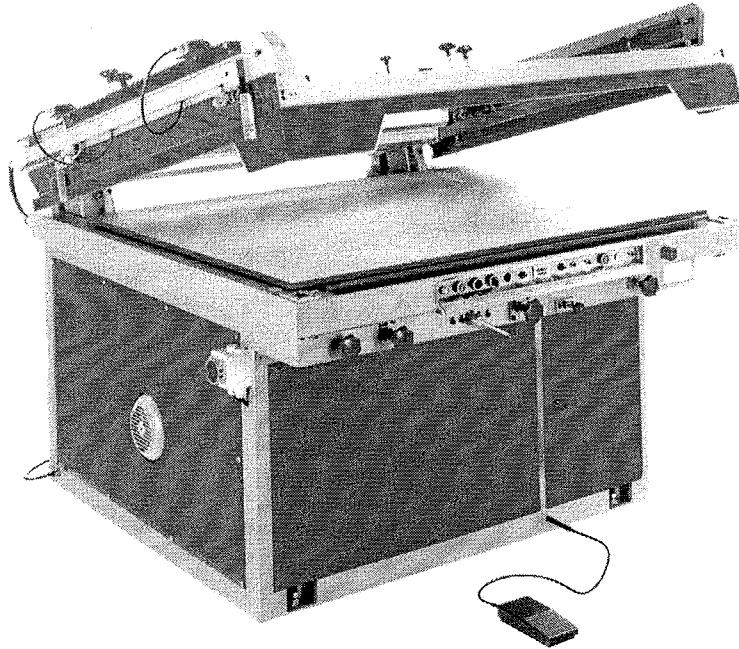


per Email von Alitec (8.12.2011) Alternativhandbuch  
• scheint aber auch nicht zu 100% zu passen K.Kandler

## Owners Manual



Maschinen-Typ Mecana

### Erkenntnisse:

13.12.11: laut Bochonow wurde spezielle Kundenwünsche eingebaut, die kein Standard sind. CK

**Attention before first operation:**

**Please do only admit skilled staff working with electrical appliances.**

**The installation of SIRI-MECANA should always be done by our mechanics (also in case of a move).**

**When working with removed coverings, do never grasp into the machine as moveable pieces may cause danger! Do only remove coverings when the machine is switched off!**

**The device is suitable for substances with a flash point of more than 21°C.**

**Please consider the legal safety regulations!**

### **Check rotary direction:**

1. Press EMERGENCY-OFF-BUTTON 2. Master switch OFF 3. Open switchbox 4. Master switch ON 5. Briefly press connector K5 6. Watch fan (right side) if rotary direction is anti-clockwise! Remove metal covering for this purpose.

### **When coverings are open - always work**

**!!!without current!!!**

### **Preliminary remark**

SIRI-MECANA is maintenance-free to a great extent. You should, however, take the following information seriously and have the machine regularly maintained by our service.

We would like to point out that screen printing machines have to be checked every two years (according to \_ 40 VBG 7 i), and this checking must be documented by a check badge. This checking is also done by our service. For further details, please do not hesitate to contact us.

Repairs should be effected in time and by skilled staff. It is advisable to enlist our service technicians for that purpose.

If there is a claim for guarantee, you should inform our company immediately in writing, indicating the production number as well as describing the damage in detail.

Moreover, we would like to draw your attention to the following:

It is only the company Bochonow who decides about guarantee claims.

If defects or damages are repaired by the customer or third persons without our agreement, there is no claim for compensation.

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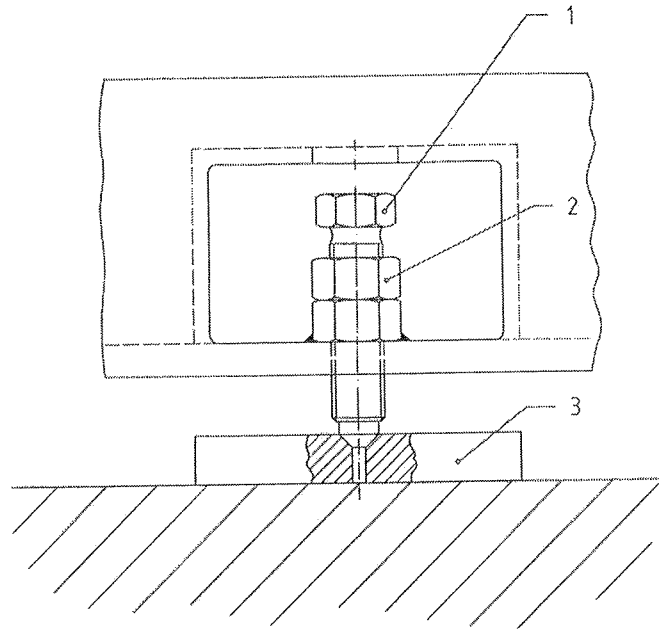
## 1.0 Installation of the machine

1.1 Unpack the machine carefully.

1.2 Put the machine onto the enclosed bases using the enclosed screws and nuts (see figure FDM 1-1).

1.3 Adjust the machine in balance. For that purpose, put the spirit-level in the middle of the basis plate to all directions.

1.4 In the case of smooth or wooden floors, it is advisable to put the bases onto a non-slip material (e.g. double-sided adhesive tape).



