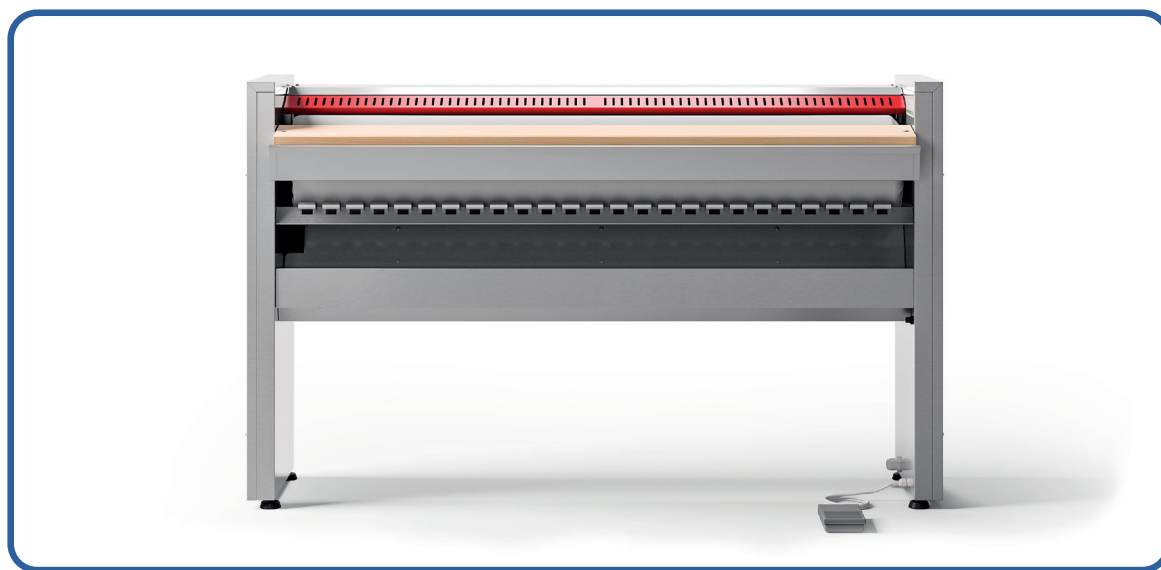


OPERATING AND MAINTENANCE INSTRUCTIONS

ROLLER IRONER GI 1218 - 1418 - 1225 - 1425

Edition 05.2023 - GR811010300073



PREFACE

All rights reserved. No part of this manual may be reproduced or transmitted in any form or by any means, electronic or mechanical, including photocopying, recording, information storage and retrieval systems, for any purpose other than the purchaser's personal use, without the express written permission of the Manufacturer.

The Manufacturer cannot be held liable for the consequences resulting from incorrect operations performed by the user.

GENERAL CONSIDERATIONS

Comply with all operating, maintenance instructions and recommendations described in this manual.

For better results, The Manufacturer recommends performing cleaning and maintenance operations regularly to keep the machine in the best conditions.

It is essential to train the personnel in charge of running, performing maintenance, and inspecting the machine in compliance with the operating procedures and safety standards indicated in these user manual.

Remember that the Manufacturer, in any case, is always available to provide clarifications or further information.

MODIFICATIONS AND UPDATES

If the appliance needs any changes or functional replacements, the instructions review or update shall be borne by the Manufacturer. The Manufacturer is responsible for delivering the update instructions.

The user also has the responsibility to make sure that if this document undergoes changes by the Manufacturer, only the updated versions of the instructions for use and maintenance are actually available at the points of use.

The Manufacturer reserves the right to change, correct or update this handbook without notice.

LANGUAGE

The original manual has been drawn up in Italian.

Any translations into additional languages must be made from the original instructions.

The Manufacturer shall be responsible for the information contained in the original instructions. Translations into different languages cannot be fully verified so, in case of inconsistencies, please follow the text in the original language, or contact the Manufacturer's Technical Documentation Office.

SUPPORT AND AVAILABILITY

If needed, instructions are available on the Manufacturer's Website or can be directly requested to the Manufacturer.



IMPORTANT!

Read these instructions for use and maintenance before proceeding with the installation and use of the appliance.

INDEX OF REVISIONS

Version	Revision	Date
1	0	05 / 2023

INDEX

PREFACE.....	2
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INFORMATION AND DEFINITIONS

RECIPIENTS.....	7
SUPPLY AND STORAGE	7
SYMBOLS USED IN THE MANUAL.....	7
GLOSSARY OF THE TERMS USED.....	8

WARNINGS AND RESIDUAL RISKS

DEFINING THE OPERATOR QUALIFICATIONS	9
SAFETY GENERAL WARNINGS	9
ADDITIONAL WARNINGS FOR SELF-SERVICE ENVIRONMENTS.....	12
SAFETY WARNINGS FOR THE IRONER	12
OBLIGATIONS.....	14
PROHIBITIONS	15
RESIDUAL RISKS	15

IDENTIFICATION

MACHINE IDENTIFICATION	17
MANUFACTURER IDENTIFICATION	17
SUPPLIER IDENTIFICATION.....	17
MACHINE VERSIONS.....	18
IDENTIFICATION PLATE	18
DECLARATION OF CONFORMITY.....	19
WARRANTY	20

DESCRIPTION, TECHNICAL DATA, INTENDED USE

INTENDED USE.....	21
IMPROPER, REASONABLY PREDICTABLE USE.	21
NOISE	22
GENERAL DESCRIPTION	22
MAIN COMPONENTS.....	23
DIMENSIONS	24
TECHNICAL DATA	25
IP PROTECTION	25
SAFETY DEVICES.....	25

TRANSPORTATION, STORAGE, UNPACKING

SAFETY WARNINGS FOR TRANSPORT	27
TABLE OF DIMENSIONS AND WEIGHTS FOR TRANSPORT	27
SPECIFIC SAFETY WARNINGS	27
TRANSPORT WITH TRANSPALLET.....	28
UNPACKING	28
PACKAGING DISPOSAL.....	29
STORAGE	29

INSTALLATION AND CONNECTIONS

INSTALLATION	31
LIMITS AND PERMITTED ENVIRONMENTAL CONDITIONS	31
INSTALLATION AND POSITIONING SITE.....	32
LEVELLING.....	32
SECURING.....	32
ELECTRICAL CONNECTION	34
POWER SUPPLY CONNECTION	34
IRONING VAPOUR EXHAUST (FUMES).....	37

SETTINGS, ADJUSTMENTS, COMMISSIONING

ADJUSTMENTS	39
COMMISSIONING AND TESTING	39
REMOVAL OF THE BASIN BLOCK.....	39
ADJUSTMENT OF THE INTRODUCTION AXIS	39
FIRST START-UP	40
TIPS FOR THE CORRECT USE OF THE MACHINE.....	40
PROCEDURES TO BE ADOPTED IN EXTRAORDINARY CASES	41
NO NETWORK.....	41
ENTRAPMENT OF THE PERSON.....	41

ROUTINE MAINTENANCE, CLEANING

ADDITIONAL SAFETY INSTRUCTIONS FOR MAINTENANCE.....	43
ROUTINE MAINTENANCE	43
VERIFICATION TABLE	44
CHECKING THE ROLLER CIRCUMFERENCE	44
WASHING OR REPLACING THE CLOTH.....	45
TENSIONING THE ROLLER DRIVE CHAIN	47
TIGHTENING TORQUES.....	47
VERIFICATION OF THE IRONING BASIN	48
VERIFICATION OF EARTH CONNECTION.....	48
VERIFICATION OF THE BASIN PREMIUM COMPLEX.....	49
LUBRICATION.....	50
CLEANING.....	51
CLEANING OF PANELLING AND GRIDS.....	52
CLEANING AND WAXING THE BASIN.....	52
CLEANING THE INSIDE OF THE MACHINE	53

OPTIONAL MODULES

PRESSURE ROLLER RIBBON DEVICE	55
INSTALLATION	55
LAUNDRY TUB	55
INSTALLATION	55

TECHNICAL MAINTENANCE

EXTRAORDINARY MAINTENANCE	57
REPLACING FUSES.....	57
REMAKING THE ROLLER COVER.....	58
REPLACING THE BASIN ROPE.....	62

TROUBLESHOOTING, REPAIRS

TROUBLESHOOTING - COMMON	63
MALFUNCTIONS OR FAULT MESSAGES	63

DECOMMISSIONING, DISPOSAL

DECOMMISSIONING	65
DISPOSAL	65

RECOMMENDED SPARE PARTS

RECOMMENDED SPARE PARTS	67
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INFORMATION AND DEFINITIONS

RECIPIENTS

The instructions for use and maintenance are designed for the **people in charge of using and managing the appliance** and the **technician enabled to perform installation and maintenance procedures**.

Here, reference is made to a correct use of the appliance, with a view to maintaining the functional characteristics and quality thereof unchanged over time. All information and warnings on proper use and maintenance in total safety are also provided.

SUPPLY AND STORAGE

The instructions for use and maintenance are provided in **hard copy**, and attached to the packaging with an adhesive envelope.

All additional documentation (e.g. pneumatic and electrical diagrams, sub-suppliers manuals) is attached to this instruction manual.

Keep this manual with the equipment, so that it can be easily consulted by the operator.

The instructions are crucial for safety, therefore:

- **They must be kept intact** (in all their parts). If they are lost or damaged, a copy must be immediately requested;
- **They must follow the appliance until disposal** (even in case of transfer, sale, hire, rent, etc....).

The attached manuals are an integral part of this documentation and the same recommendations/prescriptions as those contained in this manual apply.


















IMPORTANT!

Read these instructions for use and maintenance before proceeding with the installation and use of the appliance.

The instructions are also available on the website of the Manufacturer.

SYMBOLS USED IN THE MANUAL

Here below the symbols and signs used in this handbook:

Symbol	Description	Symbol	Description	Symbol	Description
	Consult the instructions.		General warning.		Electric hazard
	Required action.		Hot surface hazard		Biological hazard
	Use protective gloves		Fire hazard		Danger of crushing
	Use safety shoes		Poisoning and/or intoxication hazard		Tipping hazard
	Use protective suit		Explosion hazard		Danger of moving parts

GLOSSARY OF THE TERMS USED

To facilitate the comprehension of the handbook and terms commonly used in laundry facilities, here below some definitions of the terms used are provided.

Term	Definition
APPLIANCE or MACHINE	Product being the subject of the handbook/instructions.
DANGER	Potential source of damage.
DAMAGE	Physical injury, damage to people's health, deterioration of assets or of the environment.
SEVERITY	Damage extent.
PROBABILITY	Frequency of occurrence of a given damage.
RISK	Combination of the probability of damage occurrence and damage severity.
SAFETY DEVICES	Protection device (different from a guard) which reduces risk (mechanical or electric devices).
GUARD	Part used to provide protection by means of a physical barrier.
SOAKING	Phase required to loosen dirt that is particularly difficult to remove.
WEIGHING	Phase used to detect the weight, expressed in Kg, of the load inside the drum.
PRE-WASHING	Phase of the washing cycle that helps loosen organic dirt.
WASHING	Main phase of the wash cycle required to loosen and remove dirt from fabric.
RINSING	Phase of the washing cycle required to remove the detergent and suspended dirt from fabric.
SPINNING	Phase of the washing cycle at high speed of rotation required to remove mechanically water and detergent from fabric.
UNROLLING	Final phase of the washing cycle carried out to help the laundry outfeed from the drum
DRYING	Removal of humidity contained in the fabrics through evaporation at controlled temperature.
COOLING	Temperature decrease up to a proper value to handle fabric
IRONING	Removal of fabric creases thanks to the combined action of proper temperature, humidity and mechanical pressure.
G FACTOR	Capacity of the appliance to extract water by means of centrifugal force
CYCLE / PROGRAMME	Sequence of operations for fabric treatment saved in the machine that can be recalled as you wish
DETERGENT PUMP	Dispenser of specific products required to facilitate the removal of dirt or useful for the fabric treatment
FINISHING	Final treatment of a fabric required to improve the aspect, fragrance or conservation
PAYMENT	When a preset rate is reached, expressed in tokens or money, required to use the basic service
INCREMENTAL PAYMENT	Further payment of money or tokens, besides the basic payment, required to extend the service provided.
DOMESTIC USE	Use of the equipment by inexperienced users in a domestic or similar context.
COMMERCIAL USE	Use of the equipment by non-expert users in non-domestic or similar environments, places where a commercial activity is carried out for the use of a service against payment of a fee.
PROFESSIONAL USE	Use of the equipment by trained users, other than domestic and commercial, for the processing of products with non-continuous production processes and for non-mass production.
INDUSTRIAL USE	Use of the equipment by trained users, other than domestic, commercial and professional users, for industrial processing of products with continuous-type production processes and for mass production.
AREA OPEN TO THE PUBLIC	Area accessible to the general public, including children and frail persons.

WARNINGS AND RESIDUAL RISKS

DEFINING THE OPERATOR QUALIFICATIONS

Operators are people responsible for the installation, operation, adjustment, and implementation of the appliance routine maintenance and cleaning (each within the limits of the tasks assigned).

They are classified as:

Term	Definition
INFORMED PERSON	Person adequately advised or supervised by a trained person in such a way as to be able to perceive risks and prevent dangers potentially posed by the appliance operation or maintenance.
FORMAT USER	Person in charge of operating the equipment, with sufficient training, knowledge and experience to perceive risks and avoid hazards that may arise from interaction with the equipment.
ENABLED TECHNICIAN	Trained, experienced person able to perceive risks and prevent dangers that may derive from interacting with the appliance. This person is trained to operate the machine with reduced safety devices or partial failure.
PLANT CONDUCTOR	A person who: <ul style="list-style-type: none"> ▪ is in charge of using the appliance; ▪ has read and understood all the relevant parts of this manual; ▪ Is able to perform routine maintenance and clean the appliance
USER or USER	Informed person who: <ul style="list-style-type: none"> ▪ is in charge of using the appliance; ▪ is aware of the requirements on equipment use.

WARNING!



Operators must always adhere to:

- The limits of their duties
- The warnings on the appliance safety plates
- The service procedures provided for

SAFETY GENERAL WARNINGS



IMPORTANT!

Read these instructions for use and maintenance before proceeding with the installation, use and maintenance of the appliance.



IMPORTANT!

Keep this identification and warning manual near the appliance for future reference.



WARNING!

**Do not remove the safety signs applied to the appliance.
Observe the signs to avoid personal injury.
Maintain the safety system signs legible.**



WARNING!

The Manufacturer reserves the right to change the manuals without notice.



WARNING!

The appliance must only be used by trained, informed and instructed persons.



