



Pamilas Italia S.n.c.

Via S. Bernardino, 39/A 40017 San Giovanni in Persiceto (Bo) - Italia
Sistemi di movimentazione ed imballaggio per indumenti.

CONVEYORS AND PLASTIC BAGGING MACHINES

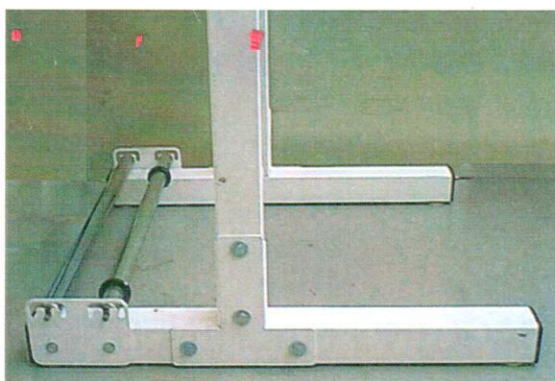
PMS603ECO

SUPPORTO BIANCO PER IMBUSTATRICE AD 1 PORTAROTOLO
WHITE STAND FOR POLYBAGGER WITH 1 ROLL HOLDER
SUPPORT BLANC POUR EMBALLEUSE AVEC 1 PORTE-BOBINE

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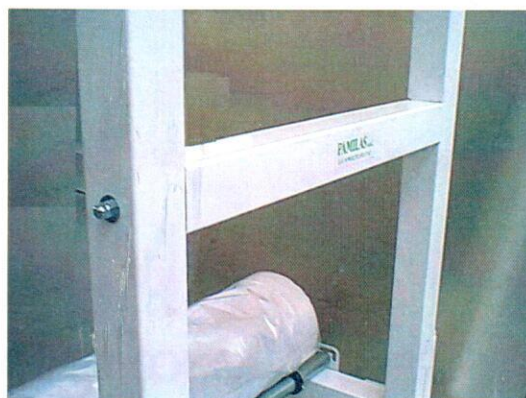
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SUPPORTO ASSEMBLATO
ASSEMBLED STAND
SUPPORT ASSEMBLE



ASSEMBLY AND MAINTANCE MANUAL FOR THE
GARMENT PLASTIC BAGGING MACHINE

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ASSEMBLY AND MAINTENANCE MANUAL





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1. General information

1.1 Introduction

This manual refers to the garment plastic bagging machine and consists of three sections:

- **Section 1 – Assembly and maintenance manual:** this provides all indications regarding the machine components, its safe use and maintenance, aimed at guaranteeing the best possible results and longest life for the machine.
- **Section 2 – Operative manual:** this provides all indications for using the machine and solve problems.
- **Section 3 – Spare parts manual:** this provides all indications for identifying and ordering the components supplied as spare parts.

This represents an indispensable tool for the installer for being able to:

- Assemble the machine
- Identify the instructions and information to be inserted in his own use and maintenance manual to be supplied to the user before starting up the machine.

PAMILAS ITALIA is at your complete disposition for all assistance requirements that could arise, and wishes to remind you that failure to observe the instructions contained in this document will bring about the invalidating of the warranty and any resulting liability.

PAMILAS ITALIA reserves the right to make any modifications retained necessary for improving the performance of the machine.

For further clarifications or requests please contact:

PAMILAS ITALIA S.n.c.

Via San Bernardino, 39/A 40017 San Giovanni in Persiceto (BO) ITALY

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1.2 Definitions

Operator : the person who takes care of carrying out the operations of hanging the hangers with garments into the plastic bagging machine, of cutting and welding as well as all cleaning operations required for normal use of the machine.

Person in charge of assistance: the person who performs activities differing from those carried out by the everyday user, like maintenance, extraordinary servicing and adjustments in general.

Installer: the person who takes care of carrying out all the operations involved in the assembly of the machine and start up in order to guarantee its correct operation.

For all the operations requiring their intervention, the person in charge of assistance and the installer mentioned above must have accrued specific experience and posses considerable basic technical know-how, allowing them to carry out their tasks in conditions of maximum safety.



All qualified personnel who are required to carry out tasks on the machine must have an in-depth knowledge of the contents of this manual, its warnings, all information relating to safety and everything else regarding the control devices and the accessory equipment assembled by the installer. In the event of failure to respect these conditions PAMILAS ITALIA shall decline all liability.

1.3 Marchings and technical features

PAMILAS ITALIA guarantees that the components are compliant with the technical features container herein as long as their assembly, installation and maintenance comply with the indications in this manual.

You are therefore advised that is prohibited to put the machine into operation until its compliance with the provisions of the EEC Directive 89/392 and following amendments has been identified and declared, that is to say until the components, the object of this manual all form and integral part of the machine.

The following tables contain the main technical features and some of the conditions to be observed in assembling the system. A more detailed explanation is given below and in the paragraph: Installation.

Power supply voltage	Volt	220
Frequency	Hz	50/60
Weight	Kg	38
Max. weight to be hung for each cycle	kg	2
Screw clamps for legs		M8
Min. load for each screw (traction)	N	4000
Side screw clamps		M8
Min. load for each side clamp (traction)	N	4000



2. Section 1: Assembly and maintenance manual

2.1 Use of the machine

The machine installed consists of a mechanism capable of welding and cutting a film of plastic material allowing the superimposition of the film to clothes that are hung to an hanger. Using different kind and/or thickness of materials is not an obstacle to the regular working of the machine provided that you use the following material: Polyethylene from 0 to 80 Micron.

Any use differing from that specified by PAMILAS ITALIA will relieve them from all liability with regard to any damage caused with regard to the warranty.

2.2 Conditions for use

The machine must be used in closed environments on a round surface with sufficient strength for supporting the load of the legs, and fitted with suitable lighting for carrying out the work. For wall installation, the wall must have a solidity fit for consenting the proper holding of the screw anchors for machine fixing.

The air inside the working environment must not contain dust in suspension, corrosive substances or salt.

