HOLO

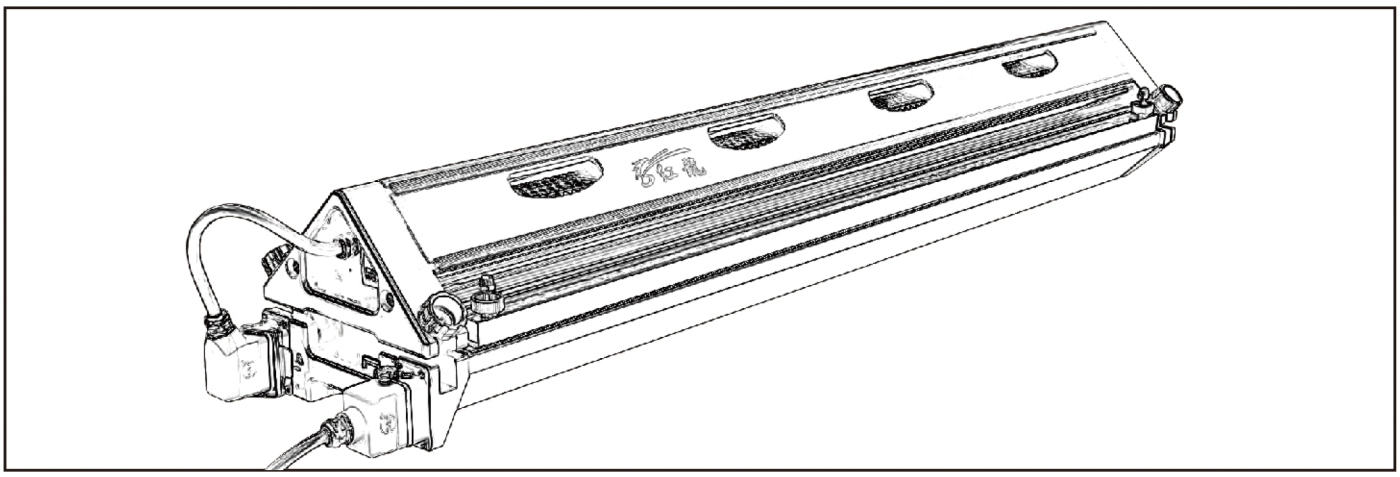
Splice press

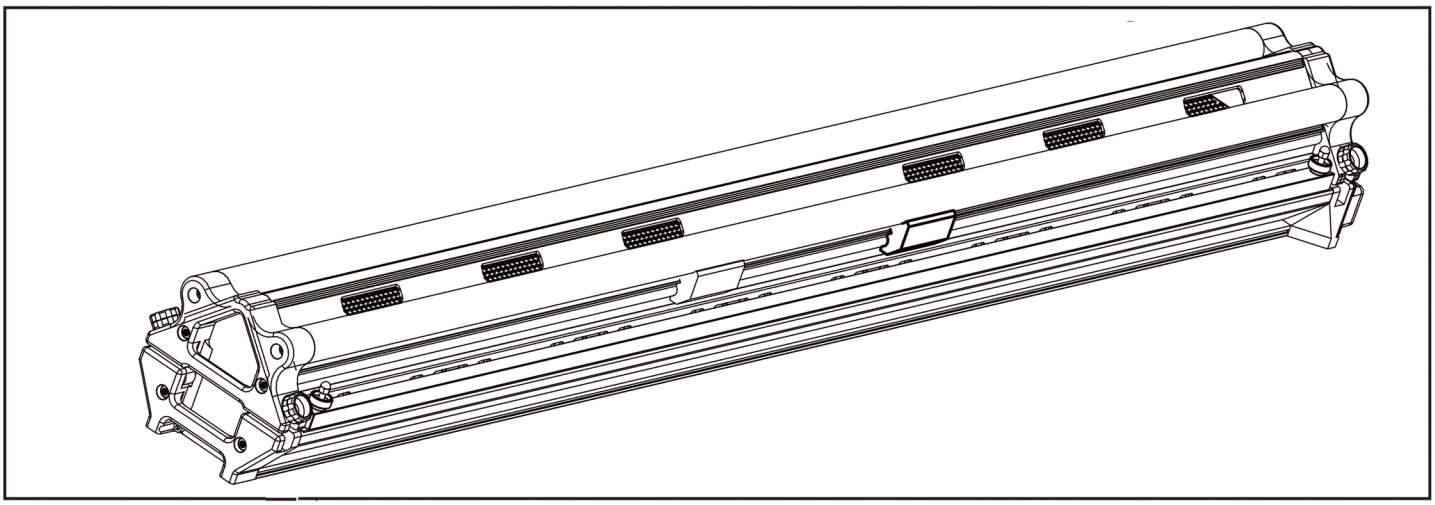
Safety and Operation Manual

Quick Joint All-in-one Machine Vulcanizing Press

PA300 – PA600 – PA900 – PA1200 – PA1500

PA1200H – PA1500H – PA1800H – PA2100H



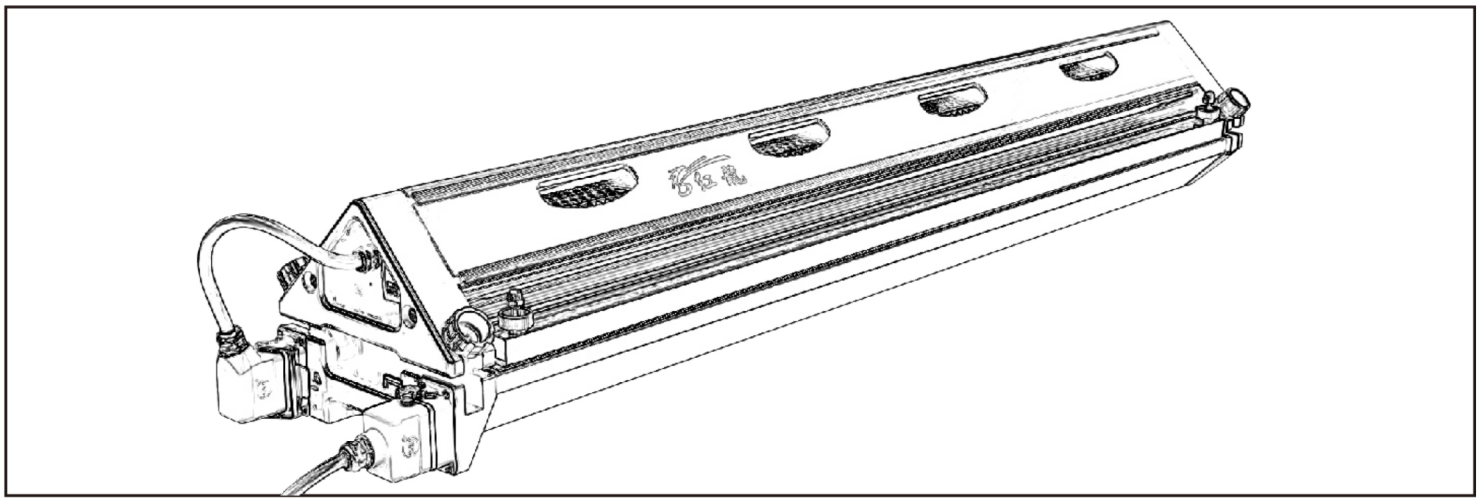


WARNING

IMPROPER OR UNSAFE use of this tool can result in serious bodily injury! This manual contains important information about product function and safety. Please read and manual available for other users and owners before they use the tool. To understand this manual BEFORE operating the tool. Please keep this is manual should be stored in a safe place.

Quick Joint All-in-one Machine Vulcanizing Press

Be sure to read and completely understand this procedure before applying product.
Be sure to select the proper PREFORMED product before application.



CONSIDERATIONS:
This Application Procedure is valid for PLP Compression Splice (CMPSP) Assemblies on ACSR Conductors only.

