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EMBLEM® LEADING THE WAY

# OPERATING INSTRUCTIONS

**Version 1.0**

# EASY AIRPRESS
# PREMIUM MOBILE Chrome
## Pneumatic Eyepress

MODEL: **PRMCH**

**Note:**

**DATAPLOT does not assume any liability as a result of inappropriate use, as well as operating errors in case of misunderstanding the operating instructions.**

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# INDEX

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# 1 Introduction

## 1.1 Area of application

The Easy Airpress Premium Chrome Mobile (PRMCH) was developed in order to manage the lug-attachment in one work operation, i.e. to stamp a hole, to press in a lug and to supply a new lug automatically. Either plastic lugs or metal lugs can be processed in this case. For this, the operator must install the corresponding tool (see Chapter 5). The device processes 12 mm EMBLEM plastic lugs or 11 mm EMBLEM metal lugs exclusively.

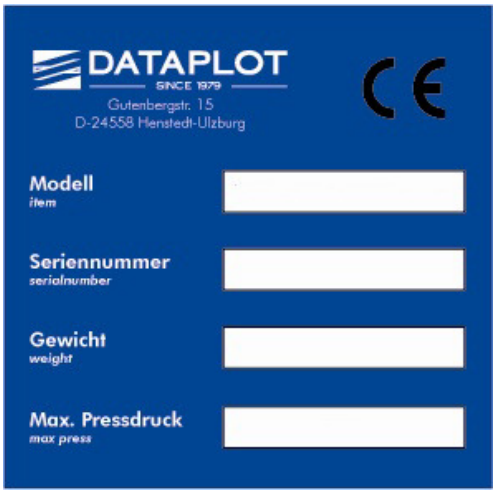
The PRMCH is mainly employed to process lugs in PVC banners. In case of textile materials, creasing can result since no adaptations to the tool can be carried out.
However, this is basically possible. Corresponding material tests are to be implemented before the processing.

**Caution**:
- Lack of knowledge of the user about the operation of the device can result in inferior results or damage to the device.
- Please read through this operating instructions carefully in order to ensure safe operation and the optimum employment of the device.
- This applies in particular for the tool change.

## 1.2 Rating plate and "CE" identification

Every device has a rating plate with the following specifications:

- Name and data of the manufacturer
- "CE" labeling
- Model designation
- Serial number
- Weight
- Maximum air pressure in bar



# 2 Technical description

## 2.1 General

The PRMCH is mounted on a plastic table made of PE. This mobile table is equipped with five rollers which are provided with brakes. The lug press was developed in order to press in lugs and to follow up fully-automatically. However, single holes alone can also be stamped in the material (see Chapter 4.4).

The pneumatic cylinder, the supply mechanism for lugs and washers, as well as the electronic control, power supply unit and fuse protection, are located under the blue covering.
The electrically-operated valves, the Emergency Off switch and the On/Off switch are arranged on the right-hand side.

The device is delivered as standard with electrical foot-operated switch, however, it can also be ordered with a manual switch on request.

The PRMCH is delivered with rollers in order to move it flexibly on the ground or on a table. If the customer works at a stationary position, the rollers can be fixed by the brakes for safety.

The PRMCH works with 6 bar. This pressure can be adjusted on the manometer of the device.
In this case, it is to be ensured that the pressure does not drop even after several lug-attachment processes following on each other rapidly, which can result in malfunctions. This could be the case with the utilization of a compressor with insufficient performance. We recommend the compressor advanced by EMBLEM with a suction capacity of 286 l/min.

## 2.2 The lug-attachment process

1. If the foot pedal is activated, the supply system shifts one lug and one spacing washer from the supply areas (B) + (D) to the lug-attachment area (X) by means of a small pneumatic cylinder.

2. The main cylinder under the blue covering moves the axes with the upper adapter downward.

3. With the processing of plastic lugs, the upper adapter stamps a hole in the material. With the processing of metal lugs, the hole is stamped by the lugs themselves.

4. Then the adapter continues to move downward and presses the upper and lower part of the lug together.

5. After this, all parts are taken back to their start position in order to be ready for a new lug-attachment process. Simultaneously, the lower spacing washers are blown into the supply by means of the air nozzle on the right-hand conduit.

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## 2.3 Component parts

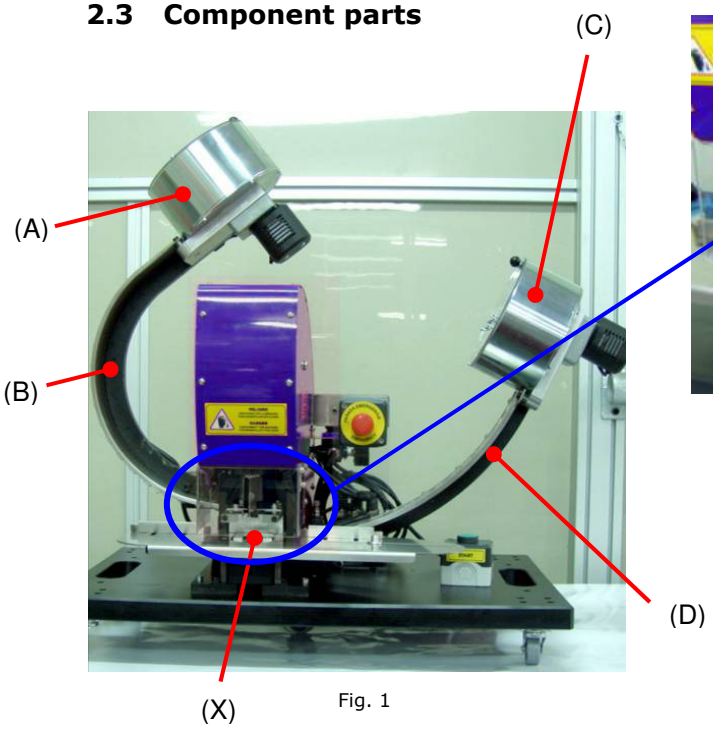
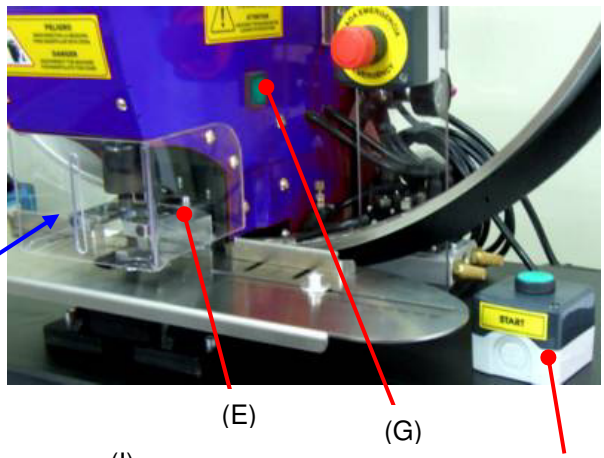



Fig. 1



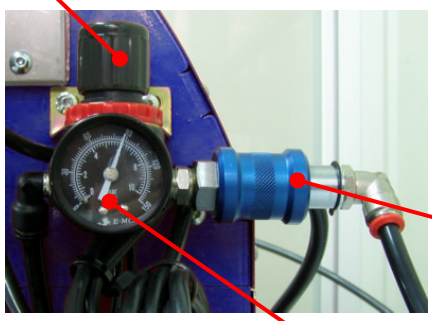




Fig. 1a

**(A) Storage container for lugs**

**(B) Supply conduit for lugs**

**(C) Storage container for washer (spacing disks)**

**(D) Supply conduit for washer**

**(E) Safety cover**

**(F) Foot-operated switch or manual switch**

**(G) Switch-on button**

**(H) Air inlet valve**

**(I) Pressure setting (turn knob)**

**(J) Pressure indication (manometer)**

**(X) Lug area**

## 2.4 Technical data

| | |
|---|---|
| **Width x depth x height** | 24 cm x 32 cm x 41 mm. |
| **Weight** | 28.5 kg / 63 lb. |
| **Required air pressure** | 6 bar / 87 psi. |

# 3 Installation

## 3.1 Prerequisites

Sufficient space must be existing around the device so that the user can work safely on all sides.

For the operation and the maintenance of the machine, a minimum illumination of 300 lux is necessary.

Ensure that the electrical cable and the compressed air hose are never completely stretched out or extended.

Read through these operating instructions carefully before the first operational startup, in order to avoid operating errors.

## 3.2 Transport

Always unload and move the transport box, together with the device, with a forklift or a suitable lift truck.

For the transport of the machine to the required location, the following precautions should be considered:

- Never stand below the wooden box.
- Wear protective gloves.
- Avoid swinging the machine.
- Never tilt the machine in one direction.
- Exercise care when lifting or moving the machine.
- Do not make any sudden movements.

The machine is supplied with packaging which is suitable for avoiding damage during transport.

If, for some reason, the machine should be transported again after the installation, and the user has already disposed of the packaging, we recommend to dispatch the device in a wooden box. The plastic table should be screwed to the base of the wooden box with suitable bolts.

## 3.3 Setup and alignment

The PRMCH is supplied in a wooden box and is fixed with bolts to both sides of the plastic plate.

Please follow the steps listed below:

- Open the wooden box.
- Remove the protective foil.
- Loosen the bolts on both sides of the plastic plate which connects the machine with the wooden box.
- Move the machine to its location with a lift truck.

***Ensure that the device is supported only at the two grip holes in the plastic plate. Never load the two lug conduits!***

If you wish to place the device on a table, ensure sufficient stability and correct leveling. Before beginning work, fix all roller brakes.

## 3.4 Compressed air connection

The machine is provided with an air inlet valve (H) with quick coupling ISO 6150-B Standard for the connection of a ∅ 8 mm compressed air hose.

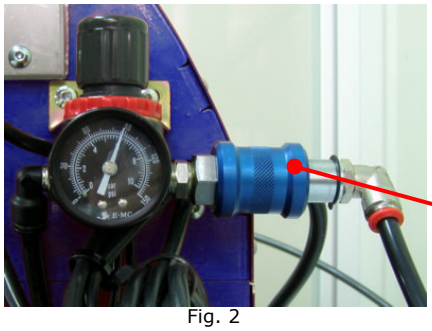


Fig. 2

Using the rotation wheel on the manometer, the operating pressure of 6 bar can be adjusted.
In this case, it is to be ensured that the pressure does not drop even after several lug-attachment processes following on each other rapidly, which can result in malfunctions. This can be the case with the utilization of a compressor with insufficient performance. We recommend the compressor advanced by EMBLEM with a suction capacity of 286 l/min.

In order to accelerate the air supply, in particular in case of long compressed-air lines, the outlet pressure of the compressor can be increased up to 8 bar.
However, it is absolutely necessary to ensure that the inlet pressure is adjusted to 6 bar on the manometer of the PRMCH, in order not to damage the device.

## 3.5 Notes on use

Please read the notes carefully before starting:

- Before connecting the machine to the power supply, to the compressor or to the compressed air supply, the device should be brought to its final position.
- For the cleaning, handling or replacement of parts, the air inlet valve "H" (Fig. 2) should always be closed and the device switched off.
- Do not remove the safety devices, stick-on labels or warnings from the device. If the signs are detached in spite of this as a result of force majeure, please fix on again before starting the device.
- The machine has a manual air inlet valve "H" (Fig. 2) for the opening and closing of the air supply of the device; when the machine is not in use, the valve should be closed (see Fig. 4) to avoid possible accidents to third parties. For reasons of safety, we also recommend the disconnection of the hose from the compressor or the air supply.
- The device has an On/Off switch (G), (Fig. 1). When the machine is not used, it should be switched off, (the light of the switch goes out) to avoid possible accidents to third parties. For reasons of safety, we additionally recommend the disconnection of the electrical plug connector from the power supply.

In order to protect the user from accidents, the cutting and lug-attachment area is to be secured by an acrylic protection and a stainless steel plate. Never open this area and work there when the device is switched on and the air inlet valve is open.

