

CÓDIGO  
**90009**

**PR-ECO HEAT GLASS MACHINE**  
**USER MANUAL**



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# 1. GENERAL INFORMATION

## 1.1.INTRODUCTION

The user's manual given by the manufacturer contains necessary information about the machine parts.Each machine operator should read these instructions carefully,and the machine should be operated after fully understanding them.

Safe and efficient use of the machine for long term depends on understanding and following thne instructions contained in this manual.The technical drawing and details contained in this manual constitute a guide fort he operator.

## **1.2. MANUFACTURER**



\*In case of any technical problem please contact your nearest dealer,or head ofise through the above mentioned phone fax or e-mail adress

\* Technical labels with the model description of the machine are fixed onto the front side of cach machine.

\*The machine's serial number and manufacturing year are stipulated on the technical label.

**Average life usade of production is 10 years.If you have any furher failire and complaint,please inform to our below mentioned technical service by verbal or written**

## **AUTHORIZED TECHNICAL SERVICE CENTER ADRESS ;**

**For minimize the documantation,It is wery necessary to mention below details at the agreements signed with suppliers and dealers of the purchased machines.**

**Hastane Mah. Hadımköy – İstanbul Cad. No:12 (Hadımköy)**

**34555/Arnavutköy-İSTANBUL / TURKEY**

**Tel : 0212 858 22 22 Pbx.**

**Fax : 0212 858 21 22**

**e-mail : [info@soytasgroup.com](mailto:info@soytasgroup.com)**

**web : <http://www.soytasgroup.com>**

\*Machine's serial number

\*Date of purchase

\*Machine model

\*Average daily operation period

\*Voltage and frequency

\*Description of the machine fault

\*Name of dealer where machine was purchased

### **1.3 WARRANTY CONDITIONS**

1.The warranty period is 2 years from the delivery date of the machine.

2.All parts of the machine are under the warranty of our company.

3.If the machine has a defect within the warranty period, the warranty period is extended by the repair period. The repair period of the machine is max. 30 working days. This period begins with the date of notofication of the defect to the service station, or if there is no service station, to the authorized dealer, representative, agent, importer or manufacturer. If the defect cannot be repaired within 15 working days, the manufacturer or importer has to deliver the customer another machine with similar features until the repair has been completed.

4.If the machine has a defect due to material, workmanship and assembly fault, the repair will be carried out without any charge for parts, labor or any other charges.

5. The customer can request the replacement of the machine, or the return of the purchase price or discount in proportion with the fault if;

- the same defect occurs more than twice within the stipulated warranty period after the delivery, or in case of more than four different defects within the stipulated warranty period., or if the total defects of different defects exceeds six defects, and makes the machine unusable,

-the repair period for the machine is extended,

- it is determined with a report of the service station, or in case that there is no service station, by the dealer, representative, agent, importer or manufacturer, that a repair of the machine is not possible,

6.Defects due to use of the machine in contrary with the features described in the machine's user's manual are excluded from the warranty.

7. In connection with any issues of the warranty certificate the customer may contact the General Directorate of the Consumer and Competition Protection of the Ministry of Industry and Trade

## THE GUARANTEE CERTIFICATE

THE NAME OF FIRM OF THE MANUFACTURED : SOYTAS ALÜMİNYUM  
AKSESUAR CAM PLASTİK MERMER SAN.TİC.LTD. ŞTİ

ADRESS : Hastane Mah. Hadımköy – İstanbul Cad. No:12  
(Hadımköy)  
34555/ Arnavutköy/ İSTANBUL - TÜRKİYE

TELEPHONE : 0212 858 22 22 PBX

TELEFAX : 0212 858 21 22

THE SIGNATURE AND  
THE PRESS OF THE :

PRODUCTION KIND : HEAT GLASS MACHINE

MARK : PANA MACHINE

MODEL : PR-ECO

BANNERS & SERIAL NO :

DATE and DELIVERY PLACE :

GUARANTEE PERIOD : 2 YEARS

THE MAXIMUM TERM OF REPAIR : 30 WORKING DAYS

THE NAME OF THE AUTHORIZED

TRADING FIRM :

THE ADDRESS :

TELEPHON :

TELEFAX :

DATE-SIGNATURE-STAMP :

## 2. MACHINE'S DESCRIPTION AND USER FEATURES

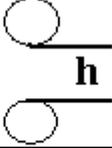
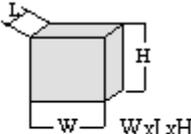
### 2.1. MACHINE'S DESCRIPTION

The spacers placed between two glass (double glazing strip) heating and double glazing presses the machine. There are glass table and glass spacer for installation.