TOOLS SPECIFICATIONS:

1. 300mm effective(12")
2. 600mm effective(24")
3. 900mm effective(36")
4. 1200mm effective(48")
5. 1500mm effective(60")
6. 1800mm effective(72")
7. 2100mm effective(84")

MAIN COMPONENTS

- Clamp Bar Studs & Thumbnuts
- Top Press Beam
- Handle
- Press Connector Bolts
- Clamp Bar
- Bottom Press Beam
- Start Button (green)
- Eurotherm Heat and Time Controller
- Umbilical Power Cable Connector
- Pressure Controller
- Pressure Relief Button (red)
- Main Power Cable Connector

FEATURES AND BENEFITS:

The PA series air cooled press, have different models for width from 300 mm to 2100 mm

1.Used for pvc belt etc. thermoplastic belt materials portable splice press, light weight and with flight case as standard packing, is easily removed to any where for job site use

2.Fast splicing: include heating time and cooling time, only 9-12 mins.

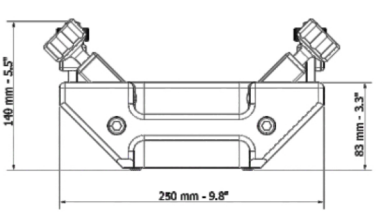
3.All In one design: the press has an integrated air-cooling system and also air compressor inside, to ensures that the belt is quickly cooled down and auto press on, without water pump or additional air compressor.

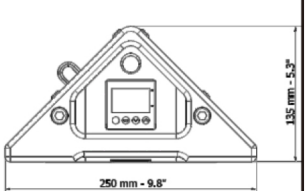
4.Light weight

5.Easy to use and assemble, how to operate pls freely to refer to below video.

6.Reliable and automatic temperature control with time control (in one meter, also you can set by yourself), air pressure controller (set the air pressure and display the current pressure)

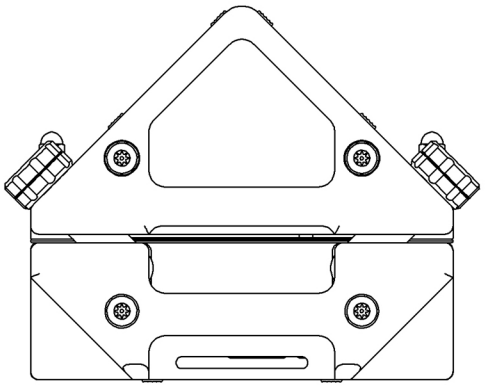
7.Voltage: 220v or 380v, if special voltage pls freely to inform us.



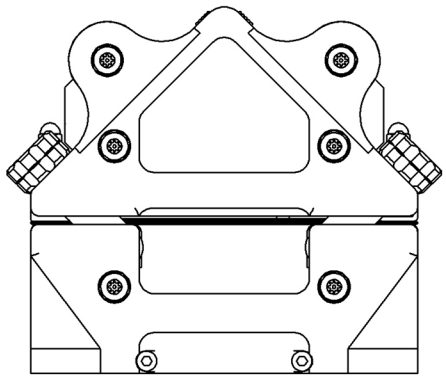


DATASHEET AIR COOLED PRESS

Model	PA 300	PA 600	PA 900	PA 1200	PA 1500	PA 1500H	PA 1800H	PA 2100H
Effective length	305mm / 12″	610mm / 24″	914mm / 36″	1219 mm / 48″	1524 mm / 60″	1524 mm	1829 mm	2200 mm
Effective width	130mm / 5.1″	130mm / 5.1″	130mm / 5.1″	130mm / 5.1″	130mm / 5.1″	130mm	130mm	130mm
Weight upper part	10 kg	16 kg	20 kg	28.5 kg	30 kg	45KG	63.3kg	72 kg
Weight lower part	11 kg	13 kg	18 kg	25.5 kg	30 kg	53kg	47.5 kg	67kg
Total weight	21 kg	30 kg	38 kg	54 kg	62 kg	100 kg	121 kg	142kg
Overall Height	220 mm	225 mm	225 mm	225 mm	225 mm	255 mm	255 mm	255 mm
width						250mm	250mm	250mm
Length	505 mm	805 mm	1105 mm	1405 mm	1705 mm	1700 mm	2005 mm	2300 mm
Max. pressure	1.5 Bar / 22 PSI	1.5 Bar / 22 PSI	2 Bar / 28 PSI	2 Bar / 28 PSI	2 Bar / 28 PSI	2 Bar / 28 PSI	1 Bar / 14.5 PSI	1 Bar / 14.5 PSI
Max. temperature	200 °C / 390 °F	200 °C / 390 °F	200 °C / 390 °F	200 °C / 390 °F	200 °C / 390 °F	200 °C / 390 °F	200 °C / 390 °F	200 °C / 390 °F
Power(仅作参考）	1.2 kW	3.2 kW	4.5 kW	5.8 kW	7 kW			
press+case weight	39KG	52kg	66kg	80kg	95kg	132KG	158kg	188kg
press+case+wooden box weight	50kg	72kg	89kg	104kg	115kg	153KG	190KG	225KG
wooden box size （L*W*H）	790*430*420	1090*430*420	1390*430*420	1720*450*430	1990*430*420	1990*430*520	2130*450*520	2500*450*520