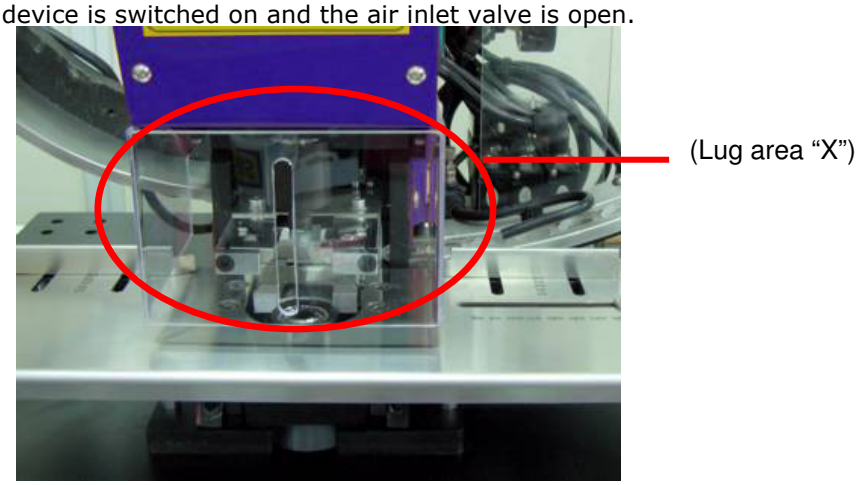



Fig. 3

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Position: Closed

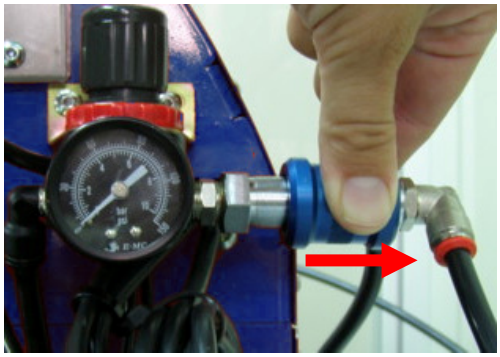

Fig. 4

Position: Open

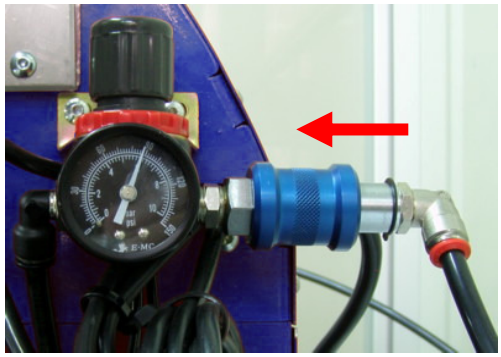

Fig. 5

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# 4 Operating processes

## 4.1 Equipment description

This device was developed in order to manage the lug-attachment in one work operation, i.e. to stamp a hole, to press in a lug and to supply a new one. It is mainly designed for the lug-attachment of materials coated by PVC and plasticized PVC.
In case of textile materials, creasing can result since no adaptations to the tool can be carried out. However, this is basically possible. Corresponding material tests are to be implemented before the processing

The PRMCH processes 12 mm EMBLEM plastic lugs or 11 mm EMBLEM metal lugs exclusively. Other lug sizes are not usable.

***The utilization of external lugs of similar size will damage the device since the EMBLEM lugs have a special form. Therefore ensure that similar lugs are not filled into the magazine by mistake.***

DATAPLOT GmbH does not assume any responsibility for the utilization of the machine for purposes other than those indicated in these operating instructions.

## 4.2 Verification of the device prior to operational startup

Before first use, in the case where the device has been converted, adaptations made or parts replaced, we recommend examining the device for damage. The main checkpoints are located on the right-hand side of the machine:

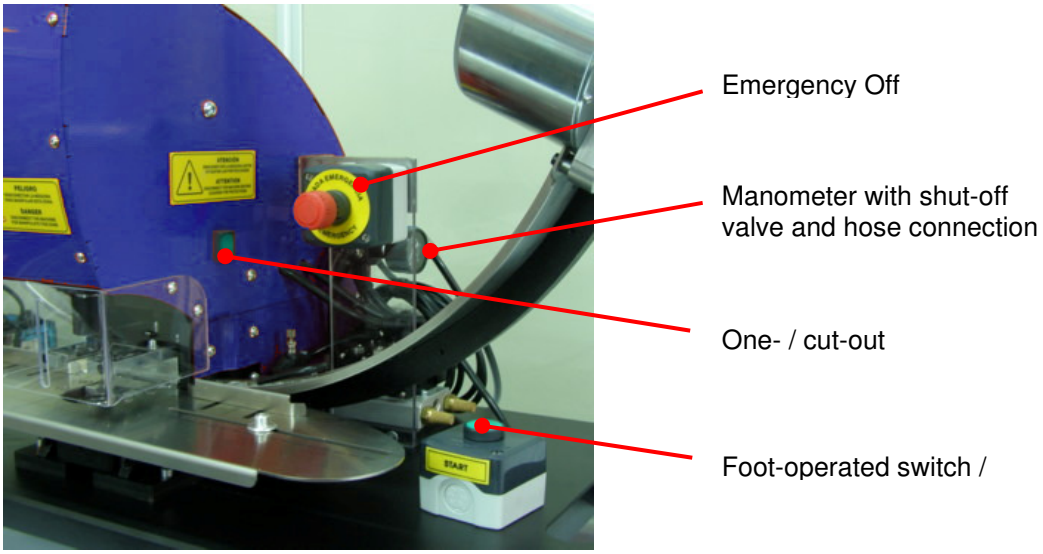


Fig. 6

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## 4.3 Lug attachment

**Start of the lug-attachment process**

1. Check that there are sufficiently lugs in the storage container (A) and sufficient spacing disks (washers) in the storage container (C). The storage containers should be filled to 2/3 maximum.

2. Connect the power plug with the plug socket and switch on the device at the switch (G) (green lamp lights up). The brushes in the storage containers begin to rotate and, as a result, the supplies (B) + (D) are filled.

3. Check that both supplies are completely filled with lugs. Possibly switch the device off and on once again and wait until both supplies are filled.

4. Connect the compressed air hose of the compressor with the connection (H) (Fig. 2) and open the air inlet valve (Fig. 5)

5. Adjust the pressure on the manometer (J) (Fig. 1a) to 6 bar.

6. Place the banner between the stainless steel plate and the safety covering (L) (Fig. 7). Use the adjustable positioning aids and align the banner.

7. Activate the foot pedal.

8. The lug-attachment process begins.

9. Check that the pressure on the manometer is still 6 bar. If necessary, adjust the pressure until it does not change any longer after the lug-attachment.

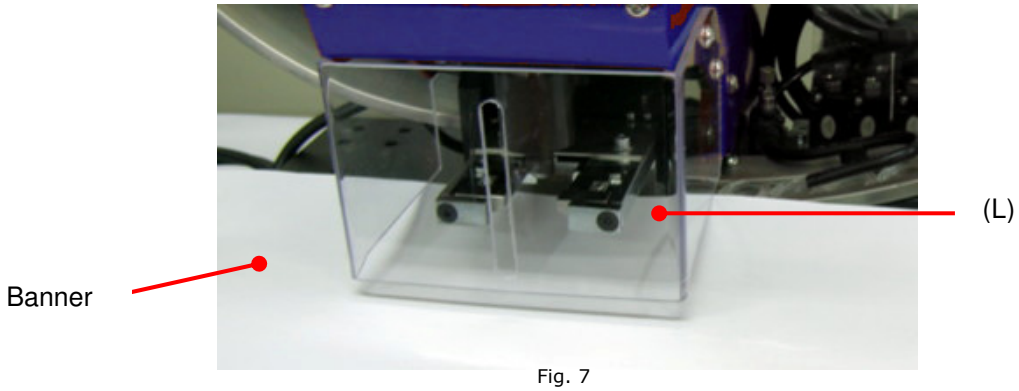


Fig. 7

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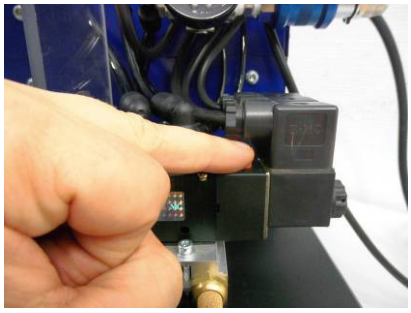
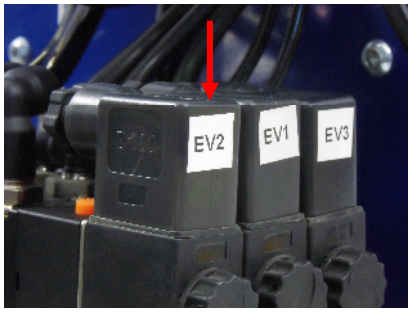
## 4.4 Further applications

With the adapter for plastic lugs, holes can be stamped into the material without pressing in a lug. For this, press the switch on the front electrically-operated valve (EV2).
The hole size is 12 mm. This is not possible with the adapter for metal lugs.





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# 5 Lug attachment and lug-attachment tools

## 5.1 The lug-attachment tools

The lug-attachment tools are normal wear parts. These parts must be replaced when the cutting or lug-attachment does no longer functions trouble-free. We recommend to always have a complete adapter kit in reserve.

Lug-attachment tool for 12 mm plastic lugs
Article number: 22664-1

Lug-attachment tool for 11 mm metal lugs
Article number: 24142

If you carry out maintenance work or change the lug-attachment tool, ensure that you mount all loosened parts again (safety cover, stainless steel plate, etc.) and tighten them at their initial location.

**Caution**: Close the main air-inlet valve (see Fig. 4) and set the main switch (G) to OFF (no green light) in order to change the adapter, to install optional equipment or to carry out other handling operations.

### Changing the lug-attachment tools or lug sorts

| | | | | |
|---|---|---|---|---|
| 5.2 | Changing the lug-attachment tools for plastic lugs | Plastic | → | Plastic |
| 5.3 | Changing the lug-attachment tools for metal lugs | Metal | → | Metal |
| 5.4 | Retrofitting from plastic lugs to metal lugs | Plastic | → | Metal |
| 5.5 | Retrofitting from metal lugs to plastic lugs | Metal | → | Plastic |

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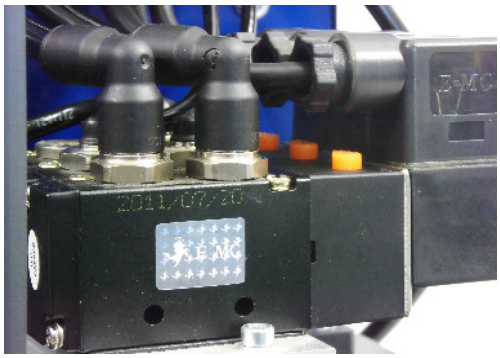
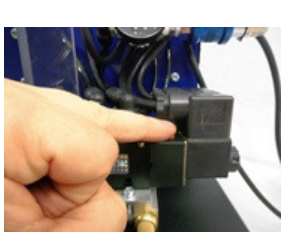
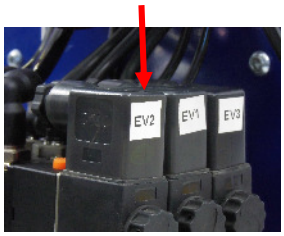
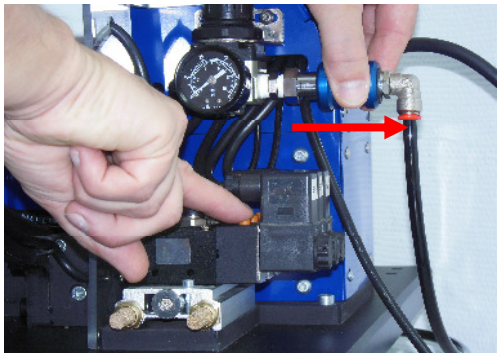
## 5.2 Changing the lug-attachment tools (adapters) for plastic lugs

**Caution**:

In order to insert a new adapter, you must remove the safety covering. Then mount this important safety protection again!

Position the manual switch so that it cannot be pressed by mistake.

| | |
|---|---|
|  | On the rear side of the machine are located 3 electrically-operated valves which take over the distribution of the compressed air, in order to control the different sequences for the lug-attachment. |
|    | Press the button on the front valve with the label "EV2" and hold it pressed. The axis of the cylinder lowers. |
|  | Without removing the finger from the switch, close the compressed-air inlet valve so that the axis of the cylinder remains at its lower position.<br><br>When the valve has changed its position from "Open" to "Closed", the compressed air leaks out from the inner system. An unexpected action of the pneumatic cylinder is prevented by this. |

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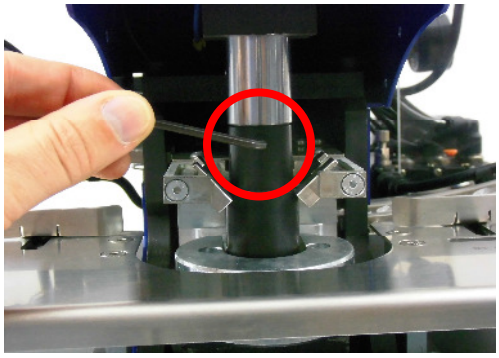
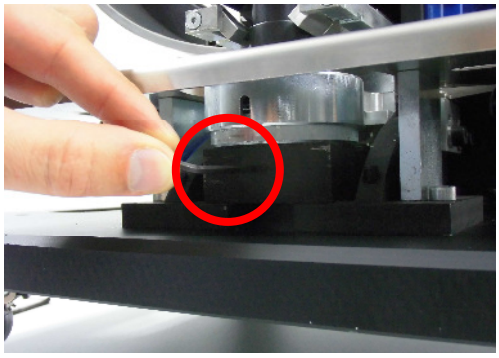
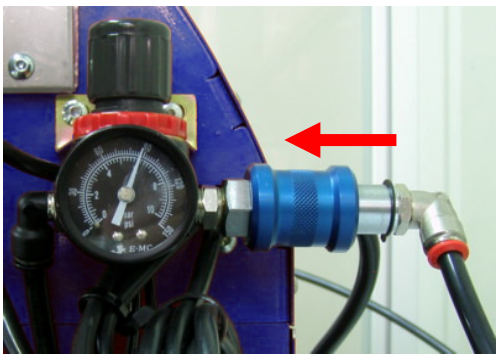
| | |
|---|---|
|  | Loosen the four bolts with an Allen key on the safety cover on the front of the machine.<br><br>Remove the safety cover. |
|  | Screw off the holding screw on the upper adapter.<br><br>IN ORDER NOT TO DAMAGE THE MACHINE, YOU MUST REMOVE THE BOLT, NOT JUST LOOSEN IT. |
|  | Screw off the holding screw on the lower adapter.<br><br>IN ORDER NOT TO DAMAGE THE MACHINE, YOU MUST REMOVE THE BOLT, NOT JUST LOOSEN IT. |
|  | Open the compressed-air inlet valve so that the cylinder moves into its upper position. |

