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Global Manufacturing and Distribution

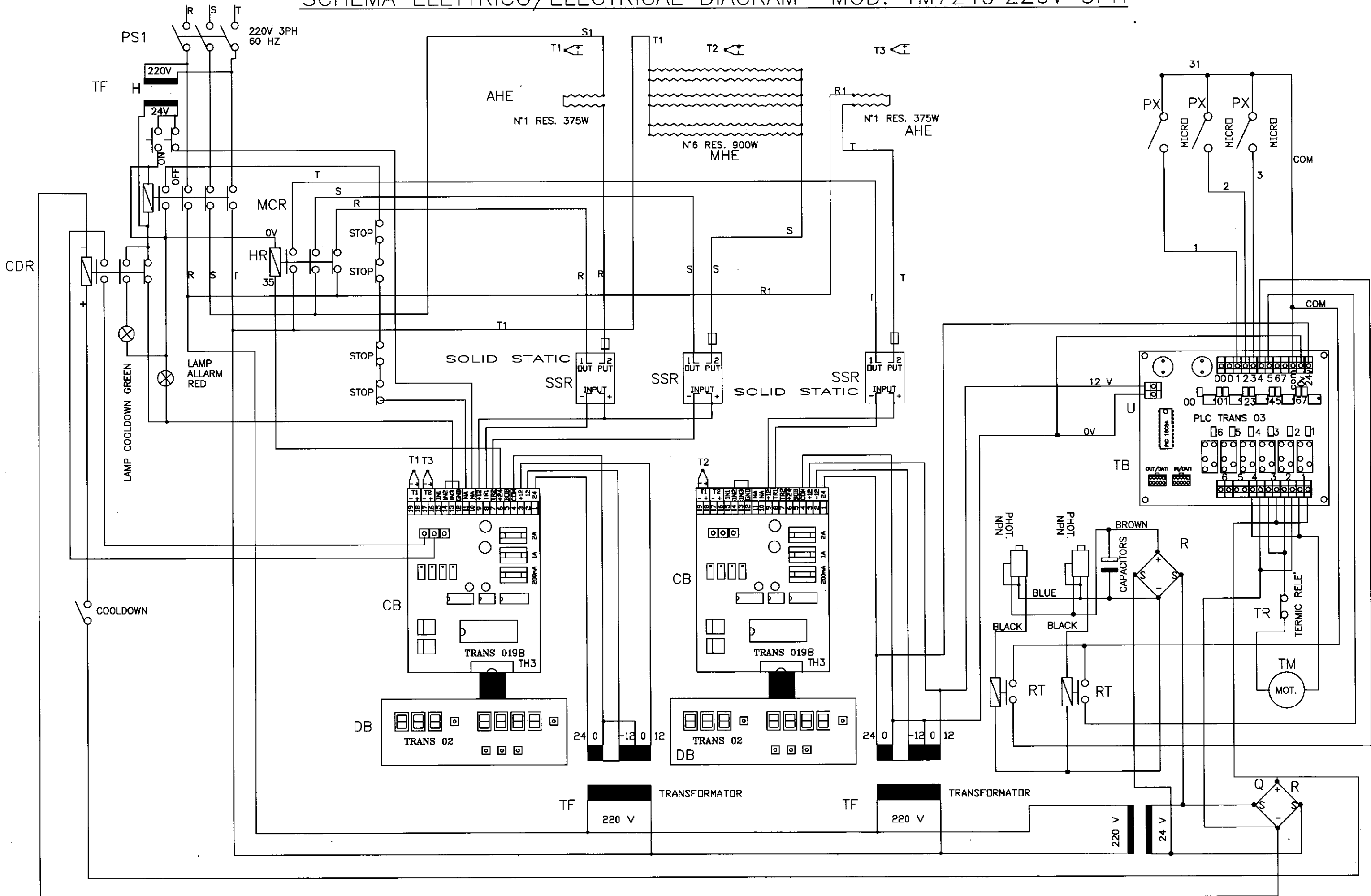
*The Manufacturer of*  
 *Value by Design*  
**Astechnologies**  
*Equipment*

# **OPERATION & PARTS MANUAL MODEL 7240IJ ROTARY HEAT PRESS**



530 Wilbanks Drive • Ball Ground, GA. 30107  
(770) 479-1900 tel. (770) 479-4179 fax

# SCHEMA ELETTRICO/ELECTRICAL DIAGRAM MOD. TM7240 220V 3PH





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## Preventative Maintenance

### Checklist for 7240

#### Daily

1. Clean Nomex (felt) belt with a lint brush, and or vacuum.
2. Check drum temperature with a Temp Strip before starting production.

#### Weekly

1. Clean and inspect machine and remove any ink residue from machine.
2. Clean and inspect temperature probes.
3. Spray high temp lubricant on Drum Bearing.

#### Monthly

1. Grease all roller bearings and sprockets with fittings.
2. Lubricate idler sprockets and drive chains.
3. Check alignment of all sprockets and adjust if necessary.
4. Oil tracking gear.
5. Check bolts and set screws for tightness. (Including drum end-cap)
6. Check chain tension and adjust as needed.

MAINTENANCE Calendar Model GFO									
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# WARNING

IT IS THE RESPONSIBILITY OF THE PURCHASER OF THIS MACHINERY TO TRAIN HIS OPERATING PERSONNEL IN THE PROPER MANNER OF OPERATION.

IT IS FURTHER UNDERSTOOD THAT A.I.T. ASSUMES NO RESPONSIBILITY FOR INJURIES, DISABILITIES OR DEATH RESULTING FROM IMPROPER OPERATION OF, REMOVAL FROM, OR THE BYPASSING OF ANY ELECTRICAL OR MECHANICAL SAFETY DEVICES INCORPORATED IN THE DESIGN AND MANUFACTURING OF THIS MACHINERY.



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# SAFETY NOTICE

The Model 7240 is equipped with a hand safety device at the entrance point of this machine. This device is for the safety of the machine operator.

**DO NOT REMOVE THIS DEVICE!**

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## **1.0 GENERAL INFORMATION - MODEL 7240**

### **1.1 INTRODUCTION**

Congratulations on your purchase of the 7240 Series Rotary Heat Transfer Printer. The 7240 Series Printer has been designed with both quality and simplicity in mind to give you many years of trouble free service. Please remember that regular preventive maintenance of your 7240 Series Printing Press will assure you of a long and profitable working life for your machine.

This manual has been written to assist you with setting up, operating and maintaining your heat transfer printing machine.

### **1.2 PARTS AND SERVICE**

Should you require parts or service, our technicians in the Parts and Service Department will be glad to help you. They can be reached at the following address and phone number:

Advanced Innovative Technologies  
530 Wilbanks Drive  
Ball Ground, Ga. 30107  
(770) 479-1900 tel.  
(770) 479-4179 fax  
sales@aitequipment.com

When contacting our Parts and Service Department, please be sure to have the model and serial numbers of your machine handy to help in identifying the correct parts. It would be a good idea to record those numbers below for future reference.

MODEL NUMBER: \_\_\_\_\_

SERIAL NUMBER: \_\_\_\_\_

530 Wilbanks Drive, Ball Ground, Ga. 30107  
(770) 479-1900 tel. (770) 479-4179 fax



### 1.3 ACCEPTING DELIVERY

Before accepting delivery of the machine from the freight carrier, carefully unpack and inspect the machine for any damage which may have occurred during shipping and handling. Please remember that your machine was accepted by the freight carrier from A.I.T., Inc. in good condition and with all parts intact. Therefore, any damage is the responsibility of the freight carrier. Make a note of any damage on the bill of lading before you sign it and immediately contact the freight carrier for information on making a claim.

### 1.4 MANUFACTURER'S WARRANTY

A.I.T warrants to the first user of each new A. I. T. product or component that such product or component is free from defects in materials and workmanship, subject to the limitations set forth below. IN LIEU OF ALL WARRANTIES EITHER EXPRESSED OR IMPLIED, INCLUDING WITHOUT LIMITATION ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, WHICH A.I.T. HEREBY DISCLAIMS, THE OBLIGATIONS OF A.I.T. UNDER THIS WARRANTY ARE EXPRESSLY LIMITED TO THE FOLLOWING:

- a. A.I.T. will repair or replace, at its option, free of charge, any product, component of its products, and any component it sells separately which is installed in A.I.T.'s products within (4) four months after shipment of same.
- b. This warranty does not apply to damage incurred in shipment. Damage incurred in shipment should be reported to the designated carrier. It is the carrier's responsibility to ensure arrival in undamaged condition.
- c. Service labor, when requested in connection with any of the above items covered by this warranty, will be charged for traveling expenses only.
- d. This warranty applies only if the product or component proves to be defective under conditions of normal use. It does not apply to breakage or to defects resulting from accident, alteration, misuse, abuse or improper installation.
- e. This warranty does not include installation of the product or component.
- f. Prior to any return of a product or component, Buyer must receive written authorization to do so from A.I.T. After written authorization, Buyer shall return the defective product or component freight prepaid and A.I.T. will ship the replacement or repaired component freight collect.
- g. This warranty is effective only if the product or component is installed in a location and manner prescribed by A.I.T.'s instructions and only if it is maintained in accordance therewith. This warranty shall become ineffective if the product or component is altered by anyone other than A.I.T.'s employees. A.I.T. neither assumes nor authorizes any person to assume for it, any obligation or liability other than as specified herein.



A.I.T. WILL, IN NO CASE AND UNDER NO CIR-CUMSTANCES, BE LIABLE FOR SPECIAL OR CONSEQUENTIAL DAMAGES, LOSS OF PROFIT OR COMMISSION OR FOR LOSS OR DELAY IN PRODUCTION. Without limiting the generality of the foregoing, A.I.T. will not be liable with respect to furnishing or delay in furnishing any product or component; the use, resale or other disposition thereof; failure to furnish the same or any other cause. A.I.T.'s liability arising out of the supply of any product or component, its use, resale or other disposition or out of any guarantee or warranty, express or implied or any other cause, shall in no case exceed the cost to A.I.T. of the product or component which A.I.T. has agreed to supply All liability of A.I.T. with respect to any product or component shall terminate upon the expiration of the four month period described above.

Failure to give notice of a warranty claim within thirty (30) days from discovery of the defect or to demand arbitration within one (1) year thereafter shall constitute a waiver of all claims by Buyer with respect thereto.

Any controversy or claim arising out of or relating to transactions or orders or breach thereof, including breach of warranty shall be settled by arbitration in Cherokee County, Georgia, pursuant to the rules of The American Arbitration Association. Any award made against A.I.T. shall be limited as provided above. Judgment upon award rendered by arbitration may be entered in any court having jurisdiction thereof. However, at A.I.T.'s option, this paragraph shall not apply to collection by A.I.T. of the price of any product sold or any action related thereto.