- 1) Stellschraube / adjusting screw
- 2) Kontermutter / rear screw
- 3) Unterlage / base

### Remarks:

After adjustment of the basis plate, there must not be any play at all four edges (in tightened condition). (e.g. a table that does not stand on all four legs but only on three).

This can be checked by pressing strongly at each edge. Adjust basis plate by moving the machines' adjusting screws (see FDM 1-1).

## 2.0 Operation of the machine

2.1 Establish connection to electricity Standard 380 Volt three-phase current, 50 Hz  
Phases: 2 x black, 1 x brown ZERO = blue, Earth = green/yellow Steering: 220 V 50  
Hz - phase brown

2.2 Engage emergency-off-button,

switch on the master-switch and open the switchbox.

Briefly operate manually the connector, marked with K 5. The fan begins to run for a short time.

Check rotary direction (arrow)

If wrong direction, convert the phase mutually (two black against each other or brown-black).

2.3 Repeat process 2.2 for control.

2.4 Switch off the master switch and close switchbox.

Release emergency-off-button and switch on the master switch.

**Attention: Frame moves upwards having switched on the master switch.  
Control lamp lights up. If not, check fuse el 6 A and precision fuse 20 x 5 e2, 5  
A (in the switchbox).**

2.5 The machine is now operational.

2.6 Using inks or thinners with a flash point under 21°C, the electrical equipment of the machine must be protected against explosion.

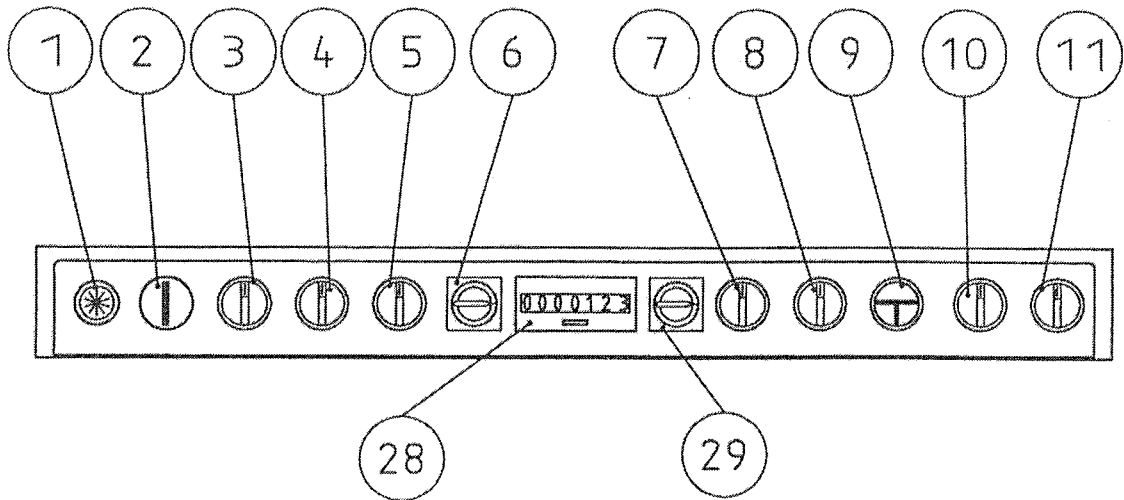
**Explosion protection within a radius of 0,5 m.**

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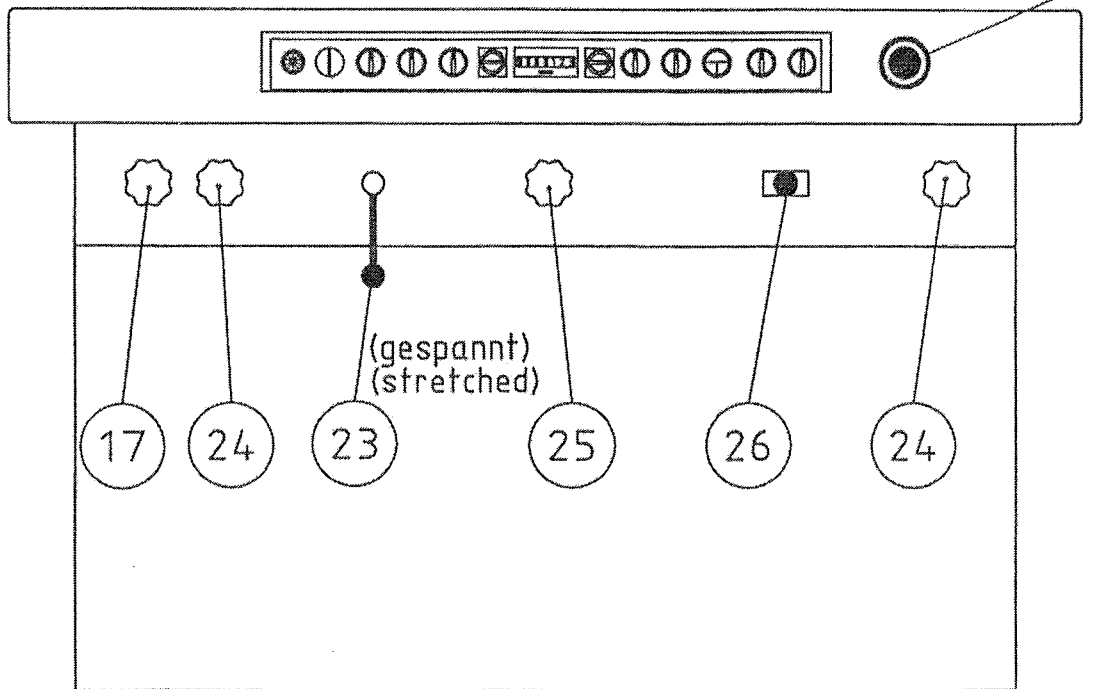