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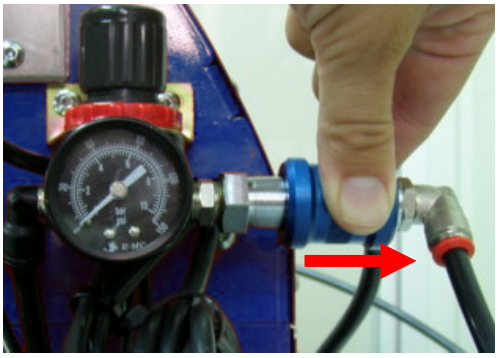
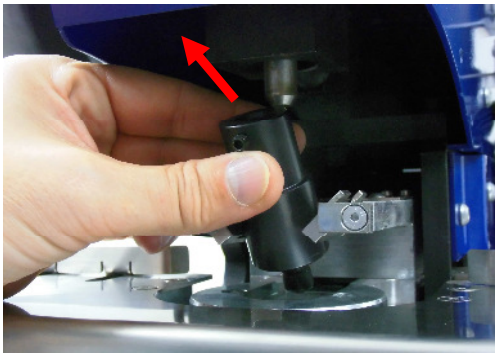
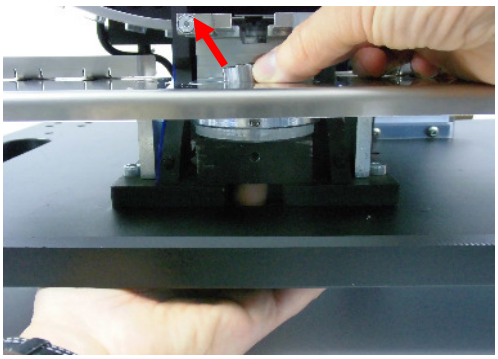
|  | Close the valve in order to work in the lug area. |
|  | Remove the upper adapter from the axis of the cylinder. |
|  | Remove the lower adapter for plastic lugs.<br><br>For this purpose, place your finger through the hole on the roller table and lift the adapter gently. |
|   | 1. Remove the holding screw of the upper part from the new adapter.<br>2. Plug both parts into each other. |

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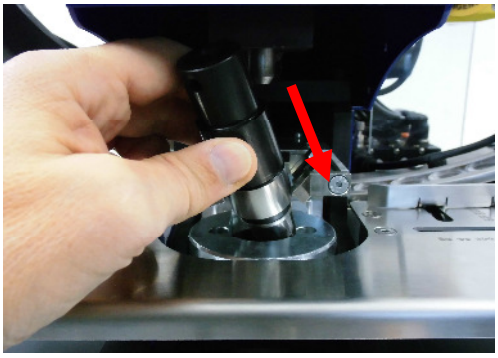
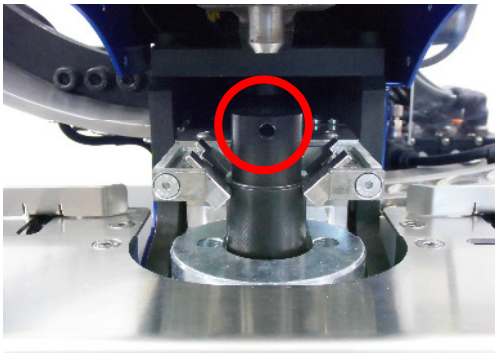
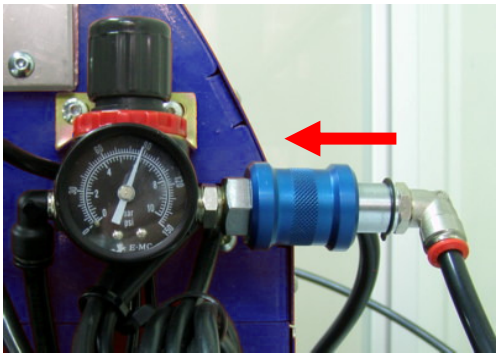
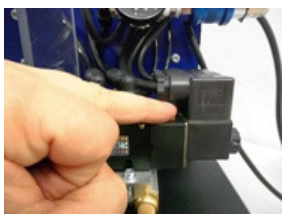
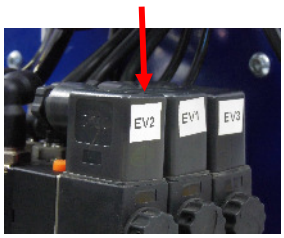
|  | Insert the new adapter with the hole in the direction of the front of the machine. |
|  | Both parts must be inserted into each other. The hole of the upper part faces front. |
|  | After you have taken your hands from the lug area:<br><br>Open the compressed-air inlet valve. |
|    | Press the front switch "EV2" in order to lower the cylinder. |

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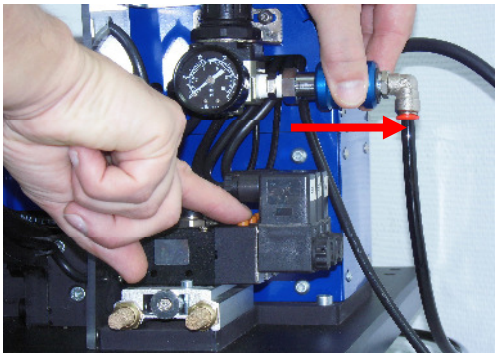
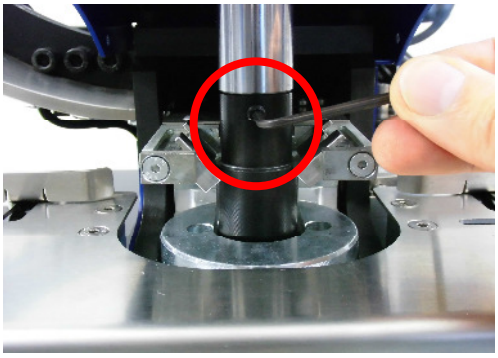
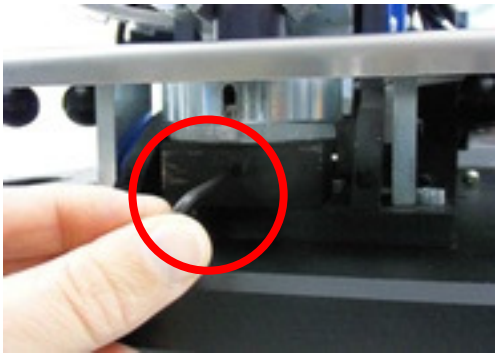
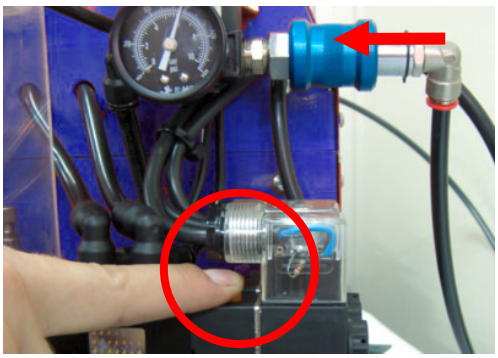
|  | Without removing the finger from the switch, close the compressed-air inlet valve. |
|  | Insert the holding screw at the upper adapter with an Allen key and tighten. |
|  | Insert the holding screw at the lower adapter with an Allen key and tighten. |
|  | Open the compressed air valve and press the front switch "EV2" with the finger in order to check whether the upper adapter fits centrally into the lower adapter. |

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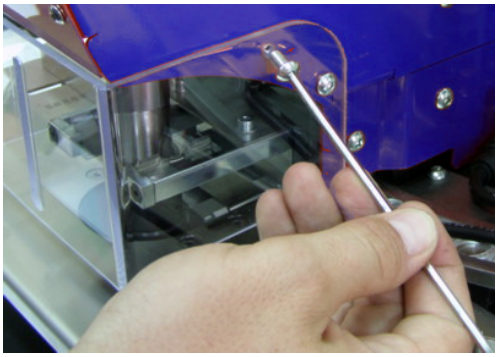
|  | Fix the bolts on the safety cover.<br><br>When you have completed these steps, you can attach the lugs as usual. |

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## 5.3 Changing the lug-attachment tools (adapters) for metal lugs

**Caution**:

In order to insert a new adapter, you must remove the safety covering. Then mount this important safety protection again!

Position the manual switch so that it cannot be pressed by mistake.

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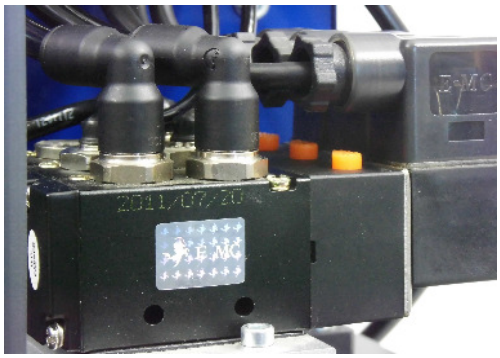
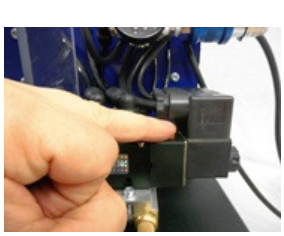
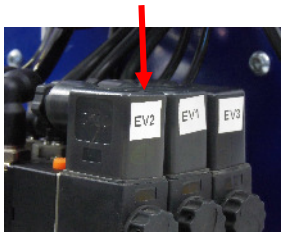
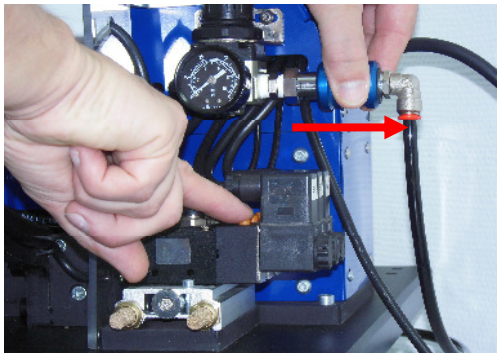
|  | On the rear side of the machine are located 3 electrically-operated valves which take over the distribution of the compressed air, in order to control the different sequences for the lug-attachment. |
|    | Press the button on the front valve with the label "EV2" and hold it pressed. The axis of the cylinder lowers. |
|  | Without removing the finger from the switch, close the compressed-air inlet valve so that the axis of the cylinder remains at its lower position.<br><br>When the valve has changed its position from "Open" to "Closed", the compressed air leaks out from the inner system. An unexpected action of the pneumatic cylinder is prevented by this. |

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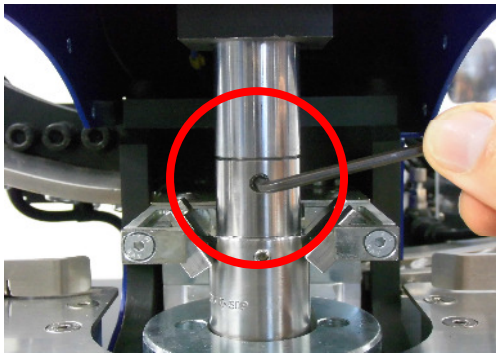
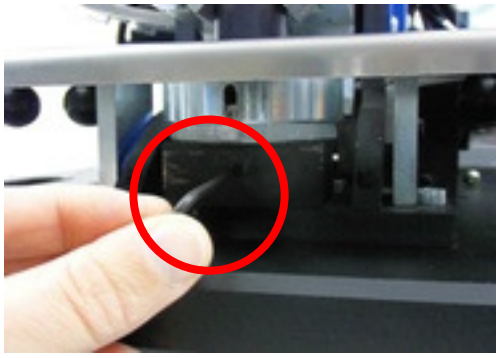
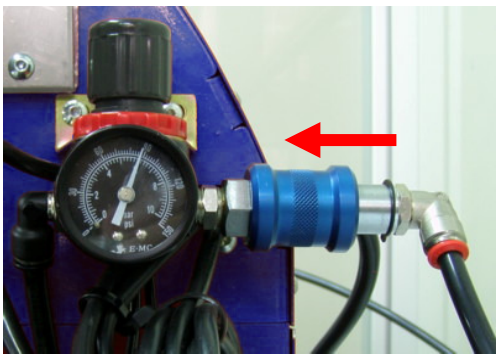
|  | Loosen the four bolts with an Allen key on the safety cover on the front of the machine.<br><br>Remove the safety cover. |
|  | Screw off the holding screw on the upper adapter.<br><br>IN ORDER NOT TO DAMAGE THE MACHINE, YOU MUST REMOVE THE BOLT, NOT JUST LOOSEN IT. |
|  | Screw off the holding screw on the lower adapter.<br><br>IN ORDER NOT TO DAMAGE THE MACHINE, YOU MUST REMOVE THE BOLT, NOT JUST LOOSEN IT. |
|  | Open the compressed-air inlet valve so that the cylinder moves into its upper position. |