## **1.5 MORE INFORMATION ON WARRANTY**

If you would like more information on the above warranty or have specific questions you would like answered, please contact our Parts and Service Department.

## **2.0 INSTALLATION AND SETUP**

### **2.1 INSTALLATION**

NOTE: INSTALLATION SHOULD ONLY BE PERFORMED BY QUALIFIED TECHNICIANS.

#### **2.1.1 POSITIONING AND LEVELING THE MACHINE**

Carefully remove the machine from the skid and position it on a solid surface where operation will take place. Note: Leave sufficient clearances around the machine for material movement and maintenance personnel. If the left side frame is higher or lower than the right side or vice versa, adjust the legs accordingly.

To adjust the legs use a crescent wrench to turn the leg bolt clock-wise or counter clockwise for correcting the height.

### **3.1.2 POWER SUPPLY CONNECTION**

#### **WARNING!**

THE 7240 SERIES MACHINE OPERATES ON AN ELECTRICAL SUPPLY VOLTAGE WHICH CAN SEVERELY INJURE OR EVEN KILL. ALWAYS DISCONNECT THE ELECTRICAL SUPPLY TO THE MACHINE BEFORE REMOVING ANY COVERS OR ATTEMPTING TO SERVICE OR ADJUST THE MACHINE. SERVICING OF THIS MACHINE SHOULD ONLY BE PERFORMED BY QUALIFIED PERSONNEL

The electrical connections should be made by a qualified electrician in accordance with local standards and national electric code for 220 Volt, 3 phase industrial equipment. Bring power supply to wall adjacent to machine. Install breaker. A fused main disconnect switch should be used as a safeguard between the machine and the power supply. Run conduit and wire to machine.

### **3.1.3 AIR SUPPLY CONNECTION**

NOT REQUIRED ON THIS MODEL

### **3.1.4 FINAL CHECK**

Check and test printer thoroughly. If there are any problems or questions, contact the dealer or A.I.T.' customer service.

### **3.2 SETUP**

Take care to perform setup properly. Note: If setup is not performed properly, quality product may not be produced.

#### **IMPORTANT!**

BEFORE OPERATING YOUR MACHINE, ALWAYS BE CERTAIN THAT THE BELT IS CLEAR OF FOREIGN OBJECTS. THESE OBJECTS CAN BE DRAWN INTO THE MACHINE WHEN IT IS RUNNING AND DAMAGE THE BELT AND OTHER PARTS

## ***SECTION 1 - INSTALLATION AND SETUP INSTRUCTIONS***

### **1.1 GENERAL INSTALLATION**

Once the 7240IJ Rotary Transfer Printer has been received, find a suitable location which will allow enough room for servicing from both sides of the machine.

**NOTE: THE 7240IJ ROTARY TRANSFER PRINTER SHOULD BE LOCATED WHERE THERE ARE NO NOTICEABLE DRAFTS. TOO MUCH AIR FLOW CAN CAUSE SIGNIFICANT HEAT LOSS, AND REDUCE THE MACHINE'S PERFORMANCE.**

Remove the 7240IJ Rotary Transfer Printer from the shipping crate and inspect for damage.



***7240IJ Top Feed Version*** for Sheet Loading Transfer Paper with the Image Side Up

### **1.2 ELECTRICAL CONNECTION**

#### **WARNING!**

**THE MODEL 7240IJ ROTARY TRANSFER PRINTER OPERATES ON AN ELECTRICAL SUPPLY VOLTAGE WHICH CAN SEVERELY INJURE OR EVEN KILL. ALWAYS DISCONNECT THE ELECTRICAL SUPPLY TO THE MACHINE BEFORE REMOVING ANY COVERS OR ATTEMPTING TO SERVICE OR ADJUST THE MACHINE. SERVICING OF THIS MACHINE SHOULD ONLY BE PERFORMED BY QUALIFIED PERSONNEL.**

Electrical connections should be made to the supply terminal located in the electrical cabinet. Refer to the appropriate electrical schematic for your voltage configuration. The 7240IJ Rotary Transfer Printer must be directly hard wired to the electrical power source. IN ALL CASES, THE 7240IJ ROTARY TRANSFER PRINTER MUST BE CONNECTED EITHER TO A CIRCUIT BREAKER OF PROPER SIZE OR A FUSED DISCONNECT SWITCH CONTAINING FUSES OF THE PROPER SIZE. A PLUG AND RECEPTACLE IS NOT AN ADEQUATE FORM OF ELECTRICAL DISCONNECTION ACCORDING TO CURRENT ELECTRICAL CODES.

Refer to the serial number located on the input sided of the machine for the correct supply voltage.

Note: The circuit breaker box or disconnect box should be located no further than 20 feet from the machine.



***7240IJ Bottom Feed Version** for Roll to Roll , Including Unwinds for Fabric and Print Paper*

**IMPORTANT!**

THE UNWIND & REWIND ROLL BARS ARE RATED FOR A CAPACITY OF 70lbs.  
IT IS HIGHLY RECOMMENDED NOT TO EXCEED THE LOADING CAPACITY.  
EXCESSIVE LOADING ON THE REWIND ROLL BARS MAY CAUSE DAMAGE TO THE MACHINE.

## **2.1 OPERATING CONTROLS**

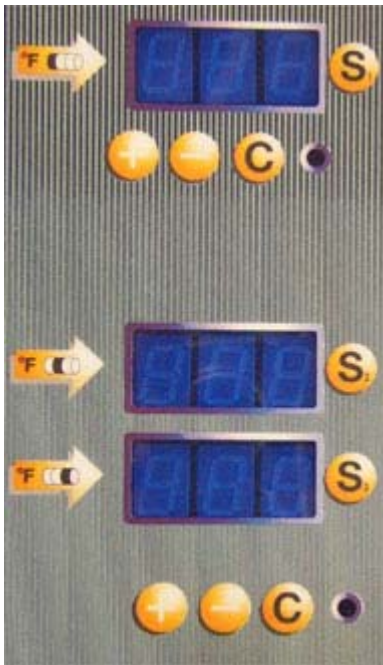
**CAUTION!**

**BEFORE OPERATING YOUR MACHINE, ALWAYS BE CERTAIN THAT THE BELT IS CLEAR OF FOREIGN OBJECTS SUCH AS SCISSORS, CLIPBOARDS ETC. THESE OBJECTS CAN BE DRAWN INTO THE MACHINE WHEN IT IS RUNNING AND DAMAGE THE BELT AND OTHER PARTS.**

*NOTE: BEFORE STARTING THE MACHINE, CONFIRM THAT THE COOL DOWN BUTTON HAS BEEN DISENGAGED.*

1. Turn the Power **OFF (0) / ON (1)** Switch to the **"ON"** position.
2. Press the **POWER ON** button.
3. Rotate the Speed Control Knob to the desired speed (Clockwise to increase, counterclockwise to decrease).





**CAUTION!**

**BEFORE OPERATING YOUR MACHINE, CONFIRM WHETHER THE TEMPERATURE DISPLAYS ARE PROGRAMMED FOR FARENHEIT OR CELSIUS. THE ACTUAL TEMPERATURE CAN BE VERIFIED USING TEMPERATURE INDICATOR STRIPS.**

3. Set the primary (center) and auxiliary (outside) zone temperature displays to the desired operating **SET POINT** temperature. Follow your transfer paper manufacturer's recommendations regarding proper printer temperature and transfer time.

Each heat zone is independently monitored. Each display panel indicates the actual temperature value, unless the **S** (SET POINT) button is pressed to indicate the set point temperature value.

To change the set point temperature, press and hold the **S** button while using the **(+)** and **(-)** buttons to change the value. While keeping the **S** button depressed, press the **C** (CONFIRM) button to enter the new set point value. Release both buttons to complete the change.

4. When the desired Operating Temperature is achieved, run sample prints through the machine.

**Notes:**

**To avoid transferring ink onto the belt and drum, feed blotting tissue or fabric before feeding the transfer paper.**

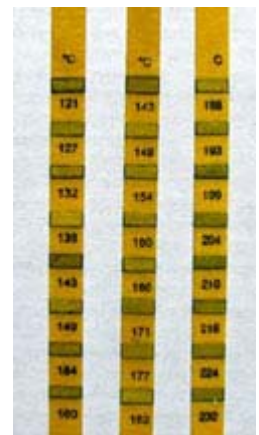
**For each printing operation, some minor adjustments in speed or temperature might be necessary (due to your particular operating conditions and the type and weight of materials you are using) in order to achieve the desired results.**

**2.3 TEMPERATURE CALIBRATION**

To help you in setting proper temperatures on your Astex Model 7240IJ Rotary Transfer Printer, Adams International Technologies makes available through our Parts and Service Department a series of temperature indicator strips. These strips, when run through the Rotary Printer in contact with the drum, change color to indicate the actual temperature of the Drum's surface.

To obtain an accurate reading of the printing temperature inside the machine, Tape a temperature indicator strip face up to the top of a swatch of fabric (approximately 4 - 6 inches in length) and feed into the printer. The piece of fabric allows the operator to pull the Temperature strip off the drum on the exit side (if it sticks to the drum surface).

THE HIGHEST TEMPERATURE WITH A FULL BLACK BACKGROUND IS THE CORRECT TEMPERATURE READING DISREGARD TEMPERATURE SQUARES WHICH HAVE ONLY PARTIALLY CHANGED COLOR



## **2.4 SHUTTING THE MACHINE DOWN**

### **CAUTION!**

**NEVER TURN THE MACHINE OFF FOR ANY LENGTH OF TIME WHILE THE DRUM IS UP TO OPERATING TEMPERATURE. THE HEATER TEMPERATURES INSIDE THE MACHINE MAY DAMAGE THE BELT.**

The 7240IJ Rotary Transfer Printer has an automatic cool down feature which shuts the machine off after the Drum has cooled down. When you are ready to turn the machine off at the end of the day, follow these steps:

1. Press the Cool Down button to start the automatic cool down operation. The belt will continue to turn until the temperature reaches app. 170 F, at which point the machine will automatically switch off.

**NOTE: BEFORE RESTARTING THE MACHINE, THE COOL DOWN BUTTON MUST BE DISENGAGED BEFORE IT IS POSSIBLE TO RESTART THE MACHINE.**

## **2.5 APPLICATION TROUBLESHOOTING GUIDE**

1. Optimum heat transfer printing cannot be achieved unless the temperature, pressure and time settings are accurately adjusted. If the resulting color in your product is not acceptable, check the following:

- a. Temperature: 380-410 degrees F.
- b. Dwell time speed: 40 - 55 seconds

If you continue to experience problems with color, consult with the supplier of your plotter for proper calibration instructions.