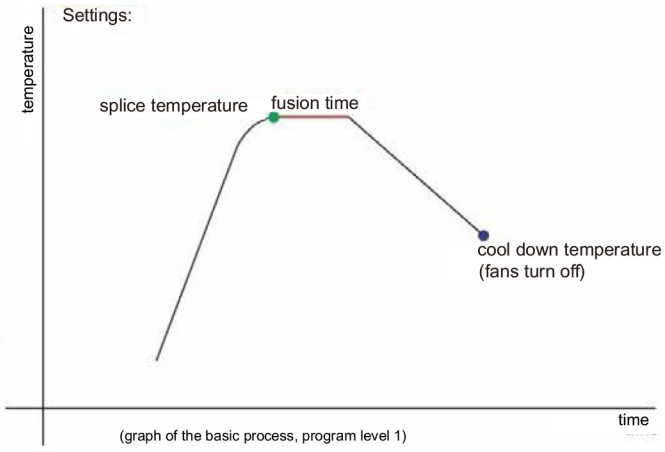


PA300-PA600-PA900
PA1200-PA1500

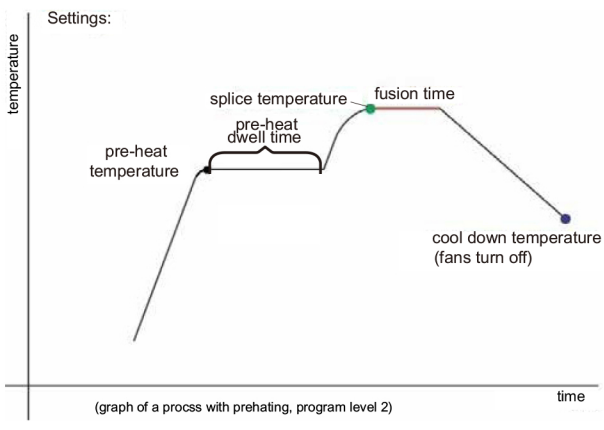


PA1200H-PA1500H
PA1800H-PA2100H

Inside to reach the required temperature. Melted material might flow away or discolor and fabrics might shrink. To avoid this problem, the preheat option can be used. This option heats the belt up (outside and inside) to a temperature just below the melting temperature. After the preheat stage, the inside splice temperature can be reached much quicker, minimizing the risk for unwanted flow of material, discoloring or fabric shrinkage.



(graph of the basic process, program level 1)



(graph of a procss with prehating, program level 2)

** The reading of the display relates to the top temperature of the press. If more or less heat is required at the bottom of the belt, the “bottom heat factor” can be used. Please note that this factor relates to a plus or minus amount of heat (%), not to a specific temperature.

Table of Contents

Flight Case.....pg.4-5
Level 1 heating operation.....pg.6-10
Level 2 heating operation.....pg.11
Common problems and solutions.....pg.12

Flight Case

1.HOLO® PA press are supplied with a flight case for both storage purposes and also for easy transport to on-site jobs.
2. Place press in the flight case so the end with the power receptacles is facing the storage compartment. This will protect the receptacles from damage when transporting.
3. Flight case for the PA 300-900 have two wheels. PA 1200-2100 are packaged in flight cases with four wheels and an extension handle.
4. Flight cases can be stacked on top of each other, but need to be secured during transportation.
5. PA 1200-2100 flight cases feature an extended handle for ease and convenience in transport. Click in the grip of the flight case to release the handle.