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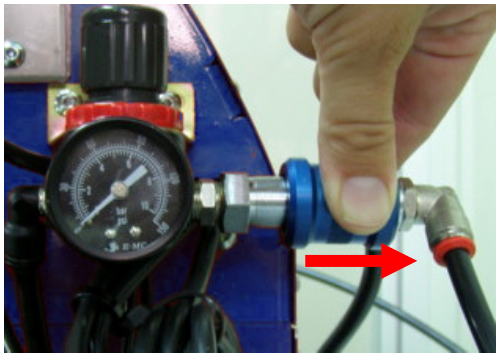
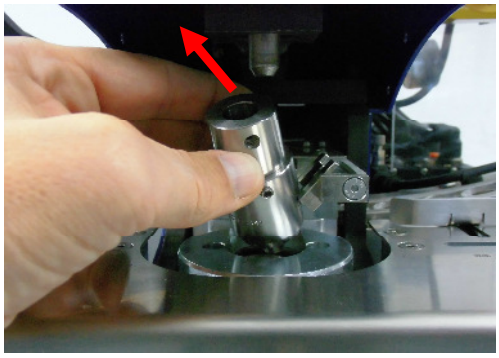
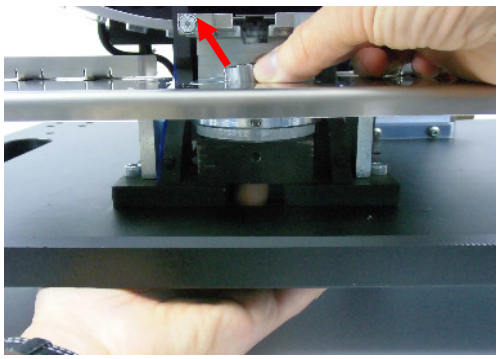
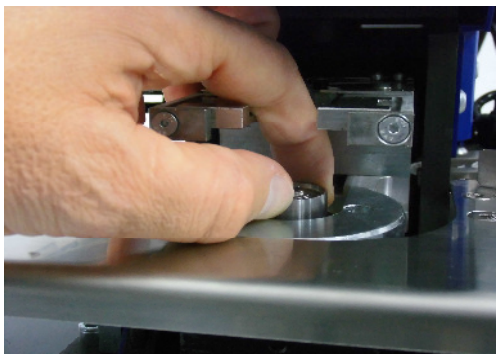
|  | Close the valve in order to work in the lug area. |
|  | Remove the upper adapter from the axis of the cylinder. |
|  | Remove the lower adapter for plastic lugs.<br><br>For this purpose, place your finger through the hole on the roller table and lift the adapter gently. |
|  | Insert the new lower adapter. |

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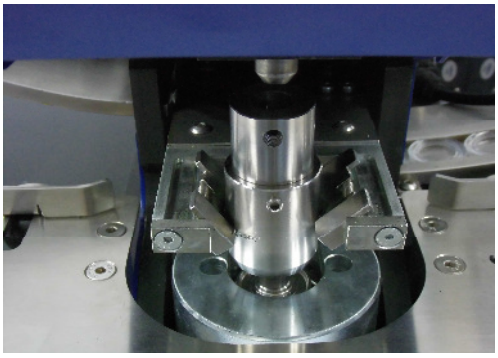
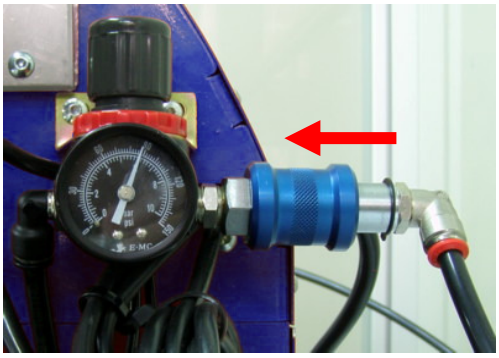
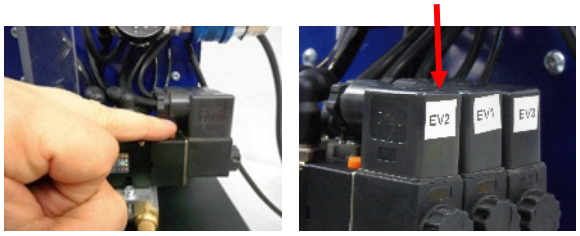
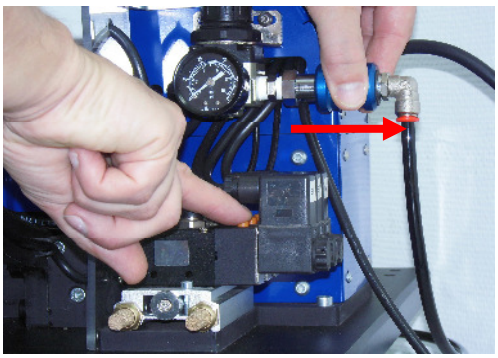
|  | Place the new upper adapter centrally on the lower adapter. Both clasps hold the upper adapter in the middle. The hole faces in the direction of the front of the machine. |
|  | After you have taken your hands out of the lug area:<br><br>Open the compressed-air inlet valve. |
|   | Press the front switch "EV2" in order to lower the cylinder. |
|  | Without removing the finger from the switch, close the compressed-air inlet valve. |

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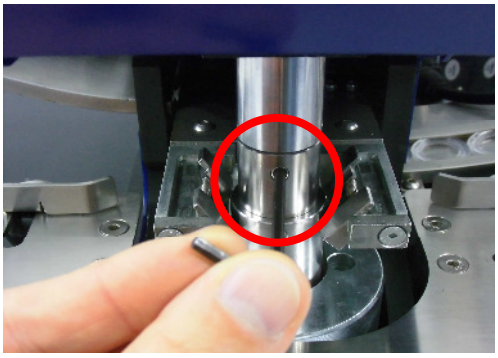
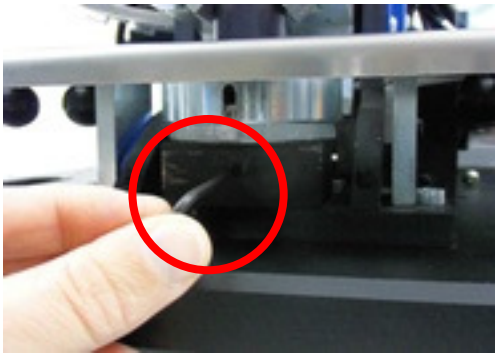
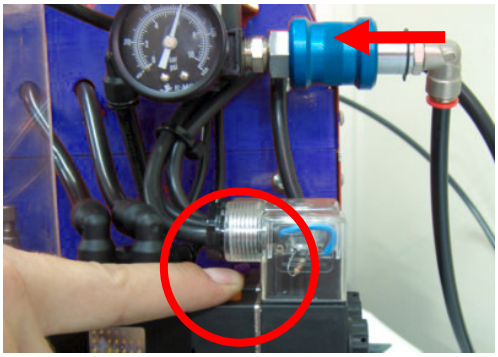
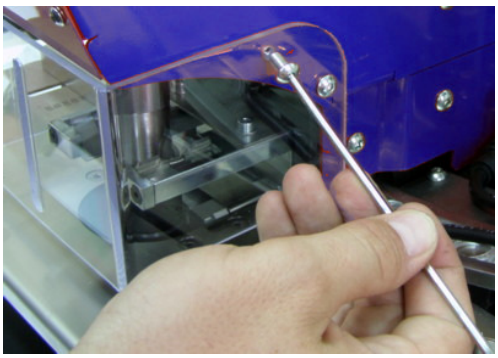
|  | Insert the holding screw at the upper adapter with an Allen key and tighten. |
|  | Insert the holding screw at the lower adapter with an Allen key and tighten. |
|  | Open the compressed air valve and press the front switch "EV2" with the finger in order to check whether the upper adapter fits centrally into the lower adapter. |
|  | Fix the bolts on the safety cover.<br><br>When you have completed these steps, you can attach the lugs as usual. |

## 5.4 Retrofitting from plastic lugs to metal lugs

**Caution**:

In order to insert a new adapter, you must remove the safety covering. Then mount this important safety protection again!

Position the manual switch so that it cannot be pressed by mistake.

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|  | Switch off the device,<br>the green control indicator lamp goes out. |
|  | Remove all washers (lower lug parts) from the right-hand magazine. |
|  | With the next action, ensure that the adjustment of the air nozzle is not changed by mistake. |

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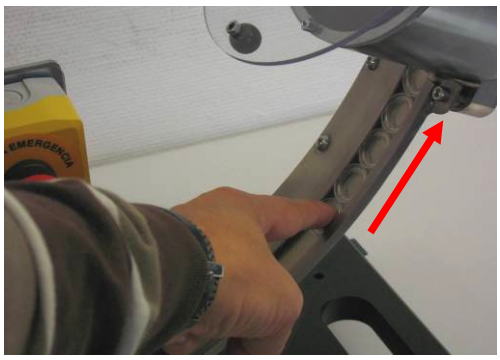
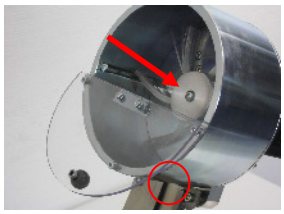
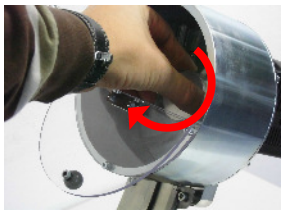
|  | With the finger, slide all washers in the right-hand supply back into the magazine. |
|   | As necessary, rotate the brush by hand so that the input to the supply is free.<br>Then remove the shifted-back washers from the magazine. |
|  | Remove all lugs from the left-hand magazine. |
|  | With the finger, move all lugs in the left-hand supply back into the magazine.<br>As necessary, rotate the brush by hand so that the input to the supply is free.<br>Then remove the shifted-back washers from the magazine. |

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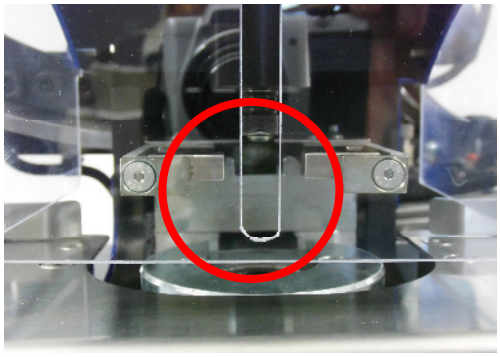
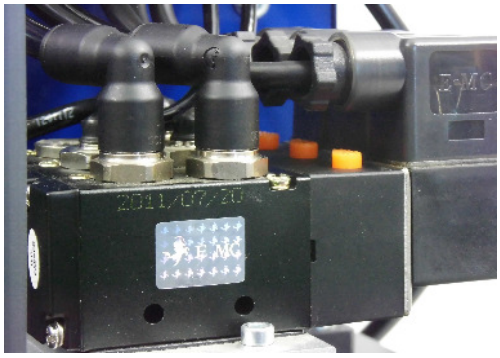
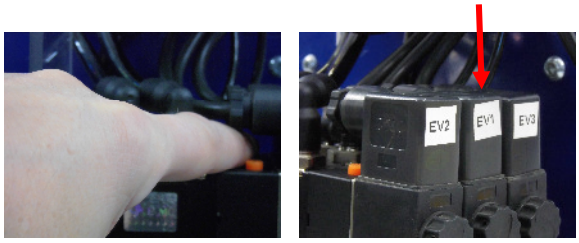
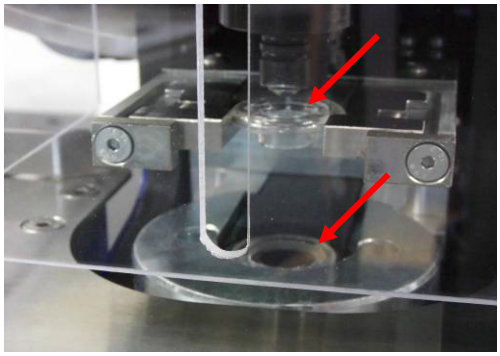
|  | Plastic lugs and washers are still located in the non-accessible area of the supply. |
|  | On the rear side of the machine are located 3 electrically-operated valves which take over the distribution of the compressed air, in order to control the different sequences for the lug-attachment. |
|  | Press the button on the middle valve with the label "EV1" |
|  | A lug and a washer are shifted towards the front. |

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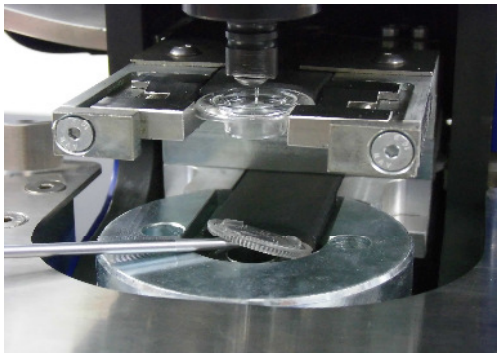
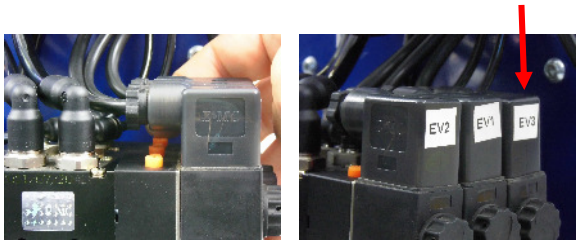
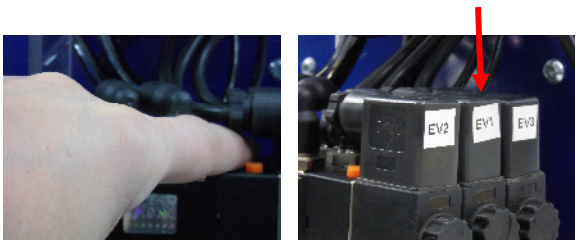
|  | With an Allen key, loosen the four bolts on the safety cover on the front of the machine.<br><br>Remove the safety cover. |
|  | Carefully remove the plastic lugs and washers with a flat screwdriver. |
|  | Press the button on the rear valve with the label "EV3", and with this the washer is blown to the correct position. |
|  | Press the button at the middle valve with the label "EV1" |