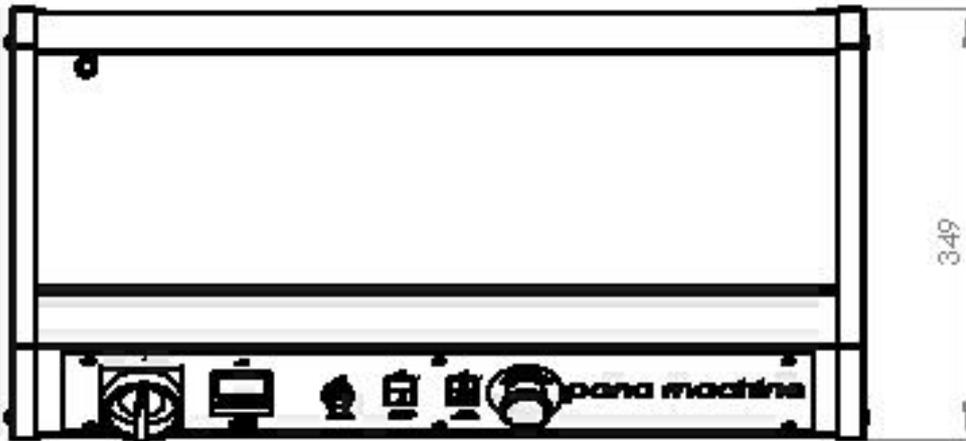
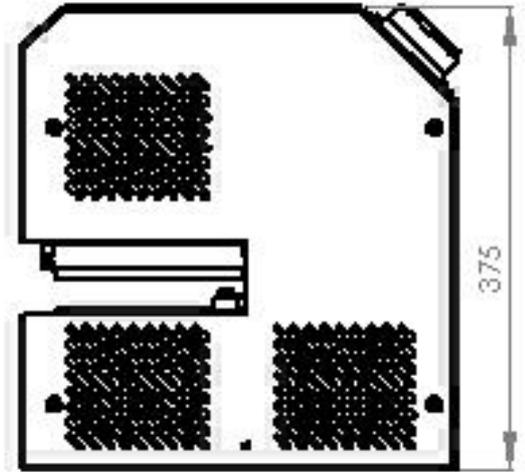
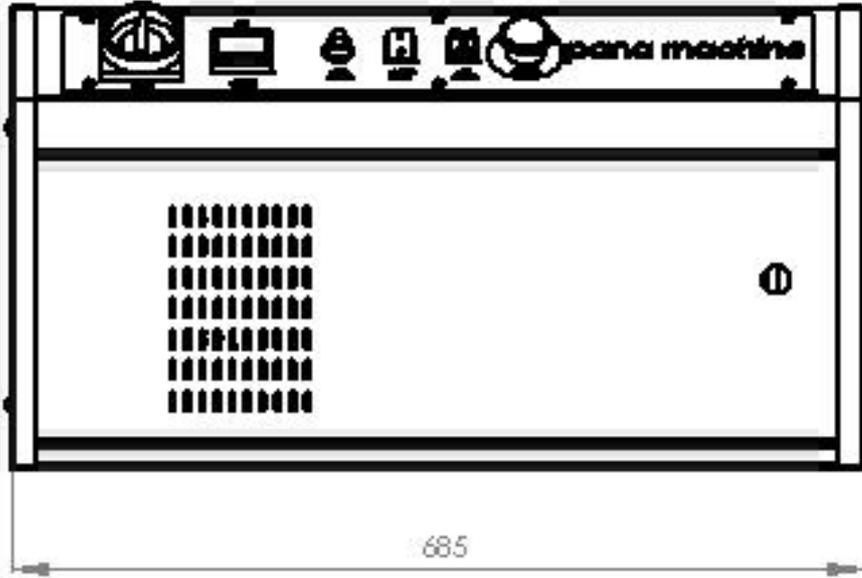
### 2.2 DIFFERENCES BETWEEN WELDING MACHINES

- \* Adjusted to the desired glass and spacer thickness.
- \* There are temperature control according to the climatic conditions.
- \* There are speed settings for ease of manufacture.
- \* There is help in the introduction of the machine mounting stand.
- \* The machine complies with CE standards.

