning screws and adjust the distance between the bed and bench so that they are 2 mm apart. Then tighten the tensioning screws again.



Tensioning screws at the bottom of the bench



Distance between bed and bench 2



Fit and secure the protective plate.

**10. Install the supplied foot pedal (optional).**

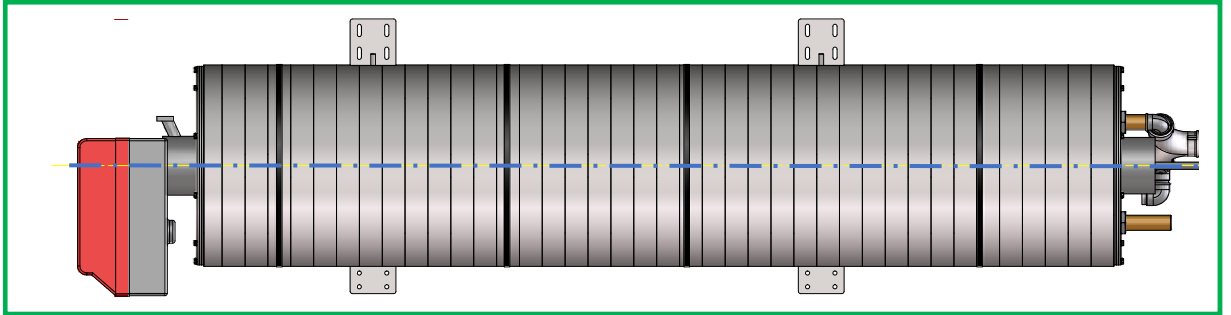


Position the footplate on the frame.

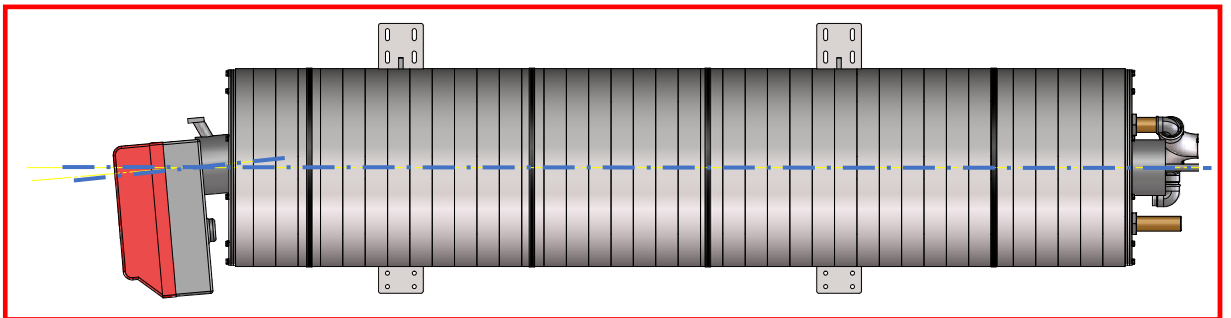
## 11. Burner adjustment.

First check if the burner is still mounted correctly on the heat exchanger. It can be possible that the burner gets loose because of transport.

### Good



### Wrong



On startup of the machine on location, burner settings have to be adjusted by an qualified or certified technician and be inspected on standards in the concerned region. Before starting the burner, it is necessary to read the enclosed manual of the burner and the gas valve. Burner settings also have to be adjusted every 12 months for optimal burning and efficiency, also by an qualified or certified technician.



When there is a **modulating burner (BS3/M)** installed, the **lowest possible power output must be regulated below 60kW !!!** This to ensure that the CO value will not be too high. (for safety reasons).

Also adjust the **“Time opening burner valve”** parameter into the touch screen.  
read the touch screen manual for more information .

First adjust the burner. (see minimum and maximum power output described in the manual ).

Put the switch on the burner on manual.

