# Training – Startup Procedures
# X20 Inteli Control

Reference manuals:

(1) **"Operations & Maintenance Instructions" for Flatwork Ironer – Cod. 550038 Rev. 16/1018 or higher**

(2) **"Instructions Manual – Technical Assistance" Cod. 555391 Rev. 01/0615 or higher**

(3) **"Electrical Maintenance Manual" for Flatwork ironers – Cod. 561514 Rev. 00/0112 or higher**

Rev. 00/0419

Operating and Use. Inteli Control

---

ⓘ **CAUTION!**

THE REGULATIONS FOR SAFETY AT WORK AND ACCIDENT PREVENTION MUST BE METICULOUSLY FOLLOWED.

DO NOT USE THE IRONER WITHOUT SUITABLE TRAINING AND EXTENSIVE OPERATING KNOWLEDGE.

NEVER START OR USE THE MACHINE IF ANY OF THE FOLLOWING ARE MISSING, INCORRECTLY POSITIONED OR MALFUNCTIONING:
- COVERS ( GUARDS) AND PROTECTIONS
- SAFETY DEVICES
- CONTROL ELEMENTS

IF THE IRONER IS TO BE USED BY MORE THAN ONE PERSON, IT IS ESSENTIAL THAT ONE OF THESE OPERATORS IS CLOSE TO THE CONTROL PANEL AND EMERGENCY STOP TO BE ABLE TO QUICKLY AND EFFECTIVELY TAKE MEASURES IN THE EVENT OF THERE BEING ANY DANGEROUS CIRCUMSTANCES.

NEVER TRY TO EXTRACT JAMMED OR BADLY INSERTED LAUNDRY IF THE IRONER IS RUNNING OR AT A HIGH TEMPERATURE, OR IF THE ROLL FIXING BRACKETS ARE NOT IN THE MAINTENANCE POSITION.

---

⚠ **DANGER!**

**MECHANICAL RISKS**
- To avoid the risk of being caught up in the machine's moving parts it is essential for the hair to be tied up and suitable fitted clothing to be worn.
- Scarves, ties, neckerchiefs, lose garments, open cardigans, hanging belts, wide sleeves, etc. must not be worn.
- Jewellery must not be worn.
- Do not use the machine without all the covers and safety guards correctly in place.
- Disconnect the power supply and close the gas supply valves and other sources of heating before removing any form of protection.

**ELECTRICAL RISKS**
- It is essential for the machine to be connected to external protection (grounded).

**HIGH TEMPERATURE RISKS**
- Do not remove any safety guards without first making sure the machine is cool (<35ºC / 90F).
- Do not put the hands anywhere near the exposed surface of the roll, particularly, the laundry output area or the heating circuit elements.
- Wear heat insulating gloves to protect the hands from the continuous contact with hot laundry.

**FIRE RISKS**
- Fluff and soot are highly flammable substances.
- It is essential to avoid these building up inside the machine and the exhaust ducting which goes from the machine to the outside.
- To achieve this, all the places likely to collect fluff and soot must be regularly cleaned (e.g.: roll, base-frames, covers, exhaust ducting, filter, fan, etc.).
- Also keep the area around the machine free from fluff and any other inflammable materials or substances.

# SYMBOLS USED IN MACHINE LABELLING

**Electrical risk**
Safety warning indicating element with electricity.

**High Temperature risk**
Handle with caution.
Use adequate protection.

**Mechanical risk**
Protection guard for moving parts.

**Risk of inhaling harmful or irritant vapours**
Keep the doors/covers closed.
Use adequate protection.

**Flame risk** (only on some machines)
Protective guard for flame.

**Risk of falling**
Use proper access and safety methods.

**Access prohibited**

**Refer to instruction manual/booklet**

# SYMBOLS USED IN THIS MANUAL

Symbol used to highlight a possible HAZARD, WARNING or NOTE.

This symbol is used to give relevance to any precise explanation .

## NOTES:

*(1)* **Trained personnel** refers to those who have read and understood the Instruction Manual, who have been trained by the Authorised Technical Service or by a representative of the customer present at the start-up who is familiar with the operation of the machine and is authorised to use it.

*(2)* **Authorised Technical Service (ATS)** is one that has been recognised under contract and properly trained by the manufacturer.

*(3)* **Registered Installation Contractors** are those officially approved by the government of the country the machine is to be installed.

