

# Operating Instruction

IRONING TABLE

MODEL TDZ-B1

TD-B1





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## Summary

As the most widely used high performance ironing table, TDZ-B1 and TD-B1 series desk type flat ironing tables are the products with the longest producing history of our company, featured with stable and reliable quality, easy operation, excellent performance and low cost. These products have the function of suction, dehumidification and hold-to-run control. The floor and die head are equipped with electric heating devices inside to allow heating temperature setting as required. Together with steam iron or electric heating steam iron, these products can perform the leveling, dehumidification, shaping and ironing of semi-finished and finished costuming and dresses. As the essential equipment for dress production and daily care, these products are widely used for the ironing of semi-finished and finished costuming and dresses made of cotton, fur, silk, hemp and chemical fiber etc.

The ironing tables of this series have the features of hold-to-run control, automatic switchover of suction and electric heating temperature control, which enable the products to win extensive welcome and praise. During operation, the dehumidification suction fan inside the base frame is controlled by the foot pedal at the base frame through hold-to-run control. As the foot pedal is depressed slightly, the fan will start to generate negative pressure and dehumidify; when the foot pedal is released, the fan will be powered off and stop suction slowly. When used on the floor, rocker arm or die head, the suction action allows automatic switchover each other. The electrical heating elements inside the floor and die head control the heating temperature automatically through WK-R11 temperature controller, allowing any temperature between room temperature and 110°C. The above features guarantee the excellent performance and reliable quality of the ironing tables.

The users may select the different product models basing on individual requirement according to the floor size, whether floor and die head requiring electrical heating element and whether requiring rocker arm and die head. In addition, using single-phase 220V or three-phase 380V power supply can be indicated in the purchase contract. The air exit at the back of base frame of this series flat ironing tables are downward. Where upward air exit is required, it should be indicated in the contract, and our company can meet such user's requirements.

## Main Technical Parameters

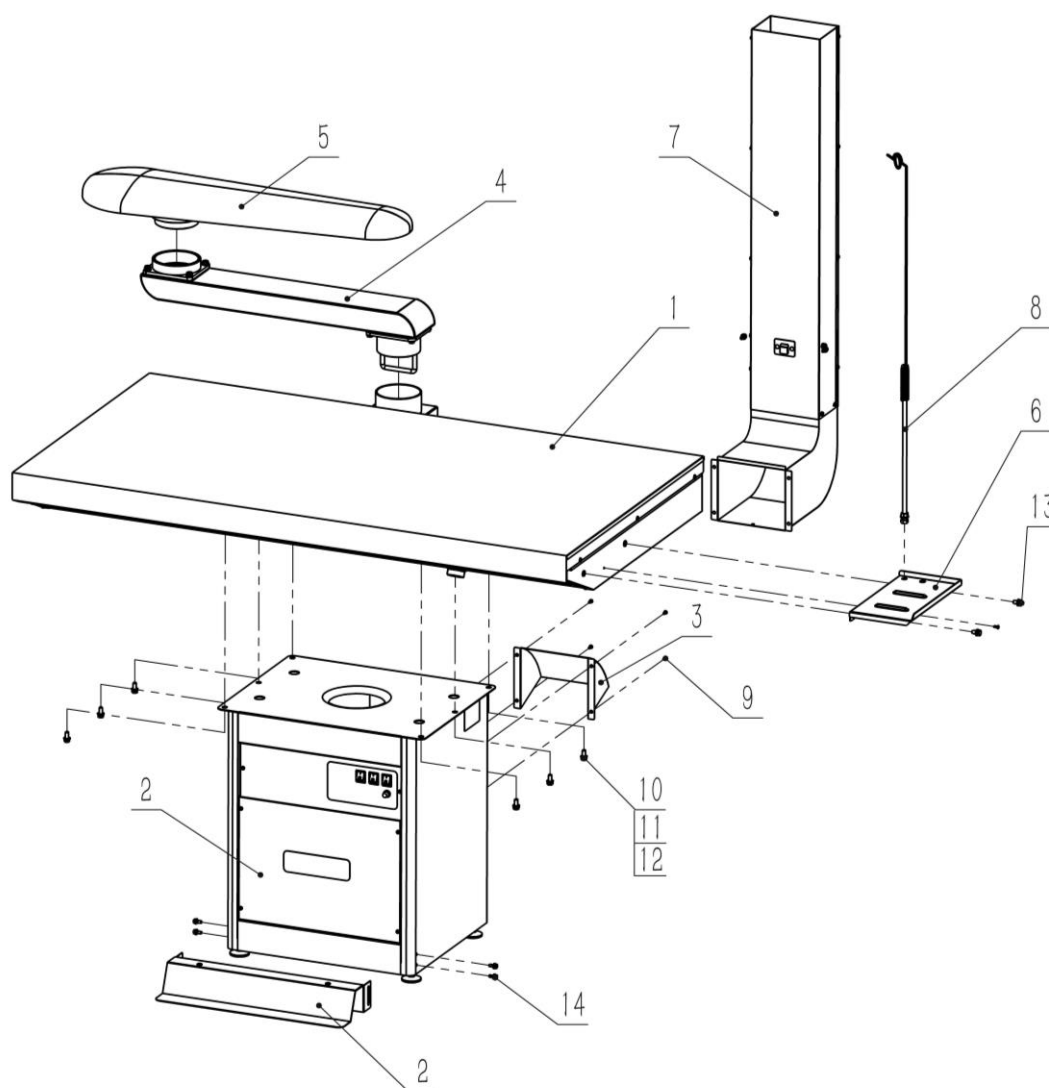
Model	TDZ-B1		TD-B1		TDZ-B1/TD-B1	
Table size            mm	820×1200	820×1500	820×1200	820×1500	820×1200	820×1500
Suction motor power    W	750	750	750	750	750	750
Suction pressure        Pa	<-300	<-300	<-300	<-300	<-300	<-300
Table flat heating element   W	1000	1000	——	——	——	——
Buck1 heating element    W	350	350	——	——	——	——
Buck2 heating element    W	250	250				