WARNING!

Read and understand instructions before attempting to operate the appliance. Improper use of the appliance may cause a risk of fire, electric shock or serious body injuries and/or death, and serious damage to the appliance and environment.

**WARNING!**

Any other use that is not explicitly indicated in this manual must be considered dangerous. The Manufacturer cannot be held liable for damage deriving from any improper use, or in any case not taken into account in this manual.

WARNING!

THE APPLIANCE MAY BE USED BY CHILDREN OF AT LEAST **8** YEARS OF AGE AND BY PERSONS WITH REDUCED PHYSICAL, SENSORY OR MENTAL CAPABILITIES, OR LACK OF EXPERIENCE OR THE NECESSARY KNOWLEDGE, PROVIDED THAT THEY ARE SUPERVISED OR HAVE RECEIVED INSTRUCTIONS CONCERNING THE SAFE USE OF THE APPLIANCE AND UNDERSTANDING OF THE DANGERS INVOLVED.



CHILDREN UNDER THE AGE OF **3** MUST BE KEPT AWAY FROM THE EQUIPMENT UNLESS THEY ARE CONTINUOUSLY SUPERVISED.

CHILDREN MUST NOT PLAY WITH THE APPLIANCE.

CLEANING AND MAINTENANCE MEANT TO BE PERFORMED BY THE USER MUST NOT BE PERFORMED BY UNSUPERVISED CHILDREN.

**WARNING!**

The safety standards and warnings for operating personnel, contained in the instructions, must be printed and made available in a visible place near the appliance.

**WARNING!**

During transport and storage operations do not exert excessive pressure on the packaging as the machine components located along the packaging edges may be damaged.

**WARNING!**

Assembly and adjustment must be carried out by qualified technicians, authorised by the Manufacturer. Incorrect installation and improper adjustment may create hazardous conditions.

**WARNING!**

The appliance must not be stored, installed or exposed to the elements, low or high temperature and humidity levels. Do not wet the appliance. Completely dry the machine, both internally and externally, before connecting to the electrical mains.

**WARNING!**

Comply with and apply the regulations in force in the appliance installation country.

**WARNING!**

Any installation changes must be approved by the Manufacturer. Otherwise, the manufacturer will not be responsible for any damage to the appliance and/or injury to operators.

**WARNING!**

The appliance has not been designed for operation in explosive atmospheres and/or with such products.

**WARNING!**

Comply with standards in force for the connection to the electrical mains, in compliance with the local distribution system (TT, TN, IT, ...).

It may not always be possible to connect systems in the standard version to the IT electricity networks. Contact the Manufacturer.

**WARNING!**

All types of appliances are manufactured according to the Directive on Electromagnetic Compatibility (EMC). They can be used only in the spaces corresponding to the appliance class of electromagnetic compatibility (conform at least to Class A - industrial environment). For safety reasons, please comply with the minimum safe distance from electrical or sensitive electronic systems.

**WARNING!**

To minimise the risk of fire, electric shock and injury, the appliance must be properly earthed.


WARNING!

Use only copper conductors. The appliance must be connected to a power supply circuit to which no lighting units or general use equipment are not connected.


WARNING!

Make sure that in the place of installation of the appliance there is no possibility that the latter is exposed to direct or indirect water jets.


WARNING!

Do not change the setting of the frequency inverter parameters. This can cause serious injury, fire, damage, etc.


WARNING!

Mark the danger zone in the laundry room and hinder access when the appliance is in operation. Keep the surface of the appliance and the surrounding area clean. Keep the appliance away from flammable materials.


WARNING!

During use, cleaning and maintenance, do not get close to the moving parts of the appliance, such as motors, belts, fans and transmission components with body parts or tools.


WARNING!

The use of hypochlorite causes corrosion that may cause breakage or deterioration of the appliance components.


WARNING!

The appliance warranty does not cover damages caused by the use of chlorine, its derivatives or substances that can release chlorine during the normal use.


WARNING!

Incorrect amounts of detergent or additives during the phases of the treatment may reduce the durability and performance of the appliance.


WARNING!

Do not tamper with the controls of the appliance and do not ignore the safety warnings.


WARNING!

In case of danger, turn off the main switch and/or other emergency disconnecting devices.


WARNING!

Do not use the appliance in case of broken or missing parts, and/or with lids/guards open. Correctly restore fixed guards before using the appliance.


WARNING!

Disconnect the power supply, turn off the water, gas and steam supply and any other supply sources before performing cleaning and maintenance, as well as at the end of each working day.


WARNING!

Should problems or faults occur, contact the Manufacturer or the authorised Service Centre.


WARNING!

Do not repair, replace parts of the appliance or attempt any intervention unless specifically recommended in this manual and/or if you do not have the skills to perform them. Only qualified personnel may disassemble the appliance for maintenance.



WARNING!

Any water, condensate, steam leak or similar must be repaired immediately.



WARNING!

In case of replacement of parts of the appliance, use original spare parts or equivalent ones approved by the Manufacturer.

See the Technical Appendix for ordering.



WARNING!

Even if the main switch of the appliance is set to "OFF", the power supply clamps of the switch are always live.



WARNING!

Wait at least 10 minutes before performing maintenance on the device after disconnection from all power (electric, thermal and similar) supplies.

Before performing maintenance on the frequency inverter, check that the residual voltage thereof is less than 30V CC.



WARNING!

Pay special attention to use and maintenance operations, especially for those appliances that usual treat fabrics coming from structures in which the presence of bacteria is strong (hospitals, nursing homes, and similar).

ADDITIONAL WARNINGS FOR SELF-SERVICE ENVIRONMENTS



WARNING!

An emergency stop device must be installed inside the laundry room, located in a visible place accessible to all users.

For the installation in a self-service environment, refer to standards in force.

Install sufficient stop devices so that at least one is visible from any position inside the operator access area.

Each device is to be positioned within 8 m from the operator's workstations. If this device consists of an emergency stop button, it must be positioned between 0.7 and 1.7 m above the ground or working platform.



WARNING!

Provide appropriate signage to inform non-system users of the correct use of the equipment and residual risks.

SAFETY WARNINGS FOR THE IRONER



WARNING!

The appliance has been designed for ironing fabrics. Other objects can damage the appliance and cause damage or injury.



WARNING!

Do not wear garments that could get caught, such as ties, scarves, large sleeves. Entanglement hazard!



WARNING!

Do not iron dry garments, fire hazard!



WARNING!

Check that the ironing parameters are appropriate and compatible with those shown on the label of the fabric to be treated. An incorrect temperature can pose the risk of fire!



WARNING!

Do not insert in the ironer or attempt to iron cloths that are sensitive to heat with a too high temperature: The fabric deterioration can be the cause of fire and intoxication hazard!


WARNING!

Do not leave garments inserted or entangled in the stopped ironer: fire hazard!
 In case of failure or power cut, release the garments from the ironing plate as described in the handbook.


WARNING!

Do not cover the ironer or the ventilation grids of the machine, not even at the end of ironing! The machine takes time to get cooled and the residual heat of the appliance can pose a fire hazard!


WARNING!

If garments are excessively dry, they tend to adhere and wind round the roller, creating a spiral. Lift the basin, turn off the heating, wait for the appliance cooling and remove fabrics wound or entangled. Fire and burn hazard!


WARNING!

Thoroughly rinse the garments before introducing them in the appliance. Do not introduce in the machine garments that still have traces of inflammable substances, solvents or other chemical compounds, derivatives from treatments, which could degrade or catch fire in contact with the ironing plate. Fire or intoxication hazard!


WARNING!

Use the entire surface of the ironing roller, by varying the areas used during the cycle. The use of the machine in the same ironing area leads to a quick degradation of the roller cover as well as an overheating of the ironing plate in the unused area. Fire hazard!


WARNING!

Do not introduce garments in the ironer that have a thickness larger than 8 mm. The excessive thickness can damage the machine and cause entanglements.


WARNING!

Do not attempt to iron garments that contain more humidity than that set in the technical data.


WARNING!

DO not iron fabrics with buttons, pins, metal clips, zips, buckles or alike. The ironing basin is immediately damaged.


WARNING!

Do not iron garments that are not provided for this type of treatment and do not attempt to iron fabrics with an irregular shape, with uneven or undefined edges.


WARNING!

Do not let the machine working unattended with the heating turned on. Turn off the machine and heating if not used.


WARNING!

The ironed, hot and dry garments are charged with static electricity: adjust the appliance temperature and cloth humidity so as to minimise the effect.


WARNING!

Only iron garments that have been previously well rinsed with soft water. The excessive content of salts dissolved in water causes a quick formation of scale deposits on the surface of the ironing plate, by deteriorating the machine performances and making the introduction difficult.


WARNING!

The handling of moist garments during several hours per day can cause irritation to the skin. Use appropriate protection devices (gloves or similar)


WARNING!

Connect and convey the exhausted fumes outside of the building. Steams from ironing, even if they are not toxic, lead to the creation of a moist and unhealthy environment.



WARNING!

Garments are particularly hot at the machine outlet and, in certain cases, can still contain residual humidity: burn hazard!



WARNING!

The outlet edge of the ironing basin is at a temperature equal to the ironing one. Burn hazard during the withdrawal of treated garments!



WARNING!

The ironing basin has a high temperature even when it is detached from the roller and it is in home position: do not introduce hands or other objects other than treated fabrics, between basin and roller. Burn injury hazard!



WARNING!

Do not place hands or fingers between the ironing plate and the roller while the ironing plate comes down: serious burn hazard!



WARNING!

Do not iron material with synthetic seams, printed drawings or plastic parts. If this cannot be avoided, adjust the temperature according to the most delicate material to be treated (with the lowest ironing temperature).



WARNING!

Only start ironing when the desired temperature has been reached. Considering that the machine takes some minutes to reach the desired temperature, we recommend to divide garments according to their type.



WARNING!

Do not steam inflammable substances on the ironing plate or close to the ironer.



WARNING!

Do not keep liquids or other inflammable materials close to the appliance. Dry garments are generally considered as inflammable.



WARNING!

Keep the appliance clean, removing possible traces of down or parts of fabric from the machine. Perform cleaning only while the appliance is turned off, disconnected and cold.



WARNING!

Keep products required to the basin waxing away from the machine.



WARNING!

Because of the danger of laundry catching fire, ensure that the work area is equipped with appropriate fire extinguishers.

OBLIGATIONS

- Only allow properly trained personnel to operate on the appliance.
- Do not use the appliance improperly, i.e. for uses other than those specified in the "Intended Use" paragraph.
- Do not allow the appliance to be used by children, people with limited physical and mental abilities, and/or personnel not yet trained, without proper supervision.
- Do not remove or by-pass safety devices.
- Never use water jets directly or indirectly on the appliance.
- Do not run the appliance if it has defective or missing parts, or if the side panels have been removed.
- At the end of each working shift, cut-out all electric and heating supply sources (e.g. gas, if present).
- In case of malfunctions, alarms or defects contact the after-sales centre.

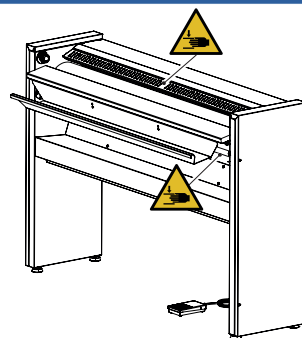
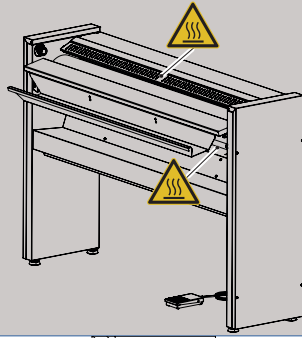
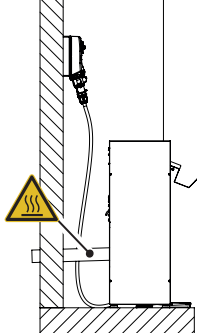
PROHIBITIONS










- Do not touch the appliance with wet or humid hands or feet.
- Do not use the washing machine barefoot.
- Do not leave the appliance exposed to weather agents (rain, sea salt, etc...).
- Do not smoke close to the appliance during use.
- Do not touch the water or steam loading pipes (if present) even when the appliance is not running.
- Do not treat garments that carry the "hand wash only" or relative symbol care label.
- Do not use hypochlorite (bleach), as it may oxidise some parts of the appliance (electric, electronic, or metallic).
- Do not expose the appliance to the elements, excessively high or low temperatures and humidity.
- Do not store flammable materials near the appliance.
- Do not add petrol, detergents for dry cleaning or other flammable or explosive substances in the appliance. These substances release vapours that may cause fires or explosions.
- Do not store materials, of any type, near the appliance.

RESIDUAL RISKS

Safety has been integrated, as far as possible, in the appliance design and construction.

Therefore, the operators must be protected against residual risks especially during maintenance, installation, and cleaning operations.

Residual risk	Provision	Picture
RISK OF SHEARING/ CRUSHING	Do not insert hands or objects between the fixed part and the mobile part of the appliance.	
RISK OF BURNING OR SCALDING	Do not touch the ironing basin (plate) with fingers: serious burn hazard! Pay attention to the hot roller and the outfeed garments	
RISK OF BURNING	Do not touch the flue pipes, which can reach high temperatures. Pipes must be suitably insulated and protected.	

Residual risk	Provision	Picture
DRAGGING RISK	Do not wear garments that could get caught, such as ties, scarves, large sleeves.	
RISK OF OVERTURNING	When ironing, lay the garments along the ironing board, never pull them towards you.	
RISK OF FIRE	Do not iron dry garments.	
RISK OF FIRE	Do not use the appliance to treat fibres soaked or contaminated with flammable substances, such as oil, grease, or fuels.	
RISK OF FIRE	The ironed, hot and dry garments are charged with static electricity: adjust the appliance temperature and cloth humidity so as to minimise the effect.	
RISK OF POISONING AND INTOXICATION	Do not iron fabrics soaked with substances that can degrade with the temperature. Chemical reactions may result from reagents capable of developing dangerous liquids or gases for human health or capable of affecting the appliance functional parts.	
RISK OF INTOXICATION	Ensure proper ventilation of the room in order to prevent the formation of a damp and unhealthy environment.	
RISK OF SHEARING	The smoke exhaust manifold is connected to an exhaust pipe to the outside of the room.	
WARNING	Aerate rooms during the first hours of use of the appliance. Residues from processing can cause smell during the first hours of operation: this is normal. The smell is not toxic and will disappear after a short time.	