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**3.0 Test run of the machine**



Not-Aus  
Emergency-stop



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3.1 Switch (3) on "INCHING"

3.2 Press start button briefly.

3.3 Switch (4) "frame-up" and "frame-down"; repeat several times.

3.4 Move both stroke-switches (16) approx. 10 cm to the middle by releasing the screws, then tighten slightly the screws.

3.5 Switch (3) on "RUN"

3.6 From the starting position (frame up, squeegee back) press start button (2). Switch (8) "CLEANING" "on".

**Attention: during movement of the squeegee. Check function - Switch (8) "off".**

3.7 Switch (3) on "INCHING".

Switch (4) on "FRAME-DOWN"

Press button (9) "SQUEEGEE JOG"

The squeegee is moving to the front as long as the button is pressed down. This means that the squeegee stops to move if button is released. Pressing the button again, the squeegee is moving again to the front. Arrived at the front, the squeegee stops automatically at the stroke-switch (16), even if the button is pressed. In this position, it is easy to put in or to take out the squeegee and floodbar.

Switch (4) on "FRAME-UP" . Press button (9) "SQUEEGEE-JOG" The described process is repeated, the squeegee returns.

Switching on "RUN" with switch (3), the machine is operational.

3.8 All important functions are now checked. The machine is now operational.

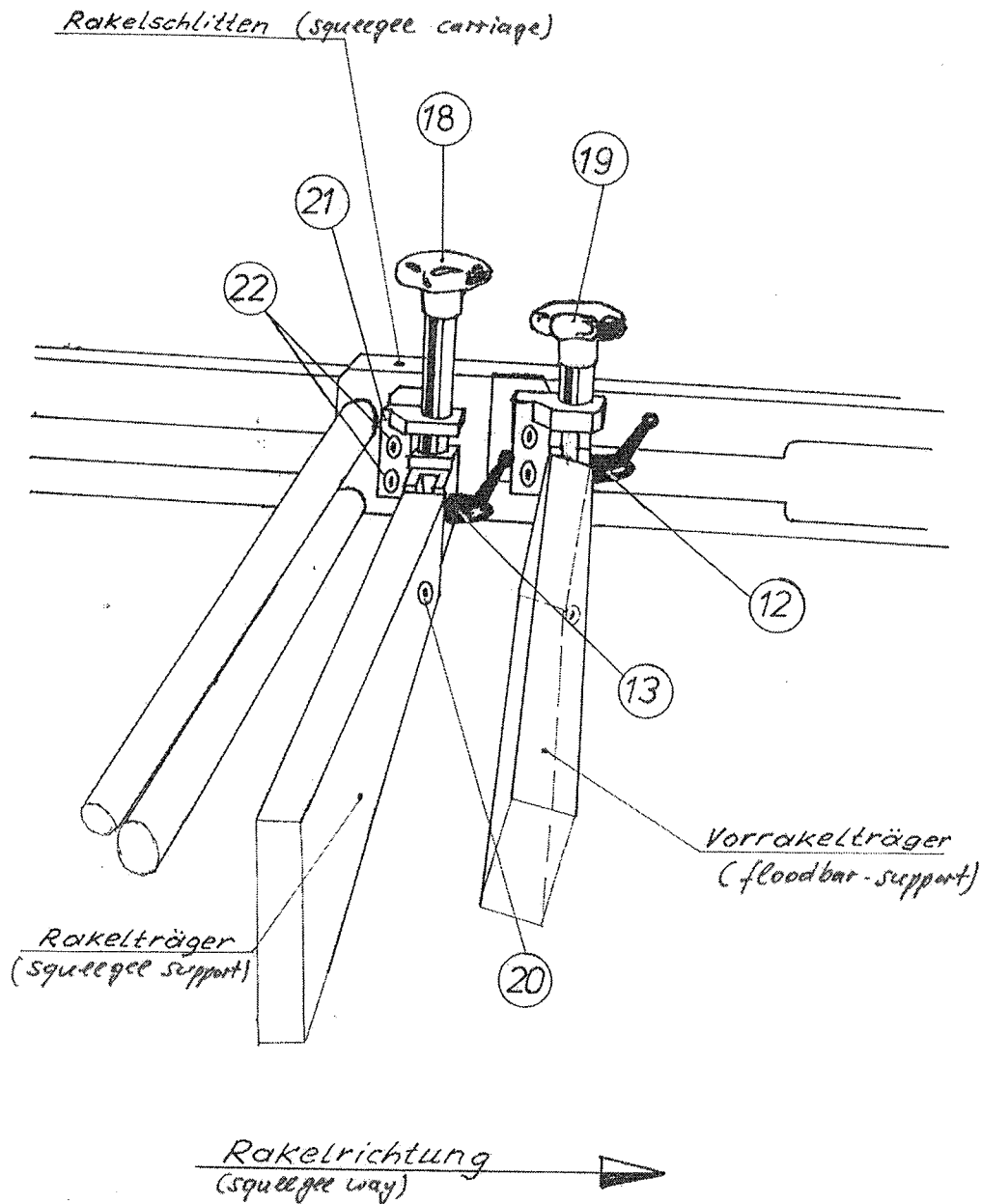
3.9 In the case of machines with an additional FRAME-DELAY turn switch (7) on "ON", press start button (2). Check slowing down (29) by variable adjustment by having done several work phases with start button (2).