2. "Ghosting" is a term used for double imaging. If you experience this phenomenon, check the following:

- a. Make sure that your fabric is heat set prior to printing.
- b. Excessive temperature can cause "blow out" of inks in the gaseous state resulting in ghosting.
- c. Upon exiting the heated drum, the fabric and transfer paper must be separated simultaneously.

3. If you experience wrinkling or uneven pressure in your fabric or transfer paper during the heat transfer process, check the following:

- a. Make sure the fabric and transfer paper have an even cut on the leading edge prior to threading the machine.
- b. Make sure that your rolls of fabric have been supplied with an even edge. Rolls of fabric that have "funneled" edges will not track properly - resulting in wrinkling and uneven pressure.



## **Tracking Adjustments for the 7240IJ**

1. Although the belt tracking is automatically controlled by a photo cell on the left side of the felt belt, some preliminary adjustments may be necessary to make the auto-tracking function correctly.
2. After setting up the machine, and leveling, turn on the machine and watch the edges of the felt belt. The left edge of the felt belt activates a photo cell that in turn moves the tracking roller and causes the belt to travel to the right.
3. If the edge of the felt belt tracks to the right side, adjust the tension roller bolt (figures below) by turning the bolt clockwise to tighten the tension roller on that side.
4. Make small adjustments (usually two or three rounds) and wait between adjustments to allow time for the machine to react to the last adjustment. You may speed up the machine to make the belt react more quickly.
5. The belt should move toward the left side until it reaches the photo cell on the left side which will activate and move the belt back toward the center. If it overrides the left photocell you have over-adjusted the tension roller on the right side and need to back off on that adjustment.
6. When properly adjusted, the belt will naturally track toward the photo cell side & when the tracking roller is activated, the belt tracks toward the center of the machine.





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## Temperature Calibration Model 7240 Trans-19 Temperature Control

1. Set the temperature to 400 degrees F (204 C) and allow the machine to stabilize at that temperature.
2. Once the machine is stable at the set point, put a temp strip thru at each of the temperature probe positions with the face side against the drum. Its best to place the strip on a piece of paper with masking tape at the top of the strip and marked with the position it was put thru the machine. (Left Auxiliary, Center or Main and Right Auxiliary)
3. Compare the actual temperature to the displayed temperature and determine the difference. (Example; display = 400 and temp strip = 390, the difference is 10 degrees lower than set point)
4. Open the panel that covers the temperature control boards (trans-19) and locate the row of 4 temp control potentiometers (small rectangular blue with a small adjustment screw on top. If the board is installed with the large green plug at the top, the first pot on the left and the third from the left will be the only adjustment allowable. Do not adjust any other pot on the board, if unsure call the office for an explanation. Use caution high voltage.
5. On a three-zone heat machine, one board will control one zone and the other board will control two zones. On the single zone board the first pot on the left will control the display, on the two-zone board the first and third pot will control the display. You must determine which pot controls which zone.
6. Turning the pot to the right (clockwise) will adjust the display up and turning the pot left (counter clockwise) will adjust the display down.
7. Turn the pot to make the display match the temp displayed on the temp strip for the appropriate zone. This will make the control accurate.
8. If you have questions about this procedure please call our office for clarification at 770-479-1900 and ask to speak to a service tech.





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## AIT Heat Tape (part #62537)

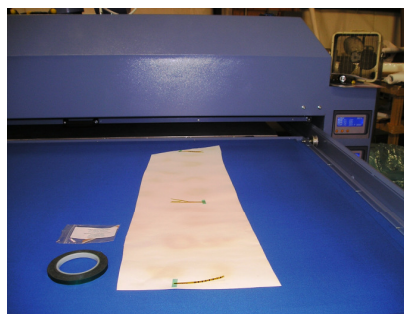
1/2" x 72 yards  
Sell price \$7.75

Green color makes tape placement obvious for both application and removal. Silicone adhesive is very heat resistant and removes cleanly from fabric and many other surfaces.

**Ideal for many dye-sublimation processes:**



Hold transfers in place.  
Prevent ghosting!



3 Zone temperature  
calibration tool



Daily temperature  
chart

530 Wilbanks Drive • Ball Ground, GA. 30107  
(770) 479-1900 tel. (770) 479-4179 fax

# Trans 19 Board

## 7300 7240 Temperature Calibration

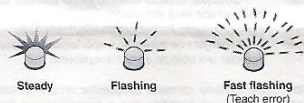
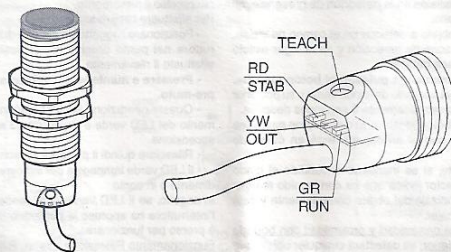




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# Osiris XUB

Osiconcept photo-electric sensors  
 Détecteurs photoélectriques Osiconcept  
 Photoelektronische Sensoren Osiconcept  
 Detectores fotoeléctricos Osiconcept  
 Interruttori fotoelettrici Osiconcept  
 Detectores fotoeléctricos Osiconcept.



RD	Red	Rouge	Rot	Rojo	Rosso	Vermello
YW	Yellow	Jaune	Gelb	Amarillo	Giallo	Amarelo
GR	Green	Vert	Grün	Verde	Verde	Verde

## English

Thank you for choosing Osiconcept technology

Please connect and install the sensor on your equipment as per wiring instructions on package label.

## Français

Merci d'avoir sélectionné la te

Raccordez et installez le détecteur suivant les instructions de l'étiquette de l'emballage.

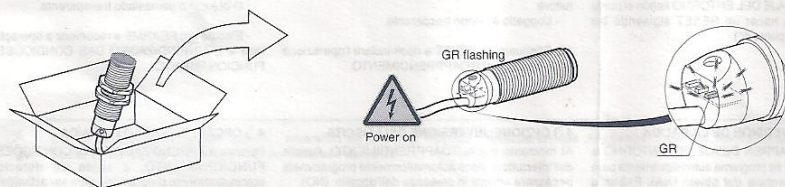
- ① Factory setting: awaiting environment teach mode / Réglage usine: attente apprentissage de l'environnement / Werksseitige Einstellung: Bereit für Teach-in der Umgebungsbedingungen / Preajuste de fábrica: En espera del auto-aprendizaje del entorno / Regolazione di fabbrica: autoapprendimento preciso / Regulação de fábrica: aguarda aprendizagem das condições de funcionamento.

### 1°) INITIAL ADJUSTMENT

Your detector is waiting for the ENVIRONMENT TEACH MODE 2°) procedure to be performed. This is signaled by flashing of the green LED.

### 1°) REGLAGE INITIAL

Le détecteur que vous avez attendu d'APPRENTISSAGE (2°). Cela est signalé par le clign

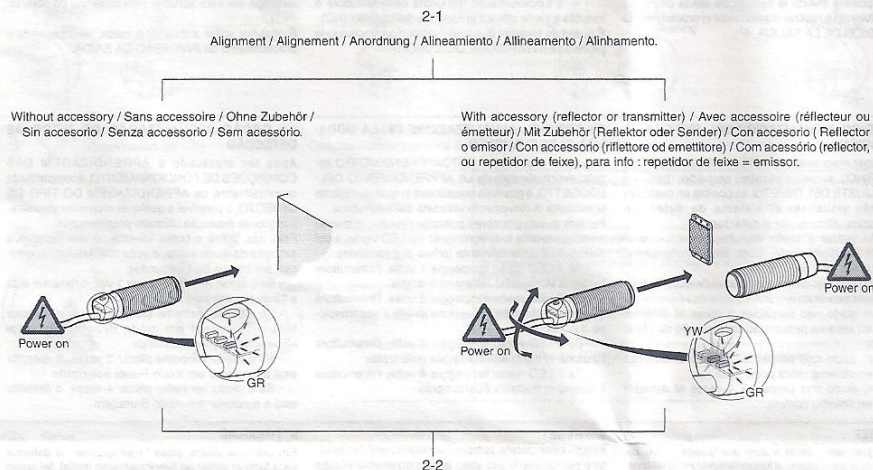


- ② Environment teach mode: Object absent / Apprentissage de l'environnement: absence objet / Teach-in der Umgebungsbedingungen: Objekt nicht vorhanden / Auto-aprendizaje del entorno: ausencia de objetos / Autoaprendimento: Assenza oggetto / Aprendizagem das condições de funcionamento: Ausência do objeto.

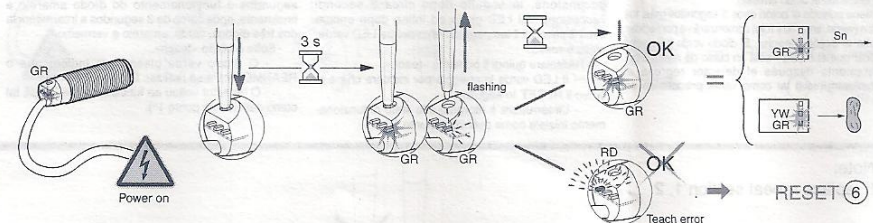
### 2°) ENVIRONMENT TEACH MODE

This detector is capable of functioning in all the standard detection modes, i.e.: Without accessory: Diffuse, Diffuse with background suppression With accessory: (Reflector or Transmitter): Polarised reflex, Thru-beam

2°) APPRENTISSAGE DE L'ENVIRONNEMENT Ce détecteur est capable de les modes standard de la dé Sans accessoire: Proxim effacement de l'arrière-plan Avec accessoire: (Réflecteur polarisé, Barrage



Environment teach mode / Apprentissage de l'environnement / Teach-in der Umgebungsbedingungen / Auto-aprendizaje del entorno / Autoaprendimento / Aprendizagem das condições de funcionamento



Before performing the ENVIRONMENT TEACH MODE procedure, you must align the detector correctly. Remove all objects from the detector's field of detection

Without accessory: place the detector opposite the zone to be detected

With accessory: align the detector on the accessory using the signals provided by the yellow and red LEDs (Yellow LED on and Red LED off signals correct alignment).

You have aligned the detector and it is now ready for the ENVIRONMENT TEACH MODE procedure. To do this:

- Remove all objects from the detector's field of detection
- Press in and hold the «teach» pushbutton.
- The green LED goes out then comes on again after about 3 seconds.
- Release the «teach» pushbutton when it comes on
- The green LED flashes to indicate that environment teaching is in progress.

Then

- If the green LED comes on, the detector has been taught the environment and is ready to function.