IDENTIFICATION

MACHINE IDENTIFICATION

Machine type	Roller ironer
Model/s	GI xx18 / GI xx25
Plaque Serial number	

IDENTIFICATION

MANUFACTURER IDENTIFICATION

Name	Grandimpianti I.L.E. Ali Group S.r.l. a Socio Unico
Address	via Giuseppe e Augusta Trevisson, 5 32037 - Sospirolo (BL) - Italy Tel. +39 (0)437 848 711 Fax +39 (0)437 879 108 e-mail: info@grandimpianti.com web: www.grandimpianti.com

SUPPLIER IDENTIFICATION

Supplier (importer)	
Stamp	

MACHINE VERSIONS

The machine version is specified in the **model** field in the identification plate.

The following describes how to unambiguously identify the commercial names of the appliances.

Pos. 1 Manufacturer	G Grandimpianti				
Pos. 2 Type	I ROLLER IRONER				
Pos. 3 Width	XX [dm]				
Pos. 4 Diameter	XX [cm]				
Pos. 5 Control	- Fox	W Wise			
Pos. 6 Heating	E Electrical	G Gas	S Steam		
Pos. 7 Extra	- NO	A Aspiration	V Speed drive	T Variable thrust	M Metallic spring

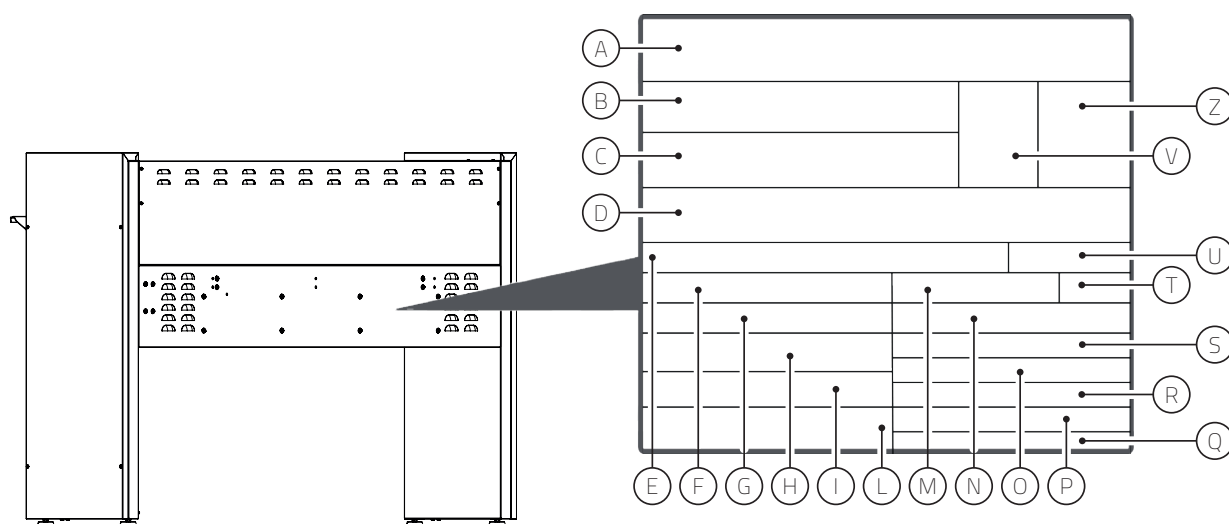
IDENTIFICATION PLATE

The **plate** bearing the identification data and CE mark is permanently attached on the rear side of the appliance. A plate bearing the identification data and the weight of the appliance is also applied to the packaging.



IMPORTANT!

Check that the model of the appliance specified on the identification plate and on the packaging plate is the same as that stated on the transport document or invoice.



IDENTIFICATION

	Description
A	Company name
B	Model
C	Serial number
D	Code
E	Power supply
F	Production date
G	Rated electrical power

	Description
H	Motor power
I	Heating power
L	Appliance type (gas)
M	PIN (gas)
N	CE Marking
O	Nationality (gas)
P	Gas type

	Description
Q	Pressure (gas)
R	Category (gas)
S	Qn (gas)
T	IP protection
U	Fuse
V	Separate collection symbol
Z	QR Code

DECLARATION OF CONFORMITY

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WARRANTY

The warranty covers a period of **twelve months**, from the date of purchase of the appliance or of an integral part thereof.

The warranty consists in replacing any failed parts for ascertained manufacturing causes and it is applied directly by your supplier.

The workforce along with shipping and packaging costs as well as transport risks shall always be borne by the purchaser.

According to the warranty conditions, damaged parts must be returned carriage paid after communicating all data regarding the model, serial number and defect of the appliance on which the component was assembled.

The warranty **does not apply** to appliances damaged due to negligence, incorrect connections, unsuitable installation, failure to comply with assembly or user instructions, and, in any case, altered by unauthorised personnel. Moreover, the warranty does not apply if the serial number has been changed, deleted, removed or is unknown.

The warranty does not cover the following material:

- Parts subject to normal wear such as belts, chains, bearings, springs, shock absorbers;
- Solenoid valve membranes, gaskets and rubber parts in general;
- Electric and electronic components, such as motors, coils, contactors, resistors, circuit boards, inverters, lamps, etc.
- Functional coverings subject to wear and tear such as roofing and cladding.

DESCRIPTION, TECHNICAL DATA, INTENDED USE

INTENDED USE

The equipment in question is designed and built for:

- Meet the specific requirements mentioned in the contract of sale
- Be used in accordance with the use instructions and limitations specified in this manual.

Intended use	Commercial / Professional
Operation	IRONING
Allowed	Flat fabrics (with weight and volume limitations)
Not allowed	<ul style="list-style-type: none"> ▪ Fabrics soaked with flammable substances, solvents, acids, grease. ▪ Any material other than fabric
Environment	Self-service, condominium laundries; laundries for hotels, retirement homes, communities, hospitals, factories and similar.

The appliance has been designed and manufactured to operate in safe conditions if:

- it is used within the limits described in this manual;
- procedures described in this manual are adhered to;
- routine maintenance is carried out at intervals and with the methods indicated in this manual;
- extraordinary maintenance is carried out promptly in case of necessity;
- safety devices are not removed and/or bypassed.



WARNING!

It is strictly forbidden to treat garments impregnated with flammable substances, solvents, acids and/or fats, including essential oils.



WARNING!

Any other use that is not explicitly indicated must be considered dangerous.



WARNING!

Remove all traces of stony and/or sandy material from the fabrics before introducing them into the machine.



WARNING!

The Manufacturer cannot be held liable for damage deriving from any improper, incorrect use, or in any case not taken into account in this manual.



IMPORTANT!

In case it is necessary to treat special fabrics, please contact in advance the after-sales assistance of the manufacturer.



IMPORTANT!

Please follow the instructions on the fabric labels. The manufacturer is not liable for damage to fabrics caused by treatment procedures other than those described in this manual.

IMPROPER, REASONABLY PREDICTABLE USE.

The following are reasonably improper uses:

- Treatment of animal fur;
- Treatment of paper sheets or similar sheets other than fabric;
- Treatment of materials other than those specified in the sales contract;
- Treatment of textiles containing traces of stony and/or sandy materials;
- Use in environments subject to atmospheric agents (and system exposure to lightning, and brackish or salty environments);
- Use in environments with a high risk of fire and/or explosion;
- Use in environments subject to electromagnetic disturbances.



WARNING!

The use of the appliance for performance other than that specified, is considered "improper use".

Any other use needs prior authorisation in writing by the Manufacturer.

In the absence of such written consent, use is considered "improper"; therefore, the Manufacturer disclaims any liability with regard to possible damage to property or people, and considers invalid any kind of warranty.



WARNING!

Do not install and use the appliance in an environment that can create an explosive atmosphere inside the machine.

NOISE

During the operating cycles, the noise emission of the appliance does not exceed the values shown in the following table:

Model/s	Sound emission [dB(A)]
GI 1218 / 1418 / 1225 / 1425	< 60
GI 1225 A / 1425 A	< 65

The actual noise level of the appliance installed at a site during operation in a production process is different from that detected, since noise is influenced by some factors such as:

- Type and characteristics of the site
- Duration of exposure
- Other adjacent appliances in operation



IMPORTANT!

It is the user's responsibility to take relevant preventive and protective measures, in accordance with the law governing the appliance installation and use country.

GENERAL DESCRIPTION



IMPORTANT!

Left and right are referred to when looking at the device from the rear.

The appliance structure consists of:

Fixed part	<ul style="list-style-type: none"> ▪ supportive side shoulders; ▪ adjustable introduction plane; ▪ collection tub for ironing (optional); ▪ pressure roller ribbon system (optional); ▪ laundry compartment; ▪ electrical panel and relevant accessories;
Moving part	<ul style="list-style-type: none"> ▪ ironing basin; ▪ roller; ▪ mechanical transmission.

On the left, in the lower side, there is the connection for the electrical power input as well as the pedal for operating the basin. If the machine has the **fume extraction system**, the exhaust is located under the laundry compartment.

The **working cycle** standard equipment can be broken down as follows:

Phase	Description
1	Start the appliance, heat it up until the temperature is reached and select the ironing parameters according to the fabric to be treated.
2	Unfold the wet garments before introduction: if necessary, moisten them with a water spray.
3	Place the garments on the feeding table so as to occupy most of the roller: alternate the used areas of the roller by drawing alternatively the garments near the machine sides.
4	Adhere the ironing basin to the roller according to the settings of the electronic control.
5	Gently pull the linen with your hands until it adheres to the roller. Keep hands close to the feeding table, without approaching them to the ironing basin. Facilitate the input of thick or difficult tissue by temporarily lifting the basin during introduction.

Phase	Description
6	Continuously follow and let out the garments during the ironing operation, keeping the fabric slightly stretched so as to avoid any crease.
7	Withdraw the ironed garments from the bottom area of the machine.
8	Once ironing is completed, decrease the temperature set to the machine idle so as to allow the roller padding to get dried by exploiting the residual heat of the machine
9	Detach the basin from the roller according to the settings of the electronic control.
10	Stop the machine and disconnect the power supply.

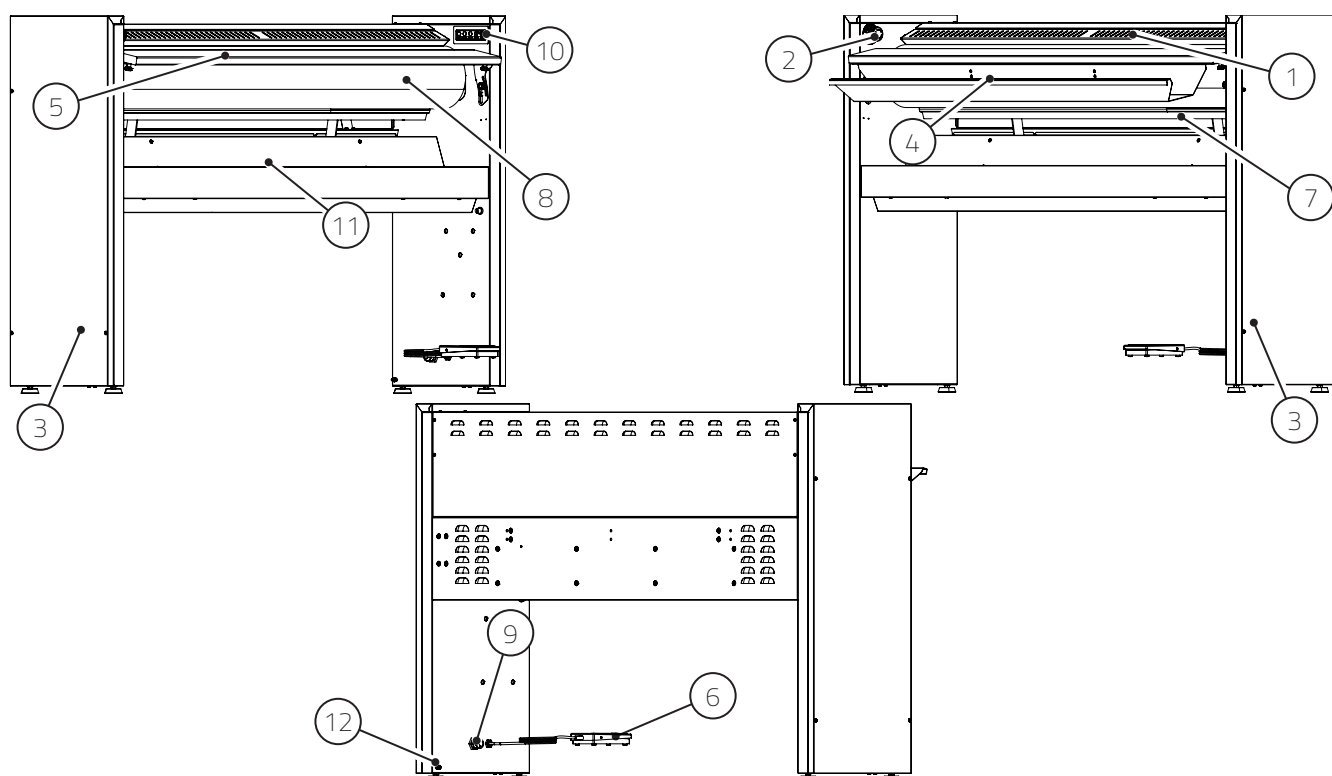
The **ironing** phases can be summarized as follows:

Phase	Description
1	Initial check: each fabric has its own best temperature and humidity conditions, to be set on the machine, in order to reach the expected result. Read the labels on the fabric to be processed.
2	Manual stretching: it avoid to introduce overlapped fabric in the machine, which is the main cause of creases.
3	Heating and evaporation: they remove permanent creases from the fibre by drying them gradually.
4	Mechanical pressure: combined to the action of heat and humidity, it forces fibres to the flat position (ironing).
5	Output and cooling: allows to maintain the ironing just performed.