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**4.0 Preparation of the machine for printing**



**Remarks: Put all switches into the original position - all switch arms are turned to the left. The same goes for each start of printing.**

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4.1 Proceed according to point 3.7, so that the squeegee carriage stops at the front.

Remove squeegee support: Release handle (12), push the support to the right, raise left end of the support and remove it.

Remove floodbar support: Release handle (13) and proceed correspondingly.

4.2 After point 3.7 bring the machine into original position and make it operational.

4.3 Put the substrate onto the basis plate. Put on the vacuum switch (1) and pull out the pull arm (26). Switch (3) on "INCHING" and switch (4) on "FRAME-DOWN"

4.4 Insert the screen in both screen supports and tighten with screws (32). In the case of smaller screens, approach the support at the back by releasing the corresponding screws (14). Tighten the screws (14).

4.5 Adjust the required off-contact by means of the corresponding spindles (15). Please consider, that the smallest off-contact as possible should be chosen to save the screen and the machine.

4.6 Proceed according to point 3.7, so that the squeegee carriages stop at the front.

4.7 Insert the right end of the squeegee support with the squeegee in the right spindle (18) and push to the right. Insert the left end of the support in the left spindle (18). Push the whole support to the left until it stops. Tighten the handle (12). The required squeegee angle can be adjusted by releasing the Allen key (marked with No 20 of spindle (19) on the figure) of the spindle (18) and (19). Please consider section 6.0. Adjust now the adjusting spindles (18) of the squeegee to a slight contact with the basis plate.

4.8 Insert correspondingly the floodbar support with the squeegee in the spindle (19). Tighten the handle (13). Adjust the floodbar angle according to 4.7 (resp. section 6.0). The floodbar must be adjusted by means of the adjusting spindles (19), so that the distance of the bottom edge of the squeegee and the work surface is approx. 15-20 mm. The precise adjustment is done according to the run of the machine. It is absolutely necessary to keep the distance of 15-20 mm, otherwise the screen mesh would tear.

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## 5.0 Adjustment of the squeegee stroke

5.1 The length of the squeegee stroke is achieved by moving both stroke-switches (16)

5.2 Both stroke-switches can be moved outwards until it stops by releasing the screws.

The maximum squeegee stroke is achieved.

5.3 The squeegee stroke can be reduced in each direction until medium stop, so that the squeegee motion can be effected in the front and the back area.

5.4 When fixing the squeegee stroke, it must be considered that the post run (despite the motor break) is higher and the squeegee stroke longer when increasing the squeegee speed. First adjust a shorter squeegee distance (of approx. 4 cm).

The final squeegee stroke must not be finally fixed unless the most suitable squeegee speed is chosen (knob (17)). Do not forget to tighten slightly the screws at the end switches.

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## 6.0 Adjustment of squeegee and floodbar angle

6.1 Depending on the varying requirements, both aggregates can be put into different angles of inclination.

6.2 Having released the Allen screws (20) of the floodbar and squeegee, it is possible to adjust the required angle.

6.3 After adjustment, tighten strongly the Allen screws (20).

6.4 Rule of thumb: - Steep angle adjustment of the squeegee means little ink laydown (e.g. half tone printing). Low angle adjustment of the squeegee means higher ink laydown.

6.5 Rule of thumb: - Steep angle adjustment of the floodbar means that more ink can be applied, while having a low angle adjustment, there can be a strong flooding. A steep floodbar angle normally requires a higher pressure on the screen. In this case, the screen would be unnecessarily stretched and its life reduced. Moreover, there is a higher pre-tension of the screen at the outer areas. It is, therefore, advisable to have an extreme smooth surface of the floodbar end radius.

6.6 Please consider:

The right adjustment of the squeegee angle as well as the appropriate choice of the squeegee rubber hardness make a strong squeegee pressure unnecessary. The machine is protected - the life is increased - stoppages are avoided and screens saved.

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## 7.0 Change-over of the squeegee at the back

7.1 Having flooded the screen with the floodbar (applying the ink), the back run of the squeegee carriage is stopped. The squeegee motor drive starts, the carriage is put a little to the front. The squeegee change into the print position and avoids a running out of the ink to the back.

The length of the run to the front can be adjusted by the time relay (40). The shortest front run of an adjustment of approx. 0.3 seconds must not fall below.

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## 8.0 The safety border

8.1 The safety border is a complete protection that means that the frame motion downwards is immediately stopped and changed upwards in the case of a forced or accidental motion of the border. The machine is going back to the starting position.

8.2 In the positions "FRAME-UP and "FRAME-DOWN" e. g. in case of cleaning processes, the safety border does not function in order to avoid unexpected frame motions and back runs of the squeegee carriage. This is important when an employee is working above the screen changing the squeegee or adjusting the reference mark.