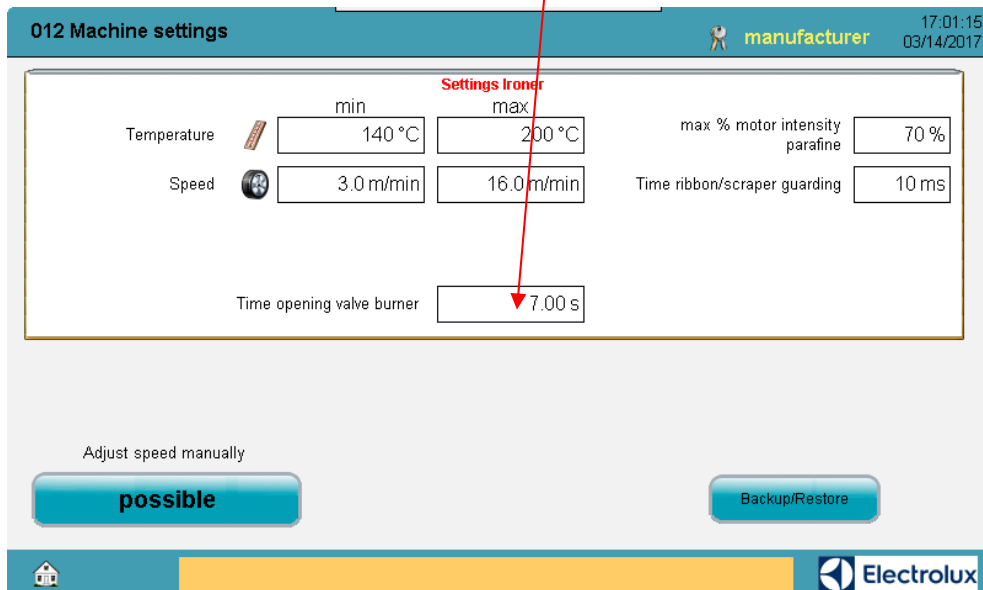
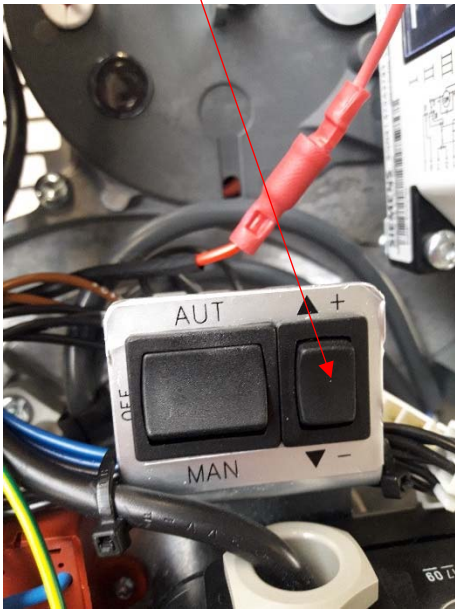
Push stop button on the screen

Now push preheat button on the screen

Wait 20seconds after the ignition of the burner.

Push on the + button from the burner until the air flap is completely opened.

The time starting from the moment you push the + button until the flap is completely opened is the time that you have to set as the value ‘time opening burner valve