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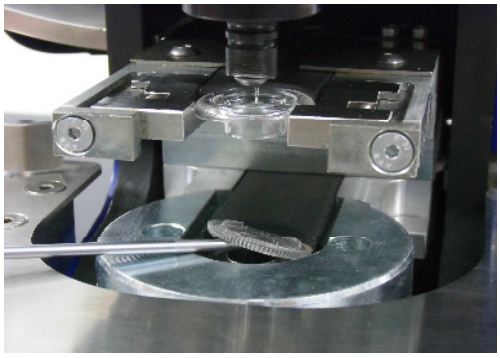
|  | Carefully remove the plastic lugs and washers with a flat screwdriver. |
|  | Fill the left-hand magazine with lugs of metal. |
|  | Fill the right-hand magazine with washers of metal. |
| ! | Caution!<br>After the next action, a complete lug-attachment process can be initiated by the foot pedal.<br><br>**Without covering, an increased danger of injury exists.**<br>**Place the foot-operated switch at a location where nobody can activate it by mistake!!!** |

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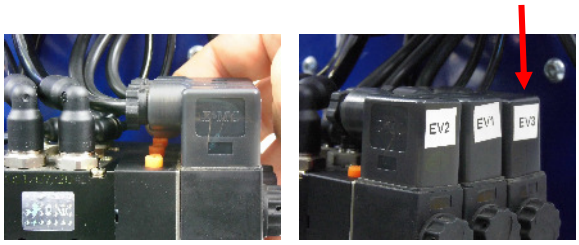
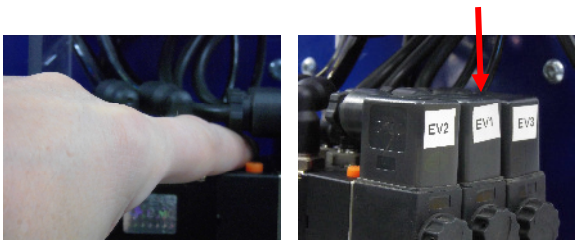
|  | Switch on the device and wait until both conduits are filled completely. |
|  | Switch off the device; the green control indicator lamp goes out. |
|  | Press the button on the rear valve with the label "EV3", with this the washer is blown to the correct position. |
|  | Press the button on the middle valve with the label "EV1" |

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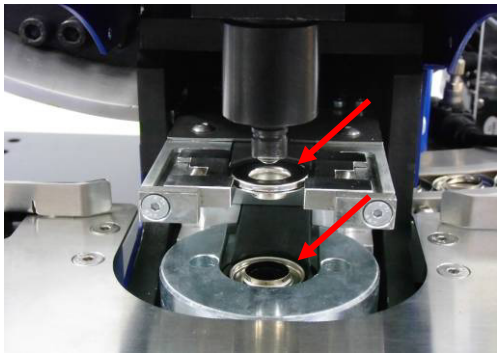
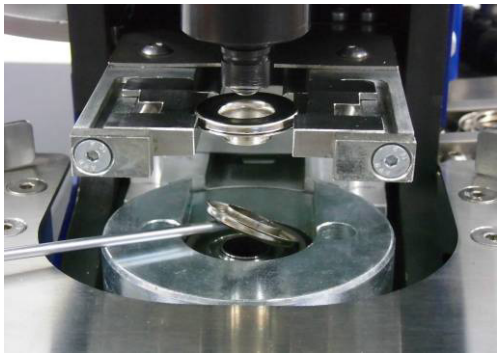
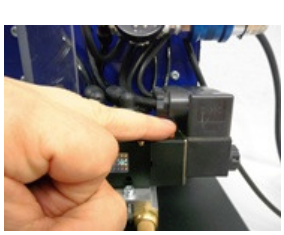
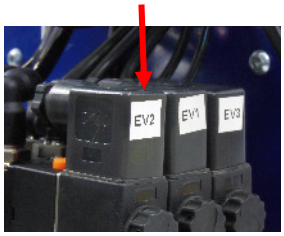
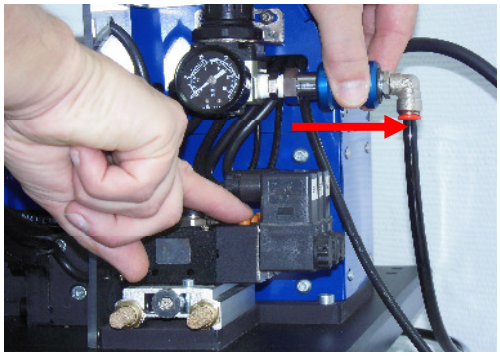
|  | A metal lug should now be located in the lug support above, and a metal washer below.<br><br>If a plastic lug or a plastic washer should still be located there, please remove both parts and repeat the two last steps until one lug and one washer of metal are present in the lug support. |
|  | Remove the metal lug and the metal washer from the lug support. |
|    | Press the button on the front valve with the label "EV2" and hold it pressed. The axis of the cylinder lowers. |
|  | Without removing the finger from the switch, close the compressed-air inlet valve so that the axis of the cylinder remains at its lower position.<br><br>When the valve has changed its position from "Open" to "Closed", the compressed air leaks out from the inner system. An unexpected action of the pneumatic cylinder is prevented by this. |

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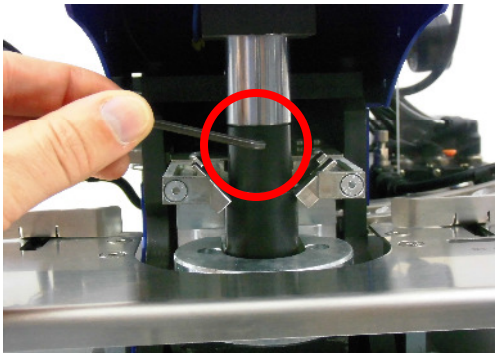
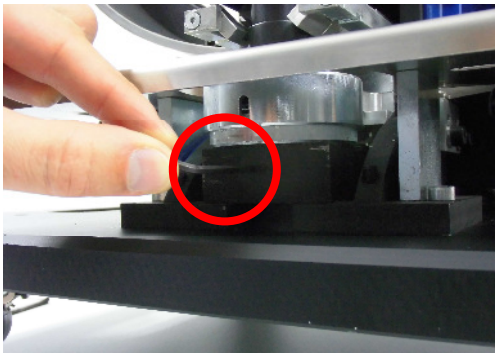
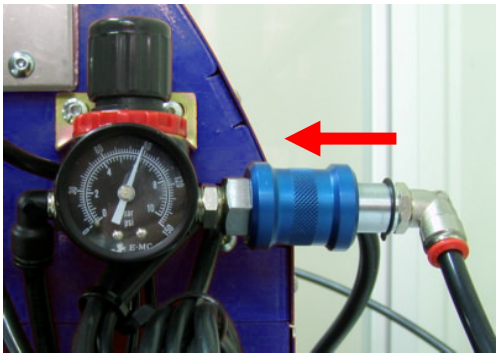
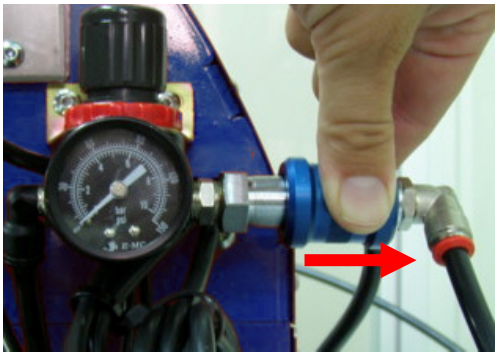
|  | Screw off the holding screw on the upper adapter.<br><br>IN ORDER NOT TO DAMAGE THE MACHINE, YOU MUST REMOVE THE BOLT, NOT JUST LOOSEN IT. |
|  | Screw off the holding screw on the lower adapter.<br><br>IN ORDER NOT TO DAMAGE THE MACHINE, YOU MUST REMOVE THE BOLT, NOT JUST LOOSEN IT. |
|  | Open the compressed-air inlet valve so that the cylinder moves into its upper position. |
|  | Close the valve in order to work in the lug area. |

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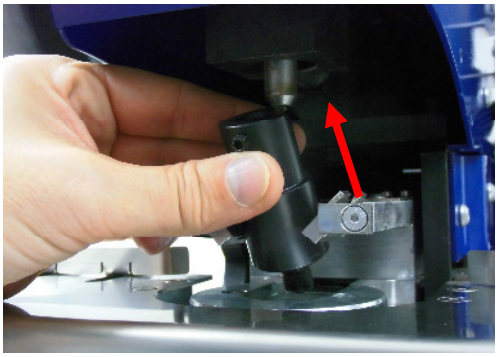
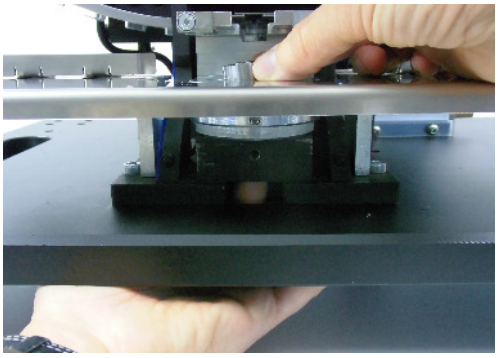
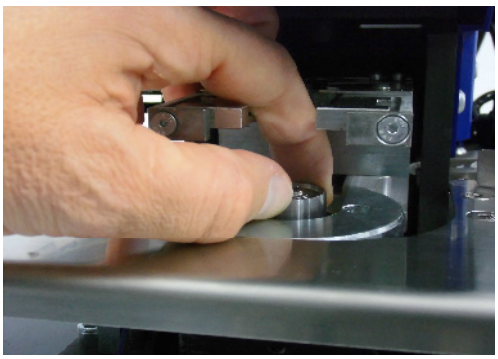
|  | Remove the upper adapter from the axis of the cylinder. |
|  | Remove the lower adapter for plastic lugs.<br><br>For this purpose, place your finger through the hole on the roller table and lift the adapter gently. |
|  | Insert the lower adapter for metal lugs. |
|  | Screw off the holding screw on the upper adapter for metal lugs.<br><br>IN ORDER NOT TO DAMAGE THE MACHINE, YOU MUST REMOVE THE BOLT, NOT JUST LOOSEN IT. |

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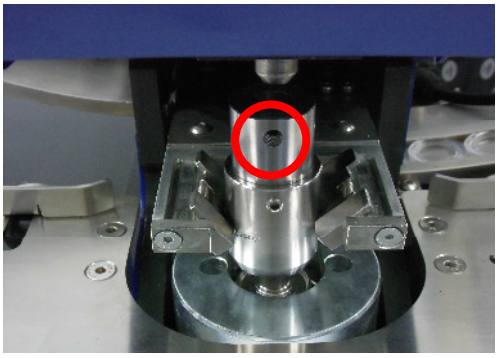
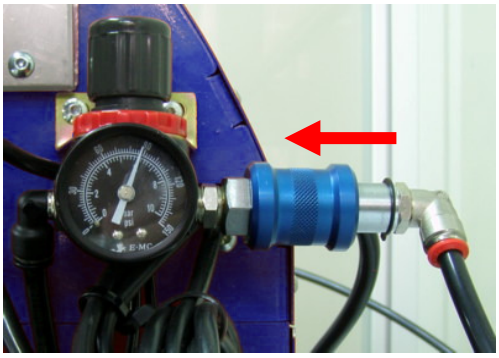
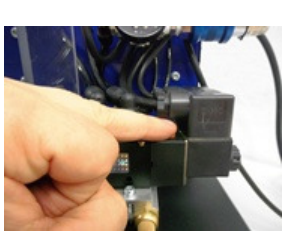
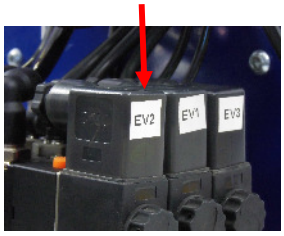
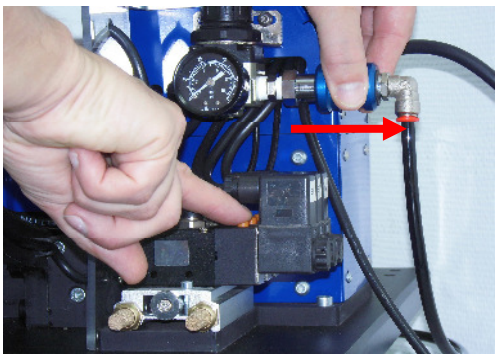
|  | Place the upper metal adapter centrally onto the lower adapter. Both clasps hold the upper adapter.<br>The hole for the bolts faces toward the front. |
|  | After you have taken your hands out of the lug area:<br><br>Open the compressed-air inlet valve. |
|    | Press the front switch "EV2" in order to lower the cylinder. |
|  | Without removing the finger from the switch, close the compressed-air inlet valve. |