8.3 The machine stops immediately when operating the EMERGENCY-OFF-BUTTON.

### To release:

Release EMERGENCY-OFF-BUTTON. Switch off the master switch - and than switch it on.

**Attention: The frame is moving upwards.**

8.4 After function of the safety border or the EMERGENCY-OFF-BUTTON, press starting switch (2).

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**9.0 Adjustment of the squeegee (floodbar) Depth adjustment in case of substrates of more than 25 mm**

9.1 Release Allen screws (22) and put the fastening (21) higher by one thread.

9.2 Tighten Allen screws (22).

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**10.0 Base plate clip**

10.1 The base plate can be released by swinging out the handle (23) to the top right. Having adjusted the reference mark, it can be fixed by tightening the handle downwards.

10.2 Never use the base plate adjustment when base plate is fixed! This would lead to a destruction of the fine thread spindles of the base plate adjustment!

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## 11.0 Adjustment of the basis plate (reference mark)

11.1 The basis plate can be moved to the front and back and diagonally by means of the star handle (24).

The basis plate can be moved to the side by the middle star handle (25).

**Attention: Release the basis plate as described under 11.0 before adjusting it and do not forget to fix it after adjustment.**

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**12.0 Pre-Vacuum**

12.1 When the frame is open, the substrate can be held by a pre-vacuum pulling out the pull handle (ball handle (26)).

12.2 The pre-vacuum functions unless the pull handle (26) is pushed back to the original position.

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**13.0 Maintenance of the machine**

13.1 The SIRI-MECANA and its drive are maintenance-free to a great extent.

13.2 The squeegee carriages are equipped with special bronze pilot-bearings which have excellent emergency properties in connection with hardened runner-rails

13.3 The runner-rails should be cleaned from time to time and according to the need as follows: Clean the runner-rails with an oil soaked cloth (ink residues, dust, graphite separations of the conduct, etc.). Repeat this cleaning process.

**Attention:** The runner-rails must not be oiled or greased, as the change squeegee to floodbar or vice versa is not assured.

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### 13.4 Tighten the chains

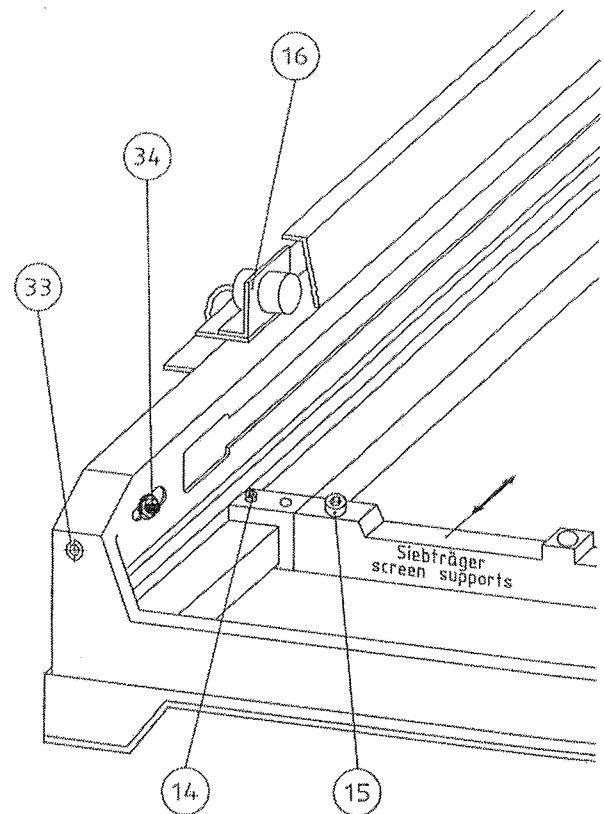
The chains are already adjusted by the supplier.

It can not be avoided, however, that the tension loosens a little, especially in the first time of operation.

It is eventually necessary to tighten the chains, as a regular and exact chain tension is important for the function of the squeegee carriage.

In this case, operate as follows:

- a. release the Hut nut and Allen screws (34)
- b. tighten the chains with Allen screws (33)
- c. tighten the elements mentioned under a.