## 12. Removing air from the thermal oil system.

### Gas heated:

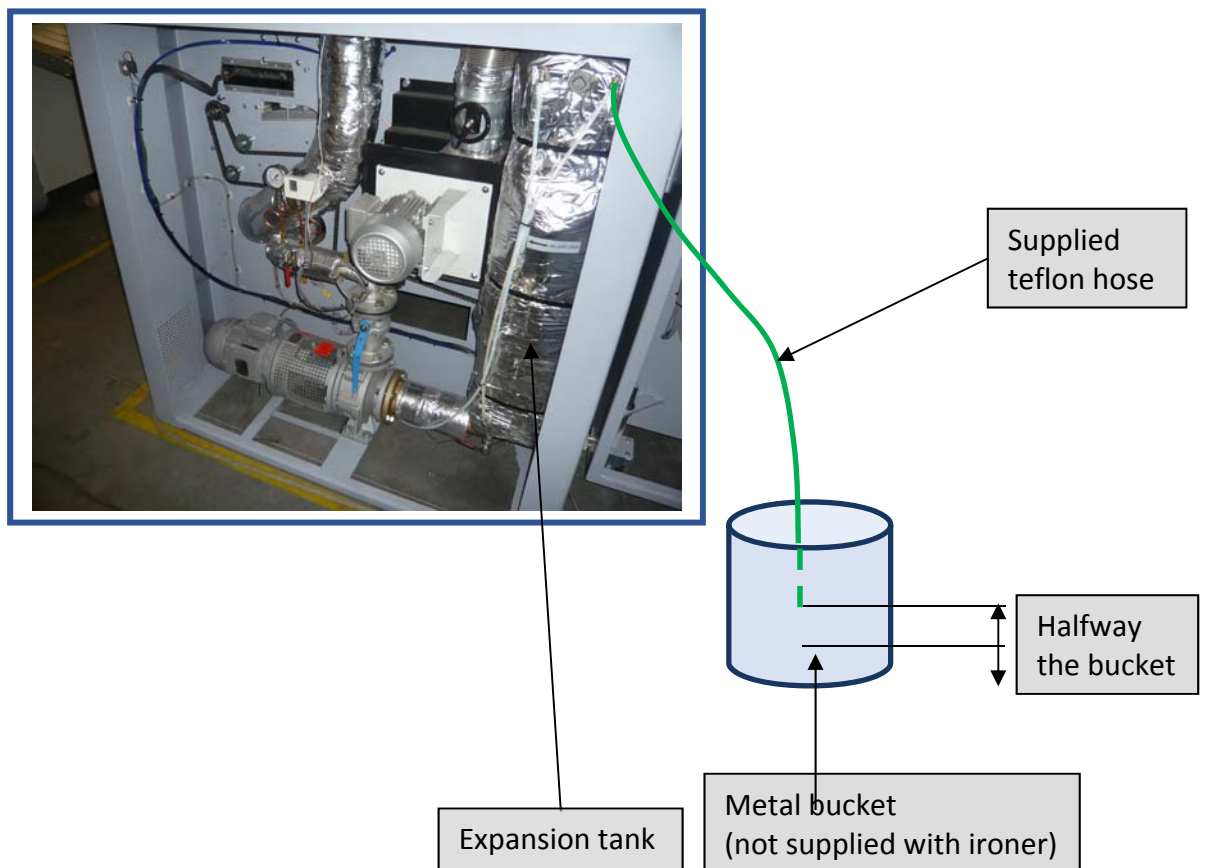
The heating system must be fully bled the first time the machine is warmed up. This bleeding is done by connecting the supplied teflon hose onto the copper pipe on top of the expansion tank next to the circulation pump.

Take a metal bucket and fix the teflon hose half way into the bucket so moisture can be captured into the bucket.

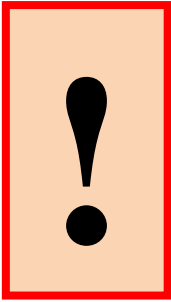
Let the machine heat up till 80°C. After 15min on 80°C you can increase the temperature till 90°C. After that you can increase the temperature like described hereunder.:

- ⇒ 15min. on 90°C
- ⇒ 15min. on 100°C
- ⇒ 15min. on 110°C
- ⇒ 15min. on 120°C
- ⇒ 15min. on 140°C
- ⇒ 15min. on 160°C
- ⇒ 15min. on 175°C

When the temperature is reached (175°C) you have to wait 15 minutes before you can removed the Teflon hose. The machine is now ready to use.



Cutting / brushing the overlap from the new padding.