*(4)* **Customer Technical Service (CTS)** is one that has been authorised by the customer and which has sufficient basic technical knowledge to correctly interpret and carry out the actions attributed to it in this manual. The manufacturer strongly recommends that the customer should have its own technical service, particularly in laundries with large-scale machinery installations.

# Introduction and Use (Inteli Control)

This guide is intended to inform owner/operator of general operation and basic set up for the Inteli controlled press models;

**X20075, X20100 and X20125 Heated roll press**


**Important instructions for use:**

- This machine is designed for processing fabrics washed in water bath only

- Linens treated with minimal amounts of chemical residue in final rinse should not exceed 6.5 – 7.0 PH levels

- For best results linens should not be folded or multi layered(exception being pillow cases)

- Use complete working area of use for best results, when pressing small items move from center to both ends during feeding of linens

- Do Not stop press using the hand guard or E-stop when unless it is an emergency as straps can be damaged if left on hot drum surface.

- When shutting down ironer always use the red stop on control panel, unit will continue running without heat until drum temperature reaches preset temperature of 200f then it will stop.
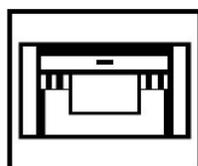

**Icons shown on display:**

| ICON | INTERPRETATION |
| --- | --- |
| ⬚ | Access to the ironing programs |
| Ⓜ | MANUAL SPEED operating mode |
| Ⓐ | AUTOMATIC SPEED operating mode |
| 191℃ | Ironing roll temperature |
| 🔥 | Burner on |
| 🔥 | Burner off |
| 🔥 | Burner disconnected |
| 25 m/min | Speed of the rolls (m/min) |

| | |
|---|---|
| | Indication that the minimum ironing temperature has not been reached |
| | Operation with linen folder |
| | Programming menu |
| | Creating a new program |
| | Modifying an existing program |
| | Deleting a program |
| | Locking a program |
| | System tools menu |

## Main menu intervention modes

The X20 ironer control is divided into three modes of intervention;

**PROGRAM EXECUTION MODE**
Covers the functions or interventions aimed at:
- Selecting and executing the different ironing programs
- Accessing information about the different functions that the ironer is executing
- Specific modifications of the program being executed

All the information that appears on the screen during the execution of a program is in graphic mode.
Information regarding this intervention mode: section 7.5 on this manual.

**PROGRAMMING MODE**
Covers the functions or interventions aimed at:
- Knowing the content of the PRE-SET program in the ironer machine's memory
- Creating a new ironing program or modifying an existing program
- Copying an existing program and modify it
- Blocking the use of programs
- Eliminating programs from the ironer's memory

All the information that appears on the screen in the program management menu is in graphic mode.
Information regarding this intervention mode: section 7.6 on this manual.

**SYSTEM TOOLS MODE**
This area offers specific menus for CONFIGURING THE SYSTEM.
Among other features:
- Configuring operation parameters
- Setting the clock of the system
- Controlling security codes

It also provides a lot of information about the characteristics and life of the ironer.
The information in this area is in text mode.
Information regarding this intervention mode: section 7.7 on this manual.