MAIN COMPONENTS

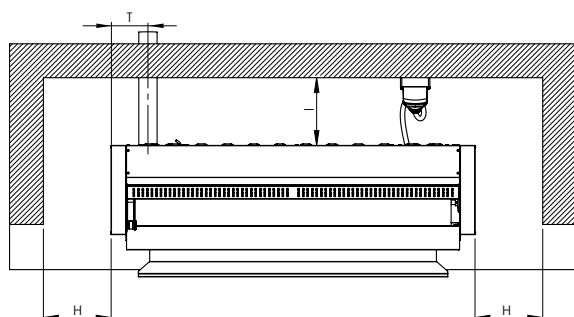
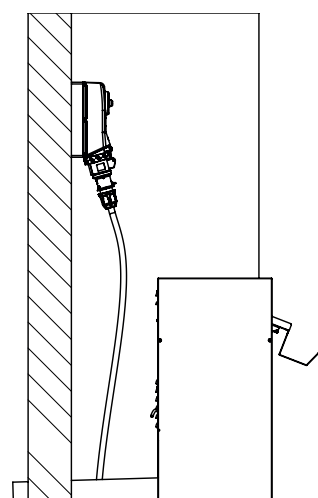
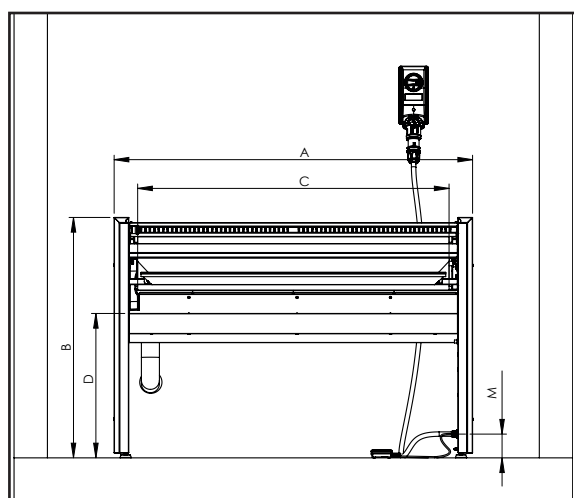
Pos.	Element
1	Finger-safety fillet
2	Emergency stop
3	Side panels
4	Linen introduction basin (optional)
5	Adjustable introduction plane
6	Pedal

Pos.	Element
7	Basin
8	Roller
9	Cable gland for electrical connection
10	Control panel
11	Laundry compartment
12	Terminal for equipotential bonding



DIMENSIONS

Pos.	GI 1218	GI 1418	GI 1225	GI 1425	GI 1225 A	GI 1425 A
A [mm]	1412	1612	1412	1612	1412	1612
B [mm]	1056 - 1076					
C [mm]	1190	1390	1200	1400	1200	1400
D [mm]	648 - 668					
E (mm)	940 - 960 (20°) 995 - 1015 (0°)					
F [mm]	-				60 - 450	60 - 450
G [°]	-				80 - 88	80 - 88
H [mm]	50					
I [mm]	50					
M [mm]	107 - 127					
N [mm]	75					
O (max) [mm]	589					
P (max) [mm]	469					
Q [mm]	402					
R [mm]	95					
S [mm]	530 - 550					
T [mm]	163					



TECHNICAL DATA

Characteristics	GI 1218	GI 1418	GI 1225	GI 1425	GI 1225 A	GI 1425 A
Contact arc [mm]	177	177	215	215	215	215
Linen dragging speed [m/min]	1,5 - 3,0	1,5 - 3,0	1,8 - 3,4	1,8 - 3,4	1,8 - 3,4	1,8 - 3,4
Hourly productivity [kg/h]	29 24 19	35 29 23	37 31 25	41 35 27	40 32 26 19	47 37 30 22
Inlet fabrics RU [%]	10 15 20	10 15 20	10 15 20	10 15 20	15 20 30 40	15 20 30 40
Aspirator flow rate [m³/h]	-	-	-	-	100	100
Payment systems	Central payment unit / Coin acceptor / Simple coin operation / Electronic coin operation					
Heating	Electrical					
Heating power [W]	4500	5400	6000	7200	7200	8400
Auxiliary and motor power [W]	100	100	130	130	130	130
Aspirator motor power [W]	-	-	-	-	75	75
Power supply	220/230/240V 1~ 230V 3~ 380/400/415V 3~ 380/400/415V 3N~ 440V 3~ 440V 3N~ 460/480V 3~ 460/480V 3N~			230V 3~ 380/400/415V 3~ 380/400/415V 3N~ 440V 3~ 440V 3N~ 460/480V 3~ 460/480V 3N~		
Frequency [Hz]	50 - 60			50 - 60		
Metallic spring Aramid felt coating	-	-	-	-	optional	optional
Cotton cloth cover	standard	standard	standard	standard	standard	standard
Aramid sheet coating	optional	optional	optional	optional	optional	optional
Net weight [kg]	80	87	89	99	104	112

DESCRIPTION, TECHNICAL DATA, INTENDED USE

IP PROTECTION

Model/s	Protection degree	Description
All	IP X0	Appliance not protected against dust and water

SAFETY DEVICES

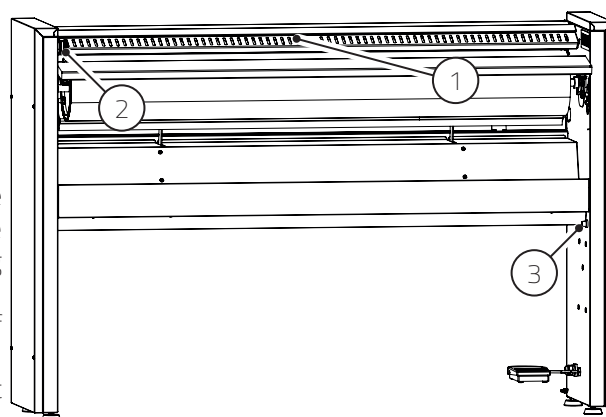
The appliance has been designed and provided with safety devices to minimise risks for the user.

Pos.	Element
1	Rotating finger-safety fillet
2	Emergency stop
3	Safety thermostat

The first two safety or emergency devices are operated by the operator. The machine stops its normal operation so that the operator can safely reorganise and restore normal working conditions.

The third safety device automatically intervenes in the event of overheating of the ironing basin, deactivating its heating. It must be reset by the operator by screwing on the thermostat protection cap and pressing the button.

In the event of repeated interventions of the safety thermostat, stop using the equipment and contact Technical Service.



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TRANSPORTATION, STORAGE, UNPACKING

SAFETY WARNINGS FOR TRANSPORT



IMPORTANT!

After receiving the appliance, check the condition of the packaging.
 In case of visible damage, remove the packaging in the presence of the carrier and sign the transport document with reservation.



WARNING!

The manufacturer is not liable for any material damage or personal injury due to accidents caused by failure to comply with the instructions in this manual.



WARNING!

The area where the appliance is transported and handled shall be occupied and transited only by the personnel involved in these operations.



WARNING!

The transit areas to the installation site must at least withstand the static load of the appliance and transport system.



WARNING!

During transport operations do not exert any pressure on the packaging as the machine components located along the packaging edges may be damaged.

TABLE OF DIMENSIONS AND WEIGHTS FOR TRANSPORT

The following table shows the dimensions and weights of the packaged appliance. Values shown are needed to select an appropriate means of transportation.

Model/s	Gross weight [kg]	Width [mm]	Depth [mm]	Height [mm]	Volume [mc]	Transpallet forks	
						min. length min [mm]	Gauge max [mm]
GI 1218	97	1520	530	1227	0.99	750	600
GI 1418	107	1720	530	1227	1.12		
GI 1225	106	1520	530	1227	0.99		
GI 1425	119	1720	530	1227	1.12		
GI 1225 A	124	1520	530	1227	0.99		
GI 1425 A	132	1720	530	1227	1.12		

SPECIFIC SAFETY WARNINGS



WARNING!

Due to the special design, the machine has a centre of gravity shifted towards the top of the unit.
 Turnover and fall hazard!

Drive the means of transportation gradually, by avoiding sudden manoeuvres.

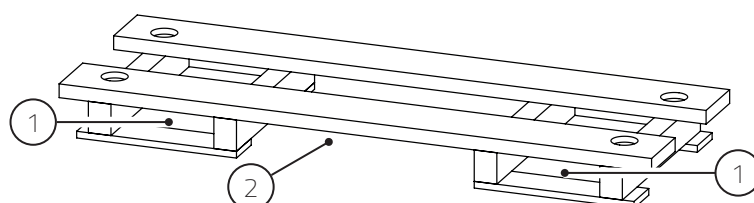


WARNING!

The original pallet is designed so as to limit the turnover effects. Keep the original packaging for future transfers.

Make sure the equipment is securely screwed to the pallet before any movement.

The pallet is equipped with two external windows (1) to accommodate the forks of a forklift truck and a central window (2) for transport with a pallet truck.



TRANSPORT WITH TRANSPALLET



WARNING!

The transport and handling activities described in this section must be performed by qualified personnel with specific skills for such operations.



WARNING!

Refer to the relevant section and check the weight of the appliance.

The appliance is transported to the point closest to the installation site **on a pallet by means of a transpallet**.

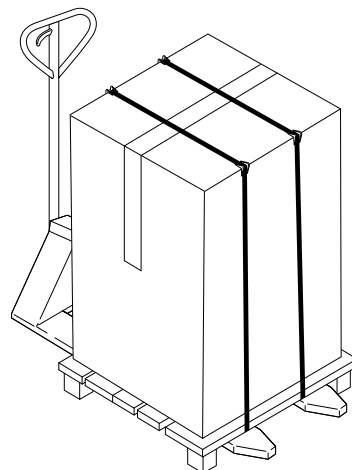


IMPORTANT!

Observe the minimum fork length specified in the section "TABLE OF DIMENSIONS AND WEIGHT FOR TRANSPORT".

To **handle the machine by transpallet**, proceed as follows:

Step	Action
1	Place the transpallet forks under the pallet to which the appliance is fastened.
2	Slowly lift by a few inches and check the grip stability.
3	Proceed slowly to the installation site and lower the load.



WARNING!

Do not lift the appliance without first anchoring it to a pallet.



WARNING!

Any damage caused by handling the machine in a different way from that described in this manual shall not be attributed to the Manufacturer.

UNPACKING



IMPORTANT!

After delivering the appliance, check the condition of the packaging.

If **damage is ascertained**:

Step	Action
1	Leave the packaging concerned as it is found.
2	Immediately require a damage assessment by the company responsible for forwarding.
3	Report the damage detected to the relevant transport insurance.

If **no damage is found**, after placing the packed equipment in its designated area (see chapter INSTALLATION AND CONNECTIONS), proceed **to unpack** as follows:

Step	Action
1	Cut the straps that secure the cardboard box.
2	Lift the cardboard box upwards.
3	Remove the protective packaging.



IMPORTANT!

Put the materials used for packaging in a safe place, not accessible to unauthorised people, so as to keep them for any future movements.

After providing for the removal of the packaging, check that:

- The various parts of the appliance do not show any physical damage due to shocks, tears or abrasions;
- There are no marks or dents on the side panels indicative of shocks during transport.

PACKAGING DISPOSAL



IMPORTANT!

If you proceed to dispose of the materials used for packaging, comply with the regulations applied in the country of installation.

The following materials are used for packaging:

- cellophane (CELLOPHANE 7);
- cardboard for the box (PAP 20);
- wood for the pallet (FOR 50);
- polystyrene corner pieces (PS 6).

The packaging is an integral part of delivery and is not collected, so the purchaser is responsible for its disposal.



WARNING!

Keep the instructions for use and all other documents related to the machine supplied with the packaging.

STORAGE

The product must be stored in a **closed environment, protected from the elements**.

The minimum and maximum conditions for the appliance storage are listed below.

Model/s	Room temperature [°C] / [°F]		Room RU [%]	
	min	max	min	max
All	0 / 32	55 / 131	0 ⁽¹⁾	90 ⁽¹⁾

(1) without condensation.

If **the equipment is not to be used for a period of more than one month**, follow the instructions below:

Step	Action
1	Disconnect the power plug.
2	Disconnect the vapour exhaust pipe (for models with suction).
3	Remove any residual detergent or dirt.
4	Protect the appliance from dust using the bag supplied.
5	Keep the appliance in a closed place under the expected environmental conditions.



IMPORTANT!

In the event of long periods in storage, leave the appliance inside its original packaging, which guarantees excellent protection.



WARNING!

Any damage caused by improper storage is not to be attributed to the Manufacturer.

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INSTALLATION AND CONNECTIONS

INSTALLATION



WARNING!

Installation must be carried out by a qualified installer trained by the Manufacturer, in the presence of an electrical technician able to make the electrical connections required.



WARNING!

Any installation changes must be approved by the Manufacturer. Otherwise, the Manufacturer assumes no liability for injury or damage.



WARNING!

The Manufacturer is not liable for any damage to the appliance caused by incorrect installation, connection or use of materials different from those specified.

LIMITS AND PERMITTED ENVIRONMENTAL CONDITIONS

The minimum and maximum conditions for the appliance operation are listed below

Model/s	Power supply		Room temperature [°C] / [°F]		Room RU [%]		Altitude [m]
	Voltage [V]	Frequency [Hz]	min	max	min	max	max
All	± 10% ⁽²⁾	± 1 Hz ⁽²⁾	0 32	40 104	5 % ⁽⁴⁾	90 % ⁽⁴⁾	1000

(1) only for appliances with this type of heating.

(2) compared to the nominal value.

(3) See technical data table.

(4) without condensation.

WARNING!

The machine is not suitable for installation in environments with corrosive, aggressive or dangerous atmospheres such as, for example:



- cities or urban areas with a high level of pollution;
- marine, coastal, brackish areas;
- areas where there is a strong presence of chlorine such as swimming pools or similar;
- mines, or excessively dusty or sandy environments;
- environments with an explosive or flammable atmosphere;
- basement areas, with stagnant air or poor air exchange;
- areas in the vicinity of installations for the production/use of chemicals, fertilisers or similar.

Installation of the device in these areas can lead to premature corrosion of structural and functional parts as well as undesirable malfunctions.



IMPORTANT!

Install the equipment in a location with sufficient natural light and ventilation.

INSTALLATION AND POSITIONING SITE

The **installation site** must meet the following requirements:

- have a floor that is suitable for supporting the weight of the equipment and in which a cement screed has been created;
- have mains connections made in accordance with the regulations in force in the country of installation and that the power supply is greater than the power consumption of the equipment.

The appliance must be positioned in such a way to avoid jets of steam, water, or other liquids.



WARNING!

In the event the appliance is not installed on the ground floor of a building, the Manufacturer provides the weight and forces applied by the appliances in order to make structural calculations.



WARNING!

Installing the appliance on wooden floors is not allowed.



WARNING!

Ensure that the equipment has the correct clearance for use and operation and that the recommended minimum clearances in this manual are observed.



WARNING!

Do not install and use the equipment with an explosive atmosphere inside the room.

After positioning the equipment at the installation site, proceed with **removing the side panels**:

Step	Action
1	Unscrew the side screws holding the ironer panels in place.
2	Remove both side panels, pulling them close to the equipment.
3	Unscrew the screws holding the equipment to the pallet.
4	Lift the unit off the pallet by means of a lifting trolley, releasing the levelling feet.
5	If the equipment is to be fixed to the ground (see next paragraph), unscrew and remove the levelling feet.
6	Remove the pallet and lower the equipment.