Note: the meanings of the letters in the model are as following: T- ironing table; D- hold-to-run

control; Z-with electric heating function; B-with rocker arm

## Installation Instructions

The above ironing tables are shipped in 3 packing cases: 1 for floor, 1 for base frame and 1 for spare parts. After unpacking the spare parts case, count the following parts: 1 set of foot pedal and pedal bracket and 1 die head, rocker arm, iron bracket, stay bar and spring spacer bar respectively. (optional upper exhaust air) and then, according to the General Assembly explosion diagram, assemble the whole machine in the following order.



Exploded view

No.	Part No.	Description	Quantity
1	TD1.01	Table flat	1

2	TD1.02	Table body	1
3	TD1.03	Air outlet	1
4	TD1.04	arm	1
5	TD1.05	Buck	1
6	TD1.06	Table cover	1
7	TD1.07	Upper exhaust duct	1
8	TQ1.08	Spring spacer bar	1
9	GB/T818-2000	Cross slot disc head screw [M4X10]	5
10	GB/T93-1987	Standard elastic washer [8]	8
11	GB/T5781-2000	Hexagonal head bolt full thread _ class C [M8×20]	8
12	GB/T97.1-2002	Plain washer class A [8]	8
13	GB/T5781-2000	Hexagonal head bolt full thread _ class C [M8x16]	2
14		Hexagonal head bolt+ washer M6X16	4

1. Remove the 4-M6×16 bolts, spring washers and plain washers in the front at both sides of the base frame, fit the foot pedal and pedal bracket assembly over the front lower part of the base frame, fasten them with the above said fasteners and then fix them. In the end, connect the 2 connecting leads of jiggle (travel) switch to the plug passing under the base frame.

2. Remove the 6-M8 Bolt and washers at the lower of floor, align the floor and base frame, tighten the Bolt and washers to connect them into one piece. In the end, pass the leads of the base frame leading to the electric heating tube inside the floor through the hole on the base frame top surface and connect wires of the electric heating tube and temperature regulating knob (see Figure 4).

3. Insert the rocker arm lower rotating shaft into the rocker arm seat (elbow) at the back of floor and then insert the lower rotating shaft die head into the rocker arm swivel seat to make the floor, rocker arm and die head into one piece, allowing flexible rotation.

Where the die head is provided with electric heating device, connect the power cord and the socket with the socket at the back of base frame. During use, regulate the operating temperature of die head through the temperature regulating knob, the same as the floor.

4. Similarly, mount the iron bracket to the right side of floor and fasten the bolts. Fit the stay bar in the hole of the iron bracket, fix it to the bracket with two nuts up and down and fit the spring stay bar over the upper part of the stay bar in the end.