The machine must be installed in such a way as to make it inaccessible to the general public and be in an area away from transport means. The barriers for creating divisions between the area designed for the system and the area designed for the general public are the customer's responsibility.

The machine must be installed in the environment in full observance of all the laws in force in the Country of use.

Operation in conditions differing from those described above will bring about the immediate invalidating of the warranty and relieve PAMILAS ITALIA from all liability, forcing the installer and the user to be responsible for all operations relating to the updating of the installation environment.

2.2.1 General safety standards

Operation of the machine must only be permitted for personnel who have been sufficiently trained in its use and who are aware of the operating standards and hazards involved. It is forbidden to make any modifications to the components, after the original performance and/or use additional equipment not compliant with the above specifications.

Before any type of intervention on the machine components it will be necessary to remove all the garments hanging on and turn off the power supply.

Never remove or deactivate the safety devices, always keep the plates, marks, warning notices located on the machine efficient and legible.

Any accident that involves people, buildings, structures or equipment, or any malfunctioning must be immediately notified to the person on charge or a direct superior.

The maintenance operations must be carried out by qualified personnel.



2.2.2 Working environment

Word environments: The machine must be used in covered environments and sheltered from atmospheric agents.

2.3 Description of the system components and layout

2.3.1 Machine components

The machine consists of the following main parts:

- Shell, that has the function of holding different components of the machine and allowing the machine fixing.
- Movable part, that is the movable part of the machine and holds the blades, the welding bars, the electric harness and the control panel.
- Big handle, that is the lever mechanism that lets the movable part turn in order to make the complete cycle of welding and cutting; in manual model the big handle is operated by an operator that pushes it enough to close it manually, **IT MUST ALWAYS BE OPERATED WITH BOTH HANDS!**

2.3.2 Installation of the machine

In the study of the positioning of the machine, a study that must be carried out by the installer, it is necessary to keep in mind the following indications as well as the specifications in the technical features:

- Dimensions of the machine whether closed or open.
- Calculate enough space for film roll replacement.
- Calculate enough space whether for clothes to be packed or for clothes already packed. Clothes must not encumber the working area of the machine.
- Calculate electrical connections very near to the machine and with proper protection.

The instructions given and the data shown in the TECHNICAL FEATURES tables will allow the installer to correctly identify the components and their quantity.

2.4 Installation

2.4.1 Packaging

The machine is shipped completely assembled using the transport means (truck or semi-trailer) and/or containers for exportation, indicated by the customer. Unless otherwise requested, the machine will be supplied with a protective coat of paint.

The Customer will naturally be aware of the provisions outlined in this manual, allowing him to make a correct choice of components to be ordered and acquire a reasonable knowledge of everything pertaining to the operations of machine assembly, adjustment and ordinary maintenance.

2.4.2 Trasport

The machine must not be stored outside in the open as it could be damaged and it is also necessary for it to be shipped in closet vehicles and be stored in covered areas protected from inclement weather.

WE RECOMMEND CHECKING THE INTEGRITY CONDITIONS OF THE PACKAGES AND THE COMPONENTS ORDERED ON ARRIVAL. IF ANY DAMAGE IS DETECTED IT WILL BE NECESSARY TO CONTACT THE CARRIER WITHOUT DELAY.



2.4.3 Installation

First of all decide the right height at which the machine must be fixed, this depends on the operator's height and on the length of the garments that are usually packed.

Mark on the wall the quadrature of the through holes of the machine in order to verify if the machine is positioned in a right horizontal and vertical position.

After having moved the machine into the specific area and having organised the equipment and personnel necessary, proceed with the assembly, if possible starting from the upper part.

Fix the two upper screw anchors, hang up the machine and verify the horizontal alignment, in case you have to make some little correction, use lower screw anchors, **PAY ATTENTION BECAUSE BOLTS OF THE SCREW ANCHORS MUST NEVER COME OUT FROM THEIR SLOTS.**

At the end check all the camping and tightening.

2.5 Start up

When the installation of the machine is finished, let it start following step by step these instruction:

1. Put the film roll on proper rollers marked n°12 in drawing 1 and 1 bis. If the machine has a floor rollholder, check if two rollers are positioned at the right distance between centers in order not to let the film roll follow down passing through them when it is smaller because it is finishing. Pass the film around the roll hanger as indicated in drawings 1 and 1 bis. Pay attention not to bring the hanger out of its seat: it must remain between two cones positioned on back roller but it must move a little bit sideways.
2. Pull the film from lower part of machine till two welding bars are covered (more or less 35 cm). Do not switch on the machine and close the big handle till end of stroke, in this position the machine keeps closed, open again pulling a little bit and verify the film is well cutted. If it is not well cutted, check if the big handle has been closed till the end and if the problem continues, check that there is nothing between film-stop and the contrast (n° 4 e 7 of drawings 1 e 1 bis).
3. Position time check on 05 (half second) and switch on the machine. At start up the machine makes a "beep" and the green led lights indicating the presence of current. Pull again the film till resistances are covered and close the machine, when the big handle arrives at end of stroke, the machine makes another "beep" and a red led starts to lighten indicating that resistances are working and machine is welding. When the cycle is finished, there is another "beep" and the red led switches off. Open the machine, check the welding, it will be cold and you will not be able to tear the two unnecessary triangles.
4. Repeat this operation increasing the time one tenth of second each time (05...06...07...etc.) till achievement of a perfect temperature fit for the film that will be used. **ATTENTION, NEVER set time higher than 1,2 sec, this is the highest suggested time in order not to damage heaters. Do this only first time, then if it is not changed the type of film, the time will always remain the same.**
5. once found the right temperature, the machine is ready and people can start to work.

2.5.1 Checks after start up

One week after putting into operation check the tightening of all the screws and clamps.



2.6 Technical standards applied

The technical standards, applied, certifications and system emissions are indicated in this chapter.