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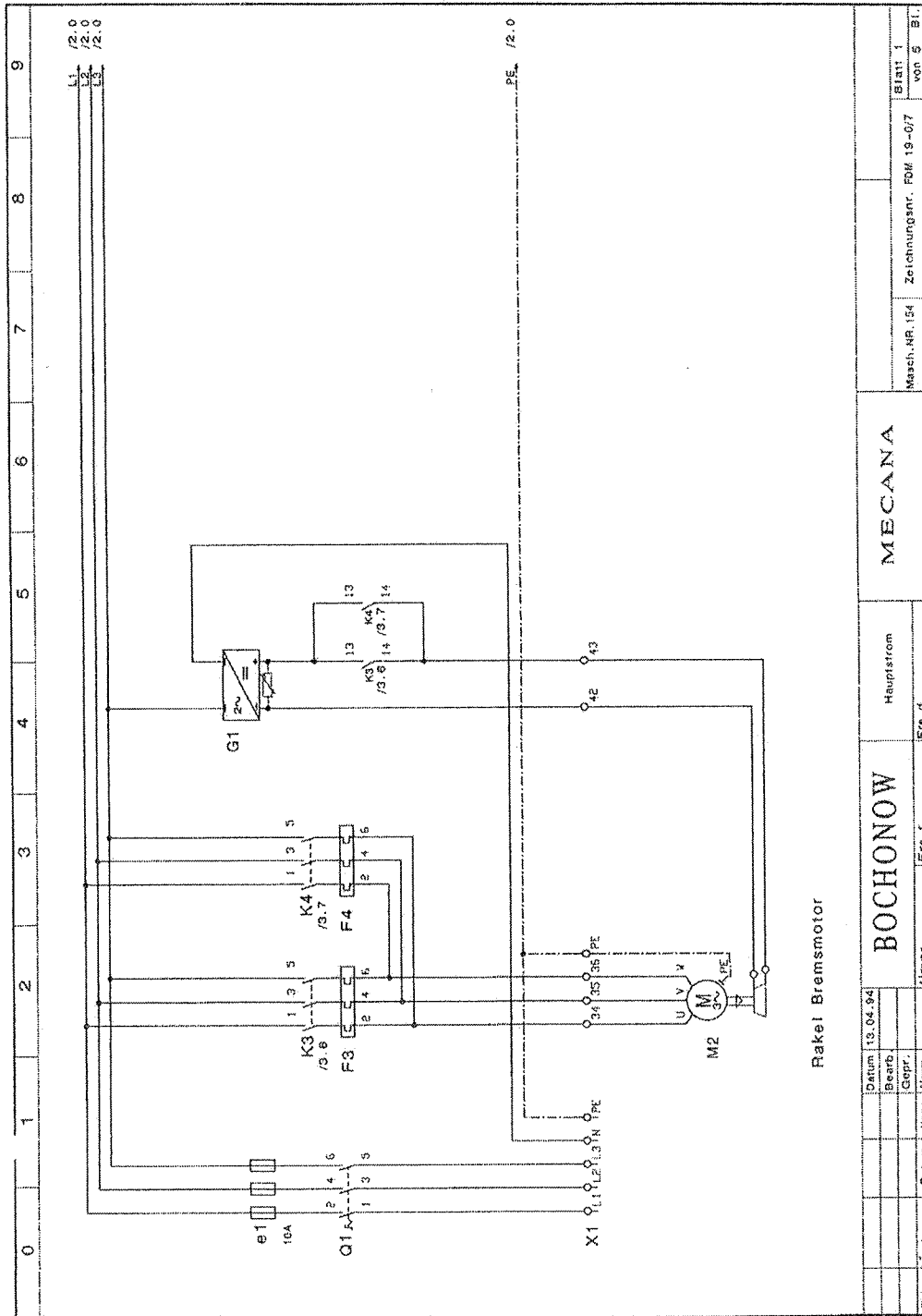
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**14.0 Wiring Diagram**