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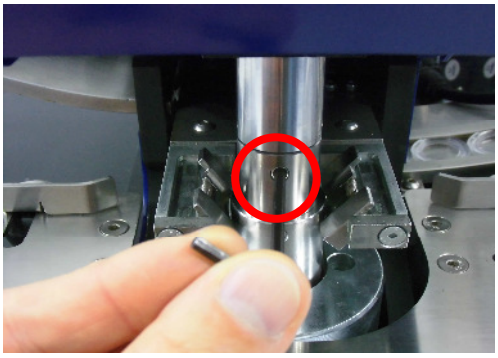
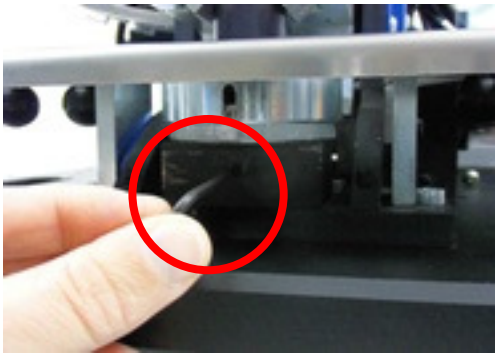
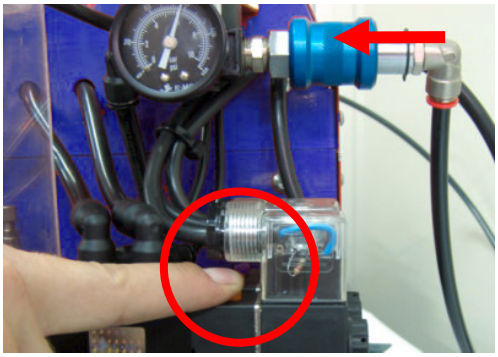
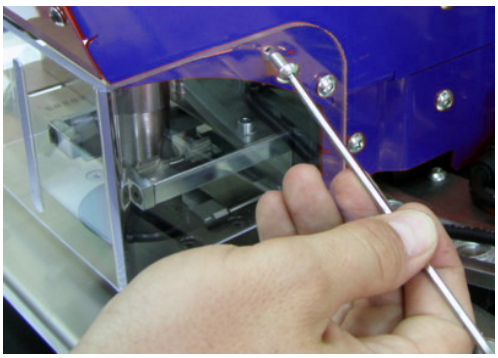
|---|---|
|  | Insert the holding screw at the upper adapter with an Allen key and tighten. |
|  | Insert the holding screw at the lower adapter with an Allen key and tighten. |
|  | Open the compressed air valve and press the front switch "EV2" with the finger in order to check whether the upper adapter fits centrally into the lower adapter. |
|  | Fix the bolts on the safety cover.<br><br>When you have completed these steps, you can attach the lugs as usual. |

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## 5.5 Retrofitting from metal lugs to plastic lugs

**Caution**:

In order to insert a new adapter, you must remove the safety covering. Then mount this important safety protection again!

Position the manual switch so that it cannot be pressed by mistake.

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|  | Switch off the device,<br>the green control indicator lamp goes out. |
|  | Remove all washers (lower lug parts) from the right-hand magazine. |
|  | With the next action, ensure that the adjustment of the air nozzle is not changed by mistake. |

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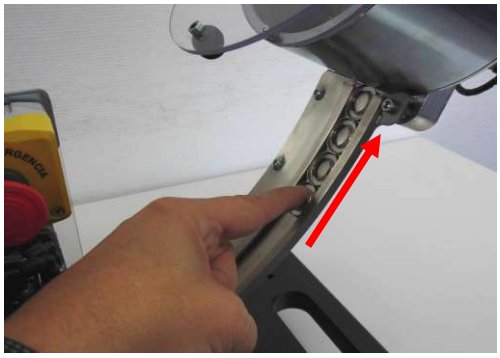
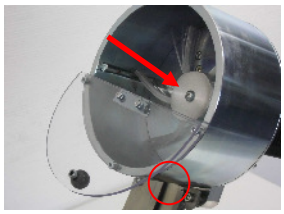
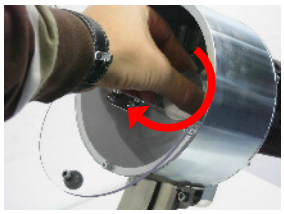
|  | With the finger, slide all washers in the right-hand supply back into the magazine. |
|   | As necessary, rotate the brush by hand so that the input to the supply is free.<br>Then remove the shifted-back washers from the magazine. |
|  | Remove all lugs from the left-hand magazine. |
|  | With the finger, move all lugs in the left-hand supply back into the magazine.<br>As necessary, rotate the brush by hand so that the input to the supply is free.<br>Then remove the shifted-back washers from the magazine. |

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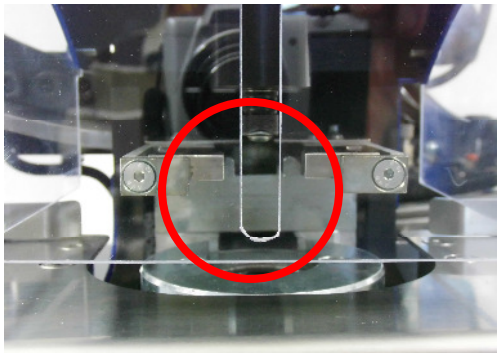
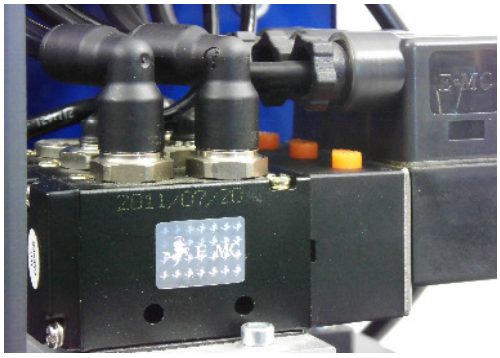
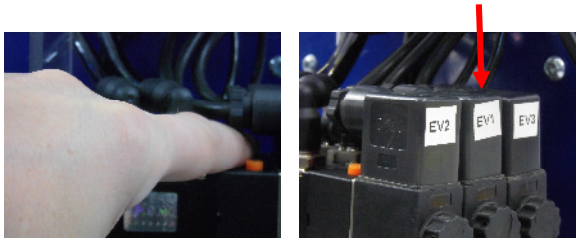
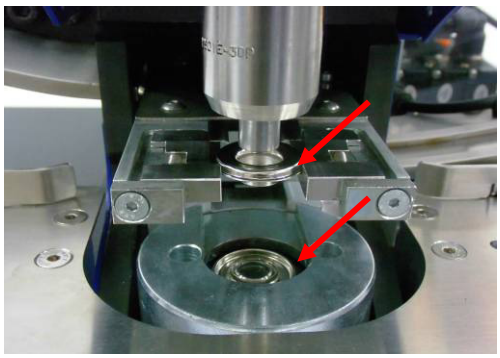
|  | Metal lugs and washers are still located in the non-accessible area of the supply. |
|  | On the rear side of the machine are located 3 electrically-operated valves which take over the distribution of the compressed air, in order to control the different sequences for the lug-attachment. |
|  | Press the button on the middle valve with the label "EV1" |
|  | A lug and a washer are shifted towards the front. |

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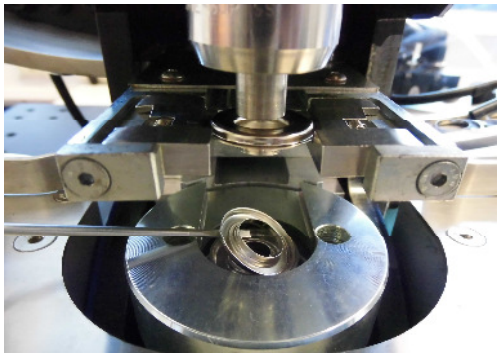
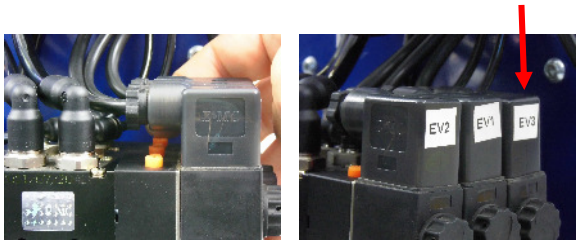
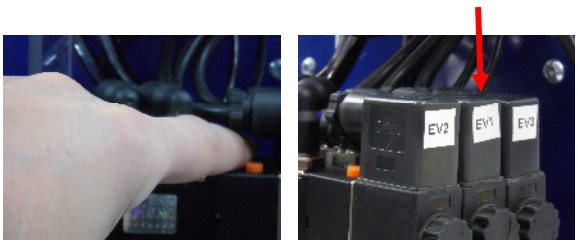
|  | With an Allen key, loosen the four bolts on the safety cover on the front of the machine.<br><br>Remove the safety cover. |
|  | Carefully remove the metal lugs and washers with a flat screwdriver. |
|  | Press the button on the rear valve with the label "EV3", and with this the washer is blown to the correct position. |
|  | Press the button at the middle valve with the label "EV1" |

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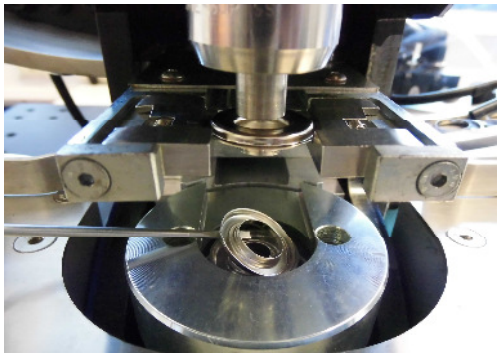
|  | Carefully remove the metal lugs and washers with a flat screwdriver. |
|  | Fill the right-hand magazine with the washers of plastic. |
|  | Fill the left-hand magazine with the lugs of plastic. |
| ! | Caution!<br>After the next action, a complete lug-attachment process can be initiated by the foot pedal.<br><br>**Without covering, an increased danger of injury exists.**<br>**Place the foot-operated switch at a location where nobody can activate it by mistake!!!** |

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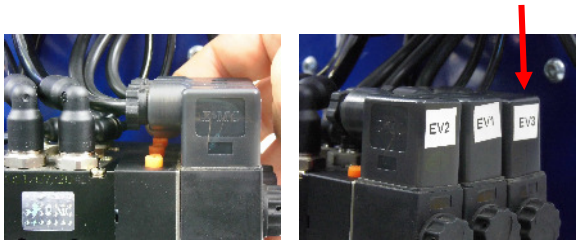
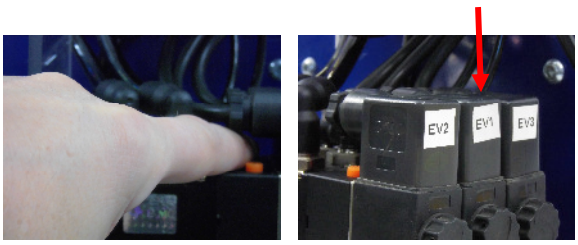
|  | Switch on the device and wait until both conduits are filled completely. |
|  | Switch off the device; the green control indicator lamp goes out. |
|  | Press the button on the rear valve with the label "EV3", with this the washer is blown to the correct position. |
|  | Press the button on the middle valve with the label "EV1" |

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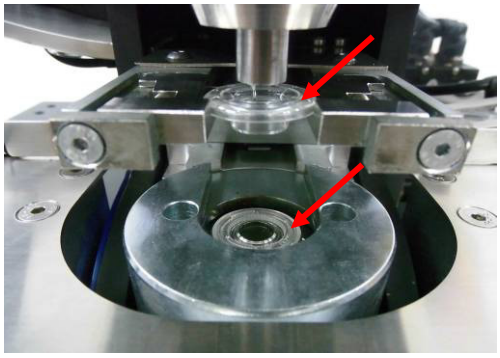
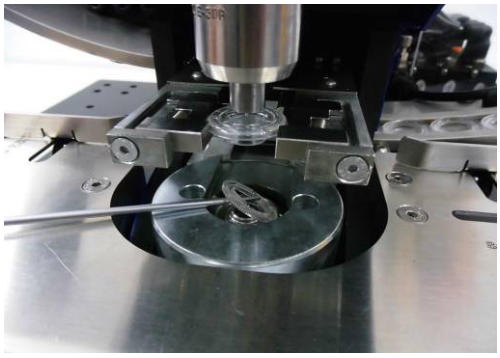
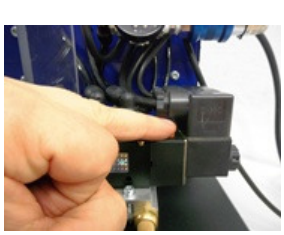
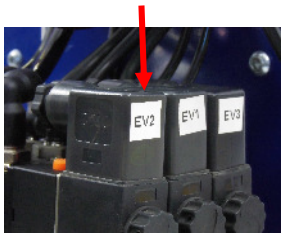
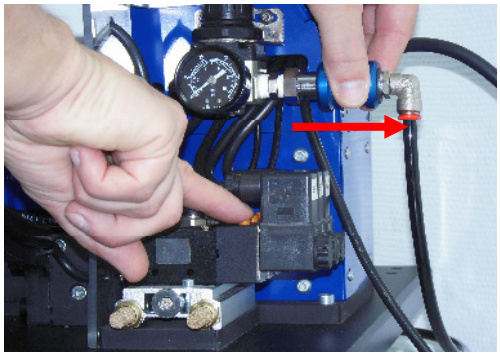
|  | A plastic lug should now be located in the lug support above, and a plastic washer below.<br><br>If a metal lug or a metal washer should still be located there, please remove both parts and repeat the two last steps until one lug and one washer of plastic are present in the lug support. |
|  | Carefully remove the plastic lug and washer with a flat screwdriver. |
|    | Press the button on the front valve with the label "EV2" and hold it pressed. The axis of the cylinder lowers. |
|  | Without removing the finger from the switch, close the compressed-air inlet valve so that the axis of the cylinder remains at its lower position.<br><br>When the valve has changed its position from "Open" to "Closed", the compressed air leaks out from the inner system. An unexpected action of the pneumatic cylinder is prevented by this. |