2.6.1 Technical standards applied

The technical standards taken into account in the design and with which the machine complies, are as follows:

A – Legal provisions

DL - 19-9-1994 - n. 626 (Legislative Decree)	Putting into effect of the provisions 89/391/CEE, 89/654/CEE, 89/655/CEE, 89/656/CEE, 90/269/CEE, 90/270/CEE, 90/394/CEE, 90/679/CEE relating to the improvement of safety and health of workers in the work place.
DPR - 27-4-1955 - n. 547	Standards for the prevention of industrial accidents.
DPR - 24-5-1988 - n. 224 (Presidential Decree)	Strict liability for detective products.
DL - 12-8-1991 - n. 277	Putting into effect of EEC provisions no. 80/605 - 83/477 - 86/188 -88/642 with regard to the protection of workers from hazards deriving from exposure to chemical, physical and biological agents during work, in accordance with article 7 of law 30 July 1990 n. 212.
DL - 4-12-1992 - n. 476	Acknowledging of EEC provision no. 89/336 regarding electromagnetic compatibility (EMC).

B – National and International Standards

- EEC Provision n. 85/374	- Liability for damage from detective products
- EEC Provision n. 89/392	- Machine provisions
- EEC Provision n. 91/368	- Amendment to provision 89/392
- EEC Provision n. 93/44	- Amendment to provision 89/392
- EEC Provision n.93/68	- Amendment to provision 89/392
- EEC Provision n. 73/23	- Low Voltage (DBT)
- EEC Provision n.89/336	- Electromagnetic compatibility (EMC)

C – Harmonised Standards - Harmonised Standard Designs – National Technical Standards

Harmonised Standards are the technical standards issued by the CEN – CENELEC and the references of which have already been published in the Official Gazette of the European Community.

Standard designs are the technical standards of levels A-B-C being defined by a section of the technical committees "TC 114 – Machinery Safety" and "TC 122 - Ergonomics" of the CEN.

CEN/TC - 114 - Ref. EN 292-1992

Machinery safety – Fundamental concepts: general design principles

Part I - Basic methodological terminology (EN 292-1)

Part II – Technical specifications and principles (EN 292-2)

CEN/TC - 114 - Ref. EN 294-1192

Machinery safety – Safety distance for preventing the upper limbs from coming into contact with hazardous areas.

CEN/TC - Ref. EN 349-1993

Machinery safety – Minimum distances for preventing parts of the body from being squashed.

CENELEC - Reference 60204-I

Machinery safety: Electric equipment of the machines

Part I – General requirements



2.6.2 Certification of components

The components used are guaranteed to be:

- Supplied by selected and screened manufacturers.
- Marked and equipped with certificates of compliance with the standards in force, issued by the suppliers.
- In-factory design and manufacture.

2.6.3 Noise

The detection of the noise of the system was carried out with the system in movement, during the various operating cycles, and in the work station at a height of 1.6 m from the operator's foot level. Values lower than 70 dBa were detected.

2.7 Safety

The operator is not subjected to vibrations as he stands with his feet on the ground near the system during the carrying out of the operations.

2.7.1 General information

The installation operations must only ever be carried out by trained personnel;

It is not necessary for **the operator** in charge of running the machine to have any specific qualifications, however **he must be specifically trained in the use of the machine.**

Ordinary and extraordinary maintenance operations must only be carried out by the following:

- mechanics specialised in intervention on mechanical parts
- electricians and electronic personnel for intervention on the electric and electronic systems

All professional personnel who are about to operate the machine must have a thorough knowledge of the contents of this manual, including the warnings, recommendations and all information relating to safety contained herein.

PAMILAS ITALIA declines all liability arising from the failure to observe the above conditions.

2.7.2 Incorrect or unforeseen use

Improper and/or incorrect use consists of the following :

- Tampering with the safety devices (safety guards etc.);
- Carrying out maintenance while the system is not in full safety conditions;
- Packing material different to garments;
- Packing garments with a weight exceeding the values indicated in the technical features;
- Installation of the machine in unsuitable environments or which do not comply with indications in this manual;



Failure to respect these conditions, or any others indicated in any part of this manual, plus any modifications to the machine and/or the installation of parts and/or accessories that could alter the initial safety will bring about the invalidating of the warranty and the undertaking of all liability by the user or customer.

2.7.3 Safety in the operating and control area

The system must be designed to allow user-friendly control of all functions related to the ordinary running.

The operator work stations must be capable of guaranteeing the following:

- safety and protection from all foreseeable hazards.

The control panel must be located in a position allowing for maximum control and user-friendliness of all the devices while at the same time guaranteeing prompt activation in the case of emergencies and/or breakdown.

The safety of the personnel circulating in the transiting and working areas must never be underestimated.

2.7.4 Safety

The following terms have been defined in Provision 89/392:

- HAZARDOUS AREA: Any area inside or in the vicinity of the system that represents a hazard for bodily harm.
- EXPOSED PERSON: Any person who is found, fully or in part, in a hazardous area .
- OPERATOR: The person assigned to install, use, adjust, service, clean or repair the system.

The components are originally fitted with all the safety guards necessary for working in conditions of maximum safety.

Below is the description of the safety systems used by PAMILAS ITALIA S.N.C.:

- Protection of blades;
- Resistances feeding only when the machine is closed.

Incorrect use or deliberate actions, like the removal of the safety guards or safety systems in general, will bring about the invalidating of the warranty and the undertaking of full responsibility by the user.

2.8 Residual hazards

In conditions of correct installation and correct use, the machine does not present risks of environmental pollution, however it must be pointed out that residual pieces of PTFE tape, silicone rubber and plastic in general, used for maintenance and equipment must never be dispersed in the environment, and instead disposed of according to the legal provisions.

In these cases the updating of the Regulations regarding worker protection and/or conservation in force in the user's country are the purchaser's complete responsibility.

Hazard for the operator derive mainly from the following:

- an insufficient working space that could present the hazard of being trapped between the big handle and fixed surfaces;
- a dirty or slippery walking area that could cause falls;
- incorrect use of the machine and/or tampering with the safety devices;
- failure to wear non-slip safety boots and gloves;

- failure to use personal safety devices during maintenance operations;
- excessive effort required in lifting the machine components during the installation phase;



- the risk of falling from high places during the checking and maintenance of the control head:

The risk of cutting and burning exists in the case of introducing hands inside the machine while pushing the big handle, for the above reasons it is necessary to observe the following:

- Keep well away from the above-indicated areas;
- Frequently clean the walking surfaces;
- Always use the personal safety devices;
- Always follow the instructions in this manual and in the manual supplied by the installer;

A series of hazard-warning plates are located on the machine, even when adequate hazard protection is provided.