The detection mode (Diffuse, Diffuse with background suppression, Polarised reflex, Thru-beam) is memorized, and the INITIAL SETTING can only be restored by a RESET

Any object passing within its detection field (in front of a background or between the detector and the reflector or transmitter) will be detected; the Yellow LED comes on and the output is activated.

If the red LED starts flashing very rapidly, the environment teaching procedure has failed:

- The detector may be misaligned
- An object passed within its detection field during teaching
- The background or the reflector is too close to the detector

Readjust the alignment conditions, perform a RESET 6°) then repeat the ENVIRONMENT TEACH MODE procedure.

Avant de procéder à l'APPRENTISSAGE DE L'ENVIRONNEMENT, il est nécessaire d'aligner le détecteur correctement. Éliminez tout objet dans le champ de détection

Sans accessoire: placer le détecteur en face de la zone à détecter

Avec accessoire: aligner le détecteur sur l'accessoire en utilisant les signaux jaunes et rouges (diode Jaune s'allume et diode Rouge s'éteint = alignement correct)

Vous avez aligné le détecteur et il est maintenant prêt à réaliser l'APPRENTISSAGE DE L'ENVIRONNEMENT. Pour cela:

- Éliminez tout objet dans le champ de détection
- Appuyez et maintenez enfoncée la touche «teach».
- La diode verte s'éteint puis s'allume à nouveau après environ 3 secondes.
- Relâchez la touche «teach» quand la diode verte s'allume
- La diode verte clignote pour indiquer que l'apprentissage de l'environnement est en cours.

Ensuite:

- Si la diode verte s'allume, le détecteur a appris l'environnement et est prêt à fonctionner.

Le mode de détection (à l'arrière-plan ou entre le détecteur et le réflecteur ou l'émetteur) est mémorisé, et le réglage initial ne peut être rétabli qu'à l'aide d'un RESET 6°)

Tout objet passant dans son champ de détection (devant un arrière-plan ou entre le détecteur et le réflecteur ou l'émetteur) sera détecté; la diode Jaune s'allume et la diode Verte s'éteint. Si la diode Rouge commence à clignoter très rapidement, la procédure d'apprentissage de l'environnement a échoué:

- Le détecteur peut être mal aligné
- Un objet est passé dans son champ de détection pendant l'apprentissage
- L'arrière-plan ou le réflecteur est trop proche du détecteur

Revenez aux conditions d'alignement, effectuez un RESET 6°) puis répétez la procédure d'APPRENTISSAGE DE L'ENVIRONNEMENT.

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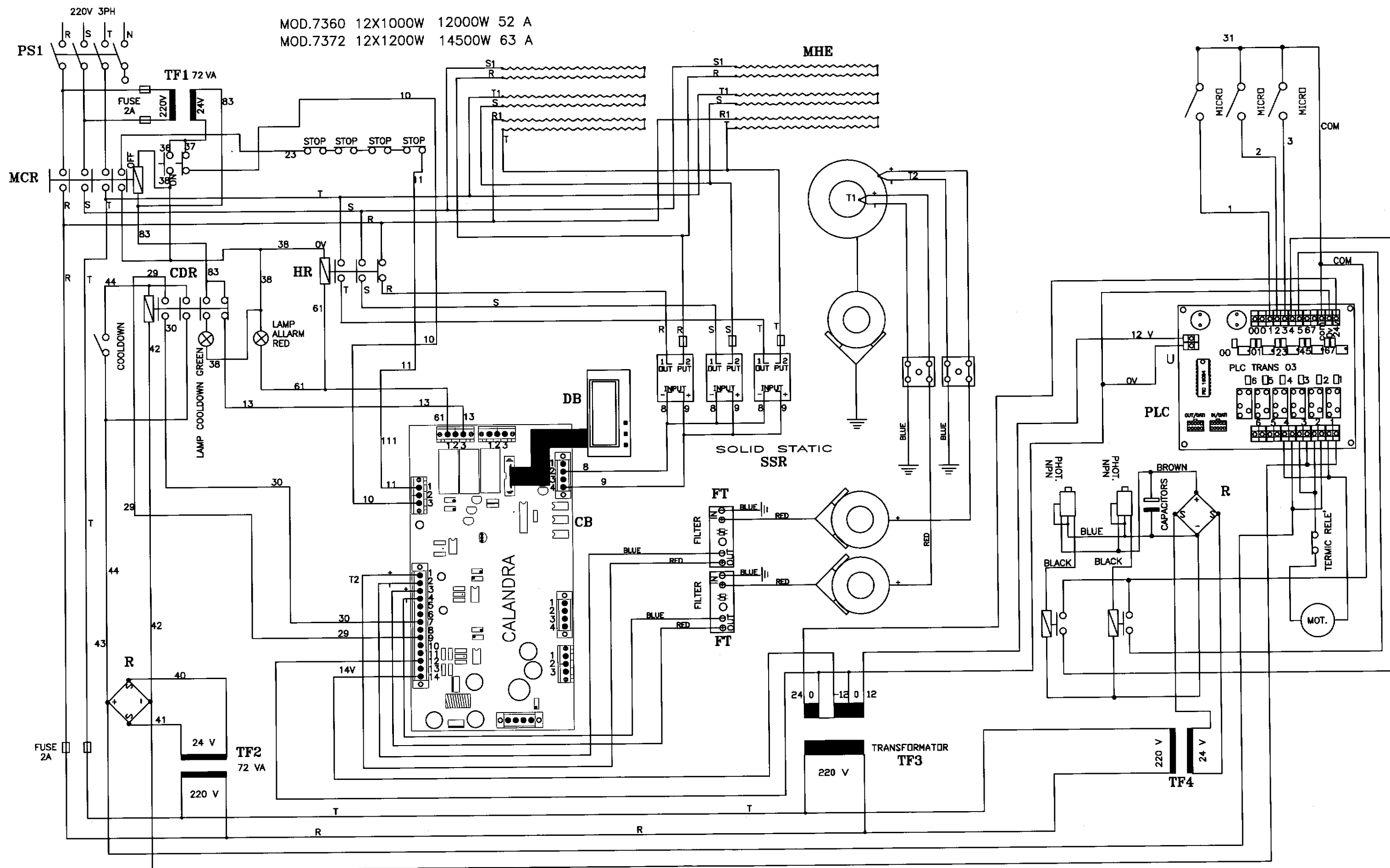
Revenez aux conditions d'alignement, effectuez un RESET 6°) puis répétez la procédure d'APPRENTISSAGE DE L'ENVIRONNEMENT.

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LEGEND MOD. 7240-7360-72

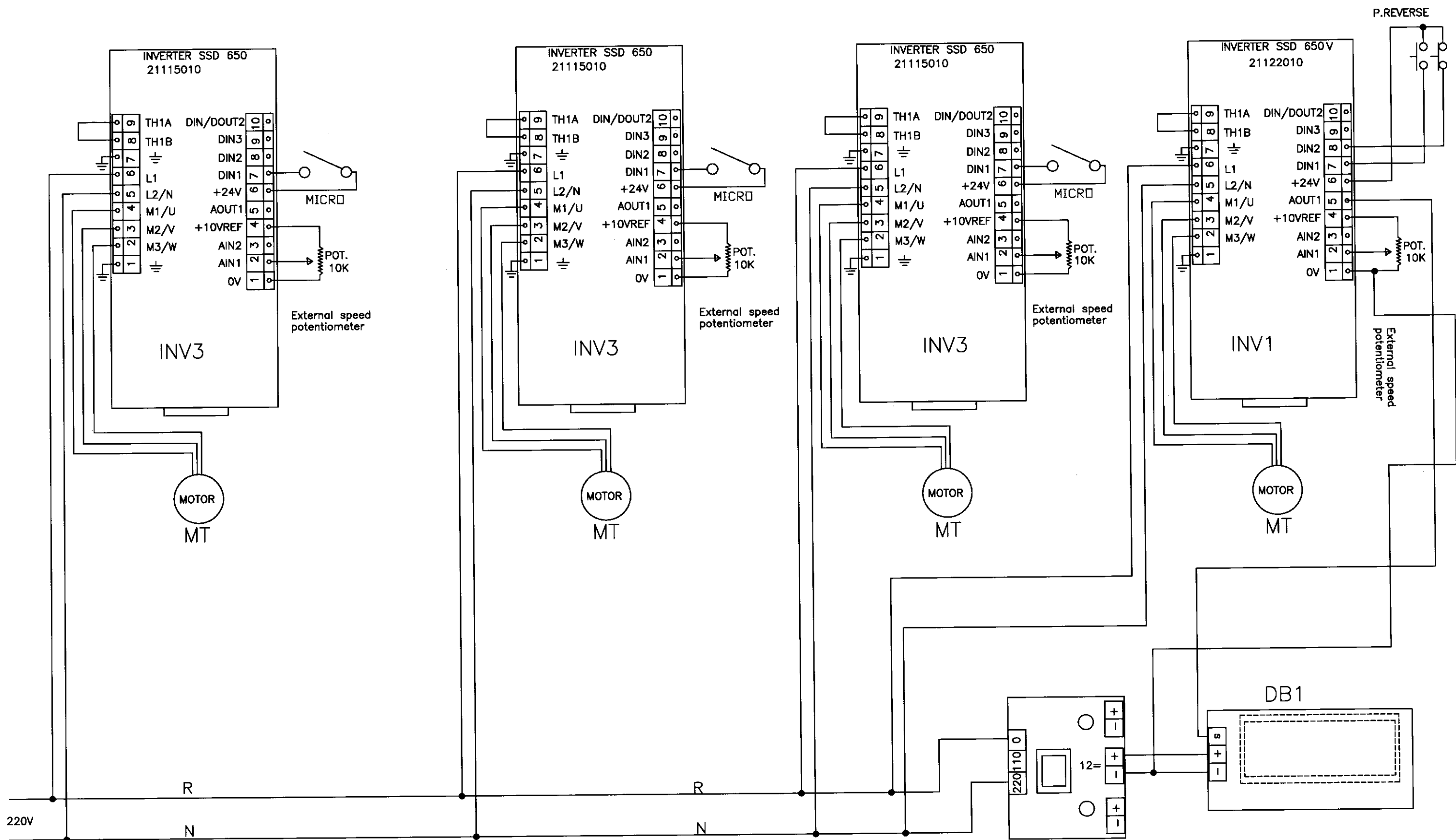
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SCHEMA ELETTRICO/ELECTRIC DIAGRAM MOD. 7360-7372 OIL 220V 3PH