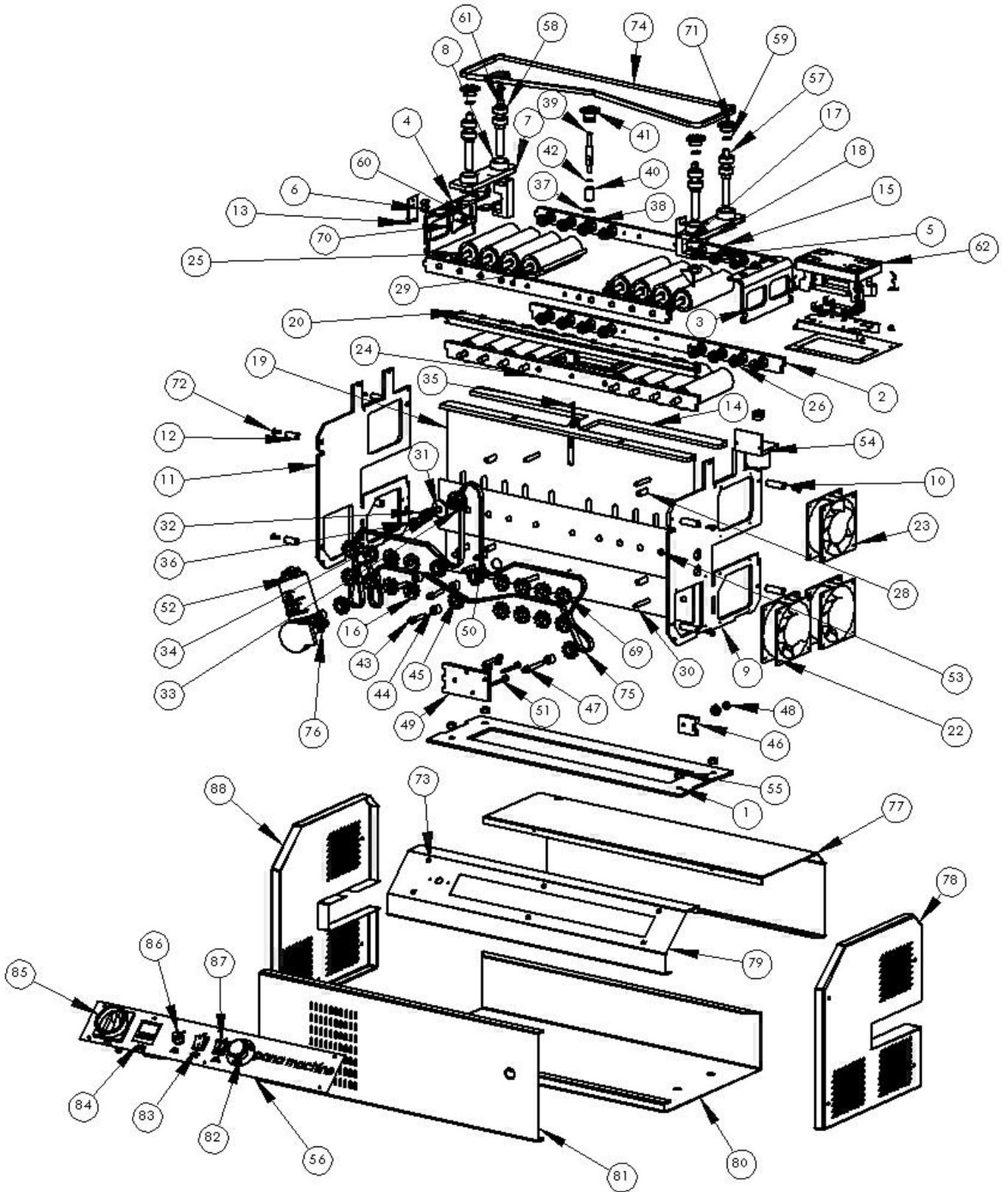
### 2.2. TECHNICAL FEATURES

TEKNİK ÖZELLİKLER TECHNICAL FEATURES						
			BAR			Hava tüke. Air cons.
<b>PR-ECO</b>	2.2 kW 220V 50Hz	Min: 13 mm Max: 45mm	6-8 Bar	20 Lt./dak Lt/min	240x180x133	270 kg