## Control Panel

The Inteli control is the premier control offered in today's commercial/Industrial laundries where program flexibility is needed for special linen processing. Control viewing uses graphic icons for press functions for better understanding of normal operations.
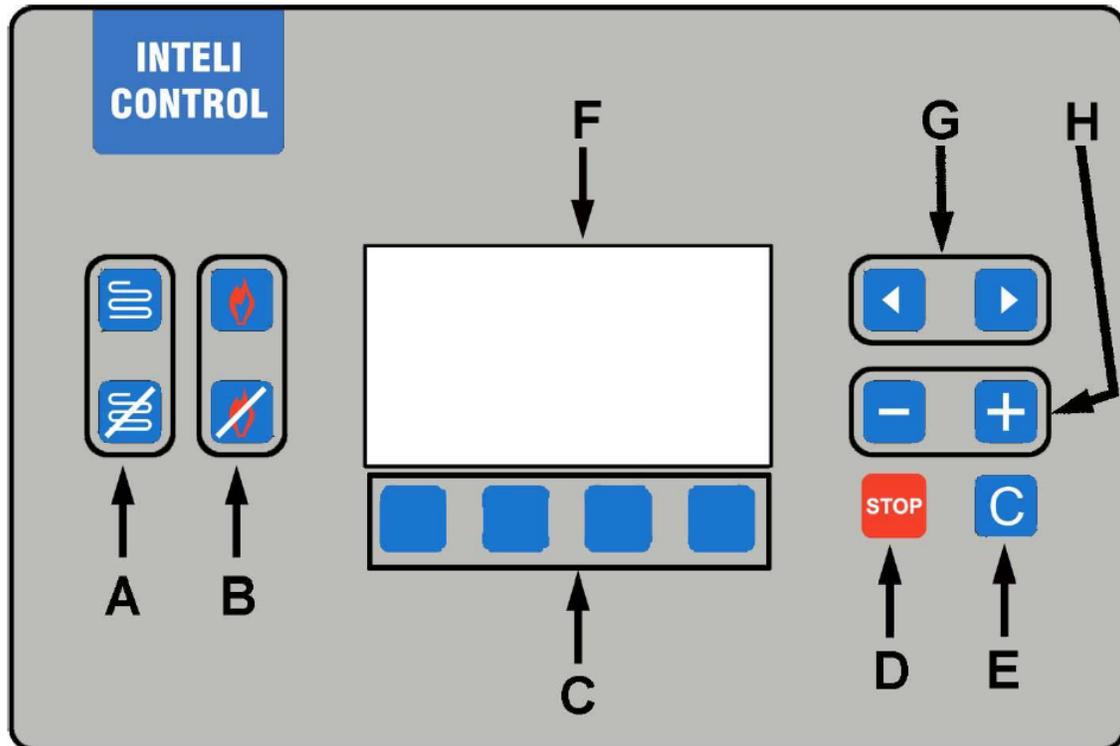


Fig. 7.1

**Description of the control panel** (Fig. 7.1)

A ->   Folder START and PAUSE buttons
B->   Buttons for lighting and turning off the burner (machines with gas heating only)
C->   Multifunction keypad
D->   STOP button. Normal machine stopping
E->   Button for special functions
F->   Display
G->   Display movement buttons
H->   Buttons for inserting text and selecting values
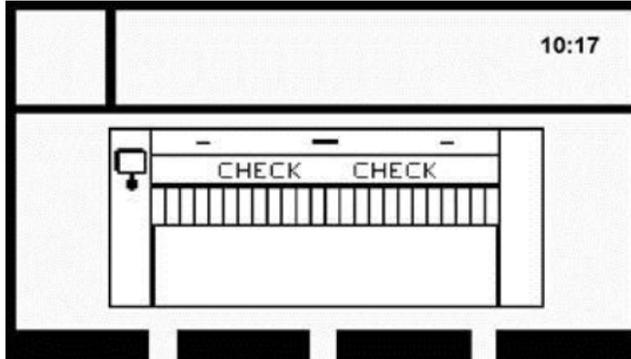
## 7.5. Executing an ironing program

### 7.5.1. Initiating an ironing program

Group the fabrics together into homogeneous loads to be ironed and arrange them in a way that aids their insertion into the ironer.

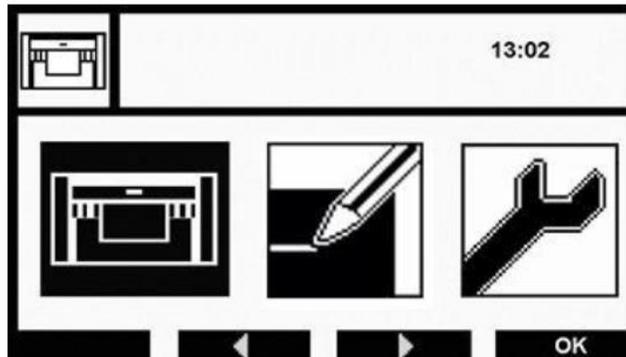Connect the energy supply system for the heating: steam or gas.

Switch on the power supply switch breaker. The **CHECK** report is displayed on the screen. Activate the hand-guard. Press the **OK key.**

Remember that the correct functioning of the emergency stop buttons must be checked on a daily basis (refer to chapter 13. Maintenance).

Once hand guard has been pushed to verify the safety is working, it allows us to view the main screen of operation.

Select the icon of the program to be executed.

A list of the programs saved will appear on the display.