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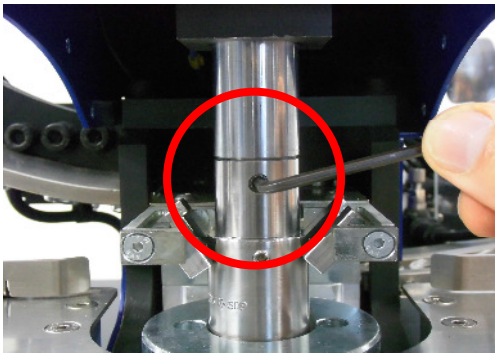
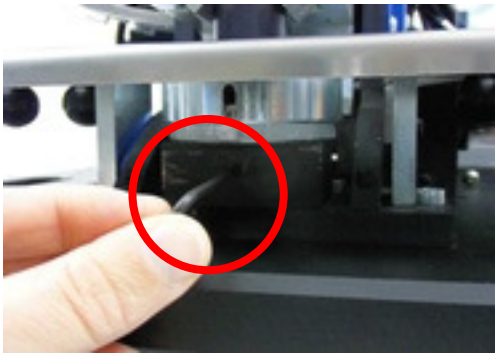
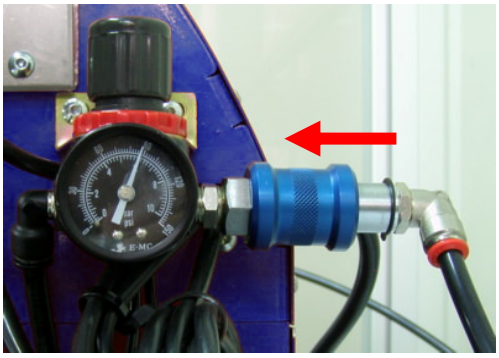
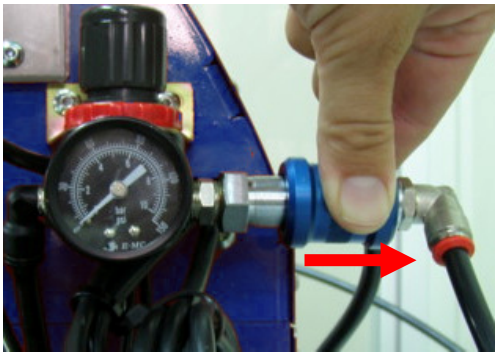
|  | Screw off the holding screw on the upper adapter.<br><br>IN ORDER NOT TO DAMAGE THE MACHINE, YOU MUST REMOVE THE BOLT, NOT JUST LOOSEN IT. |
|  | Screw off the holding screw on the lower adapter.<br><br>IN ORDER NOT TO DAMAGE THE MACHINE, YOU MUST REMOVE THE BOLT, NOT JUST LOOSEN IT. |
|  | Open the compressed-air inlet valve so that the cylinder moves into its upper position. |
|  | Close the valve in order to work in the lug area. |

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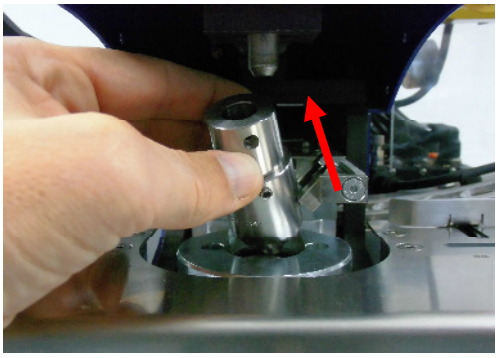
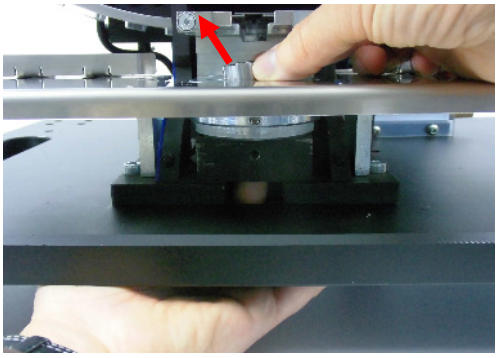
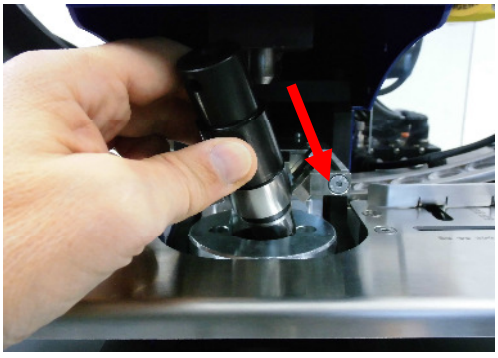
|  | Remove the upper adapter from the axis of the cylinder. |
|  | Remove the lower adapter for plastic lugs.<br><br>For this purpose, place your finger through the hole on the roller table and lift the adapter gently. |
|   | 1. Remove the holding screw of the upper part from the new adapter.<br>2. Insert both parts into each other. |
|  | Insert the new adapter with the hole in the direction of the front of the machine. |

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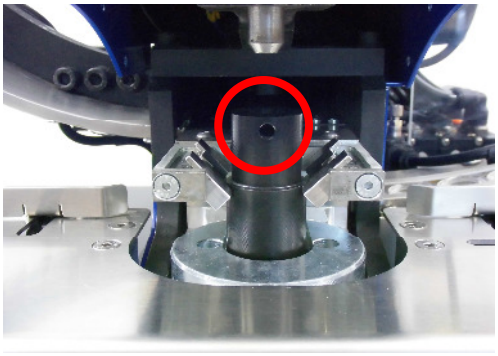
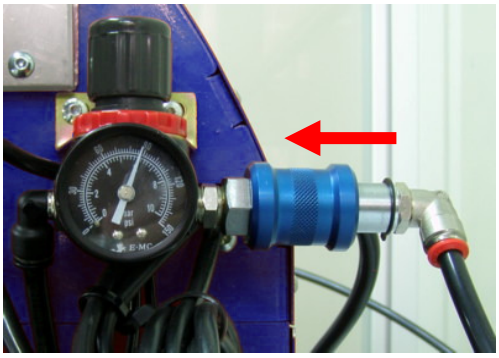
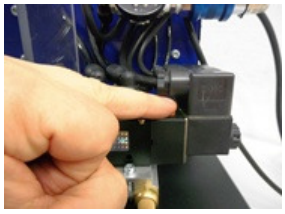
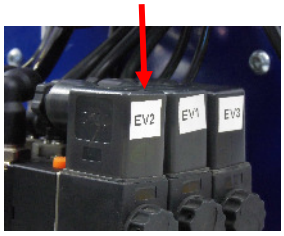
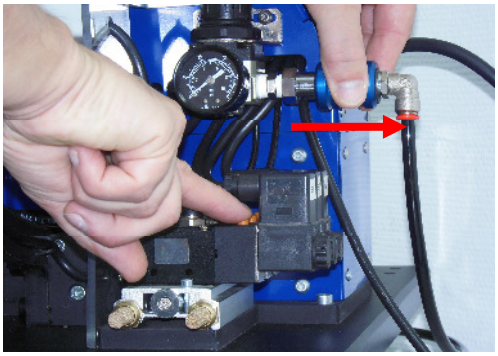
|  | Both parts must be inserted into each other. The hole of the upper part faces front. |
|  | After you have taken your hands from the lug area:<br><br>Open the compressed-air inlet valve. |
|    | Press the front switch "EV2" in order to lower the cylinder. |
|  | Without removing the finger from the switch, close the compressed-air inlet valve. |

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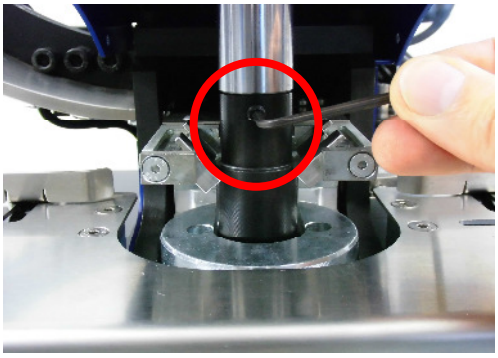
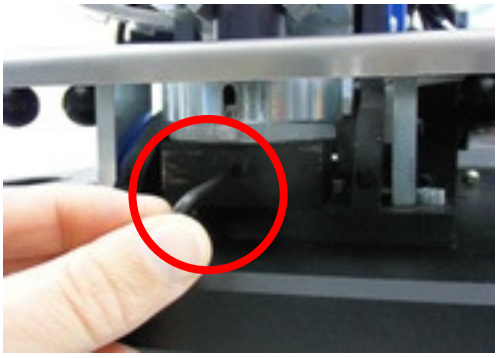
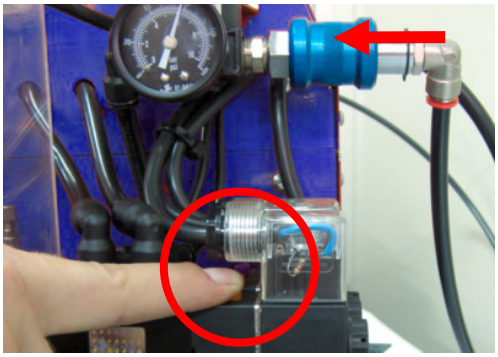
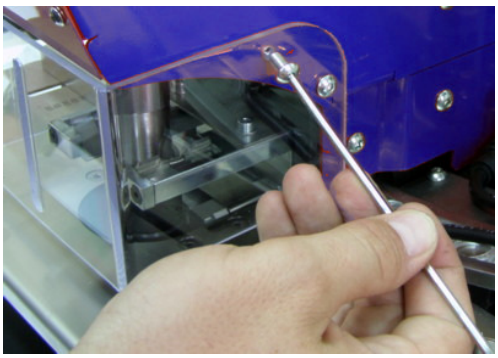
| | |
|---|---|
|  | Insert the holding screw at the upper adapter with an Allen key and tighten. |
|  | Insert the holding screw at the lower adapter with an Allen key and tighten. |
|  | Open the compressed air valve and press the front switch "EV2" with the finger in order to check whether the upper adapter fits centrally into the lower adapter. |
|  | Fix the bolts on the safety cover.<br><br>When you have completed these steps, you can attach the lugs as usual. |

# 6 Maintenance

It is not necessary to lubricate mechanical parts of the machine.

For an optimal operation of the PRMCH, it is important to keep some areas clean. This should always be done with the following adjustments a) air pressure valve at "closed" and b) main current switch at "OFF" (no green light).

The supplies of the lugs and spacing washers should always be clean; we recommend cleaning with compressed air at the end each working day. Small parts or threads can stop the run of the lugs and spacing washers.

It is important to keep the lug area clean, particularly the upper adapter where threads or residues can possibly stick, see the area in Fig. 9a and 9b.

Adapter for plastic lugs
Fig. 9a

Adapter for metal lugs
Fig.9b


Fig. 10

We recommend cleaning with a compressed air gun through the open slot in the safety cover on the front of the device (Fig. 10). This procedure should be carried out at least once a day, where this can be necessary more often depending on the materials employed.

The release button and the foot pedal should always be clean so that no parts hinder a trouble-free lug-attachment process.

The exterior parts of the machine should be wiped off with a lint-free textile (particularly important with the supply of the lugs and spacing washers).

If you do not use the machine for a longer period, we recommend the following steps:

1. Disconnection from the compressor
2. Disconnection from the power source.
3. Cleanup.
4. Covering, in order to protect against dust and humidity.

If you have connected the machine to a compressor or compressed-air system, please remember the insertion of an air filter and a moisture separator.

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# 7 Notes on faults

## 7.1 Problem handling

| PROBLEM | CAUSE | SOLUTION |
|---|---|---|
| **The device does not function.** | 1. Check whether the air hose is connected to the compressor. | 1. Connect the air hose. |
| | 2. Check whether the air pressure valve is open. | 2. Open the air pressure valve. |
| | 3. Check whether the main switch is on (green lamp lights up) | 4. Switch the device to "ON". |
| | 3. Check whether the air pressure is adjusted to 6 kg/cm$^{2.}$ | 3. Operate the manometer until the correct pressure is adjusted. |
| **The device does not cut.** | 1. Check whether the air pressure is adjusted to 6 kg/cm$^2$ | 1. Operate the manometer until the correct pressure is adjusted. |
| | 2. The edges of the lower adapter are worn or are defective. | 2. Change the adapter. |
| **During lug-attachment process the plastic lugs crush together.** | 1. Check whether the air pressure is adjusted to 6 kg/cm$^2$ | 1. Operate the manometer until the correct pressure is adjusted. |
| **Suddenly the lugs do not close correctly.** | 1. Check whether the air pressure is adjusted to 6 kg/cm$^2$ | 1. Operate the manometer until the correct pressure is adjusted. |
| **Lugs/Spacing washers do not come from the container/supply** | 1. Check whether the exit of the container is blocked. | 1. Stop the motor and remove the block/parts. |
| | 2. Check the container (particularly in case of the spacing washers) as to whether this is not overfilled. | 2. Take out a part so that the container again functions trouble-free |
| **Compressed air leaks out from the device.** | 1. Check the compressed air valve as to whether it is completely open. | 1. Open the valve completely. If it is open only half-way, the compressed air leaks out. |

# 8 Safety

## 8.1 Safety devices

The device has a series of safety devices so that the user does not unintentionally enter into dangerous areas (except for maintenance or repair) and sustain injuries.