5. At last, connect the power cord to the power switch (supplied by the user). Except for connecting 3 phase conductors (live conductors), connect the zero conductor and safety earthing conductor to guarantee the equipment safety and personnel safety of operators.

## User Method

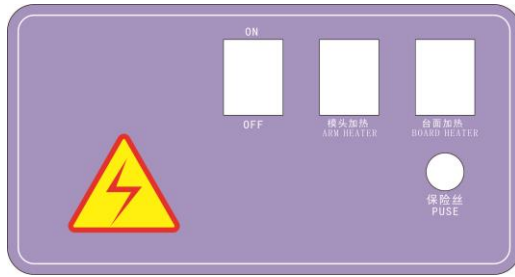


Figure 1:TDZ - B1 operation panel

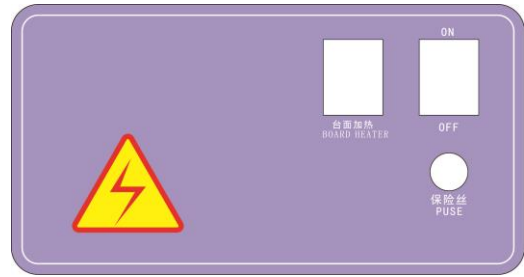


Figure 2:TDZ operation panel

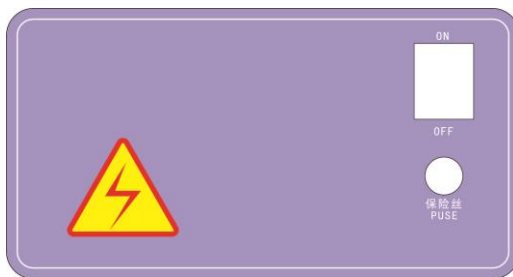


Figure 3:TD operation panel



Figure 4 : temperature adjusting knob

The electrical operating panel and control elements of this series ironing tables are mounted on the upper right of base frame. For the operating panel of 3 types ironing tables, refer to Figure 1 to Figure 3 respectively. The temperature controller of floor and die head electrical heating elements is mounted at the lower of floor or die head right side, which can be operated or regulated independently. For the knob of temperature controller, refer to Figure 4.

1. Connect the power supply and get ready to start. Verify whether the power is single-phase 220V or three-phase four-wire system 380V and confirm it's suitable for the ironing table voltage, and then turn on the power switch.

2. Turn the power switch AK1 at the left of base frame operating panel (refer to the electrical schematic diagram, i.e., the ship form switch at the left of operating panel) to ON, then the indicator lamp inside the switch will be on to indicate power on.

3. Depress (or touch) the foot pedal by foot to make the inching switch QTS contact and switch on the contactor KM of fan motor M. Then the motor M will start running and generate

suction.

4. For TDZ-B1 and TD-B1 type ironing tables, after turning on power switch AK1, turn on the inching switch (at the right of operating panel) as well to switch on the control power. Then depress the foot switch to enable QTS and KM and start the suction fan. The fan will stop when the foot switch 3 is released.

5. For the initial use of three-phase power ironing table, where the suction force is found to be relatively weak, change the phase sequence of power cords, namely, exchange the joints of any two phase conductors (live conductors), then the motor will rotate reversely to increase the suction force. Note: when changing the power cord joint, cut off the three-phase power first and proceed under uncharged conditions to ensure safety.

6. Where the floor or die head is provided with electric heating device, connect the corresponding *Floor Heating* switch AK2 and *Die Head Heating* switch AK3 and set the corresponding temperature switch DK1 or DK2 first, then make the floor or die head heat. At this point, the indicator lamp inside the *Floor Heating* switch or *Die Head Heating* switch will be on to indicate heating in process. When the heating temperature reaches and exceeds the temperature set by knob DK1 or DK2, the indicator lamp will be off.

7. To stop the machine, turn the power switch AK1 to OFF and then the fan power will be cut off and the fan will stop. For electric heating ironing table, turn off the *Floor Heating* switch AK2 and *Die Head Heating* switch AK3 as well to cut off the heating power. It's unnecessary to turn the temperature regulating knob to OFF position.