## 2.3. DIMMENSIONS



## 2.4 PART LIST AND TECHNICAL DRAWINGS

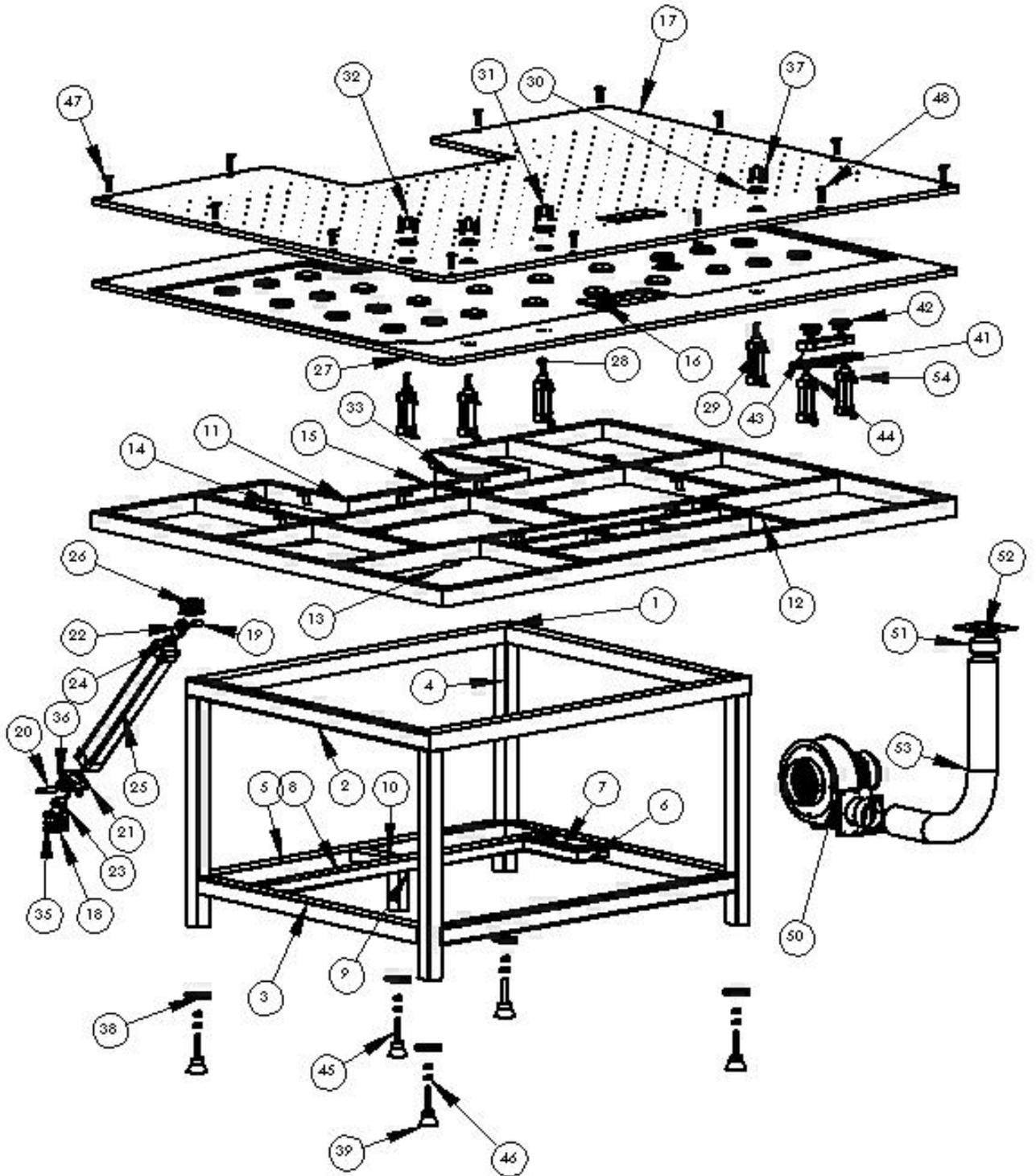


## PR-ECO PART LIST

PART NO	PART LIST	PCS
1	SHEET BASE CONNECTION	1
2	LOWER PULLEY STABILIZER	2
3	ACTIVATOR-1	1
4	ACTIVATOR-2	1
5	ACTIVTOR- WELDING	2
6	PLASTIC ROVE	2
7	BEARING HOLDER	2
8	BEARING BEARING	4
9	RIGHT HAND SIDE-1	1
10	RIGHT HAND SIDE PIN	4
11	LEFT SIDE-1	1
12	LEFT SIDE PIN	4
13	SWITCH CONNECTION	1
14	TOP LINKS	1
15	UPPER ROLLER STABILIZER	2
16	SPROCKET 3-8	16
17	ADJUSTER -1	2
18	M5x6 BOLT	2
19	CALL SHEET	1
20	SLIDING PULLEY ASSEMBLY	1
21	ENCODER CONNECTION INSTALATION. SLDPRT	1
22	MODEL 120x120x38 220-240- VAC-50-60 Hz 0.14 A IMPEDANCE PROTECTED- TIDAR PAT3638	3
23	MODEL 120x120x38 220-240- VAC-50-60 Hz 0.14 A IMPEDANCE PROTECTED- TIDAR PAT3638 -FAN	3
24	REEL RED SILICONE	16
25	PULLEY SHAFT	16
26	6900 Z C 3 BEARING	32
27	SPRING SYSTEM	2
28	SPRING SYSTEM PIN HOLDER	4
29	SUSPENSION SHAFT HEATER	4
30	BOARD HOLDER PINS	4
31	PIN ADJUSTER	1
32	608 - Z BEARING	2
33	SPROCKET 3-8 - I -13	1
34	M5x2-SHEET	1
35	M5x60 IMPUS BOLT	1
36	M5x10 IMPUS BOLT	1
37	8,5x20x3,5 SHEET	4
38	M8-1.25 BOLT	2
39	3-8 - I - 11 SPROCKET PIN	1
40	3-8 - I - 11 PLASTIC FITTING SPROCKET	1
41	3-8 - I - 11 SPROCKET	1
42	8 lık OUTER RING	1
43	M8x43- SPECIAL BOLTS	3
44	SPROCKET 3-8-I-11 SETSCREW PLASTIC	5

PART NO	PART LIST	PCS
45	SPROCKET 3-8-I-11 SETSCREW PLASTIC	5
46	CHAIN HOLDER FLAT	1
47	M8x60- SPECIAL BOLTS	2
48	M8 FIBER NUT	2
49	MAKO 64342395 FIBER THE MOTOR CONNECTION	1
50	MAKO 64342395 WASHER MOTOR HOME	3
51	M6x50-IMBUS BOLT	3
52	MAKO 64342395 MOTOR ASSEMBLY.SLDprt	1
53	INSULATION AL. SHEET	1
54	ROTARY ENCODER MOTOR	1
55	M10-1.5 BOLT	4
56	ALUMINUM PANELS	1
57	3-8 - I - 11 CHAIN BOLT	3
58	6001-BEARING	8
59	Ø 12 OUTER RNG	4
60	M14-NUT	4
61	3-8 - I - 11 NUT SOCKET KEY CHAIN	1
62	HEATER ASSEMBLY	2
63	CONNECTION PANEL	1
64	PRO-ECO-TABLE ASSEMBLY	1
65	SNAIL MOTOR ASSEMBLY	1
66	ROUND STEEL SPIRAL PIPE	2
67	SPIRAL PIPE STRAIGHT HAIR	2
68	SPIRAL PIPE	1
69	Part1 ASSEMBLY	1
70	POSTS	4
71	SPROCKET 3-8-V-1	4
72	M5 fairing bolts SHORT	8
73	M4x10 FIGURED END	6
74	UPPER CHAIN	1
75	Part2 ASSEMBLY	1
76	3/8 I 8 CHAIN GEAR	1
77	UPPER BODY COVER SHEET	1
78	HAIR BODY RIGHT SIDE COVER	1
79	UPPER BODY COVER SHEET SPICY	1
80	LOWER BODY COVER SHEET	1
81	STEEL FRAME FRONT COVER	1
82	EMERGENCY STOP BUTTON	1
83	TEMPERATURE SWITCH	1
84	DIGITAL DISPLAY	1
85	PAKO SWITCHES	1
86	SET SPEED SWITCH	1
87	HALOGEN LAMP SWITCH	1
88	STEEL BODY LEFT SIDE COVER	1

# PR-ECO TABLE



## PR-ECO TABLE PART LIST

PART NO	PART LIST	PCS
1	1500x60x60 PROFILE	2
2	1245x60x60 PROFILE	2
3	1125x60x60x3 PROFILE	2
4	755x60x60x3 PROFILE	4
5	1380x60x60x3 PROFILE	2
6	145x60x40x3 PROFILE	1
7	280x60x40x3 PROFILE	1
8	1380x60x40x2 PROFILE	2
9	120x60x40x2 PROFILE	1
10	190x60x40x2 PROFILE	1
11	TOP CARCASS	1
12	Ø16 HANGE	2
13	Ø16 HANGE	2
14	369x50x30x2 PROFILE	2
15	PR-ECO CARCASS	1
16	LOWER CHIPBOARD	1
17	TOP CHIPBOARD	1
18	Ø63 - YB- FITTINGS THE BOTTOM FLANCE	2
19	Ø63 CB-SHAFT	1
20	Ø63 - EB SHAFT	1
21	Ø63 - EB FITTINGS	1
22	Ø63 CB-CLIP YOKE	1
23	Ø63 - YB- FITTINGS	1
24	Ø63x500 PISTON SHAFT	1
25	Ø63x500 PISTON	1
26	Ø63x500 PISTON CONNECTION	1
27	Ø32x50 FIND SUPPORT	4
28	Ø32x50 SHAFT	4
29	Ø32x40 PISTON	4
30	32 PISTON TOP COVER	4
31	Ø32x50 PLASTIC	4
32	Ø 12 OUTER RING	8
33	M10x100 HEXAGON	4
34	M10 -BUTTERFLY NUT	4
35	M8x20 HEXAGON	8
36	M6x25 HEXAGON	4
37	M6x40 IMBUS	8
38	PRO-ECO- FOOT PAD	5
39	PRO-ECO-FOOT	5
40	50x10x40 FLAT	2
41	ECO VACUUM FLAT	1
42	SUCKER	2
43	VACUUM ALUMINUM FLAT	1
44	32x10-44 PSTN	2
45	M16 THE WHEEL	5
46	M16 NUT	10
47	TABLA CLAMPING FLANGES	13
48	M8x40 IMBUS	13
49	M8-1.25 NUT	13
50	SNAIL MOTOR ASSEMBLY	1
51	ROUND STEEL SPIRAL PIPE	2
52	SPIRAL PIPE STRAIGHT HAIR	2
53	SPIRAL PIPE	1
54	Part 27	14