General Safety Rules

Save These Instructions

Signal words:

"DANGER" indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury. The signal word is limited to the most extreme situations.
"WARNING" indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.
"CAUTION" indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.

Safety Symbol

This international safety symbol is used to identify and call attention to specific safety matters.

Safety Information

To Avoid Severe Personal Injury or Property Damage, read carefully and understand the following Safety Precautions.

Overall Safety rules

⚠DANGER

To Avoid Severe PersonalInjuryor Property Damage, read carefully and understand the following Safety Precautions.

⚠DANGER

Terminate electrical hazards by removing power cord from wall receptacle or machine base inlet.

⚠WARNING

Terminate pressure related hazards by pressing the red pressure relief button.

⚠CAUTION

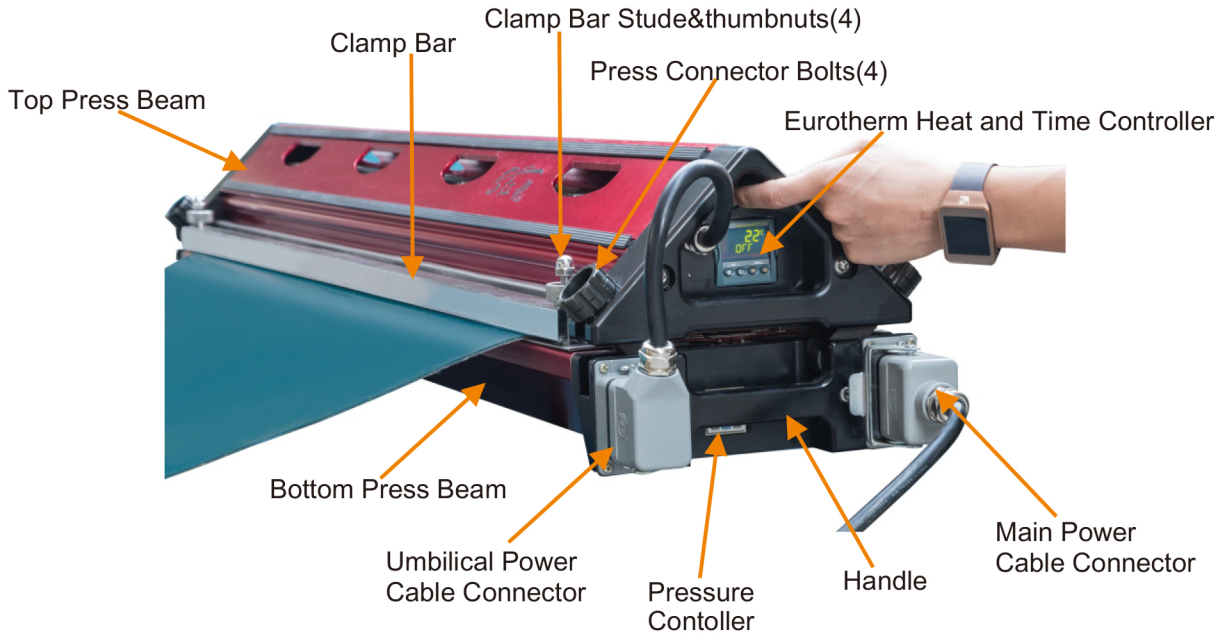
Press platens develop over 5 tons of clamping force. When operating the press keep the four press connector bolts in place by hand tightening.

⚠CAUTION

Avoid temperature related hazards by handling press components and belt once safely cooled.

MATTERS OF PARTICULAR

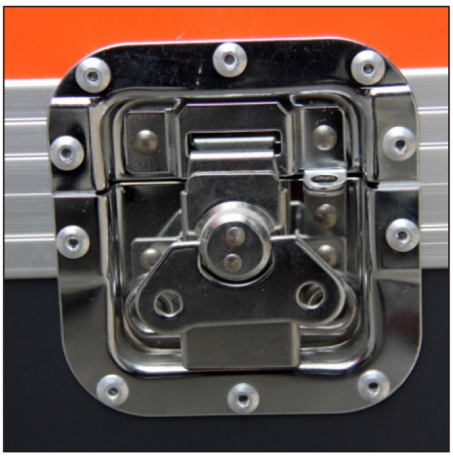
This manual will be referred to the key components of the following, if failed to account for the location, please refer to the map to understand.