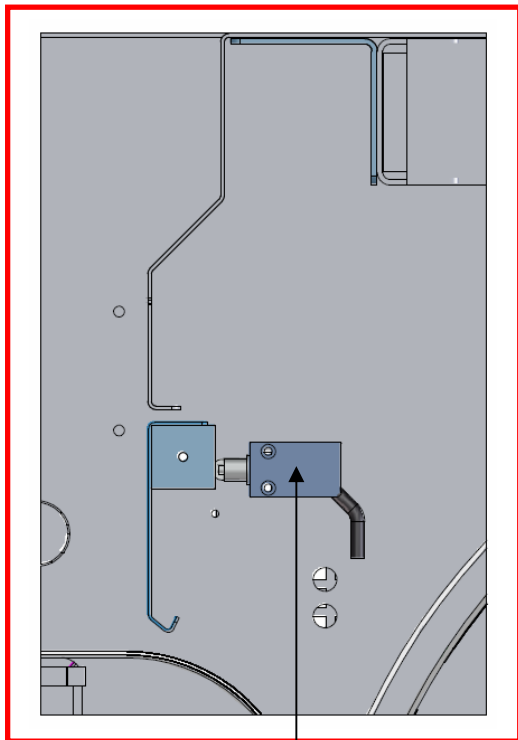
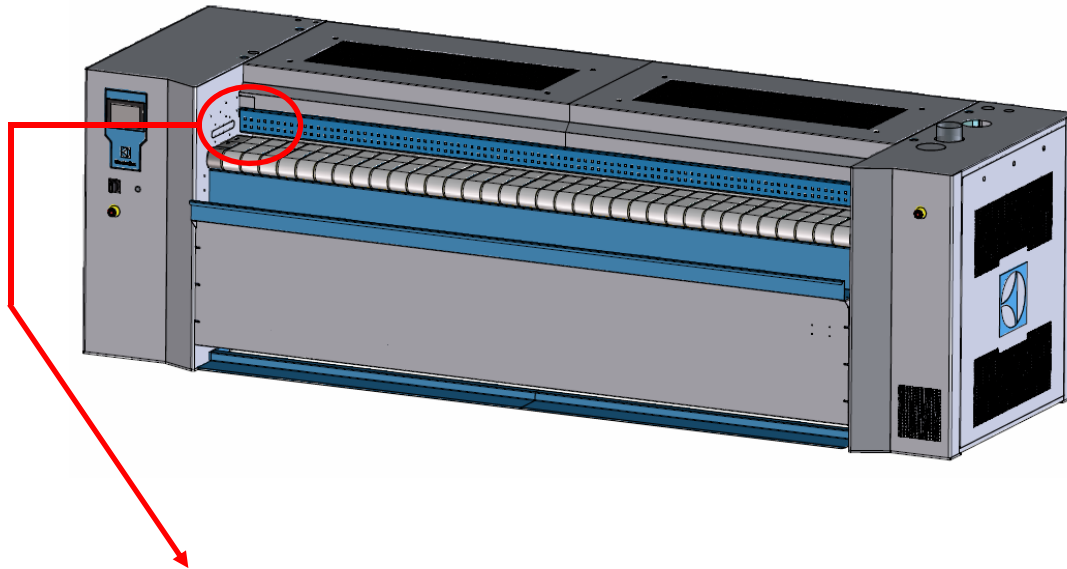
In the beginning a new padding will stretch, this will result in an overlap.

An overlap gives wet spots onto the ironed linen. Therefore it is recommended to check the overlap from the padding every day and cut / brush the padding when necessary. For more information See chapter **“Roll padding replacement”**.

After some time the padding will not stretch anymore. Then it is only necessary to check the overlap every month.