### 3. SAFETY



#### 3.1 SAFETY INFORMATION

The symbols shown hereunder are necessary to be read with special attention. Not reading or observing of them may cause damage to the equipment or personal injury.

**IMPORTANT**

The IMPORTANT symbol above is one telling to apply special care and to be careful at carrying out the specific operation.

**CAUTION !**

The CAUTION! Symbol above warns you against specific dangers, and requires to read the text. Not observing may cause damage to the equipment.



**DANGER WARNING**

The above symbol DANGER WARNING, warns you against specific dangers, and you have definitely to read them. Negligence may cause damage to the equipment and bodily injury.

Read the user's manual carefully before using the machine or carrying out maintenance works.



#### 3.2. ACCIDENT PREVENTION

3.2.1. Our machines are manufactured in accordance with EN 60204-1 and EN 292-2 CE safety directives, which cover national and international safety directives.

3.2.2. It is the task of the employer to warn his staff against accident risks, to train them on prevention of accidents, to provide for necessary safety equipment and devices for the operator's safety.

3.2.3. Before starting to work with the machine, the operator should check the features of the machine, learn all details of the machine's operation.

3.2.4. Machine should be operated only by staff members, who have read and understood the contents of this manual.

3.2.5. All directives, recommendations and general safety rules contained in this manual have to be observed fully. The machine cannot be operated in any way for purposes other than those described herein. Otherwise, the manufacturer shall not be deemed responsible for any damages or injuries. And such circumstances would lead to the termination of the warranty.

#### 3.3. GENERAL SAFETY INFORMATION

3.3.1. The power cable should be led in such a way that nobody can step on it or nothing can be placed on it. Special care has to be taken regarding the and outlet sockets.



3.3.2. If the power cable should be damaged operation, don't touch and unplug it. Never use damaged power cables

3.3.3. Don't overload machines for drilling and cutting. Your machine will operate more safely with power supply in accordance with the stipulated value.

3.3.4. Don't place your hands between parts in motion



3.3.5. Use correct illumination for the safety of the operator. (ISO 8995-89 Standard The lighting of indoor work system)

3.3.6. Use protective eye glasses and earplugs. Don't wear oversized clothes and jewelry. These can be caught by moving parts



3.3.7. Don't use any materials other than those recommended by the manufacturer for welding operations on the machine

3.3.8. Ensure that the work piece is clamped appropriately by the machine's clamp or vice.

3.3.9. Ensure safe working position, always keep your balance

3.3.10. Don't leave anything on the machine



3.3.11. Keep your working place always clean, dry and tidy for accident prevention and operation

3.3.12. Keep your machine always clean for safe operation. Follow the instructions at maintenance and replacement of accessories. Check the plug and cable regularly. If damaged, let replace by a qualified electrician. Keep handles and grips free of any oil and grease.

3.3.13. Unplug first, before conducting and maintenance works

3.3.14. Ensure that any keys or adjustment tools have been removed before operating the machine.

3.3.15. If you are required to operate the machine outside, use only appropriate extension cables.

3.3.16. Repairs should be carried out by qualified technicians only. Otherwise, accidents may occur

3.3.17. Before starting a new operation, check the appropriate function of protective devices and tools, ensure that they work properly. All conditions have to be fulfilled in order to ensure proper operation of your machine. Damaged protective parts and equipment have to be replaced or repaired properly (by the manufacturer or dealer).

3.3.18. Don't use machines with improperly functioning buttons and switches.

3.3.19. Don't keep flammable, combustive liquids and materials next to the machine and electric connections

**IMPORTANT**

#### 4. SAFE TRANSPORT OF THE MACHINE

\* The transport should be done by qualified personnel only.

4.1. The machine should be transported by lifting with proper equipment (not touching the ground during the transport).

4.2. The Machine is delivered wrapped in nylon as packaging, unless other form of packing is agreed upon with the customer.

4.3. For the weight and overall dimensions of the machine see Technical Features.

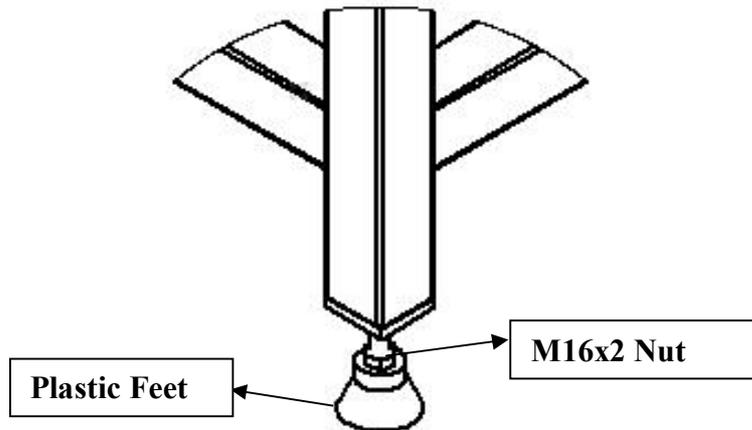
### **5. INSTALLATION OF THE MACHINE**

#### 5.1. Preparation

5.1.1. The machine should be located at least in front of the back wall. The machine is equipped with a burr collection bag connector and power supply socket on the back side (Page no 7)