LEVELLING

Proceed as follows to level the equipment:

Step	Action
1	Unscrew or screw in the levelling foot shank by slightly raising the ironer at the corresponding angle.
2	Perform this operation for each presser foot until the machine is levelled both longitudinally and laterally.
3	Tighten the M8 lock nuts with a 13 mm spanner.



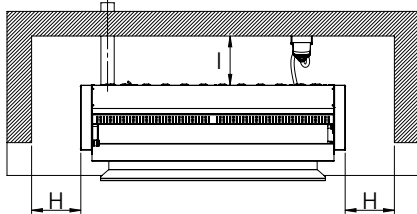
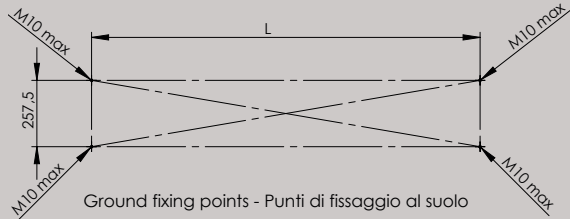
WARNING!

Carry out the levelling operation each time the machine is relocated.

SECURING

Under normal working conditions, it is not necessary to secure the equipment.

In the case of special applications (e.g. on board ship) to **secure** the equipment, please carry out the operations described below:

Step	Action														
1	<p>Locate the place where the device is to be positioned (see chapter DESCRIPTION, TECHNICAL DATA, INTENDED USE for dimensions).</p> <p>Apply the following minimum distances to allow for future maintenance work.</p> <table><tr><th>Model/s</th><th>H [mm]</th><th>I [mm]</th></tr><tr><td>All</td><td>600</td><td>600</td></tr></table> 	Model/s	H [mm]	I [mm]	All	600	600								
Model/s	H [mm]	I [mm]													
All	600	600													
2	<p>Mark the 4 fixing holes according to the image below.</p> <table><tr><th></th><th>GI 1218</th><th>GI 1418</th><th>GI 1225</th><th>GI 1425</th><th>GI 1225 A</th><th>GI 1425 A</th></tr><tr><th>L [mm]</th><td>1308</td><td>1508</td><td>1308</td><td>1508</td><td>1308</td><td>1508</td></tr></table>  <p>Ground fixing points - Punti di fissaggio al suolo</p>		GI 1218	GI 1418	GI 1225	GI 1425	GI 1225 A	GI 1425 A	L [mm]	1308	1508	1308	1508	1308	1508
	GI 1218	GI 1418	GI 1225	GI 1425	GI 1225 A	GI 1425 A									
L [mm]	1308	1508	1308	1508	1308	1508									
3	Drill the 4 holes with the aid of a dowel driver (or drill in the case of metal support)														
4	Use M8 or M10 anchor plugs (mechanical or chemical) with a minimum length of 100 mm (not supplied). Alternatively, it is possible to use a bolted joint: in this case, use anti-screwing systems (washers or self-locking nuts).														
5	If this has not been done before, unscrew and remove the levelling feet from the machine.														
6	Place the appliance over the previously installed dowels, then ensure the stable and horizontal position of the appliance in all corners.														
7	If necessary, balance by inserting stainless steel supports or galvanised spacers (not supplied) between the equipment frame and the floor.														
8	Reposition the unit: insert washers until the gap (the gap) at the bottom of the machine side is filled.														
9	Fasten the equipment to the floor by tightening the nuts with a torque of at least 40 Nm until the shims in between are found.														


WARNING!

Tighten the bolts only after checking the appliance for actual stability and proper levelling.


IMPORTANT!

If the appliance is not secured to the floor, it may move and cause damage to people and/or things.


WARNING!

Always make sure that the appliance is properly levelled.

In case of subsequent movements, levelling and securing operations must always be performed.


WARNING!

Do not weld the unit to the metal support structure as the internal components would be irreparably damaged.

If this is unavoidable, remove the electronic parts before proceeding.

ELECTRICAL CONNECTION



WARNING!

The equipment is **NOT** equipped with an on-board switch-disconnector. Provide each piece of equipment with an independent circuit, with an earth leakage circuit breaker and automatic disconnection device installed.



IMPORTANT!

The electrical connection must be carried out in compliance with the rules in force in the country of installation.

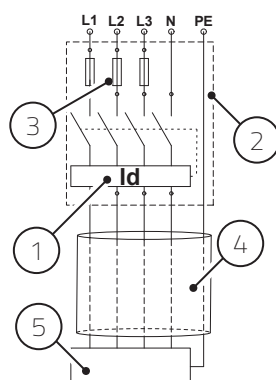


IMPORTANT!

Power the appliance in accordance with its rating plate data, and check the distribution system for correctness.

POWER SUPPLY CONNECTION

Below is the **connection diagram of the appliance to the electrical mains (with differential switch)**:



Pos.	Element	Description
1	Differential switch (RCD)	<ul style="list-style-type: none"> Operating current = 30 mA Max. 1 piece of equipment per RCD. Type B.
2	Laundry power distribution board	
3	Power protection	Protects the equipment and the electrical installation against overload and short circuit. Fuses or circuit breakers can be used as power protection devices. Note: Protection must be in curve C.
4	Power cable	Choose cable type and conductor cross-section as described in this manual.
5	Apparatus	

CHOICE OF POWER CABLE



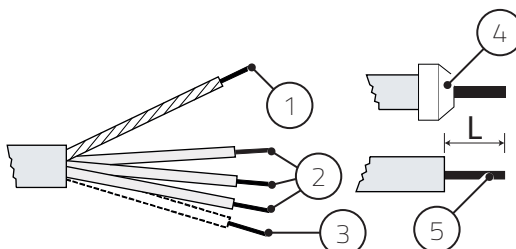
WARNING!

The power supply cable is not part of the supply.

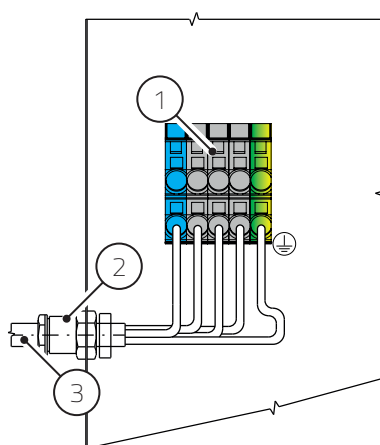
The power supply cable must be:

- conducting with copper nuclei;
- flexible;
- short and straight from the power protection device to the appliance, without deviation;
- under PVC sheathing (at least FR16OR16);
- the cross-section of the conductors must comply with the **"minimum cross-section"** table below;
- without extension cords (the appliance is intended to be permanently connected to the electrical mains).

MINIMUM SECTIONS OF POWER SUPPLY CONDUCTORS			
Power protection (US)		Phase conductor minimum section mm ² (AWG)	Protective conductor minimum section mm ² (AWG)
Int. protection	Fuses		
20A (20A)	16A (15A)	2.5 mm ² (AWG 13)	2.5 mm ² (AWG 13)
25A (-)	20A (20A)	4 mm ² (AWG 11)	4 mm ² (AWG 11)
40A (40A)	32A (30A)	6 mm ² (AWG 9)	6 mm ² (AWG 9)



POWER SUPPLY CABLE CONDUCTOR ENDS	
Pos.	Element
1	Protective conductor
2	Phase conductors
3	Neutral conductor
4	Tube terminal with plastic sleeve
5	Stripped conductors (L = 12mm)



MAIN SUPPLY CONNECTION	
Pos.	Element
1	Terminal block
2	Cable gland
3	Power cable

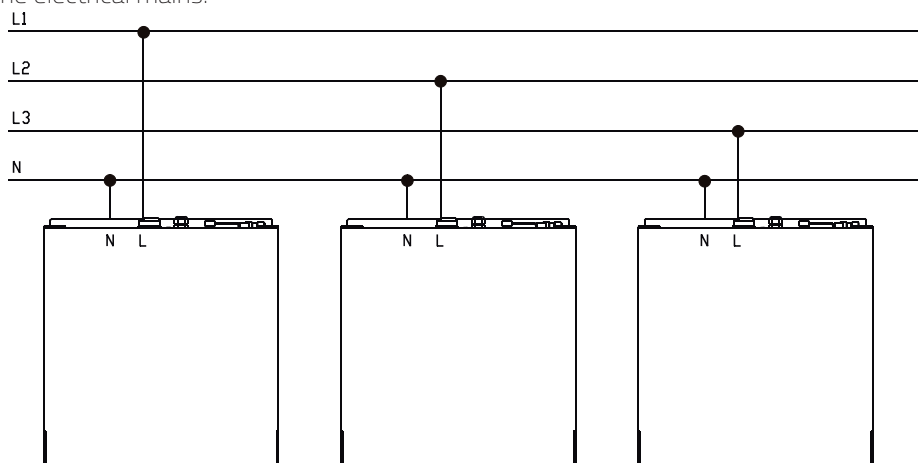
To make the **power supply connection**, follow this procedure:

Step	Action
1	Cut the outer cable sheath to a length of 10 cm.
2	Strip the individual wires for about 12 mm, leaving the earth conductor (PE) slightly longer than the others. Note: in the event of accidental detachment of the cable, the PE will detach last.
3	For stripped conductor ends, use tube terminals with plastic sleeves. Cut off any excess with scissors.

Step	Action
4	Loosen the cable gland on the left side of the machine.
5	Insert the cable.
6	Make the electrical connection.
7	Tighten the cable gland and perform a tensile test. Check that the cable does not move.

If in the installation room **multiple single-phase appliances are parallelly connected**, these appliances must be connected as shown in the picture below.

The supply phase of the equipment, must be connected alternately for the first equipment to phase L1 of the mains, for the second equipment to the second phase L2, etc. The fourth equipment must be connected to the first phase L1. This ensures a uniform load of the electrical mains.



EARTHING CONNECTION



WARNING!

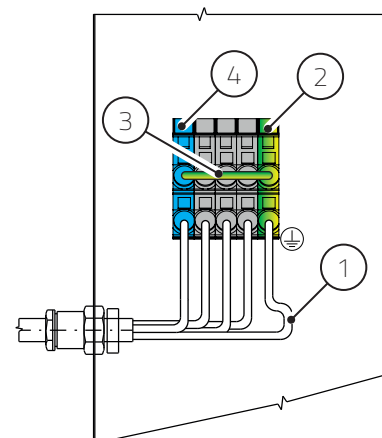
The equipment must be connected to the earthing system of the room in which it is installed.

The appliance described in this manual is set up for a "TT" or "TN" earthing system. The **protective earth connection** must be made in the machine using the PE conductor inside the multi-core power cable.

On **TN** systems, connect the PEN (1) to the YELLOW/GREEN terminal (2).

On **TN-C** systems, make a jumper (3) between the BLUE terminal (4) and the YELLOW/GREEN terminal (2).

The cross-section of the jumper must be the same as that of the protective conductor.



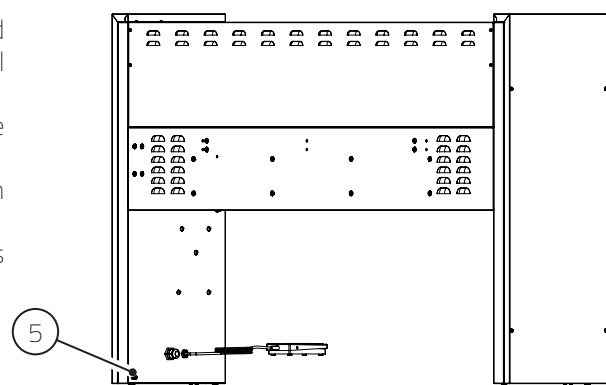
EXTERNAL EQUIPOTENTIAL CONNECTION

If there are other devices in the room that can be touched simultaneously, carry out an equipotential bonding between all these machines.

The external protective terminal (5) for this use is located on the left panel of the machine frame.

Use eye terminals with a 5mm diameter hole and tighten them with an 8mm spanner.

The minimum cross-section of the protective conductor depends on the cross-section of the power cable.



IRONING VAPOUR EXHAUST (FUMES)

Convey the vapour outlet to the outside using a pipe with a smooth inner surface and the same diameter as indicated in chapter DESCRIPTION, TECHNICAL DATA, INTENDED USE.

The maximum length should not exceed 5 metres, and no more than 3 90° bends should be installed, as suction may be insufficient.

Avoid horizontal or counter-sloping sections to avoid condensation stagnation.

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SETTINGS, ADJUSTMENTS, COMMISSIONING

ADJUSTMENTS



WARNING!

Adjustment operations must be performed by a certified technician who has been trained by the Manufacturer.

COMMISSIONING AND TESTING

Functional testing, designed to check the appliance for proper operation, is carried out at the factory.

On-site, during commissioning, a technician must check that the machine is properly installed. This means checking:

- positioning and levelling of the machine,
- distances from other equipment,
- suitability of the premises,
- functionality of the installed machine,
- electric connections.

REMOVAL OF THE BASIN BLOCK

Once the installation procedures have been completed and the panels have been reassembled, the red clamp that binds the basin in the closed position must be cut and removed before the appliance is commissioned.

Step	Action
1	Locate the red clamp with the following sticker attached on the back of the equipment: <div data-bbox="616 969 1086 1205" data-label="Image"> <p>IT TAGLIARE E RIMUOVERE LA FASCETTA ROSSA! EN CUT AND REMOVE THE RED CABLE TIE! DE SCHNEIDEN UND ENTFERNEN SIE DEN ROTEN KABELBINDER! FR COUPEZ ET RETIREZ LE SERRE-CÂBLE ROUGE ! ES ¡CORTE Y RETIRE LA BRIDA DE CABLE ROJA! PT CORTE E REMOVA A BRAÇADEIRA VERMELHA! CS ODŘÍZNĚTE A ODSTRÁŇTE ČERVENOU KABELOVOU PÁSKU! RU РАЗРЕЖЬТЕ И СНИМИТЕ КРАСНУЮ КАБЕЛЬНУЮ СТЯЖКУ!</p> </div>
2	<div data-bbox="253 1296 370 1400" data-label="Image"> </div> WARNING! Cutting the clamp causes the basin to automatically return to its rest position. Before cutting, check that there are no persons in the vicinity of the equipment. The operator carrying out this operation must keep both hands away from the equipment.
3	Cut the clamp with scissors.
4	Remove the clamp.