The removal of the safety devices will bring about the invalidating of the warranty and the undertaking of full liability by the purchaser for any hazards that could arise and/or be caused.

The warning and indicator plates located on the machine carry out an important function as they advise of hazards existing in the various areas and indicate the role played by the safety device.

In the event of damage, replace the plate.

2.8.1 Plates

The positioning of the plates is the responsibility of the installer and will depend on his assessment of the hazards. The meaning of each plate is indicated alongside. The attaching of the following plates is also recommended:

	This warns of hazards deriving from the electric current
	This prescribes the use of safety boots for carrying out the operations
	This prescribes the use of safety gloves for carrying out the operations

2.8.2 Residues and environmental contamination

We would remind you that all residues from cleaning and maintenance operations (rags, solvents, grease etc.) must be disposed of by the user in accordance with the laws in force in the user's country.

An incorrect application of these regulations will bring about the undertaking of full liability by the user.



2.9 Maintenance

2.9.1 General

Adequate maintenance represents a determining factor in guaranteeing longer system-life and ensuring optimal operating conditions and maximised performance.

For this purpose a series of checks and maintenance operations have been foreseen and are listed in the maintenance table.

Warning.

The use of **original spare parts** is recommended, as these are the only ones capable of offering the same quality guarantee as those originally assembled in the machine.

Before carrying out any maintenance operations or repairs it will be necessary to thoroughly clean the machine. For the cleaning operations use tools in good condition with suitable handles.

The material removed and the rags used must be collected and disposed of according to the legal provisions; these must not be dispersed as they cause pollution.

WARNING! All the maintenance operations on the mechanical parts and the electric system must be carried out by expert personnel with the system in safety conditions.

2.9.2 Safety: precautions and creating suitable condisions for maintenance

For any type of maintenance operation required, it is indispensable for the machine it be in suitable conditions for maintenance in order to guarantee safety.

In order to generate these conditions all the garments and work material (film of polyethylene) must be removed from the machine which must be stopped. The power supply cut off to the controls in order to avoid any uncontrolled movements.

2.9.3 Checks and functional tests of the safety devices

It will be necessary to carry out **periodic (at least once a month)** checks of the proper operation of the safety systems, in order to guarantee the functionality and efficiency even with the passing of time.

Carry out the following checks:

- Integrity of the warning plates,
- Tightening of the connecting screws and the ground and wall anchoring elements.

2.9.4 Cleaning and maintenance

As the machine had been designed to reduce all maintenance operations to a minimum, please follow the maintenance schedule table below:



HOURS	10000	15000	20000	25000	30000	35000
OPERATION.						
Replacement protective tape of resistances		♦				
Replacement silicone rubber supports whether of resistances or of contrast				♦		
Replacement resistances kit (wire and springs)						♦

FURTHER ADVISE:

- Once a week: put a small amount of oil near the bearing bush and the bush handle;
- Every six month: verify a possible tissue damage resistance of Teflon.

WEAR AND TEAR

Carry out a monthly inspection of the state of wear and tear of the protective tapes and of support rubbers. Carry out replacements whenever the wear and tear reaches the following values:

- Tape cut in the point of contact;
- Support rubbers with incisions including resistances completely.

PAMILAS ITALIA S.N.C.'S TECHNICAL DEPARTMENT IS AT YOUR COMPLETE DISPOSITION FOR ANY FURTHER INFORMATION YOU MAY REQUIRE AND NOT CONTAINED IN THIS MANUAL.

2.10 Dismalting the machine

The dismantling of the machine must be carried out according to the following operating procedures.

- 1) Remove all plastic parts and/or special rubbers (they have particular modality of elimination)
- 2) Disassemble the machine in all its components
- 3) After dismantling all the components, the residual materials must all be divided according to their typology (steel, plastic, etc.).

The disposal must be carried out in compliance with the laws in force in the user's country.

It is the user's responsibility to observe the laws in force in his own country regarding the disposal of waste and recovery of materials.



3. Section 2: Operative manual

3.1 Operative manual

OPERATION 1: When machine is open (big handle up) insert the polyethylene reel then pull down with both hands till desired length.



OPERATION 2: Close the polybagger to make welding polling down the big handle.



- **ATTENTION: KEEP THE POLYBAGGER CLOSED!**



OPERATION 3: immediately after the end of welding cycle pull the bag down.

OPERATION 4: pull up the big handle to re-open the polybagger.



OPERATION 5: take off the hanger, throw away the discard and go on with a new bag.





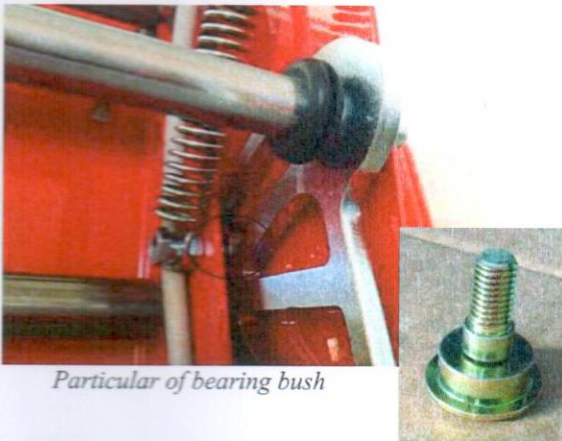
3.2 Any issue that may arise

CASE 1. the film after the welding was not cut by the blades:

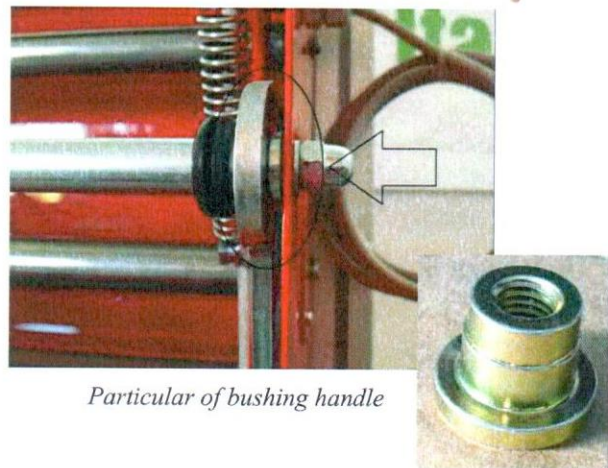
- Check the plades;
- Check the wear of the bearing bushes;
- Check the wear of the bushing handle.