5.1.2. Position of the rear wall should be approximately 100 cm in the machine

5. 1.3. Feet at the bottom of the chassis with the help of the machine can adjust the balance. (Page 1)

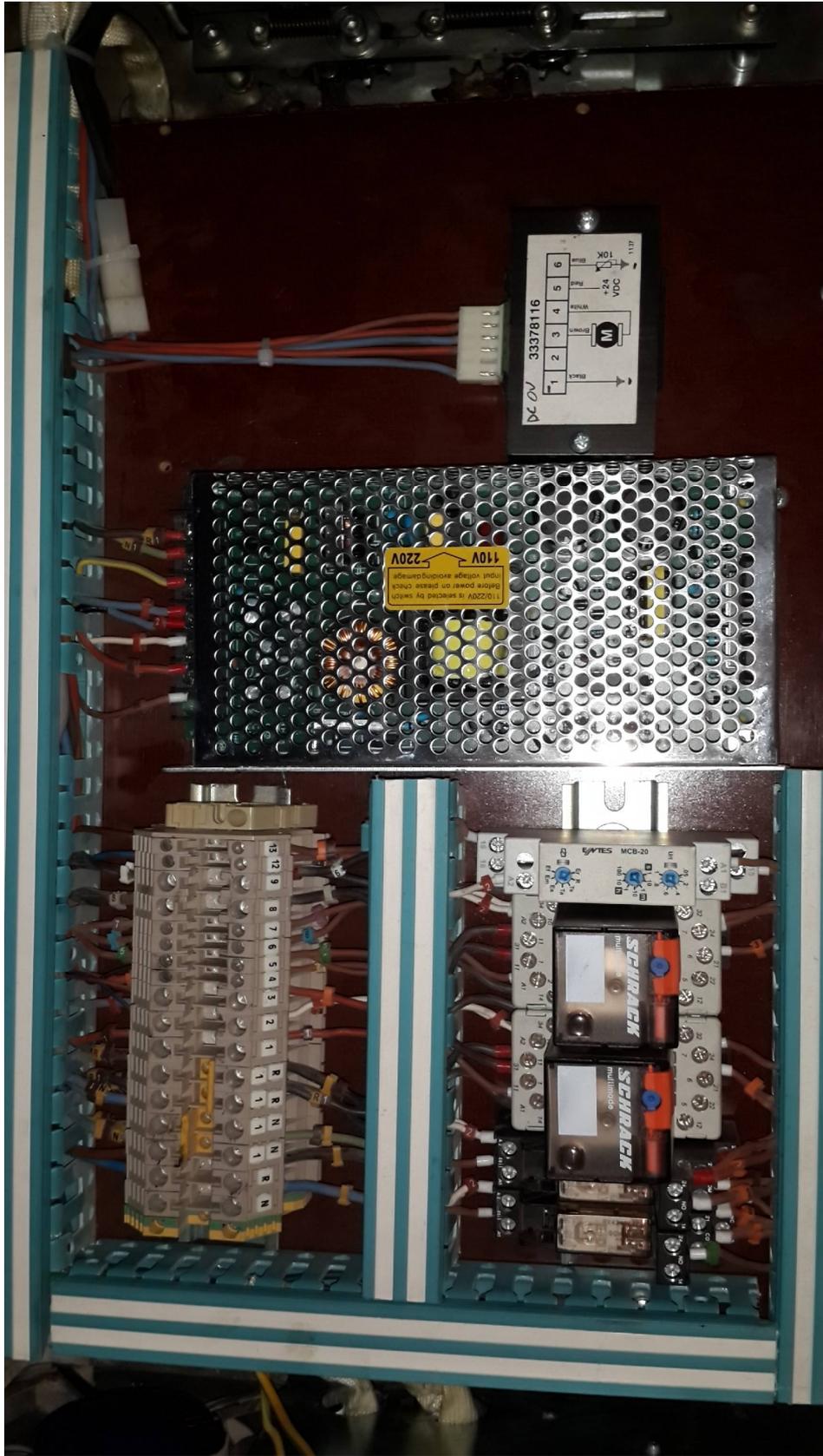


**PAGE-1**

#### **5.2. ELECTRIC CONNECTION**

5.2.1 220V 50 Hz mains voltage is applied.

5.2.2 Apply Plug the machine into a grounded outlet.



## **6. MACHINE SAFETY INFORMATION**

- 6.1. The machine used for removing the protective enclosure.
- 6.2. Remove the machine, place, qualified and authorized personnel should be used for electrical maintenance work.
- 6.3. Routine scheduled maintenance with maintenance work by authorized and qualified personnel should be done after the removal of the electrical power supply circuit.
- 6.4. Cleaning of the machine before working on the machine, ensure that the testing and maintenance made.
- 6.5. Safety equipment and moving parts of the electrical power cord as a routine check. If you see damage to equipment or parts to fulfill the functions of security with a new one without changing the machine operate.
- 6.6. Never change blades for disconnecting electric power.
- 6.7. Holds of foreign bodies in the area where the operation, Do not put your hands in between the moving parts.