Once we determine our program, we use the up and down arrows to highlight the program selection, we are ready start unit by pressing button under start key.
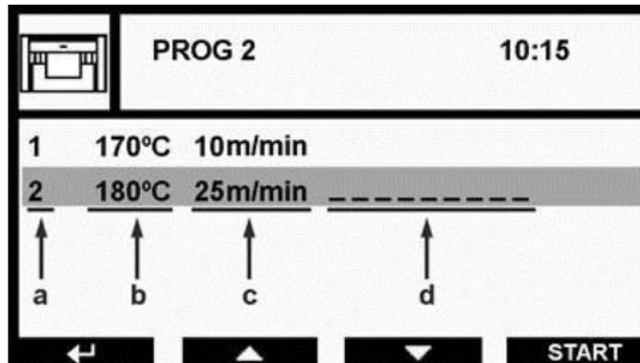
Details of the program title:
- a -> program number
- b -> ironing temperature
- c -> roll speed
- d -> text identifying the program

Select a program and press **START**.

Insert the linen into the ironer, making sure, where possible, to cover the entire surface of the roll. In the event of the linen width being less than the length of the roll, insert the linen alternately (right - left).
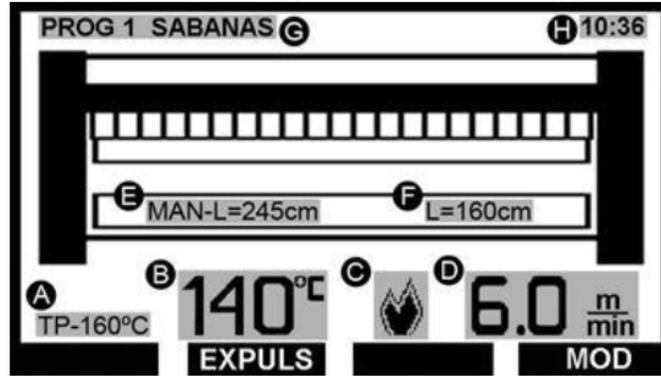
Follow the indications for the special ironing area (Section 7.5.5).

Now we see the program execution screen and its icons, at this time the ironer is in run mode allowing us to view the screen. Once the unit is started, it is possible to modify the existing program at any time.

Interpreting the program execution screen:

A- **TP**. Programmed temperature
B- Ironing temperature
    As long as the roll temperature is not 10ºC lower than the programmed temperature, it will be displayed flashing.
C- Indication of the heating status
D- Roll speed
E- Folder functioning mode and length of programmed item
F- Length of last article inserted
G- Program identification
H- System clock

**MOD** key: makes it possible to modify the parameters of the program running.
**EXPULS** key: activates the expulsion straps.



**Note: the EXPLUS key in English indicates Eject for the folder system.**

## Program modification HS models

### Manual control of roll speed;

When in manual mode the roll will rotate at programmed speed regardless of variations in the ironing temperature. This mode is more for the customer that is looking for production of linens rather than customer looking for quality of finished products. The speed is adjustable from 4ft per min up to 49 feet per min. Average speed is around 25-30 FPM.

<u>Manual control of roll speed</u>
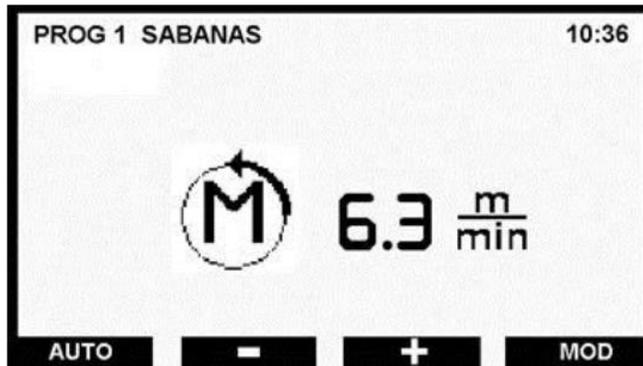
The roll will rotate at the programmed speed regardless of variations in the ironing temperature.

| Model | Programmable values |
|-------|---------------------|
| LS | m/min. 1 – 9.0 (min-max) <br> Ft/min 4 – 29 (min-max) |
| HS | m/min. 1 – 15.0 (min-max) <br> Ft/min 4 – 49 (min-max) |

Press the **+** / **–** keys to modify the speed of the rolls.

Press the **MOD** key to access the ironing temperature control screen.