The most dangerous area of the device is the lug area "X", where the user can have his fingers or hands crushed.

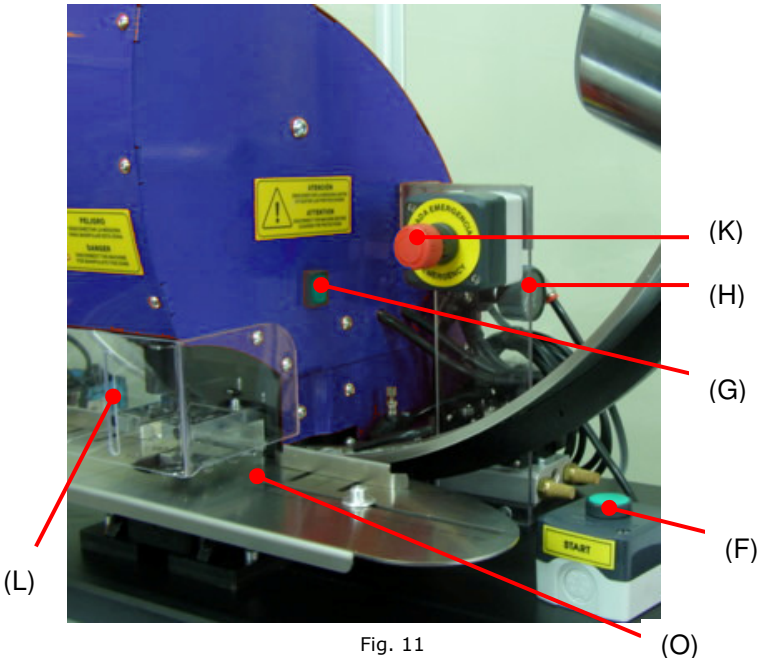



Fig. 11


Fig. 12

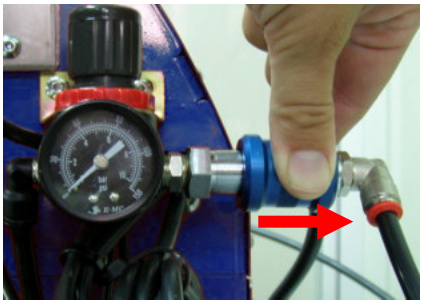
The danger area "X" is protected by the following:

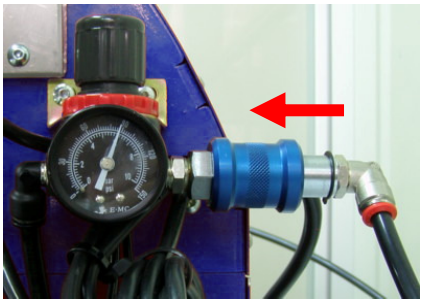
⇒ **Acrylic safety cover (L)**: Protects the user against unintentional reaching into the lug area with the fingers or hands.

⇒ **Stainless steel plate (O):** Protects the user against unintentional reaching into the danger area with the fingers or hands.

⇒ **Main compressed-air valve (H):** This valve makes possible the manual opening and closing of the pneumatic air flow from a compressor or a central air supply. As a safety device, it is provided with a decompression system where the controller position is changed from open to closed. The compressed air of the internal circuit of the machine is discharged in order to prevent any unexpected action of the pneumatic cylinder during installation or adjustment of the device.

Closed Open





⇒ **The Emergency Off switch "K":** If an emergency has occurred on the machine, the current is switched off with pressing the Emergency Off.

There are some stick-on labels on the machine which the user should consider:

⇒ **Stick-on label "Read manual"**: The stick-on label to the left on the covering of the machine makes it clear to the user that it is absolutely necessary to read the manual.


Fig. 15

⇒ **Stick-on label "Danger":** This stick-on label in front on the cover informs the user about the danger of breaking fingers or bones in the hand by carrying out changes in this area.

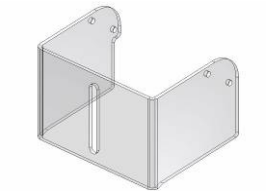
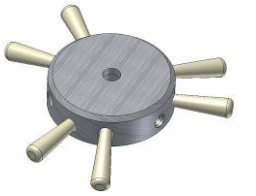
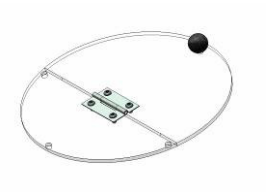

Fig. 16

⇒ **Stick-on label "Pull out the plug connector before taking out the fuse":** The stick-on label to the right on the cover informs the user that, before taking out any fuse protection, the device must be disconnected from the mains (close air inlet valve) and the main switch must be switched off.


Fig. 17

# 9 APPENDIX

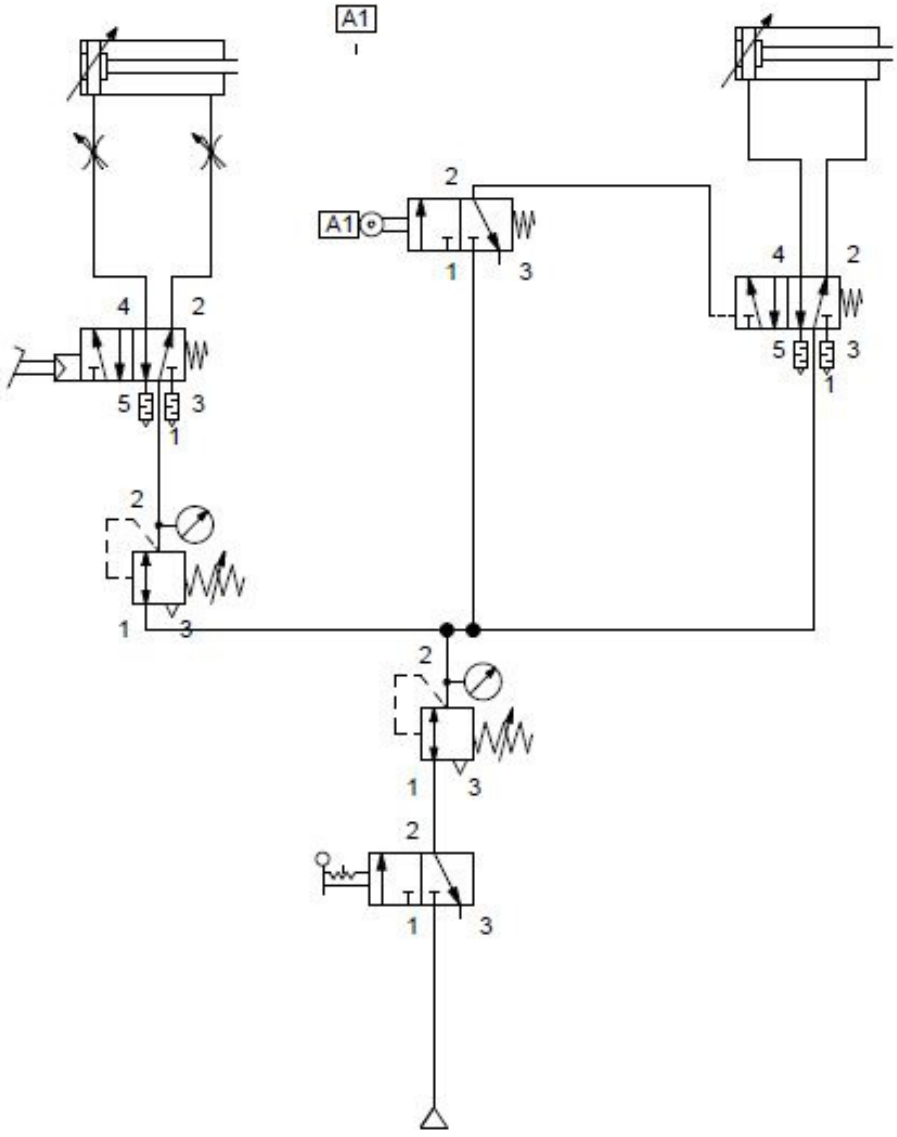
## 9.1 SPARE PARTS LIST

| DESIGNATION | ILLUSTRATION |
|---|---|
| 22664 lug receptacle 12 mm for plastic lugs |  |
| 24142 lug receptacle 11 mm for metal lugs |  |
| Safety cover |  |
| Brush |  |
| Acrylic cover |  |

## 9.2 ADJUSTING TOOL

| DESIGNATION | ILLUSTRATION | QUANTITY |
|---|---|---|
| Allen key<br># 3 |  | 1 |

## 9.3 PNEUMATICS SCHEMATIC



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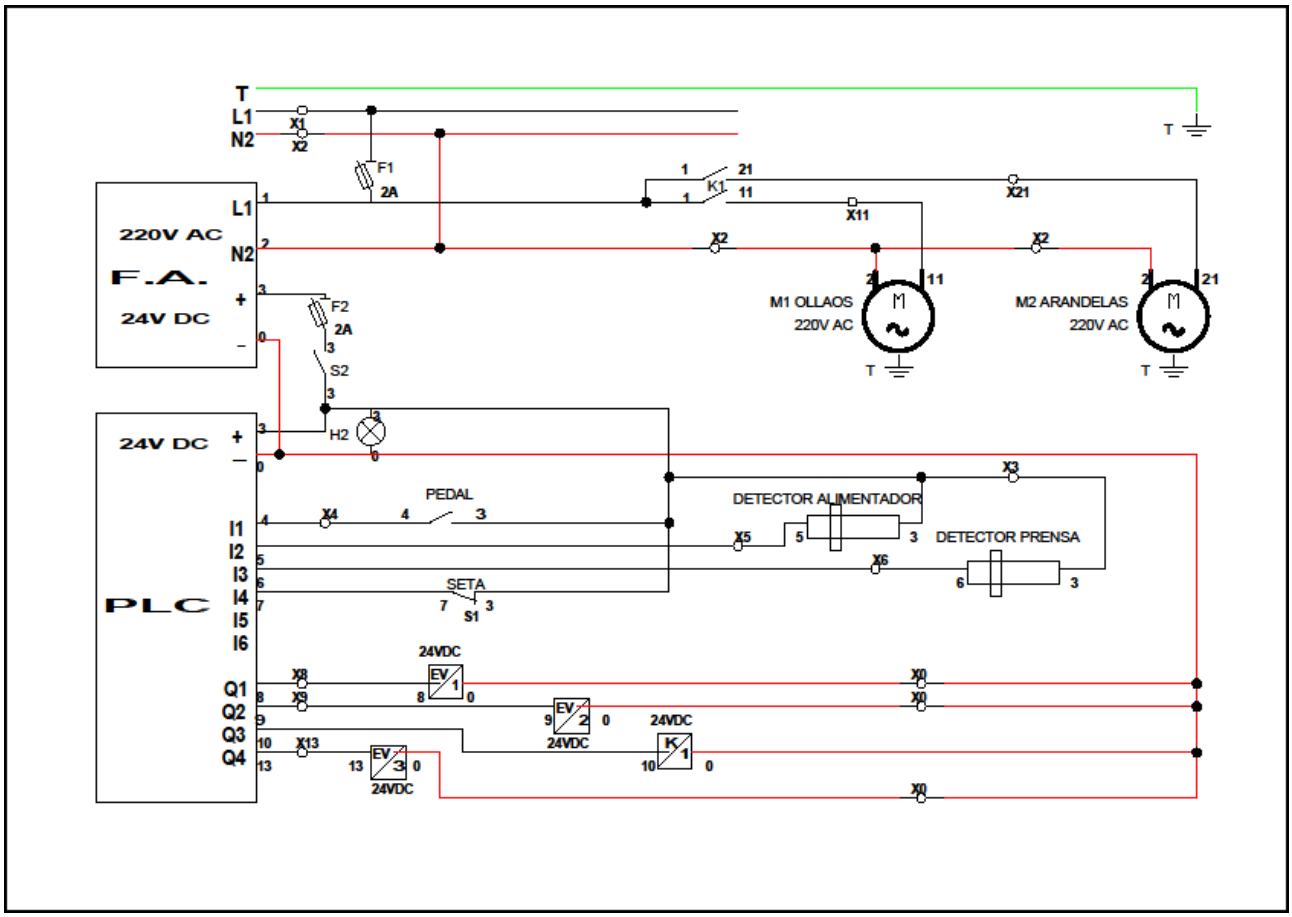
## 9.4 CIRCUIT DIAGRAM



## 9.5 "CE" DECLARATION OF CONFORMITY

**"CE" DECLARATION OF CONFORMITY**

We, **DATAPLOT GmbH**
Gutenbergstraße 15
24558 Henstedt-Ulzburg,

as manufacturer of the **EMBLEM** brand**,** declare in our own responsibility that the machine:

- Brand: EMBLEM
- Model: PRMCH
- Serial number:

conforms with the EU Directive for Safety Regulations for Operating Resources 98/37/CE and is in complete agreement with the preceding Directive 89/392/CEE and its subsequent modifications (Directives 91/368/CEE, 93/44/CEE and 93/68/CEE).