## **7. PREPARATION OPERATION**

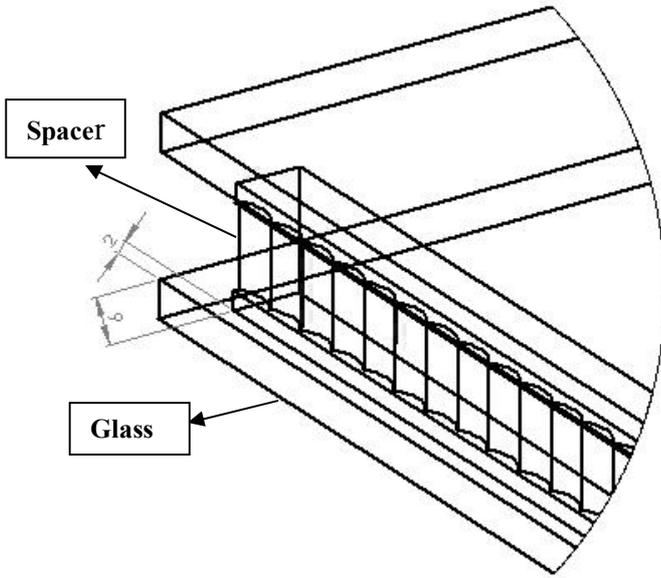
### **7.1. PRE OPERATION INFORMATION**

- 7.1.1. Check that the machine's electrical and air connections made correctly.
- 7.1.2. Adjust the heat setting machine according to climate and weather conditions.
- 7.1.3. Check the air pressure and oil level on the air adjustment unit.
- 7.1.4. Heaters (Halogen) check that the lights of the lamps.

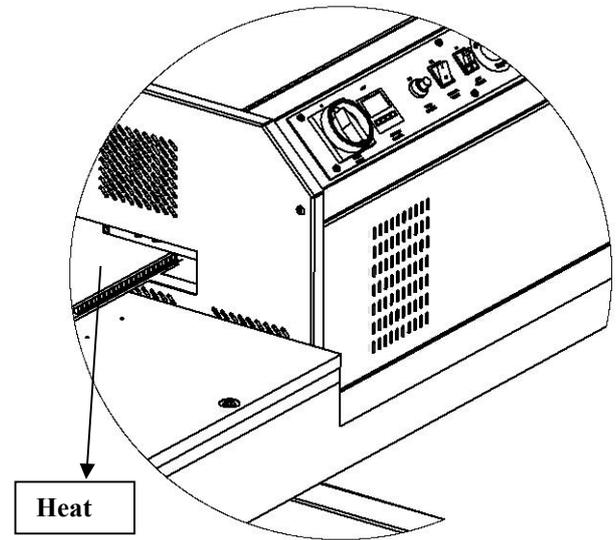
### **7.2. FINE BINDING AND THICKNESS SET**

- 7.2.1. At the exit of the heat insulating glass on the table during the manufacture of insulating glass seal must be at 45 ° C & 48 ° C.
- 7.2.2. The surface for proper adhesion to glass spacers out of the washer must be absolutely dry.
- 7.2.3. The desired temperature should be set to the glass transition speed. **(Potentiometer)**
- 7.2.4. On top of the glass thickness adjustment of the machine should be adjusted by turning the handle ¼ donuts with the right and left.
- 7.2.5. Machine while turning ¼ donuts energized without arm, calibration settings of the machine is broken.

### **7.3. SPACE INSTALLATION**



**Şekil 7.3.-A**



**Pace 7.3.-B**

7.3.1. Washing of the glass, pressed suction valve is brought to the table.

7.3.2. Spacer (Figure 7.3) as 2-3 mm and the initial part of the adhered surface so as to leave 9-10 mm.

### **7.4. HEAT GLASS MANUFACTURING**

7.4.1. Make the electrical connections of the machine.

7.4.2. Open SARTEL.

7.4.3. Remove from off the emergency stop button.

7.4.4. You choose the summer and winter mode.

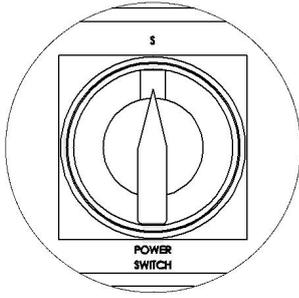
7.4.5. Start giving, make sure that the machine.

7.4.6. Make the desired thickness adjustment lever with  $\frac{1}{4}$  donuts.

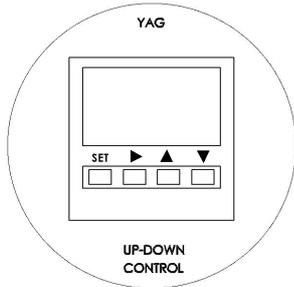
7.4.7. Double glazing which was prepared at the table (Figure 7.4-B) contains the input data of the machine.

# 8- ELECTRONIC DEVICES

## 8.1 Introduction to electronic devices



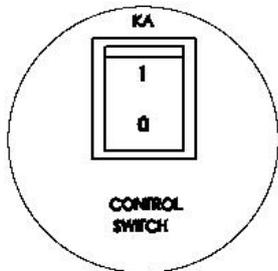
Power on-off switch (Paco switches)



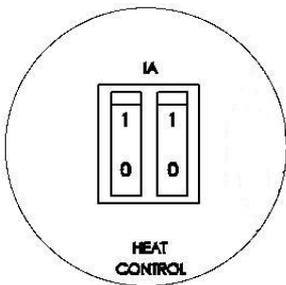
Insulating Glass thickness adjustment counter.



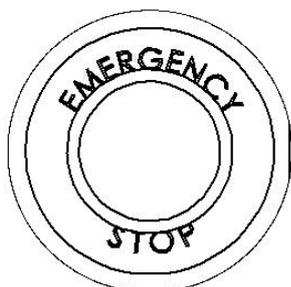
Insulating materials used to make fine-tuning the control speed (speed control) switch.



The drive motor start-stop switch.