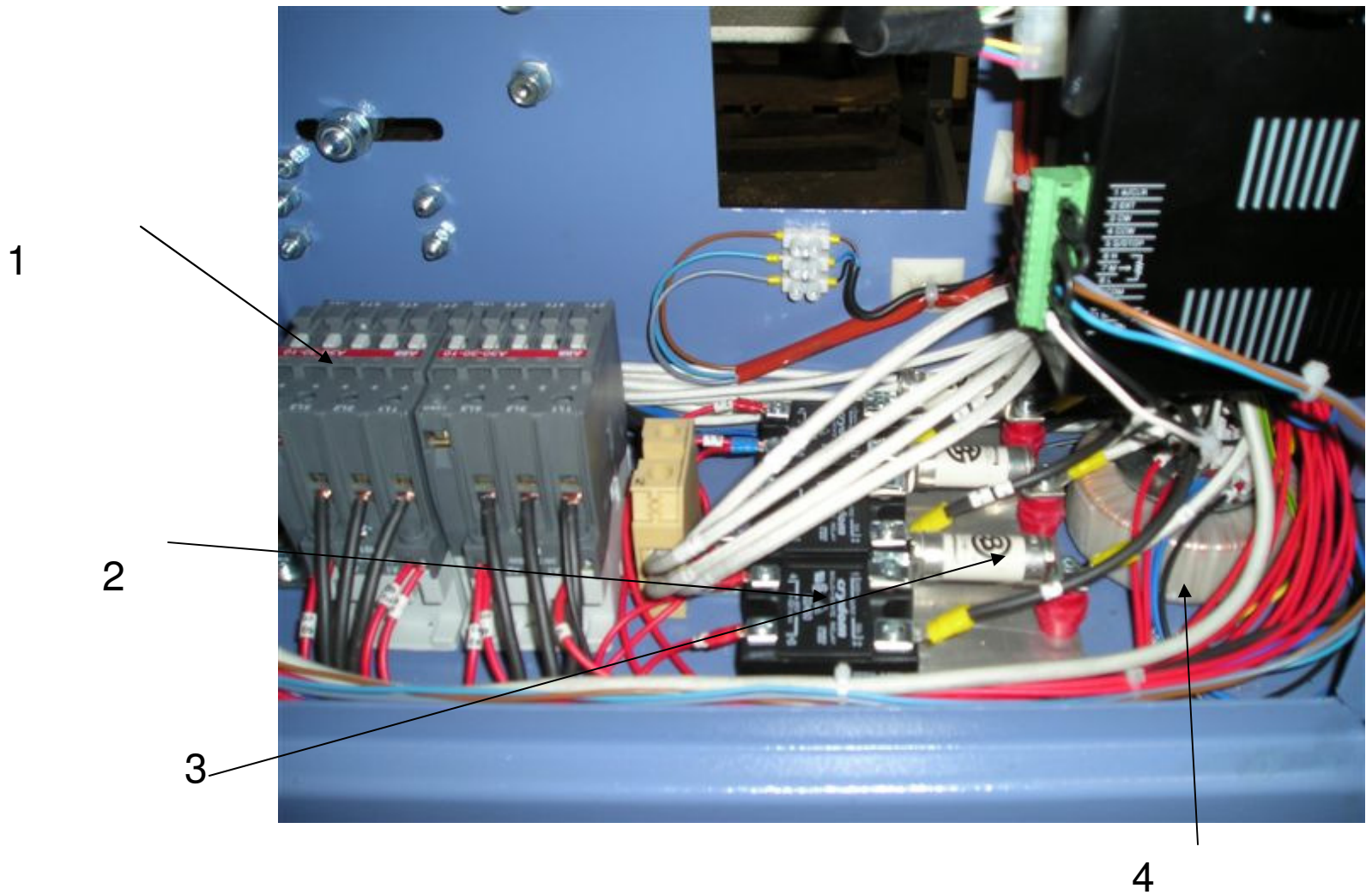
# SCHEMA ELETTRICO / ELECTRICAL DIAGRAM MOD.7240/7360/7372



7240 Parts Manual  
Part List Feb 07

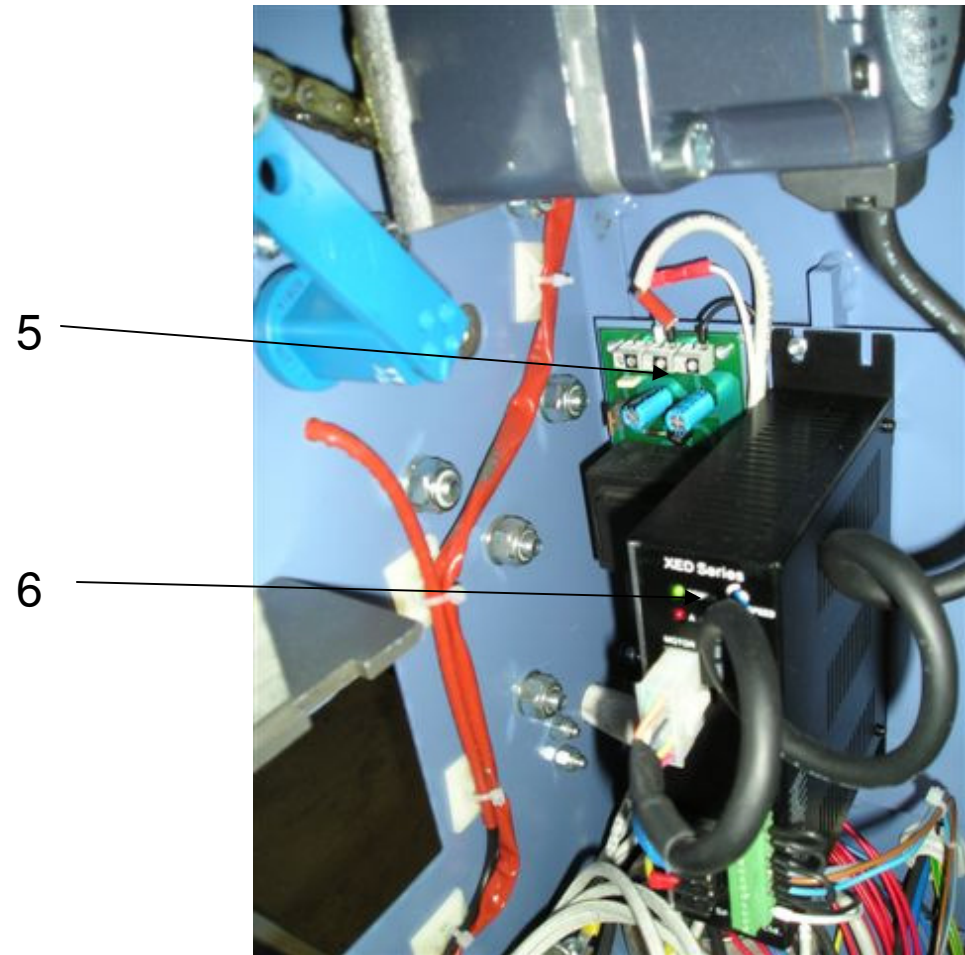
Reference #	Part #	Description	Notes
1		Contactor (2)	
2		Relay SSR (3)	
3		Fuse	
4		24V Transformer	
5		Power Supply for Inverter	
6		Inverter	
7		Rate Meter	
8		Speed Control	
9		On / Off	
10		E-Stop	
11		Motor Sprocket (not shown)	
12		Chain	
13		Drive Sprocket	
14		Drum Bearing	
15		Chain Tension Sprocket	
16		Drive Motor	
17		24V Transformer	
18		12 / 24V Transformer	
19		Capacitor	
20		Rectifier	
21		Thermal Protection	
22		Relay (3)	
23		Trans 19 Board	
24		Trans 19 Board	
25		Trans 04 Tracking Board	
26		EPROM	
27		Bearing Tracking Roller	
28		Tracking Motor	
29		Proximity Switch (3)	
30		Shaft Locking Mechanism	
31		Shaft W Bearing	
32		Cone	
33		Bolt for Cone	
34		Clutch, Unwind	
35		On Bulb	
36		Off Bulb	
37		Power Disconnect	
38		Heat On Switch	
39		Heat Off Switch	