CASO 2. The machine does not seal properly:

- Check the status of the wire of resistance;
- Check the wear of the bearing bushes;
- Check the state of wear of the bushing handle.



Particular of bearing bush



Particular of bushing handle

4. Sezione 3: Spare parts manual

4.1 General

This section of the manual contains the drawings necessary for identifying all the components supplied as parts.

4.1.1 Ordering spare parts

You are strongly advised to use only original spare parts. In the event of discovering the use of non-original spare parts Pamilas shall decline all liability and consider the terms of the warranty invalid.

All orders for spare parts must be forwarded to the following address:

PAMILAS ITALIA Snc
Via San Bernardino 39/A
40017 San Giovanni in Persiceto (Bo) ITALY
Tel./Fax +39 051 6810957

In order to identify the spare parts it will be necessary to communicate the following data:

- 1- Drawing number;
- 2- Code number of the component or group of components;
- 3- Quantity required.

Pamilas is at your complete disposition at all times for advice and assistance, and all orders and anything to report must be addressed directly to the same.



4.2 Spare parts drawings

Technical data drawings 1 and 1 bis

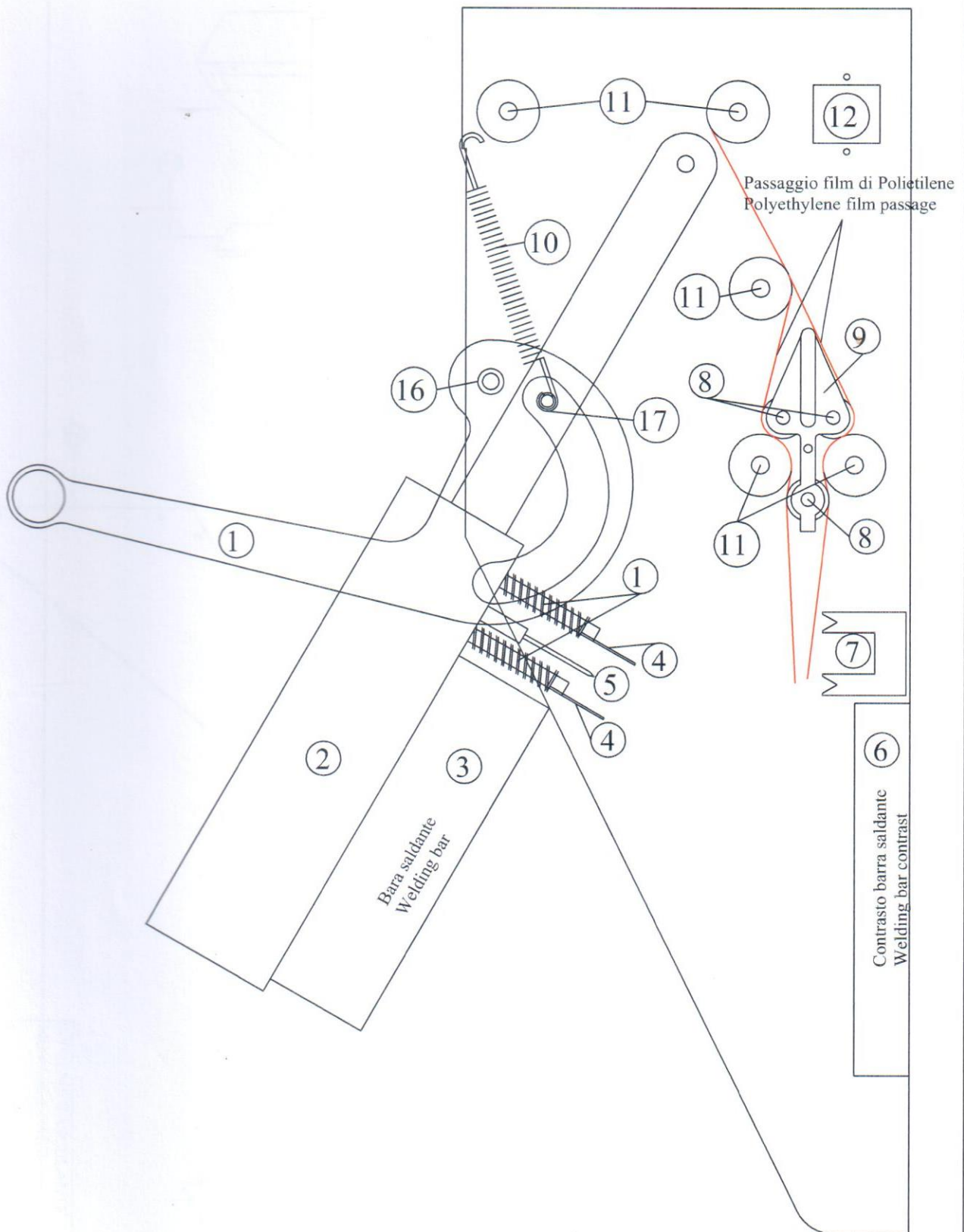
1. Big-handle
2. Movable part
3. Welding bar
4. Film stop
5. Blade
6. Welding bar contrast
7. Blades contrast
8. Hanger roller
9. Roller hanger
10. Opening spring
11. Film position roller
12. Roll support roller
13. Film stop springs
14. Electrical input socket 220V.
15. Microswitch regulation
16. Bushing handle
17. Bearing bush