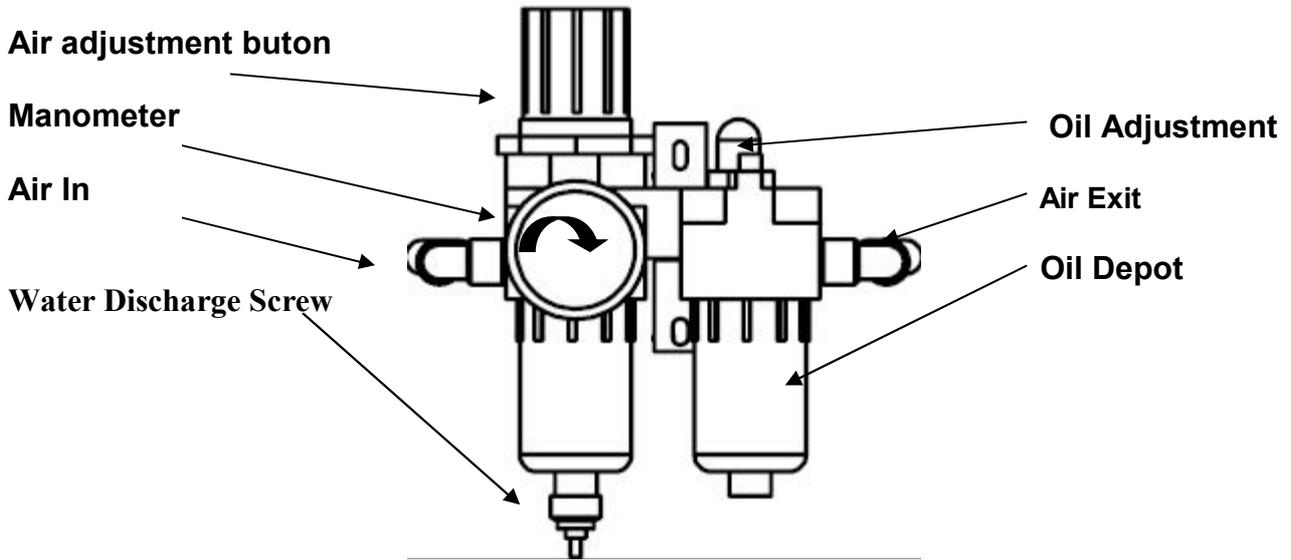
Turn on and off switch for halogen lamps.



Emergency button.

## **99. AIR PRESSURE ADJUSTMENT**

**Pneumatic systems should be 6-8 bar air pressure to function as healthy. Machine to operate at pressures lower than 6 cups. Conditioner to adjust the air pressure to control and read on the manometer. (FIGURE 8)**



- 9.1- Increasing the pressure adjustment knob clockwise direction is flipped, rotated in the opposite direction pressure Decrease
- 9.2- Once you read 6-8 Bar on the manometer, push the adjustment button of the conditioner down and lock it in that position
- 9.3- The conditioner unit collects the water within the air system in a receptacle in order to prevent damage to the pneumatic system components. Discharge this water periodically (at the end of the working day) by pressing or opening the button under the conditioner.
- 9.4 The manufacturer recommends to use the following oils with the conditioner: TELLUS C 10 / BP ENERGOL HLP 10/ MOBIL DTE LIGHT / PETROL OFISI SPINDURA 10

## **10. MAINTENANCE**

### **10.1. ROUTINE CHECKS**

10.1.1. Before any maintenance or cleaning operation, the **emergency stop** button must be in the 0 position and the Location of **sartel**.

10.1.2. Controls the halogen lamp is made.

10.1.3. 3/8 parts consisting of the chain is checked and lubrication is done when needed.

10.1.4. Any foreign material on the rollers (broken glass, remove melted plastic, etc.), if any.

10.1.4. Check the oil level in the air pressure filters and conditioners. If you complete the missing amount of fat. (Figure 8)

### **10.2. MAINTENANCE AT THE END OF WORKING DAY**

10.2.1 Keep working parts as possible, and periodically clean dirt, oil and check against corruption.

10.2.2. Avoid materials that harm the paint cleaning the machine

10.2.3. When cleaning the machine table, avoid material to the surface.

10.2.4. Check the air adjustment unit periodically, to prevent the entrance of water in the air within the system, check the oil level in the conditioner.

### **10.3. GENERAL LUBRICATION**

10.3.1. The machine is equipped with a special lubricant-free bearings do not require lubrication or greasing. Periodically check the oil level in the conditioner pneumatic system. For the oil to be used (see Article 9)

### **10.4. 10.4. SPECIAL PRECAUTIONS**

10.4.1. Not work beyond a few days in case the machine is non-painted surfaces to prevent oxidation of the grease. Clean layer of fat in case of working again

10.4.2. The machine will stay out of the long-term use;

- sartel position 0
- Close the pneumatic system

## **11. TROUBLESHOOTING GUIDE**

### **POSSIBLE ERRORS AND REMOVAL**

Emergency proposals to eliminate the problems below. If the fault can not be eliminated or encounter a malfunction other than those recommended below, please consult the technical service

<b>TROUBLES</b>	<b>CAUSES</b>	<b>REMEDY</b>
Thickness error	¼ donuts arm without power have been translated.	Adjustment lever with ¼ donuts to make sure that the necessary adjustments should be made after power on the machine.
Table does not move	Air pressure is insufficient	Check that the air hose into the appropriate machine. Set the air conditioner pressure.
The machine does not work	Emergency stop is active Cards may be problems.	Emergency stop the machine after the first energy (EMERGENCY) Make sure the button is not active. Call technical service.
One of the moving parts of the machine does not work.	Chain 3/8 Lera one or both at the top and front of the machine was broken.	We take 3/8 replace the chain.
The machine is not receiving power.	The power supply light is not lit There is a connection error.	Change your power supply Insurance, plugs, sockets and. Check. (Do not connect the machine to the ground.)
short circuit	Switch for electrical connection with mixing desk snail.	Call technical service.
If the machine has been running for any reason.	-	<b>Call technical service.</b>