# 7240 - 1

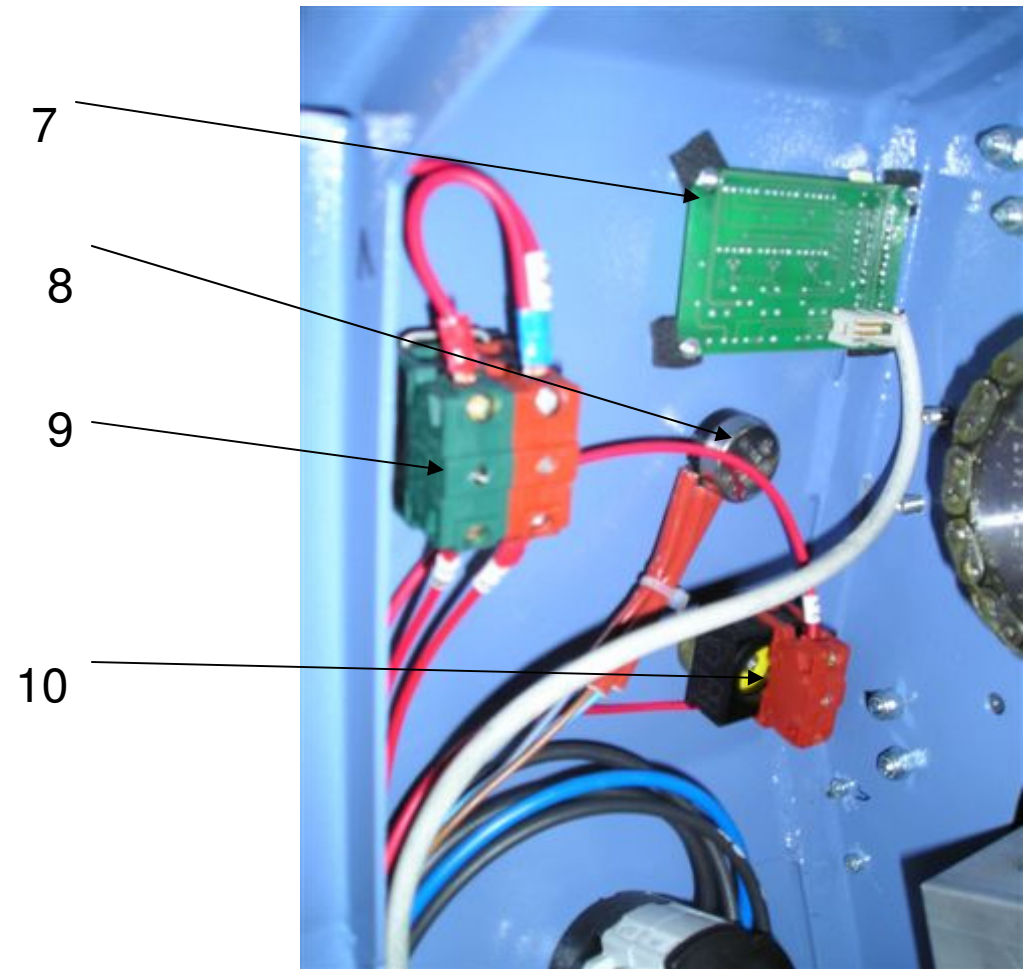




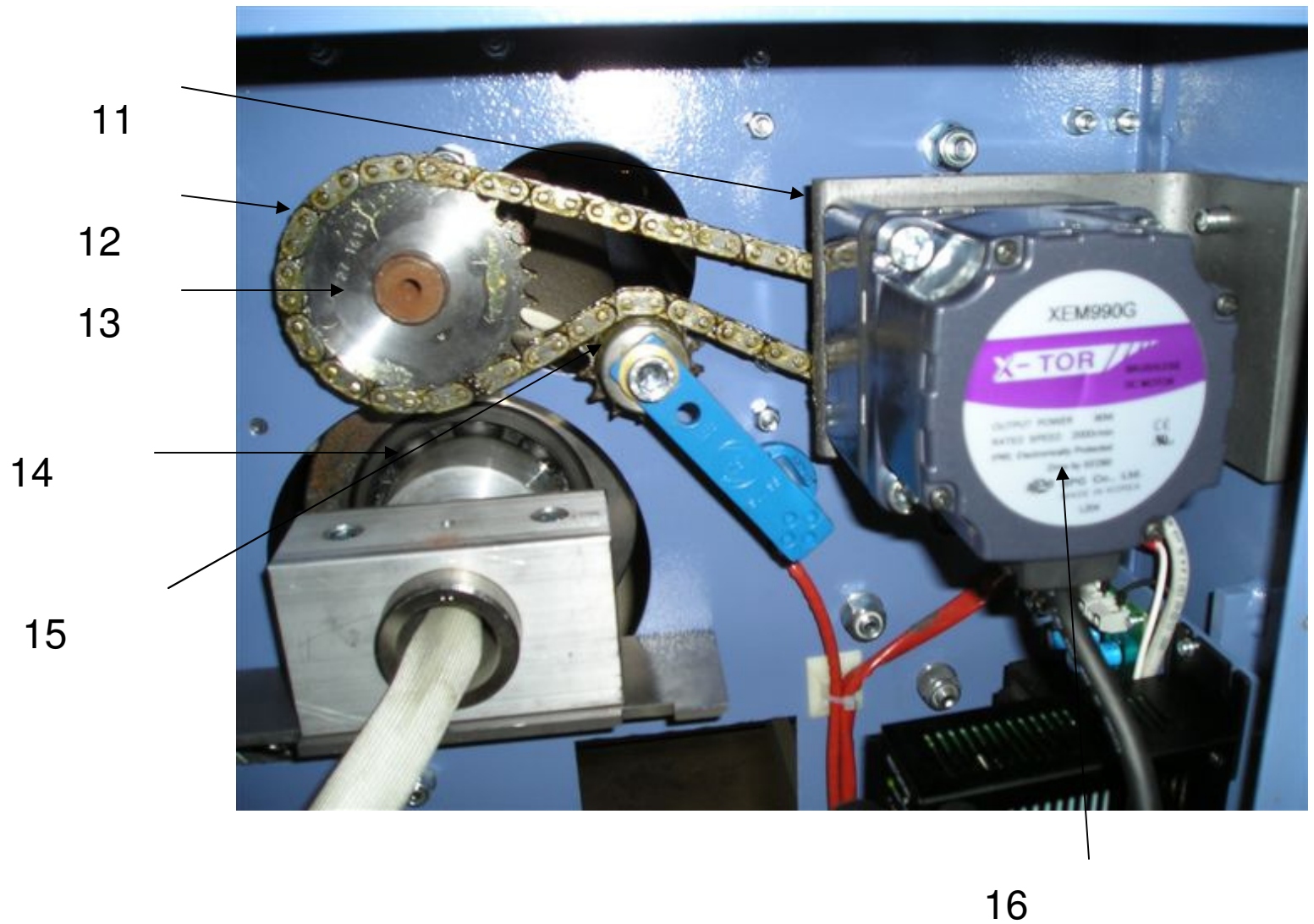
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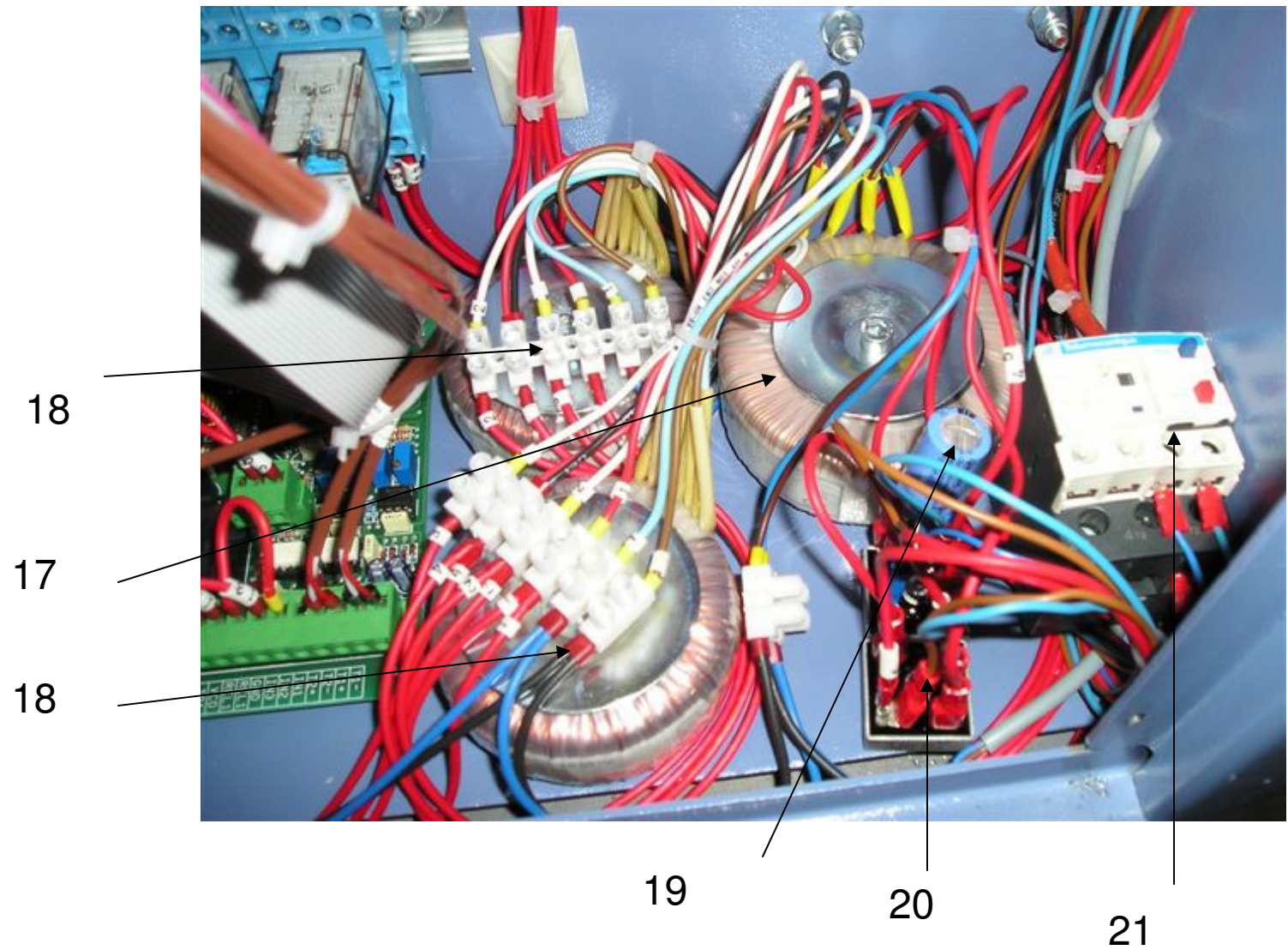