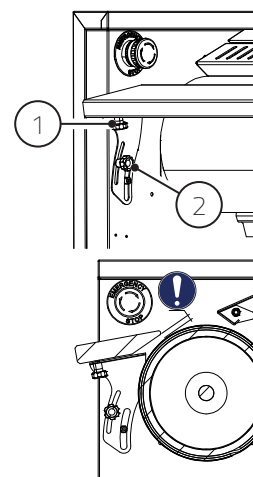
The roller is covered with a protective paper sheet. At the end of the basin release procedure, extract the sheet by gently pulling the free flap on the introduction area towards you.

ADJUSTMENT OF THE INTRODUCTION AXIS

Before commissioning, the introduction axis must be adjusted.

It is recommended that the introduction axis be adjusted whenever an operator has to start his or her shift, in the interests of greater ergonomics and less muscle fatigue.

Step	Action
1	The introduction axis is adjustable vertically and horizontally by the combined action of two knobs on either side of the axis.
2	Slightly loosen the knobs to adjust the vertical travel (1).
3	Once the adjustment has been made, retighten the knobs.
4	Adjust the horizontal travel of the axle by loosening the knobs (2), making sure that the axle does not come into contact with the roller.



FIRST START-UP



WARNING!
See WARNINGS AND RESIDUAL RISKS and apply them before starting the machine.

Step	Action
1	Energise the machine by acting on the wall disconnecter.
2	Start the machine and check that the roller is rotating.
3	Check the descent of the ironing basin.
4	Actuate the pedal and check that the basin rises to the end of its stroke. Release the pedal and check that the basin returns to its working position.
5	Set a temperature close to 140°C (see Navigation Manual) and check that the heating comes on and settles to the desired value. In models with suction, it is automatically activated when the ironing basin exceeds 100°C. Ensure that within a few minutes after the heating is switched on, the extractor is activated.
6	Introduce clean cotton previously damped with water so as to remove the presence of dust or other processing residues from the ironing surface. If necessary, facilitate the input of the fabric by temporarily lifting the basin during introduction.
8	Withdraw the ironed fabric from the bottom area of the ironer.



WARNING!
Ventilate the room during the hot start procedure.
Residues from processing can cause smell during the first hours of operation.
This is normal. The smell is not toxic and will disappear after a short use.

TIPS FOR THE CORRECT USE OF THE MACHINE

COMPOSITION OF GARMENTS

Select garments to be ironed dividing them according to their composition and **start ironing** those that require a lower temperature. **Gradually increasing the temperature, which** can be set on the control panel, iron the most heat resistant garments.

This allows to start working earlier and to avoid waiting for the ironing basin cools in the transit from high to low temperatures. **It is recommended to iron starch-treated garments last.**

Below is an indicative **table of temperatures** to be set **linked to the symbolism** used in textiles on fabric labels.

	Garments whose ironing temperature cannot be higher than 110°C (230°F)		Garments whose ironing temperature cannot be higher than 150°C (302°F)		Garments whose ironing temperature cannot be higher than 200°C (392°F)
--	--	--	--	--	--

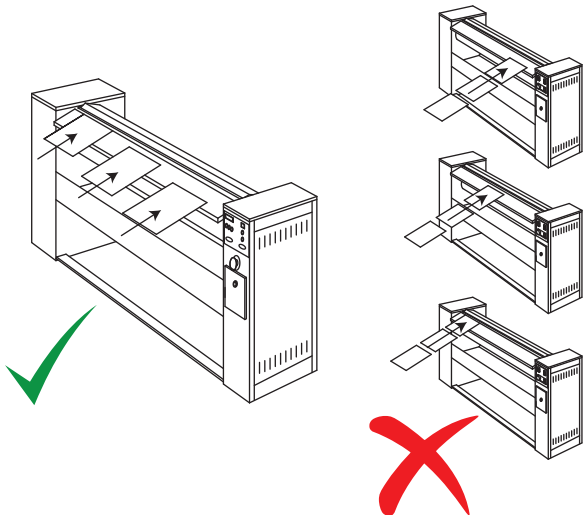
In order to reach good results, garments to be ironed is to have a relative **humidity content** from **10 to 20%**.

In the **metal spring-covered** version, this range is increased by 10% **to 30%** by suction adjusting the drive speed.

USE OF THE IRONING ROLLER SURFACE

Use the entire surface of the ironing roller, by varying the areas used during the cycle.

Use of the machine on the same ironing zone leads to rapid degradation of the roller coating, as well as to overheating of the ironing plate in the unused zone with consequent **fire hazard**.



PROCEDURES TO BE ADOPTED IN EXTRAORDINARY CASES

NO NETWORK

In the event of a mains power failure, the machine automatically brings the basin into the rest position.
Remove the fabric while it is being ironed and lay it down in a cool place.



WARNING!

Retracting a partially or incompletely ironed fabric may entail the risk of scalding due to the partial evaporation of residual moisture.

ENTRAPMENT OF THE PERSON

In the event of entrapment of the person, act promptly on the safety catch rod or the emergency stop.
Disengage the person and any linen present.

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ROUTINE MAINTENANCE, CLEANING

ADDITIONAL SAFETY INSTRUCTIONS FOR MAINTENANCE

The appliances must undergo regular technical maintenance, and any detected defect which can jeopardise the workers' health and safety must be eliminated immediately.



WARNING!

Maintenance operations must be performed by qualified, authorised personnel.

From an operational point of view, maintenance operations can be divided in two main categories:

Maintenance Routine maintenance	All those preventive operations that the operator must carry out to ensure the smooth operation of the appliance over time.
Extraordinary maintenance	All those operations that the operator must perform on the appliance when required (breakage, malfunctions, ...).



WARNING!

Before performing any maintenance work:

- **Disconnect power from the appliance and wait for 10 minutes before intervening;**
- **Disconnect all power sources such as steam/condensate drain;**
- **check that mechanical components are not moving;**
- **check that the temperature of all machine components is below 40°C.**

If the person performing maintenance work is not visible during power disconnection, people who are not aware of maintenance work being performed can power the appliance or accidentally start a cycle. In order to avoid any danger, it is necessary to affix warning signs indicating **"Appliance under maintenance"** and **lock or prevent interventions on the electric disconnectors in "0" or "OFF" position.**

Each procedure described in this manual must be accompanied by the required PPE.

After performing maintenance work and prior to re-commissioning the appliance, it is necessary to:

- Make sure that any replaced part and/or the tools used for maintenance have been removed from the appliance
- Check the emergency devices
- Carefully inspect the appliance before operating it again, and make sure all panels have been reassembled and returned to their seat.



IMPORTANT!

The machine parts must only be replaced with original parts supplied by the Manufacturer.

ROUTINE MAINTENANCE

To ensure the appliance proper operation, regular and preventive checks and maintenance work must be carried out according to the tables provided and the maintenance schedule indicated therein.

Failure to observe the above exempts the Manufacturer from any liability to the effects of the warranty.

The intervals indicated refer to normal operating conditions, i.e. in line with the expected and contractually established operating conditions.



WARNING!

Personnel carrying out maintenance activities must be authorised and specially instructed in the safety and operational procedures to be followed, the hazardous situations that could arise and the correct methods to avoid them.

VERIFICATION TABLE

Operation	Frequency			
	Daily	Quarterly	Biannually	Yearly
Check that the safety systems are activated and working, by intentionally intervening on finger-safety fillet and emergency stop.	▪			
Check that no garments, fabric pieces or other objects are left in the basin or on the roller.	▪			
Check the absence of wear or anomalous signs on the roller surface.	▪			
Check the right movement of the basin both while descending and ascending.	▪			
Check the circumference of the roller.		▪		
Wash the outermost layer of the roller with a gentle water cycle.		▪		
Check the tensioning of the roller drive chain.			▪	
Check the tightness of the contacts on the contactor terminals and other terminals of the electrical components.			▪	
Check the tightening moments of the screws.			▪	
Check the absence of wear or anomalous signs on the basin surface.			▪	
Check the earthing of all metallic parts: pay attention to parts subject to movements (basin).			▪	
Check the tensioning of the chain of the basin traction system, the wear condition of the rope, guides and pulleys.				▪
Lubricate drive chains and all moving mechanisms.				▪

CHECKING THE ROLLER CIRCUMFERENCE

PPE required	Operator qualification	Needed equipment
	PLANT CONDUCTOR ENABLED TECHNICIAN	▪ Tailor's tape measure

The machine efficiency is achieved when the roller and the ironing basin are perfectly coupled. Check periodically that the roller circumference is within the ranges in the table.

GI xx18 [mm]		GI xx25 [mm]	
max	min	max	min
600	515	785	710

Slightly higher measurements are allowed for new machines, which will fall within the canonical values after an initial settling-in period.

Use a tape measure to measure the circumference of the roller in the middle of the roller and near the side ends. The tensile force of the tape measure must not be excessive, there must be no points where the cloth is pressed and the tape measure must be in contact with the cloth at as many points as possible.




Deviations of less than 5mm on the readings taken are to be considered negligible.





If the measured circumference value is below the permissible values, the cover must be restored. See chapter TECHNICAL MAINTENANCE.

WASHING OR REPLACING THE CLOTH

PPE required	Operator qualification	Needed equipment
	PLANT CONDUCTOR ENABLED TECHNICIAN	<ul style="list-style-type: none"> Tailor's scissors


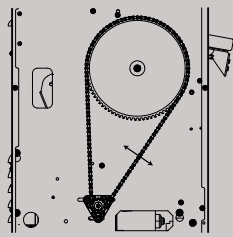
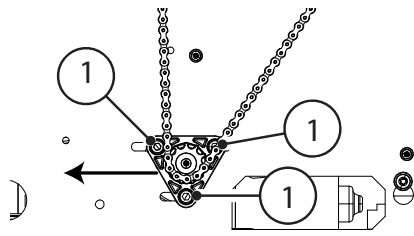

Periodically, or when you notice that the cloth needs to be replaced, carry out the following operations:

Step	Action	Picture
1	Start the machine with heating excluded and stop its operation when the end line is in front of the operator.	
2	Switch off the machine and disconnect the power supply.	
3	The upper sheet of the roll is tied at the sides and the ties are then hidden on the flap of the roll. Use your hands to search for the laces and untie them, then remove the cloth from the roller.	
4	Place the towel in the washing machine and run a delicate wash cycle at a temperature below 40°C, final spin at the highest available speed. WARNING! The cloth must have a residual moisture content of 30% at the end of the washing cycle. With lower values, any folds in the sheet will be difficult to remove.	
5	Raise the last 30 cm of the roll covering by rolling it up on itself.	
6	In this space, insert the initial part of the cloth (the laces are in the final part of the cloth) that is still damp, then lay the flap of clothespin that has just been lifted over it.	


Step	Action	Picture
7	<p>Reconnect the machine and start an ironing cycle.</p> <p> WARNING! Pull the cloth over and stretch it sideways with your hands.</p>	
8	When you have finished applying the cloth, make sure that the pad has not creased.	
9	Raise the temperature to 100 °C and leave the cloth to 'roll' for 15 to 20 minutes, in any case until the cloth is completely dry.	
10	Tie the cloth ties firmly by turning them around the roller axle and pulling them tight.	
11	The knots made should be hidden again and rolled up as before within the fold of the cloth.	

To replace the cloth, proceed as described for cleaning. The material codes can be found in the manual SPARE PARTS.

TENSIONING THE ROLLER DRIVE CHAIN

PPE required		Operator qualification	Needed equipment
		PLANT CONDUCTOR ENABLED TECHNICIAN	<ul style="list-style-type: none"> Tx20 impression screwdriver 5mm Allen key Measure
Step	Action	Picture	
1	Remove the right side panel of the machine.		
2	With a tape measure placed in the middle of the loose branch, check that the chain has a clearance of 0.5 to 0.8 cm.		
3	If the clearance is greater, tension the chain by turning the tensioning screws (1) with an Allen key.		
4	Tighten the screws and check the slack in the branch again.  WARNING! If the chain is too tensioned it gets quickly worn.		
5	Visually check the wear condition of the gear wheels. In the event of chain and/or sprocket wear, please contact the Authorised Service Centre.		


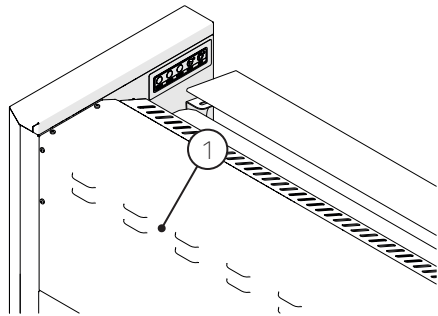
TIGHTENING TORQUES

PPE required	Operator qualification	Needed equipment
	ENABLED TECHNICIAN	<ul style="list-style-type: none"> Impression screwdriver Tx20, Ph2, Pz2


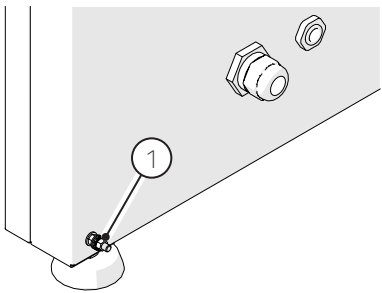
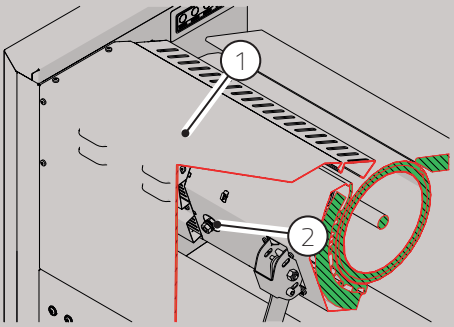
Standard tightening torques are used on the appliance, except torques specified in the specific points:

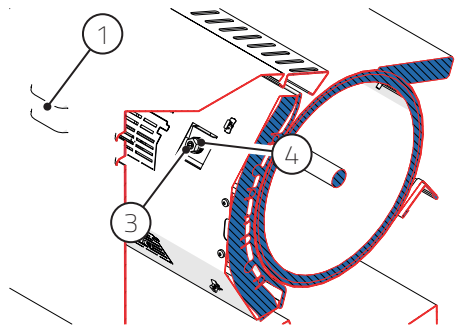
Upper frame fixing screws	Tx20 - 1,4 Nm	
Electrical component terminal screws	Heating contactors (except for GI xx25 supplied at 220/240V 3~)	Mains terminals 1,5 Nm Coil terminals 0,8 Nm
	Heating contactors (only for GI xx25 supplied at 220/240V 3~)	Mains terminals 2,5 Nm Coil terminals 0,8 Nm
	Fuse holder	1,5 Nm
Gearbox screws	Tx20 - 2,2 Nm // Inbus 5 - 2,2 Nm	
Side doors closing screws.	Tx20 - 1,6 Nm	

VERIFICATION OF THE IRONING BASIN

PPE required		Operator qualification	Needed equipment
		ENABLED TECHNICIAN	<ul style="list-style-type: none"> Tx20 impression screwdriver Spanners 8, 13 mm 4 mm hexagonal spanner
Step	Action	Picture	
1	Remove the upper panel (1) using a hexalobular screwdriver.		
2	Visually check for wear, scratches and incisions in the lining of the ironing basin. If encrustations due to lime deposits are present, wax the basin . If there are cuts and/or scratches on the basin cover, please contact Technical Service or your authorised dealer .		
3	Refit the upper panel.		