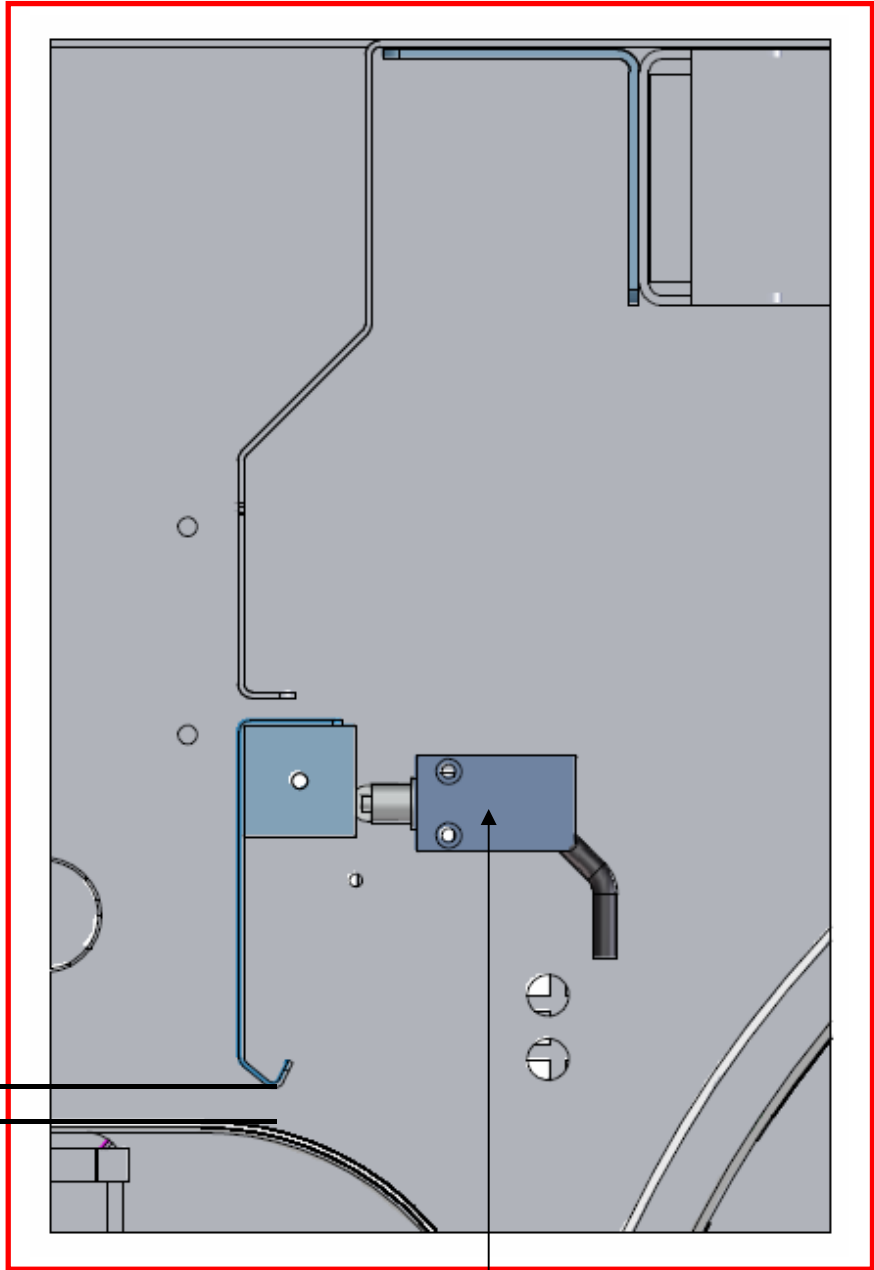
13. Check if all the emergency stop buttons and finger screen protection work.

Finger screen protection:



Contact finger guard

Should not exceed 15mm!!!



Contact finger guard



## **1.5 General.**

- The service life of an ironing machine with a steel ironing bed is approximately 15 years with normal maintenance. This is an estimate. It is not binding.  
No compensation may be claimed for a shorter service life.
- Noise level: 60-65 db depending on speed.
- The hardness from the rinsing water should be between 5°fH and 8°fH (= between 50 PPM and 80 PPM). The higher the value, the more lime deposit you get on the chest. This lime causes a lot of friction, which is very bad for the ironer.
- The PH value from the rinsing water should not be higher or lower than the ideal 6,5. If this value is not ideal, then this give friction problems in the ironer.



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