UNLOCK AND OPEN

Open the box and carried out the simple steps of the machine, the machine weight of different length is different, need two or more people to pay attention to the bottom of the box out, locking universal wheel when in operation

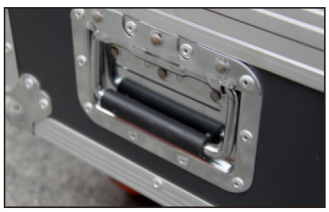














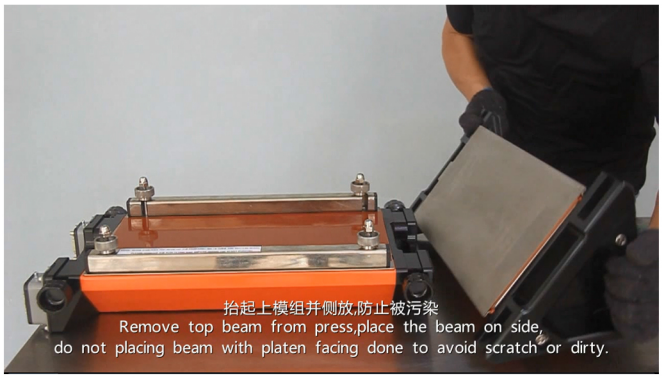








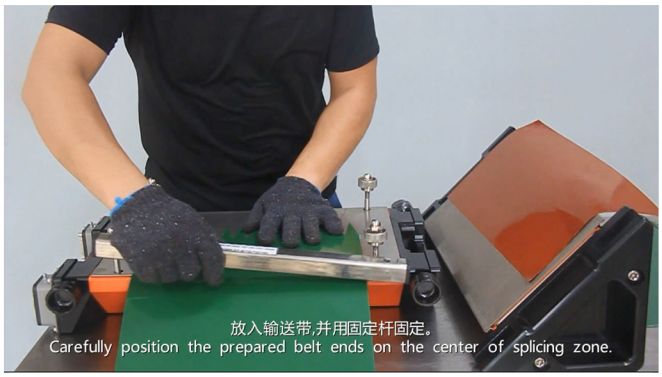
1.Lossen Press Connector Bolts

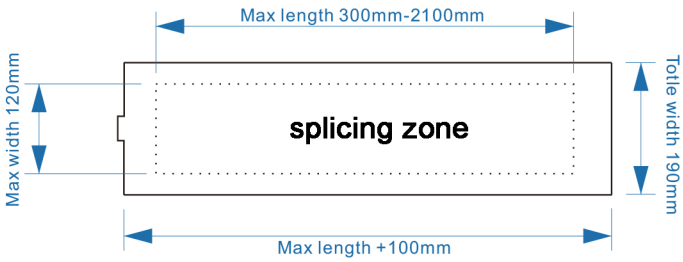


2.Remove top beam,do not placing beam with platen facing done to avoid scratch or dirty



3.Remove the clamp bars





4.Carefully Position the prepared belt endson the center of splicing zone



5.Make sure the finger tips are tightly meshed without gaps



★6.Put the same belt material to fill remain splicing platen surface on each end of the press





7.Put the Teflon,Pay attention to keeping the Teflon flat,No wrinkles



8.Carefully position top beam onto prepared belt ends and Lock.



9.Remove the Clamp bar.★Inorder to protect the clamp bar from Bending.

Note:When the air pressure come up,the machine will be bended a little bit,It will make the clamp bar bending,so the clamp bar will be bended (broken) during Long-term heating and bending.





10.Insert cable connector into machine and engage latch.



11.Connect main power cable to connector and power supply.