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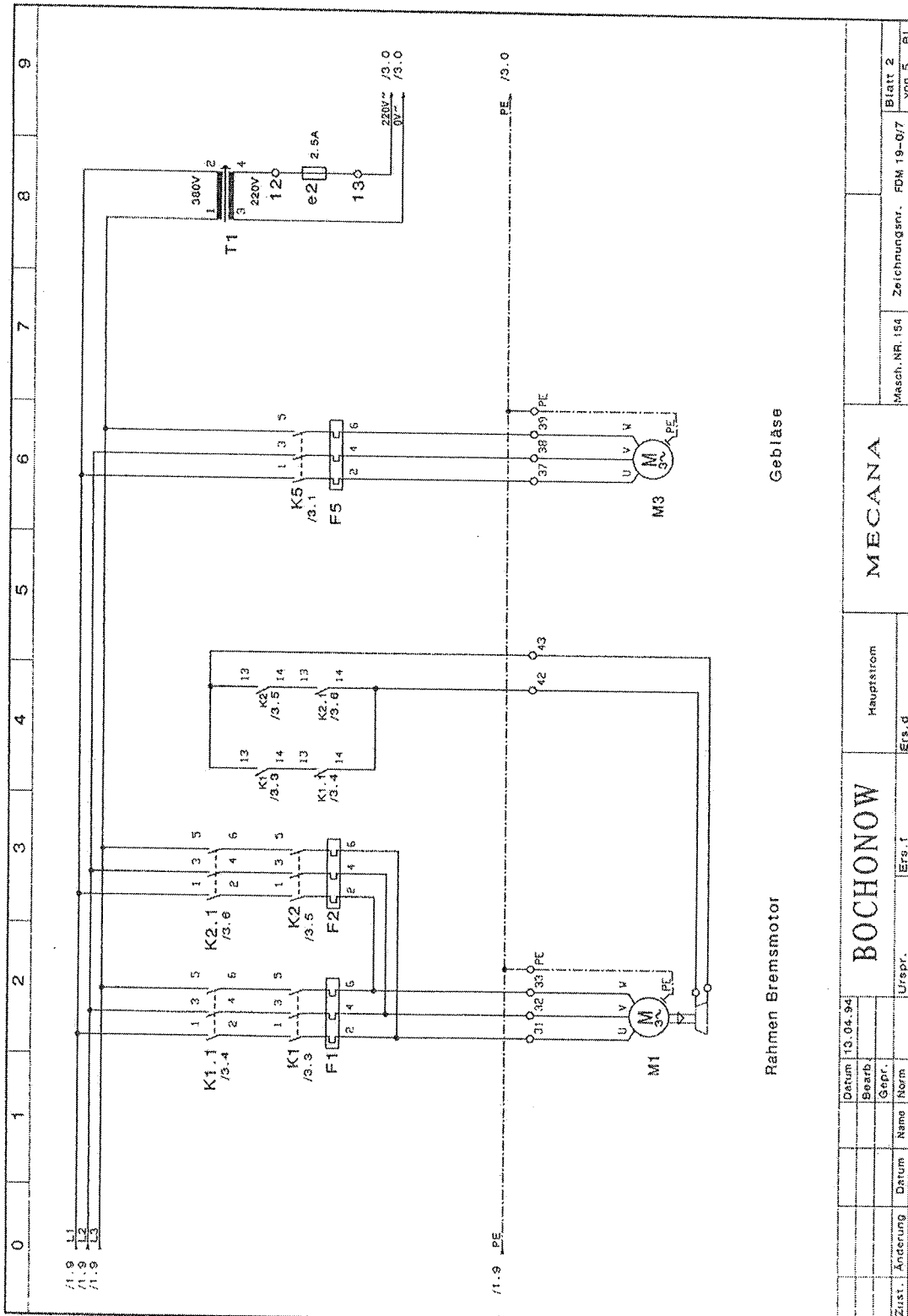
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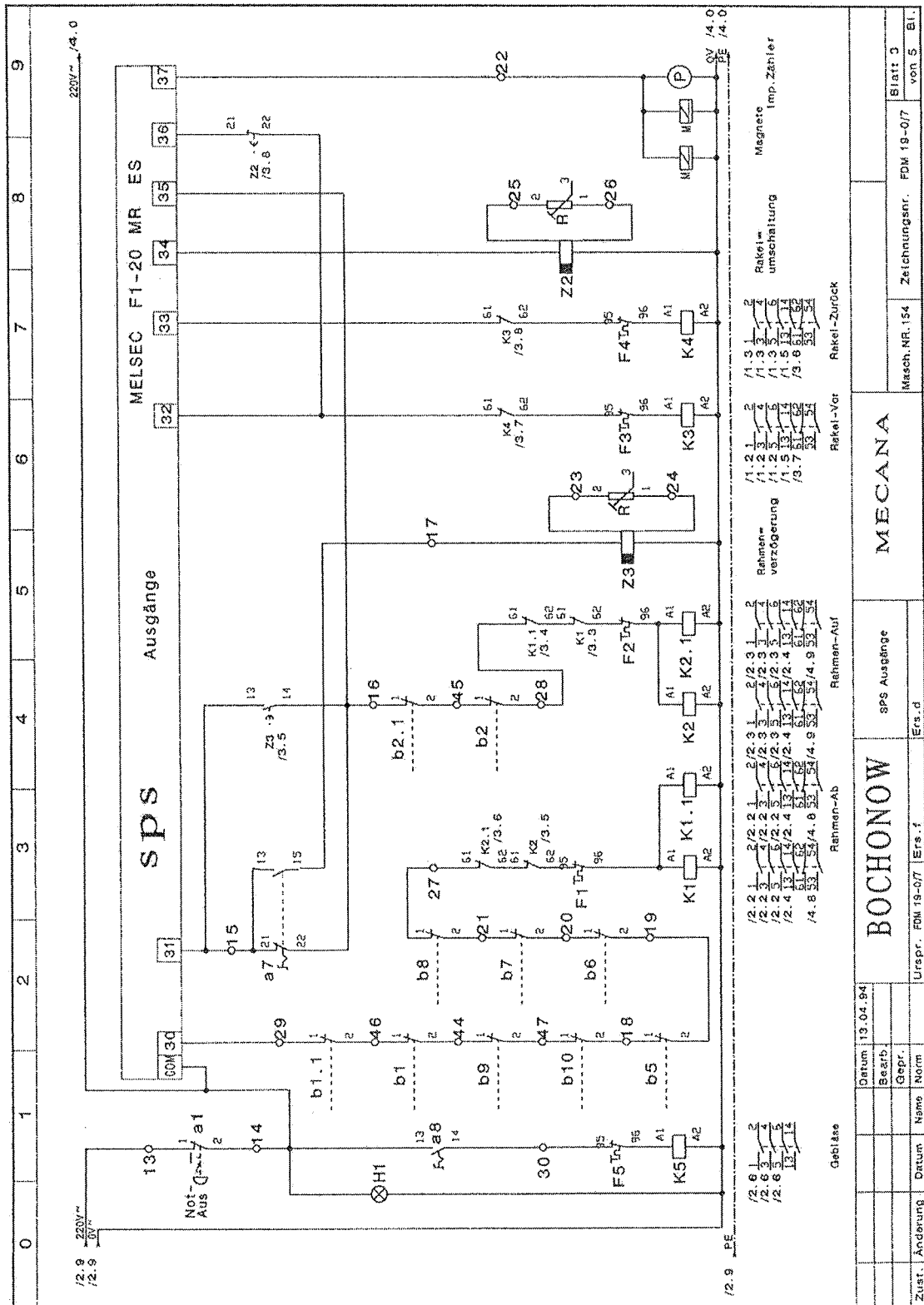
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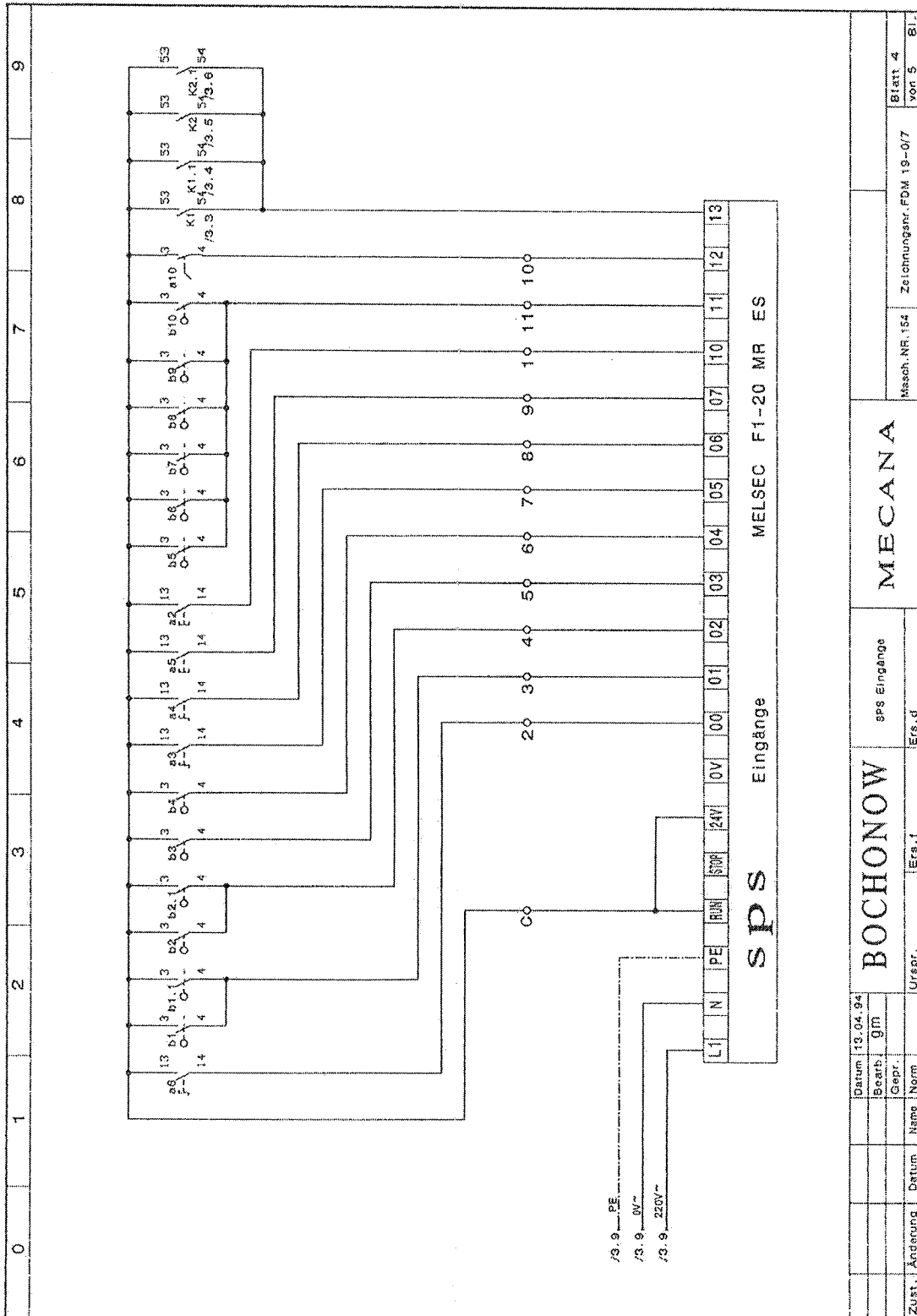
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8									
7									
6									
5									
4									
3									
2									
1									
0									