VERIFICATION OF EARTH CONNECTION

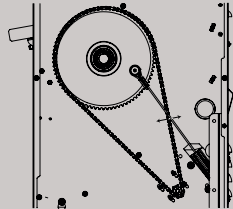
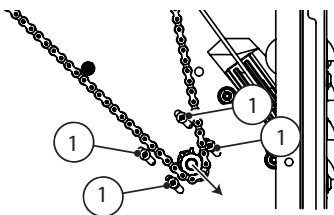
PPE required		Operator qualification	Needed equipment
		ENABLED TECHNICIAN	<ul style="list-style-type: none"> Tx20 impression screwdriver Spanners 8, 13 mm 4 mm hexagonal spanner
Step	Action	Picture	
1	Check the tightening of the external equipotential bonding terminal (1) if there is an equipotential bonding. Hold the inner nut and tighten the outer nut with two 8 mm spanners.		
Step	Action	Picture	
1	Remove the upper panel (1) using a hexalobular screwdriver.		
2	GI 1218 / 1418 Check the tightness of the equipotential terminal by holding the inner nut and tightening the outer nut with two 13 mm spanners (2).		

Step	Action	Picture
3	GI 1225 / 1425 Check the tightness of the equipotential terminal by holding the inner grub screw (3) with a 4 mm hexagonal spanner and tightening the outer nut (4) with a 13 mm spanner.	
4	Refit the upper panel (1) using a hexalobular screwdriver.	

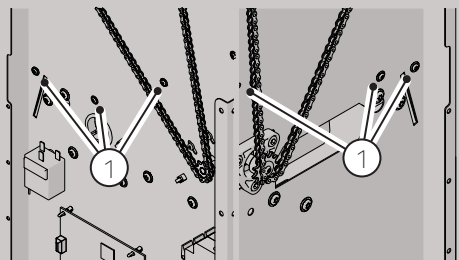
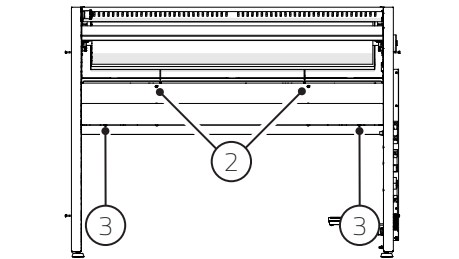
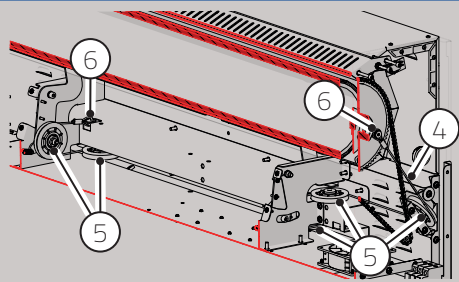
VERIFICATION OF THE BASIN PREMIUM COMPLEX

PPE required	Operator qualification	Needed equipment
	PLANT CONDUCTOR ENABLED TECHNICIAN	<ul style="list-style-type: none"> Tx20 impression screwdriver Measure


CHAIN TENSIONING

Step	Action	Picture
1	Remove the left side panel of the machine.	
2	With a tape measure placed in the middle of the loose branch, check that the chain has a clearance of 1 to 2 cm.	
3	If the clearance is greater, tension the chain by turning the tensioning screws (1) with a hexalobular key.	
4	Tighten the screws and check the slack in the branch again. WARNING! If the chain is too tight, the basin will not return to its rest position.	
5	After tensioning, check that the basin drive mechanism functions correctly both when closing and opening. Otherwise, repeat the tensioning procedure.	
6	Visually check the wear condition of the gear wheels. In the event of chain and/or sprocket wear, please contact the Authorised Service Centre.	

ROPE AND PULLEY WEAR

Step	Action	Picture
1	Remove the side panels of the machine.	
2	Unscrew the laundry compartment by loosening the screws (1) that secure it to the sides.	
3	Unscrew the front screws (2) and loosen the screws (3) located under the laundry compartment, then pull the compartment out.	
4	<p>Inspect the rope (4), pulleys (5) and ends (6). The rope must be free along its entire length from signs of wear and tear such as wire breaks, kinks or eyes. Both ends are in good condition and have no broken wires near the sleeve and on the lanyard.</p> <p>Otherwise, replace the rope.</p>	
5	Once the inspection is complete, reassemble the panels.	

LUBRICATION

PPE required	Operator qualification	Needed equipment
	ENABLED TECHNICIAN	<ul style="list-style-type: none"> Tx20 impression screwdriver Cloth White grease in tube and spray

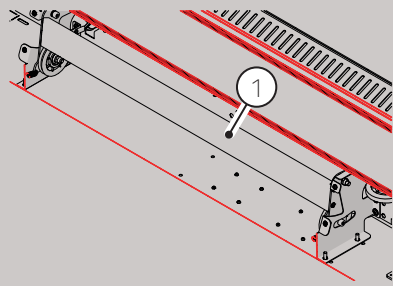
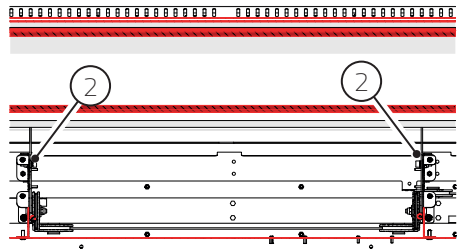
CHAINS

Step	Action	Picture
1	Remove the side panels of the machine.	
2	Wipe along the chains with a clean cloth to remove any excess old lubricant.	
3	Proceed with lubrication by spreading a film of white grease or other grease suitable for general lubrication of moving parts.	

LANYARD

Step	Action	Picture
1	Remove the left side panel of the machine.	
2	Lubricate the pin to which the lance is attached by applying a thin film of white grease or other grease suitable for the general lubrication of moving parts.	

BASIN LIFTING SYSTEM BUSHINGS

Step	Action	Picture
1	Dismantle the laundry compartment in accordance with the rope inspection operations.	
2	Remove the plate (1) covering the rope system.	
3	Lubricate the bushings (2) with spray grease.	

ROUTINE MAINTENANCE, CLEANING

CLEANING

The appliance must be kept well cleaned. Regular cleaning reduces the risk of breakdowns and accidents. Following are the main cleaning operations to be performed on the appliance:

Operation	Frequency			
	Daily	Weekly	Quarterly	Yearly
Clean the detaching device (optional) of fabric residues.	■			
Clean the collection tank from fluff.	■			
Clean the equipment panels.		■		
Clean the cooling openings and ventilation grids.			■	
Clean and wax the basin.			■	
Clean the inside of the machine from dust deposits, especially in the area where the motors are located.				■



WARNING!

Cleaning is to be performed while the machine is stopped and cooled. Do not operate on the machine while working.



WARNING!

Do not use flammable or abrasive products.



WARNING!


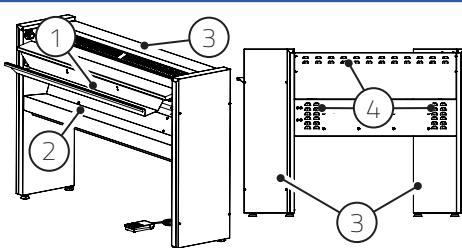
Never use direct jets of water to clean the appliance.



WARNING!

Keep the space around the appliance clean. Keep the appliance away from flammable materials.

CLEANING OF PANELLING AND GRIDS

PPE required	Operator qualification	Needed equipment
	USER PLANT CONDUCTOR	<ul style="list-style-type: none"> Damp cloth Suction device
Step	Action	Picture
1	Use a suction device and then a damp cloth to clean the pressure roller ribbon (1) and the laundry tub (2).	
2	Clean the external panels (3) of the machine with a damp cloth.	
3	Vacuum-clean the opening grids (4) at the rear of the machine.	

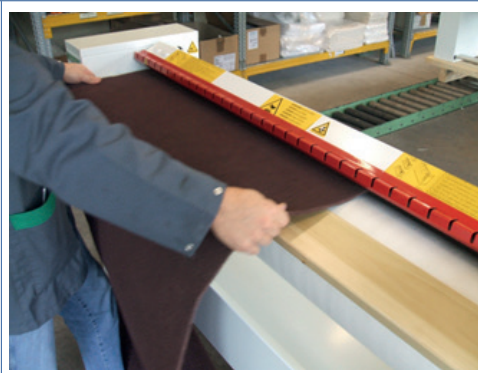
CLEANING AND WAXING THE BASIN

PPE required	Operator qualification	Needed equipment
	PLANT CONDUCTOR	<ul style="list-style-type: none"> Waxing cloth GR57-ST-000040 Wax GR57-ST-000030 Mat GR57-ST-000050

**IMPORTANT!**

Use only the specified equipment available from the manufacturer or authorised dealer.

Monthly, or when creases are noticed on ironed garments, first clean the basin as follows:

Step	Action	Picture
1	Start the machine and set a temperature of 140°C. The basin must adhere to the roller.	
2	Wait until the temperature is reached.	
3	Introduce the cleaning mat at least once and repeat the operation until it covers the entire width of the basin.	

The waxing cloth has a cotton base with:



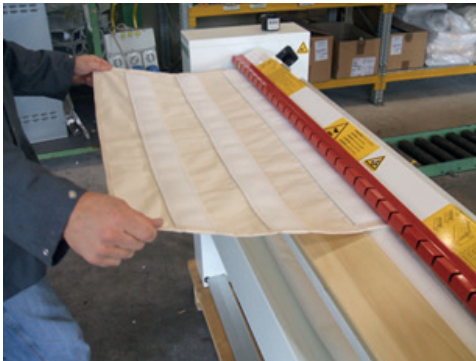
- A double silicone pocket for wax insertion. The pocket makes contact with the roller;
- Three basin polishing bands at the end of the sheet and on the opposite side of the waxing pockets;

**IMPORTANT!**


Do not wash the waxing cloth.

To wax the basin, proceed as follows:



Step	Action	Picture
1	Switch on the ironer and set the temperature to 180°C. The basin must adhere to the roller. Set the minimum ironing speed, if available.	
2	Place the waxing cloth on the ironer's linen feed table.	
3	Place a spoonful of wax on each pocket and check that it is at the bottom of the pocket.	
4	Insert the waxing sheet with the silicone pocket forward and facing the roller sheet.	
5	Repeat the operation several times until the waxing cloth has been passed over the entire width of the roller at least once.	

CLEANING THE INSIDE OF THE MACHINE

PPE required		Operator qualification	Needed equipment
		PLANT CONDUCTOR ENABLED TECHNICIAN	<ul style="list-style-type: none"> Tx20 impression screwdriver Suction device
Step	Action	Picture	
1	Remove the laundry compartment as illustrated in the rope and pulley wear check.		
2	Vacuum-clean the inside of the compartment.		
3	Replace the panels in their original position.		

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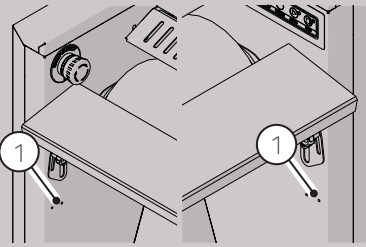
OPTIONAL MODULES

PRESSURE ROLLER RIBBON DEVICE

A pressure roller ribbon device can be installed to help detach fabrics from the roller after they have passed through the ironing basin.

It is particularly suitable when handling light-weight fabrics.

INSTALLATION

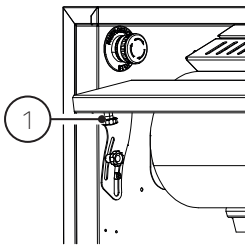
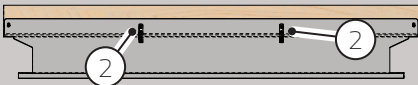
Step	Action	Picture
1	Remove the side panels of the machine.	
2	Using a Ø4.5 mm drill, drill the sidewalls at the bulges (1). Finish the hole with a round file.	
3	Install the pressure roller ribbon by screwing it to the sides using two M4x20 flange-head and knurled screws.	
4	Reinstall the panels in their original position.	

LAUNDRY TUB

A metal tub can be installed on the introduction axis to collect the linen to be treated.

It is particularly suitable when treating large fabrics.

INSTALLATION

Step	Action	Picture
1	Remove the introduction axis by unscrewing the knobs (1) which adjust the horizontal travel.	
2	Turn the axle upside down on a plane and screw the tub onto the central holes (2) using M5x10 cylinder head screws.	
3	Return the board with the tub to its original location by screwing in the knobs.	

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TECHNICAL MAINTENANCE

EXTRAORDINARY MAINTENANCE



WARNING!

Extraordinary maintenance operations are reserved for qualified, technical employees, trained and authorised by the Manufacturer or the Authorised After-Sales Centre. These interventions require in-depth, specific knowledge of the appliance as well as the operations required, associated risks and correct procedures for safe operation.

If exceptional events requiring **extraordinary maintenance operations** occur, the user must follow these procedures:

- check the status of damaged or out-of-phase components;
- if the operations to be carried out are not covered in this manual, send the Manufacturer a report with the events occurred, the inspection result and any comments;
- send the report with the events occurred, the inspection result and any comments to the address specified in the appropriate form.

The Manufacturer or the Authorised After-Sales Centre will assess the situation case by case.

They will then agree on the type of action to be taken jointly with the user, choosing the most suitable solution among those listed below:

- the Manufacturer or the Authorised After-Sales Centre will send another qualified technical employee, trained and authorised to perform the necessary operations;

or,

- the Manufacturer will authorise the user to take the required actions, sending additional instructions.




WARNING!

The spare parts to be replaced shall be ordered from the Manufacturer.

If the customer does not use original spare parts or parts authorised in writing by the Manufacturer, the latter shall be relieved of any liability on the operation of the appliance and the safety of the operators. Permissions and/or instructions must always be given in writing. Without a written permission, it is forbidden to operate the appliance, and the Manufacturer declines all responsibility.