12.Setting



1.Syetem Button (Level 2) Usually don't need
2.Function switch button
3.UP
4.Down



13.Set Splicing Temperature (SPL.T)



14.Set Splicing Dwell time (SPL.DT)



15.Set Cooling Temperature (CLD.T)



16.Set Temperature

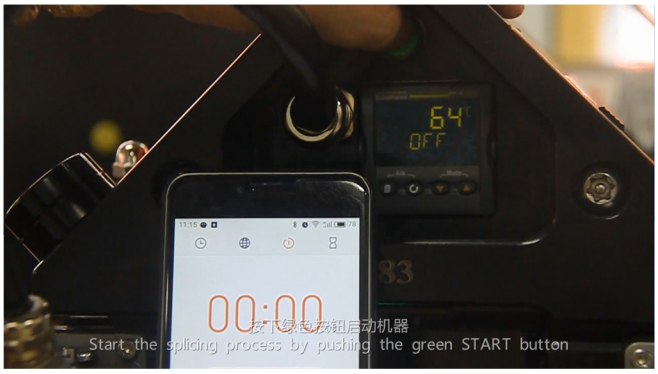


1. UP 2.Function switch button 3.DOWN

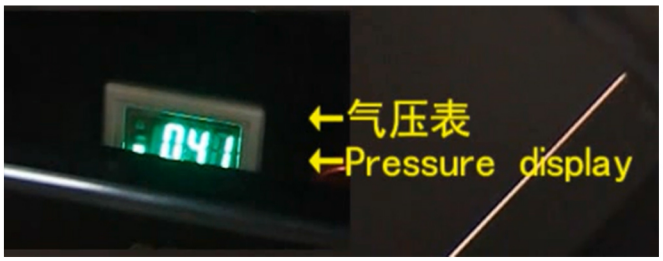


★Do not use high pressure!!!
Suggestion is around 1bar,usually is 1~1.2bar.
★Finished the pressure setting,Switch back to the display interface





17.Start (Press 1~2 seconds)



18.Observe whether the barometer is displayed normally

★We suggest you do not use more than 1.2bar pressure,the pressure is higher than the setting during the heating,it is normal phenomenonce because of the Thermal expansion and contraction of air.



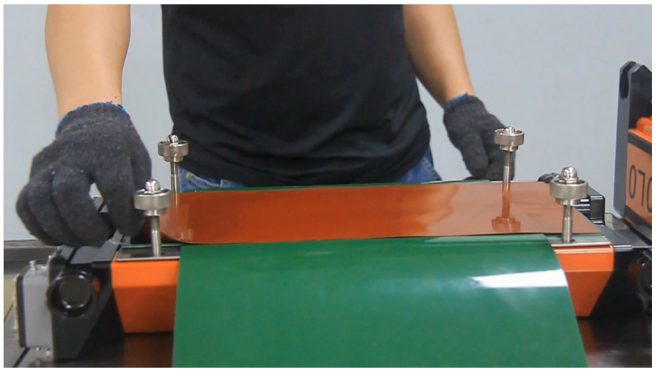
19.Joint work finished ,release pressure (Red Button)



20.Disconnect power cable

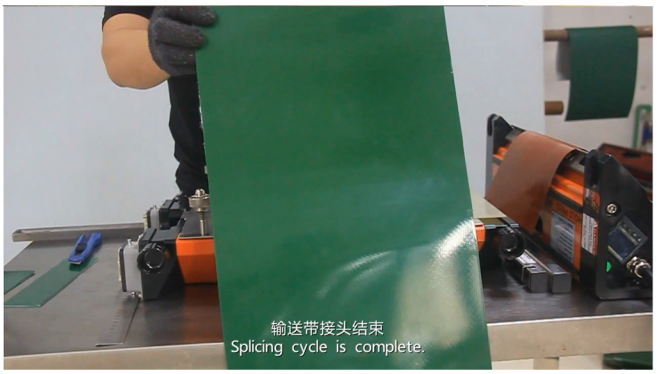


21.Losse four bolts,remove top beam.