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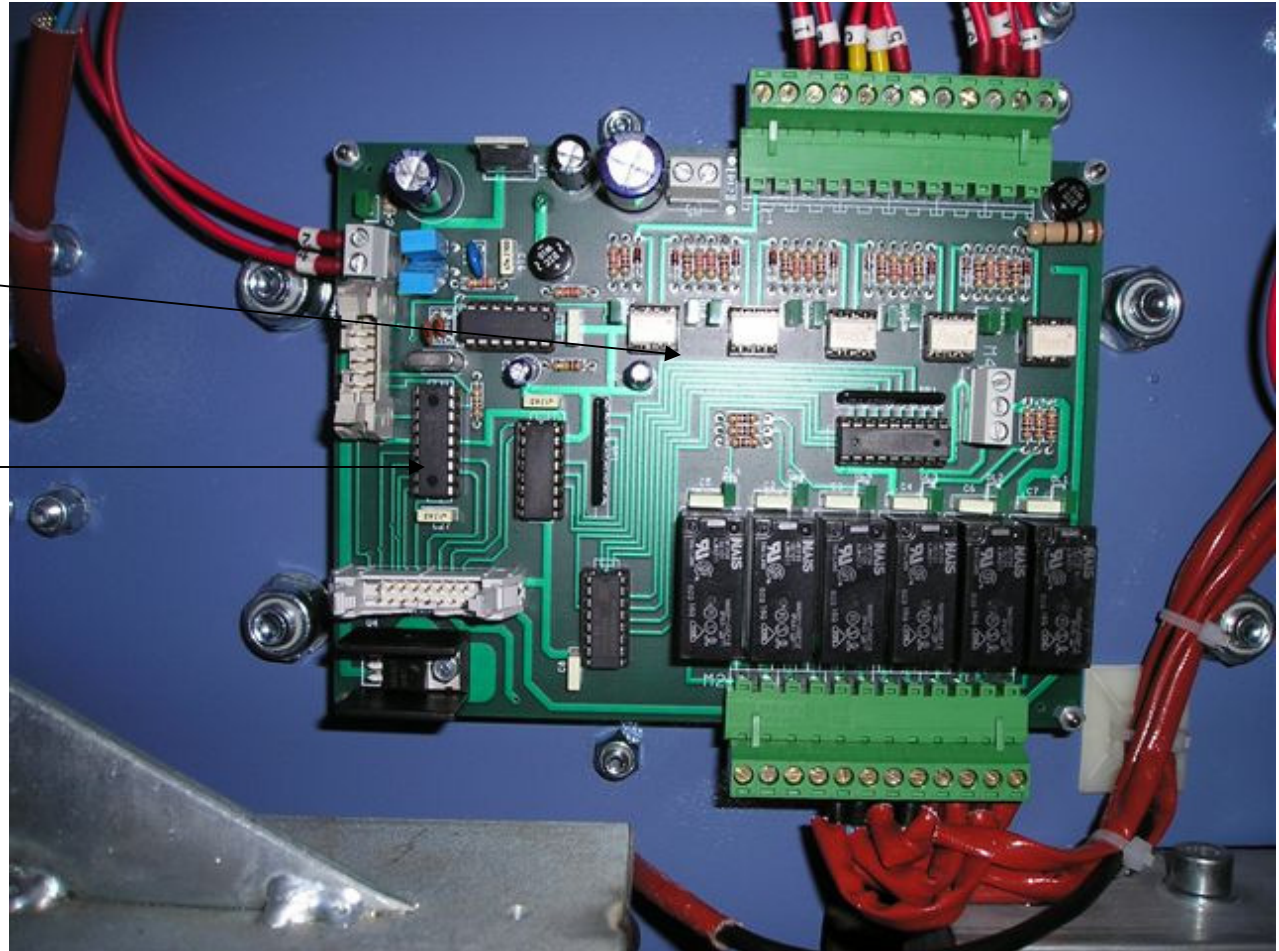
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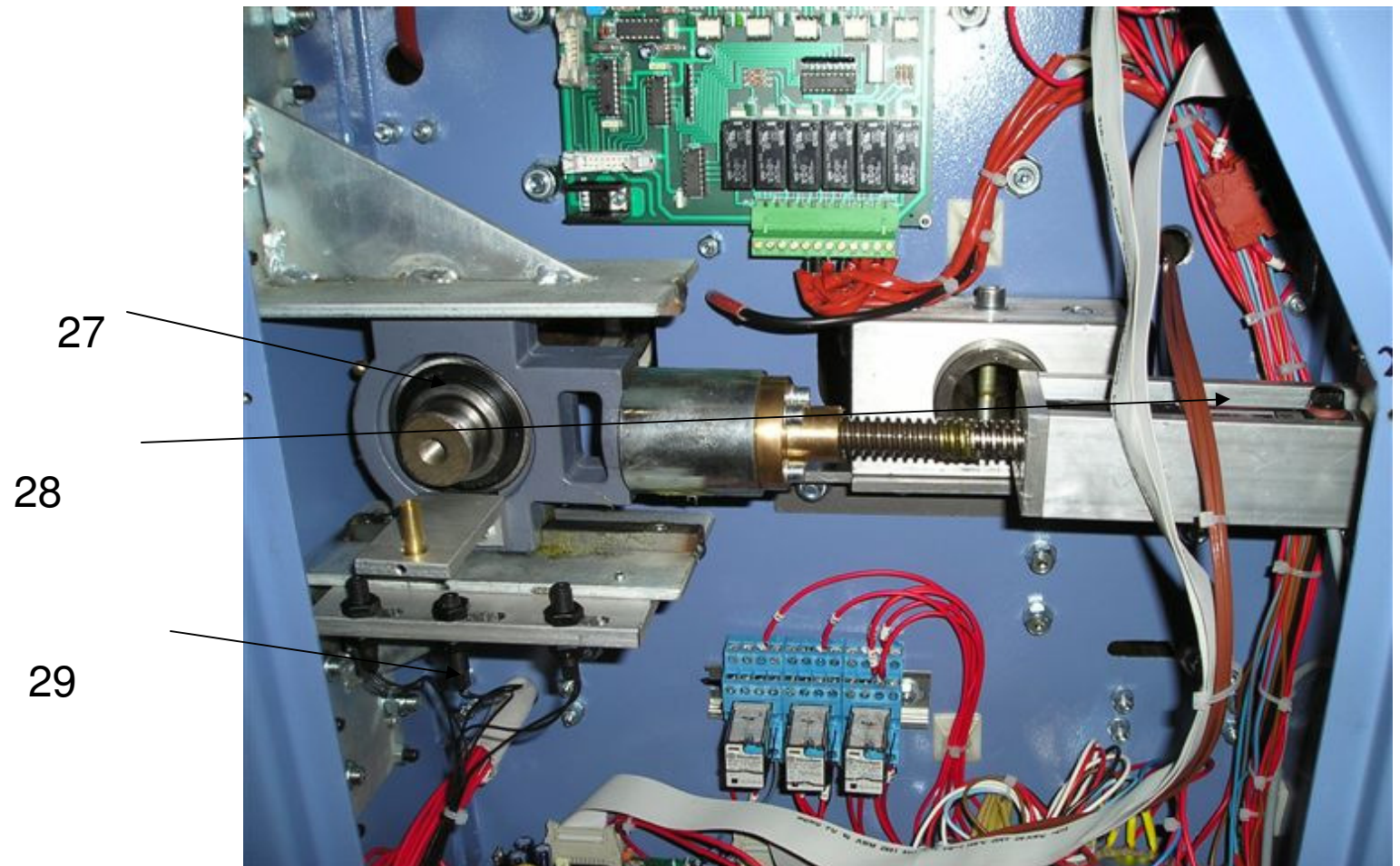
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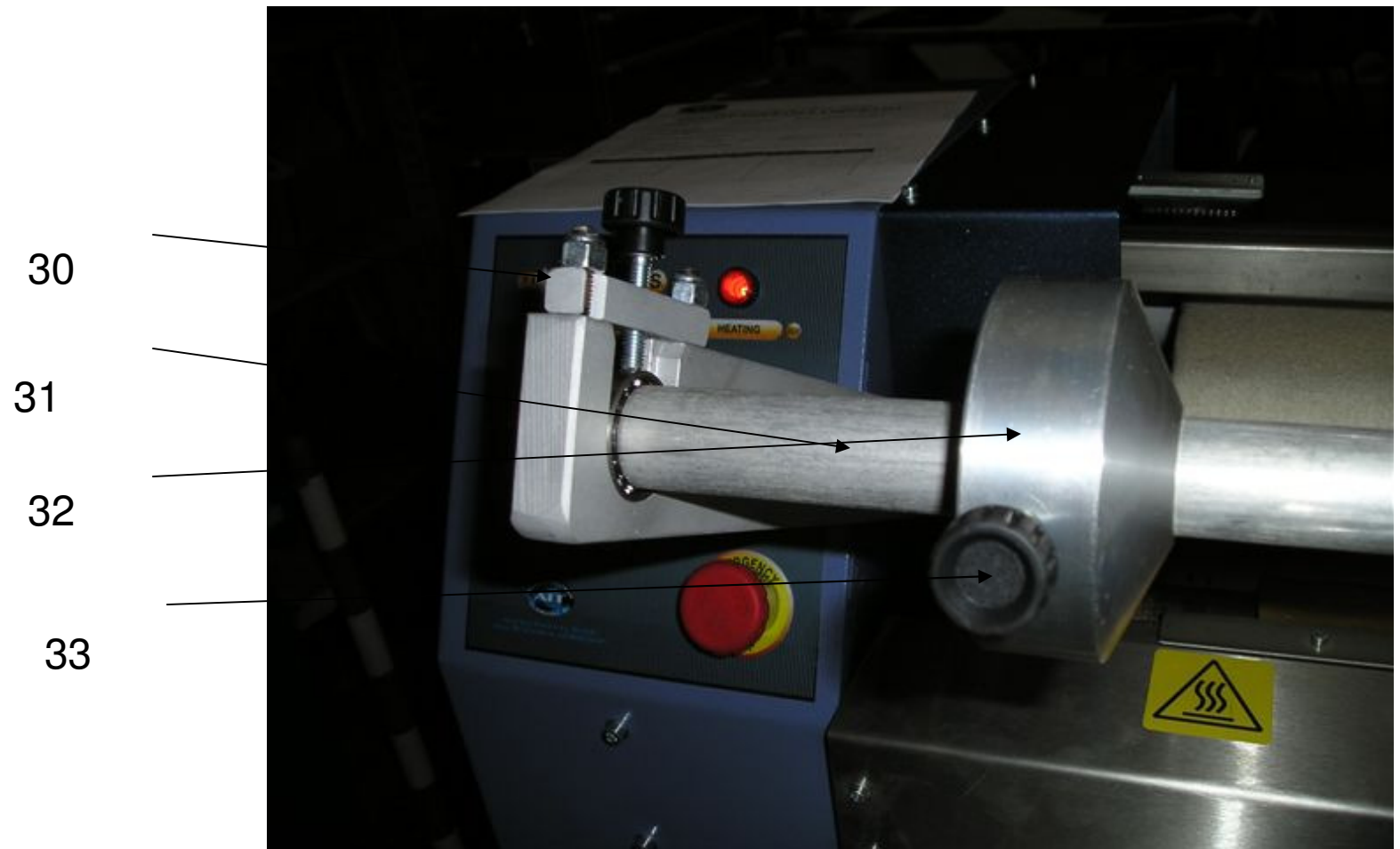
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# 7240 - 8