Press the **AUTO** key to change to **AUTOMATIC** speed control.

## Auto control of roll speed;

Automatic roll speed is used more for the customer that is wanting quality pressed linens. The auto speed control works in sequence with ironing temperature, if the microprocessor detects a decrease in the ironing temperature the rotation speed of the roll is reduced. This allows the unit to maintain temperature to ensure that the linen is dried properly with a good finish.

**Automatic roll speed control**

If the microprocessor detects a significant decrease in the ironing temperature, the rotation speed of the roll is reduced automatically.

Press the **+** / **-** keys to change the programmed roll speed.

Press the **MAN** key to change to **MANUAL** speed control.

Press the **MOD** key to access the ironing temperature control screen.

| PROG 1 SABANAS | | | 10:36 |
|---|---|---|---|
| | | $6.3 \frac{m}{min}$ | |
| MAN | — | + | MOD |

## Ironing Temperature;

Ironing temperature is controlled by the center left thermostat located on drum roll surface under feed bed.

**Ironing temperature**
Programmable range:
Machine with electric/steam heating:
  ºC: 70 – 160 (min-max)
  ºF: 160 – 320 (min-max)

Machine with gas heating:
  ºC  70 – 170 (min-max.)
  ºF  160 – 340 (min-max.)

Press the **+** / **-** keys to modify the ironing temperature.

Press **MOD** key to access the folder control screen.

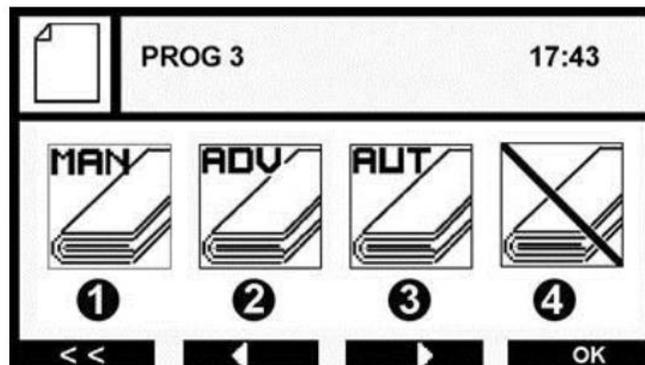| PROG 1 SABANAS | | | 10:36 |
|---|---|---|---|
| | 160 ºC | | |
| | + | — | MOD |

## Folding modes of operation;

This programming only appears on machines with a folder incorporated.

**Folding modes**

1. Operation in manual mode
2. Operation in advanced manual mode
3. Operation in automatic mode
4. Folder halted

Press the ◄/► keys to select the desired option.

| PROG 3 | | | 17:43 |
|---|---|---|---|
| MAN | ADV | AUT | |
| ① | ② | ③ | ④ |
| << | ◄ | ► | OK |

## Three folding modes of operation;

### Manual mode

The user must enter the length of the part to be folded using the control panel keyboard.
Alternatively, the ironer control can measure and memorise the length of the part to be folded.
The ironer control automatically determines the number and length of the folds.
This is recommended where the articles to be folded are of equal length, and the width of the fold is not a critical measurement.
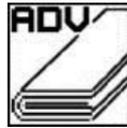
**Operation in manual mode**
The programmed length can be altered by pressing the + / – keys.
The ironer control automatically determines the number and length of the folds.

**Programmable range**:
cm. 60 – 400 (min-max)
in. 24 – 157 (min-max)

### Advanced manual mode

The user must enter the length of the part to be folded using the control panel keyboard.
Alternatively, the ironer control can measure and memorise the length of the part to be folded.
The ironer control offers the possibility of defining the number of folds.
Recommended where the items to be folded are of the same length and the user wishes to define the type of fold.
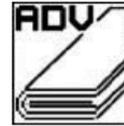
**Operation in advanced manual mode**
The programmed length can be altered by pressing the + / – keys.

**Programmable range**:
cm. 60 – 400 (min-max)
in. 24 – 157 (min-max)

The ironer displays the number of possible folds depending on the length of the article to be folded.
Users must select the most appropriate option for their requirements.

**Number of folds possible:**
2, 4, 6, 8, 10, 12, 14.

### Automatic mode

The ironer control automatically determines the number and length of the folds.
Recommended when the folded items are of different lengths and do not require very accurate folding.