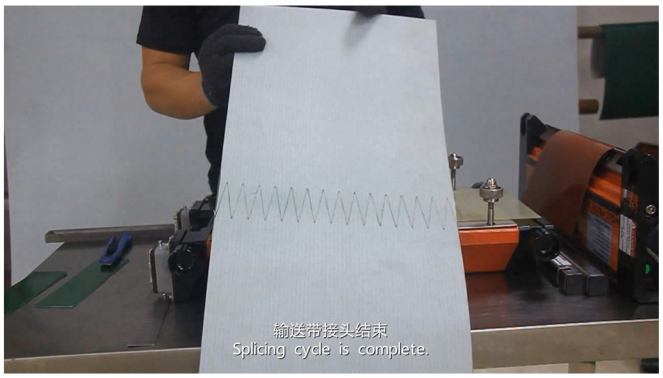


22.Remove teflon,keep it smooth and clean

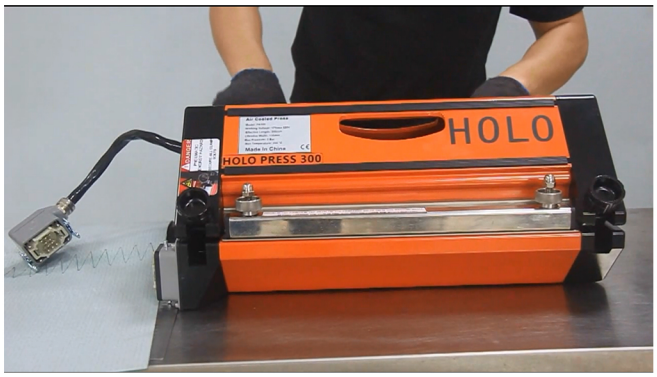




23.Cut off the belt material,check the joint quality







24.Carefully store the machine for the next use

Wish you have a nice and safty operation experience.Any problem,you can contact HOLO/BELTWIN company directly.

Video address:https://www.youtube.com/watch?v=oJ5oO0JLXRU

Level 2 heating operation

(Pre-heating System)

This function is used for the belt joint which thickness more than 6mm.



1.Long Press the System Button



2.showed “level 1 GOTO” then press “UP” ∧botton



3.Showed “level 1 GOTO” then wait 1s



4.Adjust the Pre-heating Temperature (PREHT)



5.Adjust the Pre-heating Dwell Time(PREHD)



Temperature compensation



Temperature unit

(Do not need to adjust)

6.Next 3 steps operation Same as Level 1.

Common problems and solutions

NO.	Description	Photo	
1	Sbr. SENSOR BROKEN		1.FIX the SENSOR inside the top beam. Video:https://www.youtube.com/watch?v=T-dGVZPPSUfc 2.Change a new sensor
2	Air Pump not work Pressure Stable Press the start button,air pump will work Pressure Still Stable		1.Photo showed The air pressure is set to negative,with"-",press "UP" Λ button,Turn into positive. Air pressure is in the adjustment interface,press the function button of barometer,back to Display side.
3	Air pressure Error		1.Press the "Set" button to confirm pressure setting after set pressure
4	EEE Temperature controller error		Reset the thermostat Video:https://youtu.be/2cbN5Csr1hw

SAFETY CONSIDERATIONS

This application procedure is not intended to supersede any company construction or safety standards. This procedure is offered only to illustrate safe application for the individual. FAILURE TO FOLLOW THESE PROCEDURES MAY RESULT IN PERSONAL INJURY OR DEATH.

Do not modify this product under any circumstances.

This product is intended for use by trained technicians only. This product should not be used by anyone who is not familiar with, and not trained to use it.

When working in the area of energized lines, extra care should be taken to prevent accidental electrical contact.

For proper performance and personal safety, be sure to select the proper size PREFORMED product before application.

PREFORMED products are precision devices. To insure proper performance, they should be stored in cartons under cover and handled carefully.

红龍® HOLO BELTS PRESS MACHINE

HOLO

Factory scene

© WENZHOU HOLO INDUSTRIAL EQP MFG CO.,LTD

Room 201,Building 3,NO.188 Wangxin Road Dongshan Street RUIAN Wenzhou ZHEJIANG,China

Web:http://www.holobelt.com

Tel:(86)0577 65682000 Fax:(86)0577 65916651