Particular of the pannel:

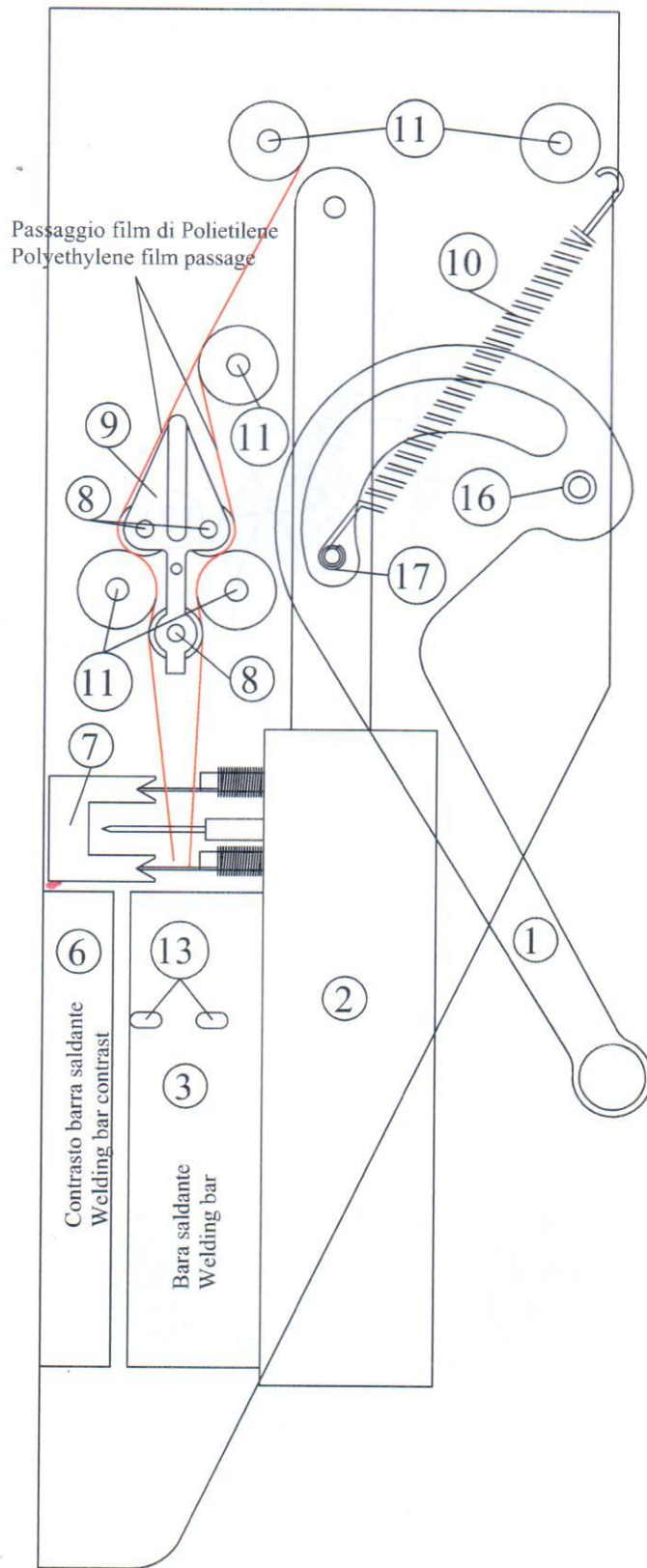
Button which decreases the welding time



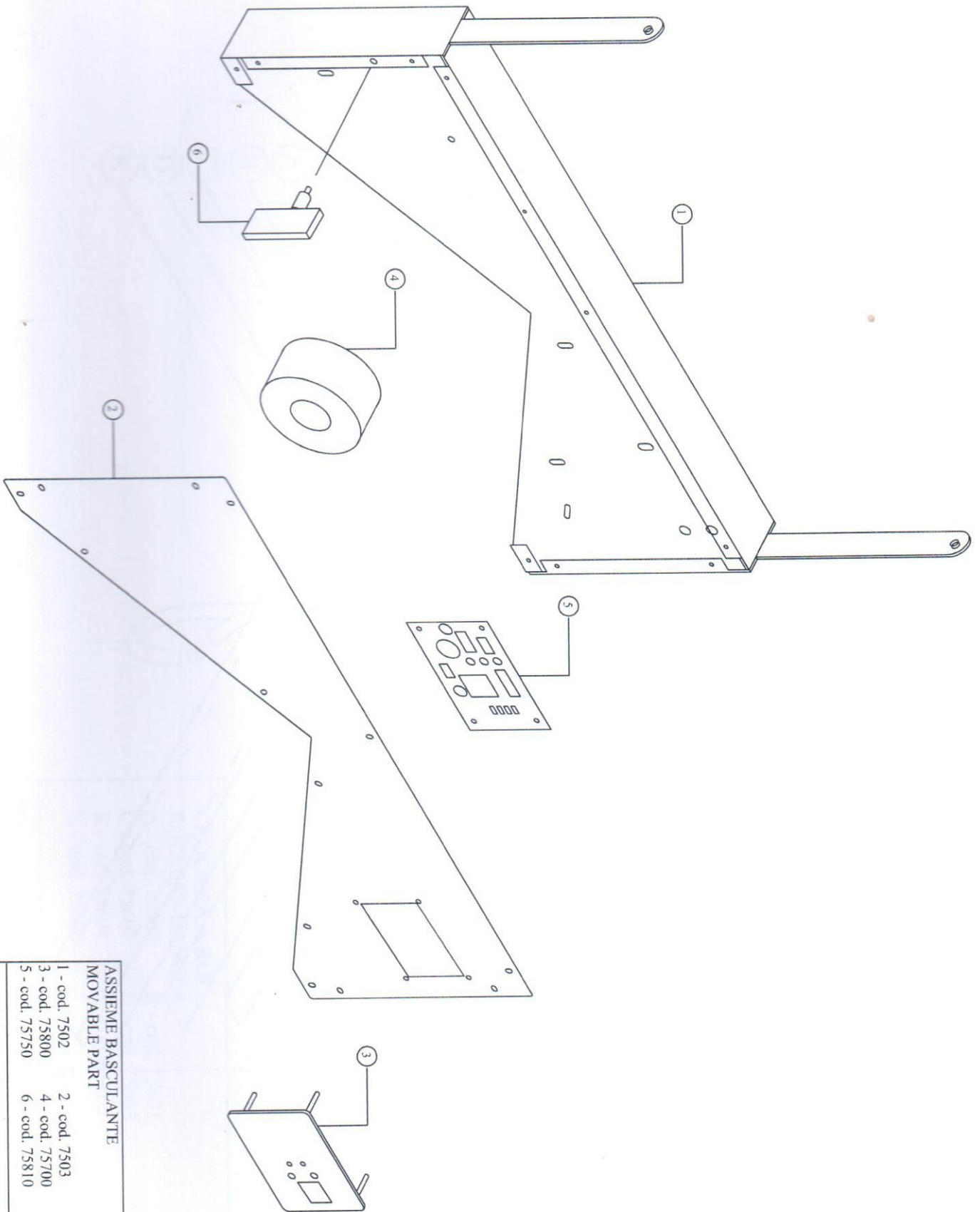
Button which increases the welding time