**Operation in automatic mode**
The ironer control measures the length of each item and automatically determines the number and length of the folds.

**Folder halted**
To restart the folder, select one of the above options or press the corresponding button on the control panel.

## "OPTIFEED" Preferable linen feeding system

The ironer's control detects the differences in temperature between the areas of the cylinder, and indicates, by illuminating the linen feeding table, which is the area or areas (Area 1, 2 or 3), on which it is preferable to iron (Figure 7.2).

Following all the combinations of these three ironing areas prevents the cylinder from overheating, increases performance and optimises the machine's consumption.

For further information on the OPTIFEED system, see the following video:

https://www.youtube.com/watch?v=oyhcq0YZutl



Fig. 7.2

## Stopping Modes

> 🛈 **CAUTION!**
>
> **THE EMERGENCY STOP DEVICE AND THE HAND-GUARD SHOULD NOT BE USED AS A REGULAR STOPPING DEVICE FOR THE IRONER.**
>
> **KEEP IN MIND THAT THESES DEVICES:**
> - **DO NOT STOP THE INERTIAL MOVEMENT OF THE FANS.**
> - **DO NOT CANCELL NOR REDUCE THE TEMPERATURE OF THE MACHINE.**
> - **DO NOT DISCONNECT THE IRONER FROM THE ELECTRIC SYSTEM.**

**Normal machine stopping**

**PRESS STOP KEY.** The heating system is turned off. The ironer enters a cooling situation: the rotation speed is reduced and the extractor fan is kept running while the roll temperature exceeds 100° C (212° F).
When the temperature falls below this value, the rotation of the roll is halted, the extractor halts and the main menu icons are displayed on the screen.

**Emergency stop devices**

**EMERGENCY STOP BUTTON.** The machine is fitted with an emergency stop identified by a red button on a yellow background located on the front right base-frame. The function of this device is to stop all machine functions immediately and to KEEP them stopped.

<u>To activate the emergency stop:</u>

Press in the emergency stop button from the front. An audible warning is produced and **ALM/EMER** appears on the display.
To deactivate the audible warning press the **STOP** key.

<u>To continue the operation:</u>

Release the emergency stop by making a quarter turn in the direction of the arrow shown on the button itself.
Press the **STOP** key of the multi-function keyboard or deactivate the audible warning and next the **START** key to restart the operation.
The **REV** key allows the roll to rotate in the opposite direction to the linen input direction. Use only under exceptional conditions.

**Hand Guard Stop**

**HAND GUARD.** The hand guard consists of a swinging motion guard on the front of the machine to prevent the hands reaching towards the roll.
Pushing or pulling the aforementioned moving guard immediately STOPS the rolls from rotating. The machine will remain in this state until being operated again.
The hand guard stop is also assigned to operate as a safety stop from any part of the introduction zone.

<u>To activate the hand guard stop:</u>

Press directly on the bottom part of the guard. An audible warning is produced and alarm message appears on the display.
To deactivate the audible warning press the key **STOP**.

<u>To continue the operation:</u>

Release the guard by taking the pressure off, checking it returns to its original upright position.
Press the **STOP** key to deactivate the audible warning and next the **START** key to renew the operation.

## General Stop – Disconnection of Power

Disconnecting the mechanically lockable isolator switch, located on the base-frame side cover. COMPLETELY disconnects the machine from the power supply. Its use is recommended for maintenance interventions and in situations of prolonged machine stoppage.

**Mechanically locking switch breaker**
Set the switch breaker at the " 0" position.
Fit a padlock on the opening to prevent the switch breaker being handled by others.

---

🛈 CAUTION!

ONCE THE SWITCH BREAKER HAS BEEN MECHANICALLY LOCKED, OPENING THE SAFETY GUARD IS NO LONGER POSSIBLE.

---

**Note:**

**THE MANUFACTURE ACCEPTS NO RESPONSIBILITY IF THE SAFETY INSTRUCTIONS AND ALL INFORMATION IN THIS AND CORRESPONDING MANUALS ARE NOT OBSERVED. KEEP THIS AND ALL USER MANUALS IN SAFE PLACE FOR FUTURE REFERENCE.**

**Note:**

**THIS TRAINING GUIDE IS USED AS A BASIC GUIDE FOR PROPER USE. IT IS THE RESPONSIBLIITY OF THE OWNER/OPERATOR TO READ THE "INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTION MANUAL"**