REPLACING FUSES

PPE required	Operator qualification	Needed equipment
	ENABLED TECHNICIAN	<ul style="list-style-type: none"> ▪ Tx20 impression screwdrivers



WARNING!


Make sure the appliance is not connected to the power supply and cannot be accidentally turned on.

The precise values of the fuses can be found in the circuit diagram supplied with the equipment.

If a fuse blows, it can be replaced with a fuse with the same value, but never with a fuse having a higher value.


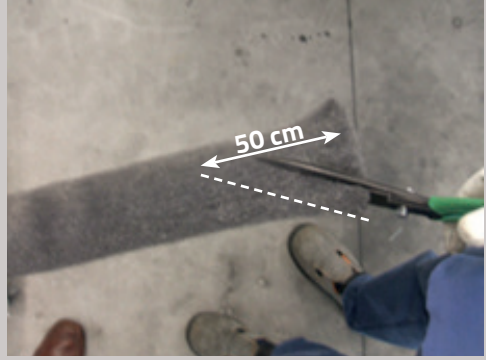

If a fuse blows again, do not replace it, but find the cause of the fault, using the circuit diagram enclosed with the equipment. If necessary, please contact the Manufacturer.

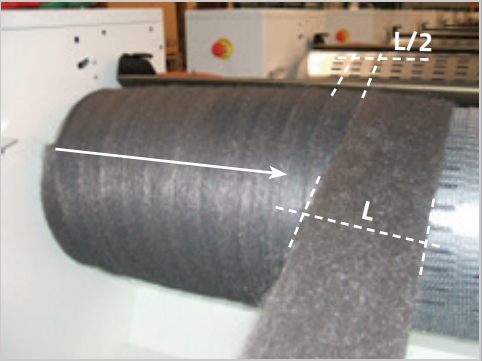
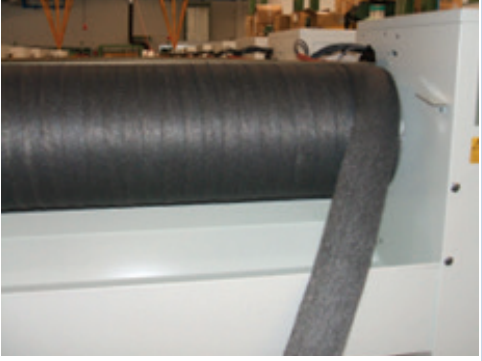
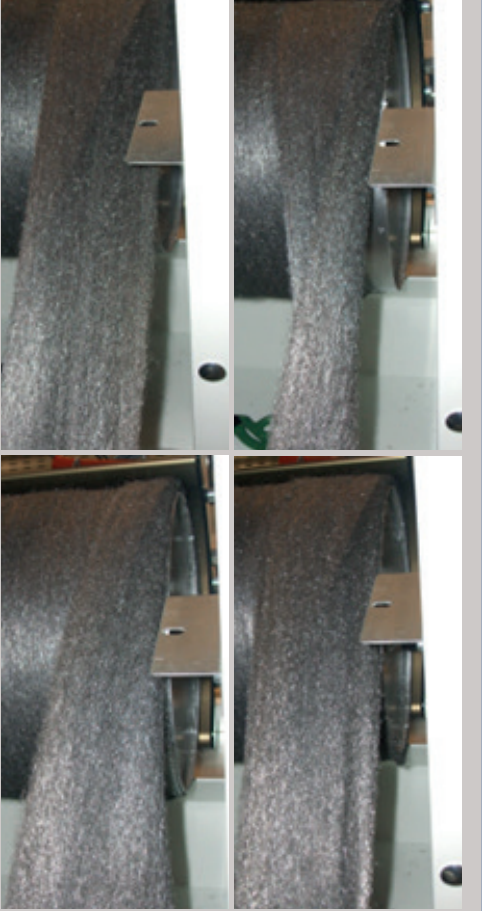
REMAKING THE ROLLER COVER

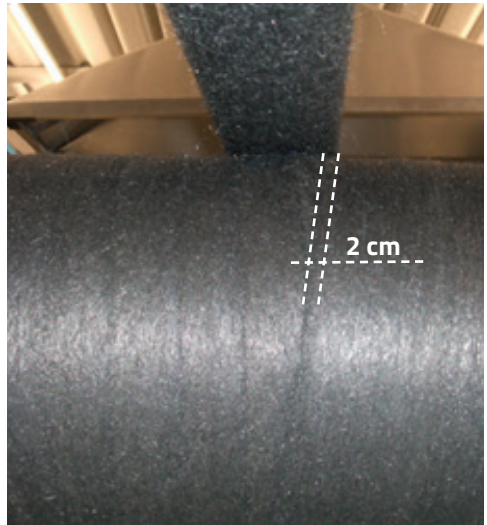



PPE required	Operator qualification	Needed equipment
	ENABLED TECHNICIAN	<ul style="list-style-type: none"> ▪ Cutter ▪ Tailor's tape measure ▪ Tailor's scissors


Carry out these operations if:

- The circumference of the roller falls outside the limit set out in chapter ROUTINE MAINTENANCE, CLEANING;
- Note a packing of the coating;
- After a prolonged period of inactivity (more than 6 months).

Step	Action	Picture
1	Start the machine with heating excluded and stop its operation when the end line is in front of the operator.	
2	Switch off the machine and disconnect the power supply.	
3	The upper sheet of the roll is tied at the sides and the ties are then hidden on the flap of the roll. Using your hands, look for the laces and undo them, then remove the cloth from the roller (see "WASHING OR REPLACING THE CLOTH").	
4	Remove and unwind the roller cover (penultimate roller cover) and the jute cover (for machines without suction) until the steel wool is in view.	
5	Using a cutter, cut the steel wool along the entire length of the roller, then remove it.	
6	Cut the beginning of the steel wool band at a sufficient angle to have a cut about 50 cm long.	
7	Switch on the ironer and set the maximum temperature. Keeping the basin in the rest position , start stretching by introducing the band from the left end of the roller. To disable basin operation, please refer to the electronic control manual.	


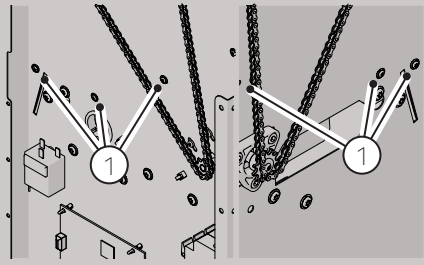
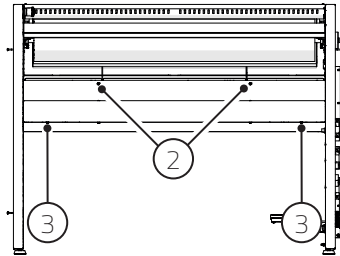
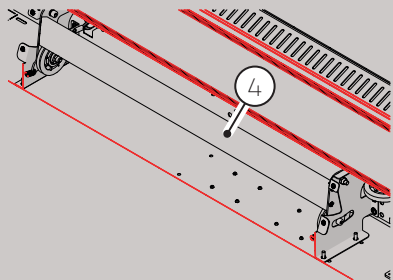
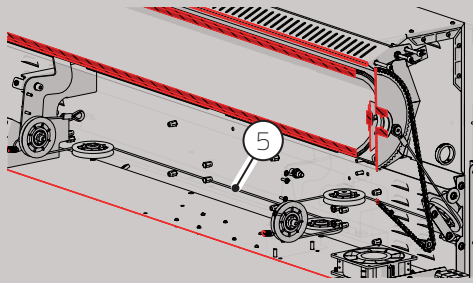
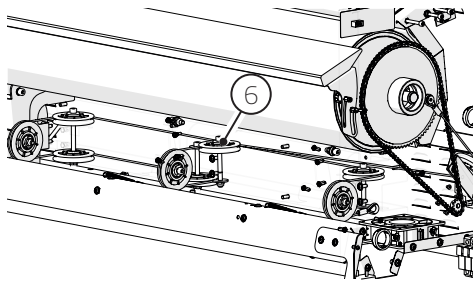
Step	Action	Picture
8	While turning the roller, accompany the band so that the overlap with the previous lap is about half the width of the steel wool band (half-overlapping taping).	
9	Once the first round of steel wool has been completed, the basin can be adhered to the roller (the steel wool does not spoil the surface treatment of the basin). To re-enable basin operation, please refer to the electronic control manual.	
10	Stop the machine with the foot pedal, then resume ironing by folding the steel wool band and continue coating the roller in the opposite direction.	

Step	Action	Picture
11	This last lap requires overlapping with the previous lap by approximately 2 cm.	
12	When the second round has been completed, make a third.	
13	At the end of the third turn, cut off the parts that exceed the length of the roll with a tailor's scissors.	
14	Lower the ironing temperature to about 110 °C and wait until this temperature is reached.	
15	Leave the roller in rotation for 15-20 minutes.	
16	Stop the machine and check with a dressmaker's tape measure that the circumference is constant on the sides of the roller Deviations of less than 1cm are to be considered negligible.	
17	<ul style="list-style-type: none"> ▪ Machine without suction: apply the jute cloth and cut off the excess quantity with scissors. ▪ Machine with suction: apply the pad directly on the steel wool. <p>WARNING! In this operation, the operating temperature must be below 100°C. For ironing machines without suction, raise the last 30 cm of the cloth and insert the spring clip underneath. Cloth and mats must be accompanied during application.</p> 	

Step	Action	Picture
17	<p>Follow the cloth replacement instructions to finish the application of the cloth.</p> <p>When this operation is also completed, compare the circumference measurement of the finished roller as required (see chapter ROUTINE MAINTENANCE, CLEANING).</p>	

The material codes can be found in the manual SPARE PARTS.

REPLACING THE BASIN ROPE

PPE required		Operator qualification	Needed equipment
		ENABLED TECHNICIAN	
Step	Action	Picture	
1	Remove the side panels of the machine.		
2	Unscrew the laundry compartment by loosening the screws (1) that secure it to the sides.		
3	Unscrew the front screws (2) and loosen the screws (3) located under the laundry compartment, then pull the compartment out.		
4	Remove the plate (4) covering the cable system.		
5	Uncoil the rope completely so that it discharges torsions and lay it on the ground.		
5	GI 1218 / 1418 The rope (5) must pass through as shown in the figure. Attach the lanyard inside the tank first, then pass the rope sequentially over the pulleys. Follow the rope in order not to create torsions that would damage the rope.		
6	GI 1225 / 1425 The rope should pass through as shown in the figure. Fasten the lanyard inside the tank first, then run the rope from the first to the last linkage, then over the central linkage (6) and finally out to connect to the sprocket. Follow the rope in order not to create torsions that would damage the rope.		

TROUBLESHOOTING, REPAIRS

TROUBLESHOOTING - COMMON

The following information is intended to assist you in identifying faults and restore the appliance functionality and efficiency.

Malfunctions related to electronic control can be found in the appropriate section of the navigation manual.

MALFUNCTIONS OR FAULT MESSAGES



IMPORTANT!

Please refer to the tables in the following paragraphs to search for 'possible causes'.

THE MACHINE DOES NOT HEAT

Check the tripping of the safety thermostat.

If the temperature of the ironing plate is above 235 °C, the circuit breaker intervenes by deactivating permanently the heating. Stop ironing, wait for the basin to cool down, then restore the circuit breaker on the left side of the machine and protected by the screw cap.

When resuming activity, remember to use the full width of the ironing roller.

If the problem persists, consult the manufacturer.

THE MACHINE DOES NOT START

Check:

- voltage presence and control panel lighting;
- Intervention of fuses.
- Emergency button pressed;
- Leakage protection rod jammed or relative microswitch tripped;
- Disconnected or defective control panel;
- Faulty CPCB;
- Broken gearing.

THE MACHINE DOES NOT STOP

- Jammed finger guard;
- Disconnected or defective control panel.

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DECOMMISSIONING, DISPOSAL

DECOMMISSIONING

To **decommission** the appliance, proceed as described:

Step	Action
1	Cut-out the external power supply to the appliance (external disconnecter or machine switch).
2	Disconnect the machine from the general plug.
3	Remove the machine following the transport procedures described in this manual.
4	Remove the fuses positioned to prevent the appliance from being re-commissioned.
5	Always keep these instructions with the machine so as to facilitate repairs or disposal.
6	Mark the machine as "Out of order".



WARNING!

Carry out all operations when the machine is cold.

DISPOSAL



IMPORTANT!

In compliance with the standards for waste disposal in force in the installation country, and with a view to safeguarding the environment in which the appliance is installed, all appliance parts must be divided so as to be properly disposed of and recovered.

The appliance disposal follows the **"WEEE - Waste Electrical and Electronic Equipment Directive (2012/19/EU)"**.

The purpose of this directive is the prevention of waste electrical and electronic equipment and, in addition, the reuse, recycling and other forms of recovery of such waste so as to reduce disposal.



Illegal disposal of the product by the user involves the application of the administrative sanctions provided by law.

In order to allow the proper disposal of materials that make up the appliance, please find below the position of the main materials:

Component	Main materials	Mode of disposal
Structural frame	Coated steel plate	Recycle as common steel
Brackets, supports, control panel steel plate	Galvanised steel plate	Recycle as common steel
Resistors	Steel	WEEE - Electric parts
Fan unit	Galvanised steel and copper	Ferrous waste
Electric motors	Aluminium, steel, copper	WEEE - Electric parts
Gearbox	Aluminium, Steel, Bronze, Oil	Used oils, metal scraps
Runners	IXEF, Copper	Not recyclable
Electric parts	Plastic materials, copper, steel	WEEE - Electric parts
Ironing basin	Aluminium	Recycle of aluminium
Batt insulation	Ceramic fibre	Not recyclable

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RECOMMENDED SPARE PARTS

RECOMMENDED SPARE PARTS

The machine is subject to normal wear and tear of mechanical and electrical components during its operation. To promptly intervene in case of appliance failure, we recommend equipping the machine with the following spare parts, divided among parts common to all appliances and dedicated parts.

Parts common to differently sized machines

- Temperature probes;
- Complete I/O Relay board;
- Emergency stop;
- Control panel;
- Panel fixing screws;
- Transmission unit;
- Basin waxing and cleaning kit.

Parts related to the size/capacity of the machine

- Heating elements;
- Fuses;
- Roller covers.

If you are in particularly disadvantaged zones with regard to the distribution of spare parts or if it is a priority to restore the machine quickly, we recommend the following additional components:

- Bearing set;
- Chains and transmission ropes;
- Roller covering materials.

Consult the spare parts section in order to identify the correct components for the used appliance.



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