SEZIONE IN TRASPARENZA MACCHINA APERTA (vista da destra) Tavola 1

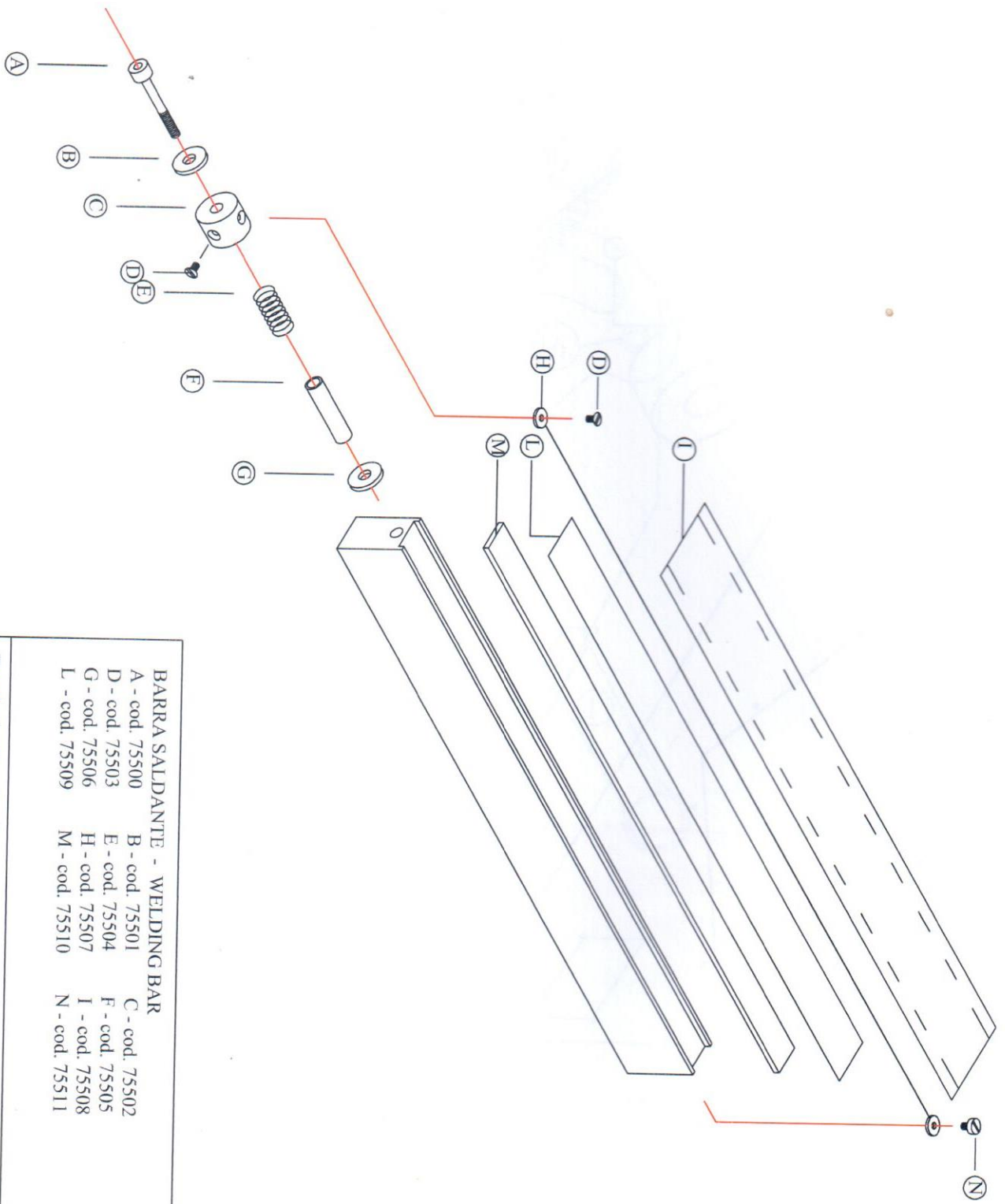


SEZIONE IN TRASPARENZA MACCHINA CHIUSA (vista da sinistra) Tavola 1bis
SECTION IN TRANSPARENCY CLOSED MACHINE (left view) Drawing 1bis