  

a 0 oder 01	Hauptschalter	K1-K1.1	Rahmen ab
a 1	Not-Aus	K2-K2.1	Rahmen auf
a 2	Start	K3	Rakel vor
a 3	Putzen	K4	Rakel zurück
a 4	Rahmen Auf/Ab		
a 5	Rakel vorrücken	P	Impulszähler
a 6	Betrieb/Einrichten	G	Gleichrichter mit Überspannungsschutz
a 7	Rahmenverzögerung	H1	Kontrollleuchte
a 8	Vakuum Ein/Aus	M	Magnet
a 10	Fußschalter	SPS	Speicherprogrammierbare Steuerung
b 1	meldet Rahmen unten	T1	Steuertransformator
b 2	meldet Rahmen oben	Z2	Rakelumschaltung
b 3	meldet Rakel vorne	Z3	Rahmenumschaltung
b 4	meldet Rakel hinten		
b 5-b 8	Sicherheitsleiste		
b 9 - b 10	Körperschutzleiste		
		e1	Sicherung 10A
		e2	Sicherung 2.5A

Masch.Nr.....154 bis.....

Ab Masch.Nr.161Endschalter b3 und b4 durch Induktive Näherungsschalter ersetzt

Ab Masch. Nr. 184 geerdete Fußschalter


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