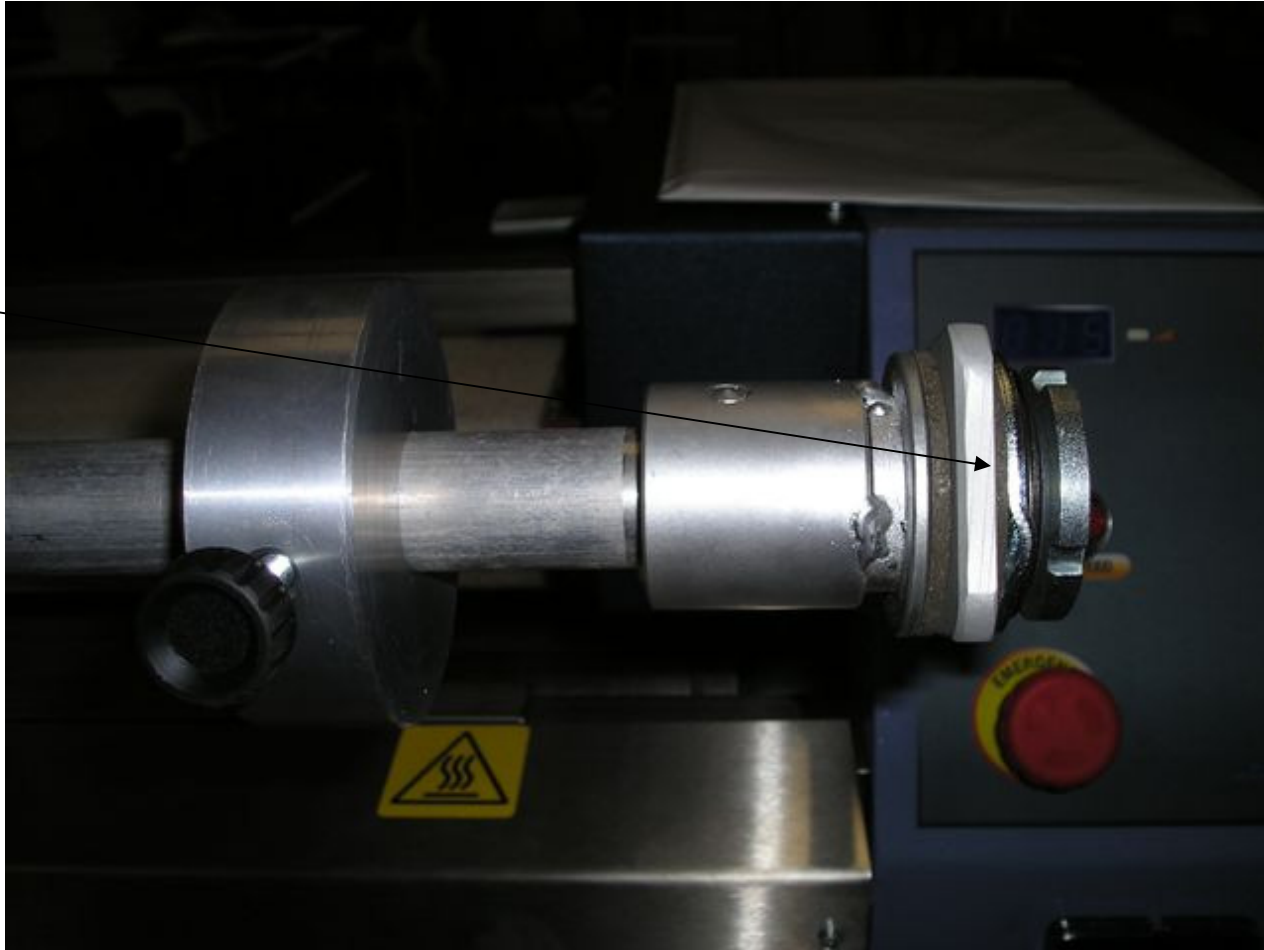
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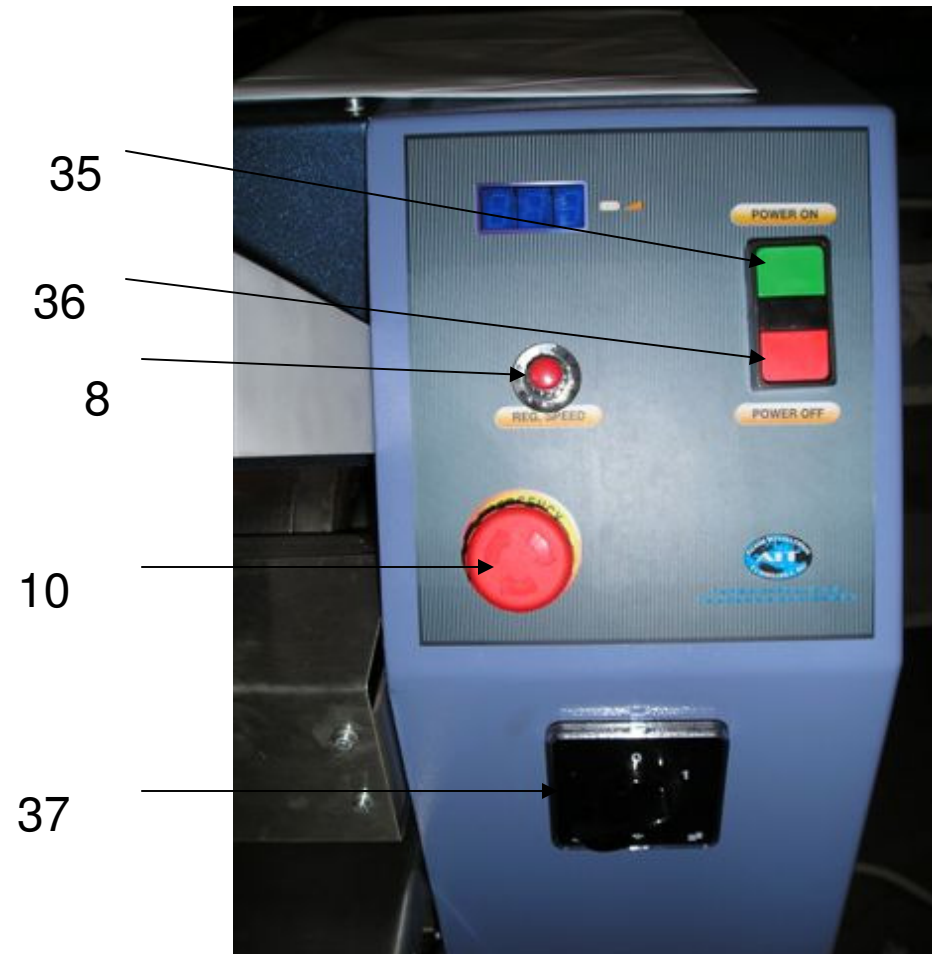


7240 - 10

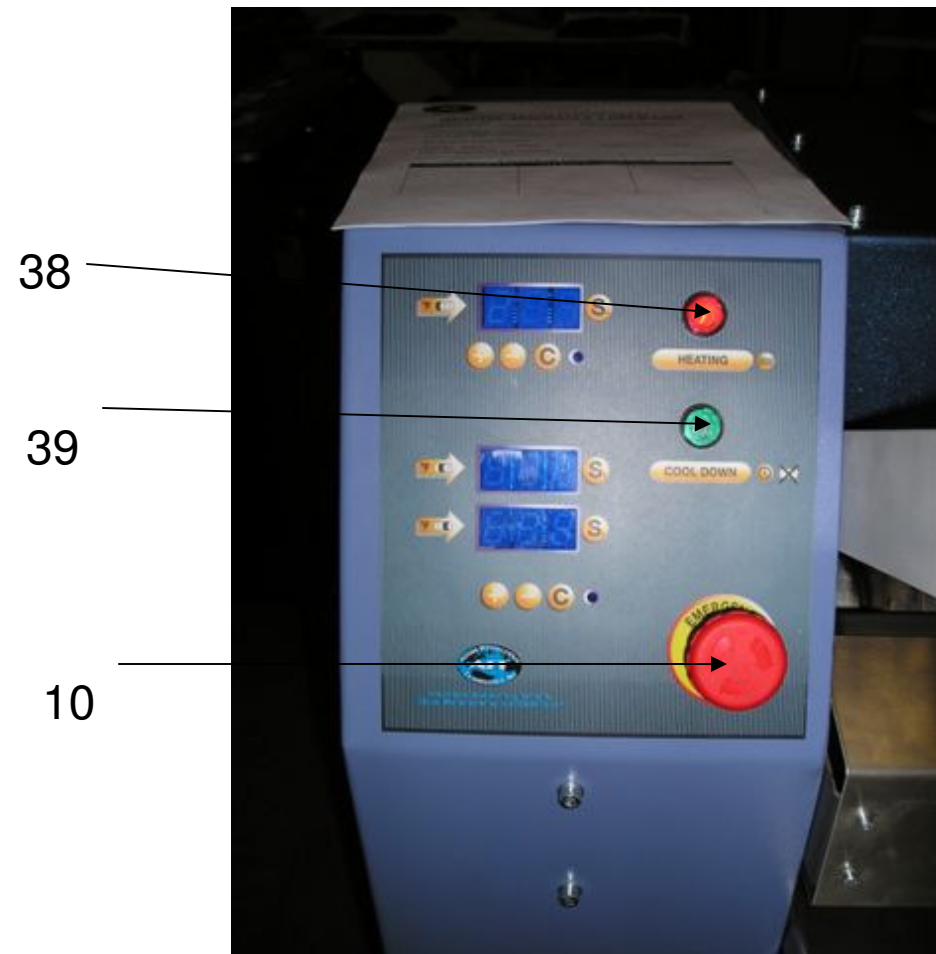
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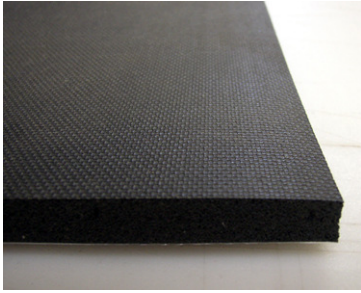
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# 7240 - 12

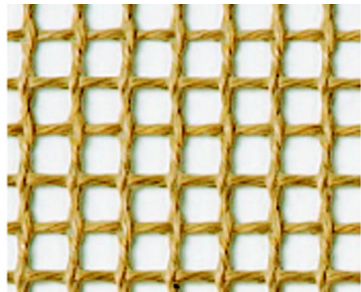


# AIT, LLC.



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The key ingredient to superior quality digital sublimation printing can often be the pad! AIT offers a complete range of high temperature padding materials, along with belting and tray cover materials for most models of heat transfer printers. We specialize in custom-made solutions according to your specific needs. Call us today for a quotation.



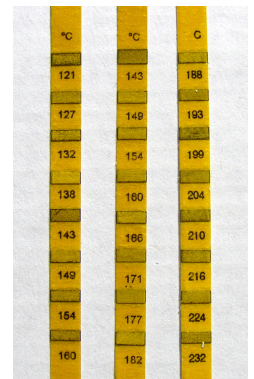
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- ☑ High Temperature Felt Padding and Endless Belting
- ☑ Nomex Cloth and “Molten” Pad Protector
- ☑ PTFE Coated Screen Belting for Conveyor Systems
- ☑ Custom-made Teflon and Canvas Conveyor Belts
- ☑ Roll Stock up to 72” Teflon Belting
- ☑ “Super Blue” Conductive Rubber Transfer Membrane for Sublimation Printing of Rigid Substrates

## **TEMPERATURE CALIBRATION STRIPS**

**PACK OF 40 - \$25.95**

AIT offers three types of temperature test strips to accurately measure the actual temperature of fusing machines and heat transfer printers.

AIT recommends a check of temperature calibration controls at least once per week for all fusing machines and heat transfer printing machines to ensure the best quality results.



	Temperature Range F°	Temperature Range C°
TYPE 1 Temperature Strips	250 - 320 F	121 - 160 C
TYPE 2 Temperature Strips	289 - 360 F	143 - 182 C
TYPE 3 Temperature Strips	370 - 450 F	188 - 232 C

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