ASSIEME BASCULANTE
MOVABILE PARTI

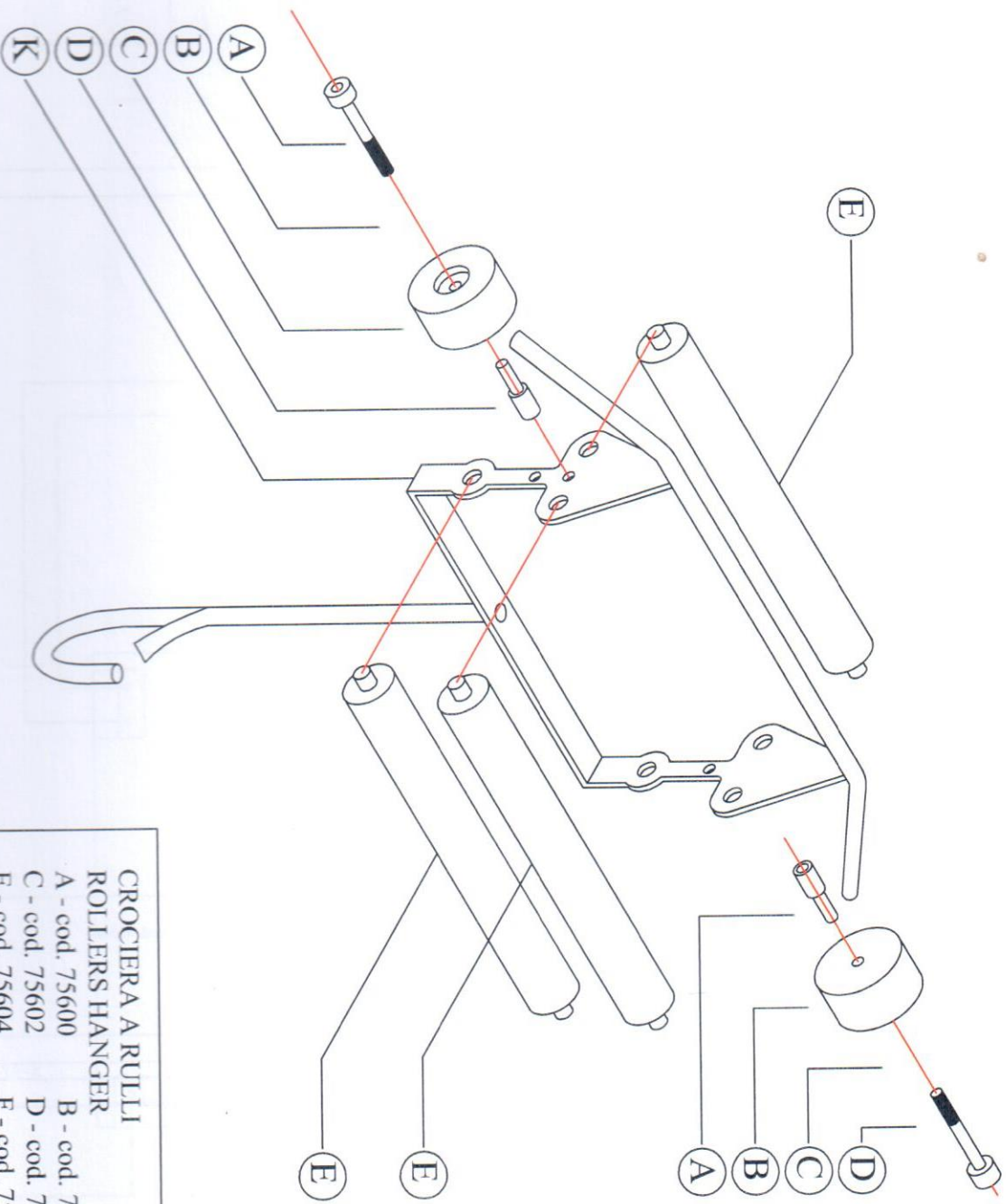
- | | |
|----------------|----------------|
| 1 - cod. 7502 | 2 - cod. 7503 |
| 3 - cod. 75800 | 4 - cod. 75700 |
| 5 - cod. 75750 | 6 - cod. 75810 |



BARRA SALDANTE - WELDING BAR

A - cod. 75500	B - cod. 75501	C - cod. 75502
D - cod. 75503	E - cod. 75504	F - cod. 75505
G - cod. 75506	H - cod. 75507	I - cod. 75508
L - cod. 75509	M - cod. 75510	N - cod. 75511

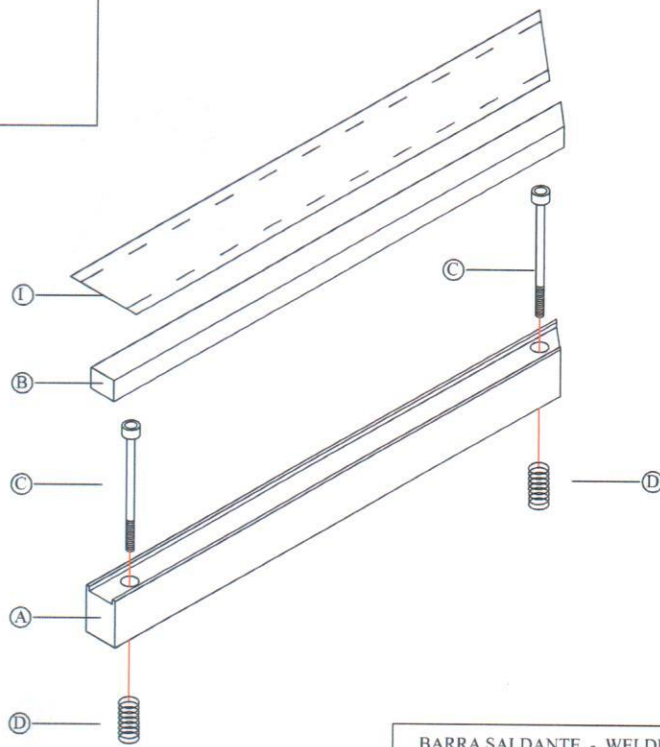
Tavola 3 - Drawing 3



CROCIERA A RULLI
ROLLERS HANGER
 A - cod. 75600 B - cod. 75601
 C - cod. 75602 D - cod. 75603
 E - cod. 75604 F - cod. 75605
 K - cod. 75606

Tavola - Drawing 4

PAMILAS
PMM7500



BARRA SALDANTE - WELDER

A - cod. 75510 B - cod. 75511 I - cod. 75508

Tavola - Drawing 5

SCHEMA ELETTTRICO ELECTRIC DIAGRAM