## **Maintenance and matters needing attention**

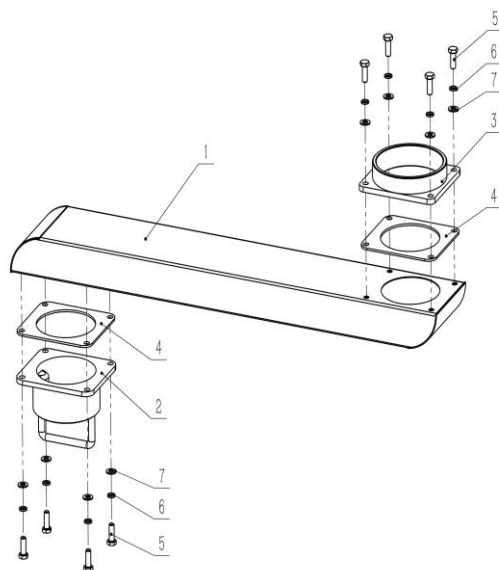
1. Dust, fiber wool and other residues accumulated on the motor and impeller should be cleaned regularly to ensure that the motor is clean in appearance in order to facilitate ventilation and heat dissipation.
2. Dust, fiber flocculation, steam and high temperature, water, etc., will make the table, rocker arm, die head defiled, rust and aging, but also easy to make hot felt defiled and aging, affecting the ventilation effect, should be cleaned regularly and replaced in due course according to its aging degree.
3. The impeller of the fan is tested and adjusted by dynamic balance. If it is not necessary, please do not remove the counterweight block on the impeller.
4. After use, the power supply should be cut off to prevent accidental danger and damage.
5. Heavy objects are not allowed to be stacked on the top of the countertop and die head, nor are percussion allowed.
6. Long-term electric heating of electric heating element is strictly prohibited without turning on suction fan ironing, resulting in damage to padding and even other dangers.



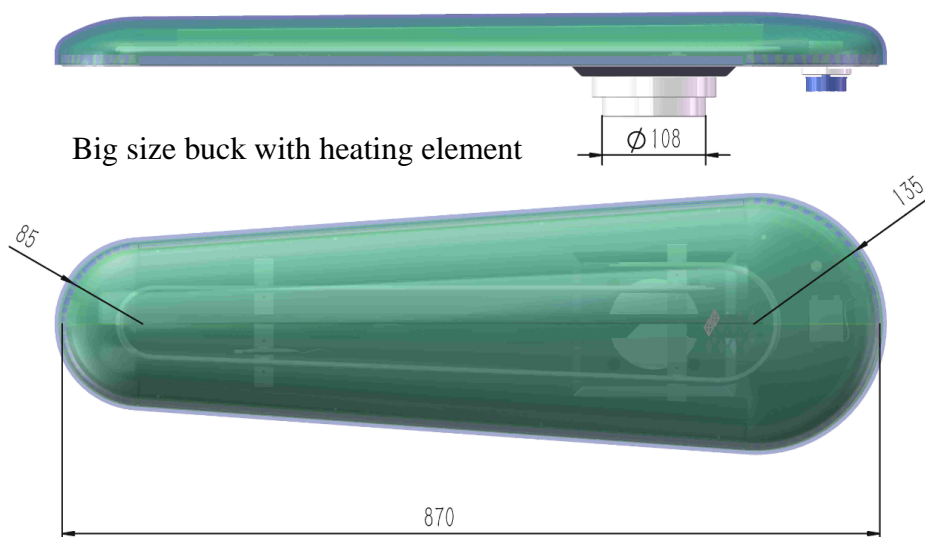
## Common faults and troubleshooting methods

Fault phenomenon	Fault cause	Exclusion method
The power indicator is not on light	Incorrect or not powered on power supply	Check the power supply and verify that the power supply is a 3phase four-wire
	Fuse broken	Replacement the fuse
	Indicator light broken	Replacement the indicator light or switch
Motor stop	Poor contact of switch	Replacement the switch
	Limit switch broken	Replacement the limit switch
	AC contactor failure	Replacement the AC contactor
	Motor fault	Replacement the motor or repair
Weak suction	Motor reversal	Adjust the phase sequence of power supply wiring, that is, the exchange of two fire wires
	The door of the air suction won't open.	Repair the door of air suction
	Impeller fault	Replace impeller or clean up
Heating element no heating or Temperature control is not adjustable	Heating switch broken	Replace the heating switch
	Temperature regulating switch broken	Replacement the temperature regulating switch
	Heating element broken	Replacement the heating element

## Arm Exploded View



No.	Part No.	Description	Quantity
1	TD1.06.01	Arm	1
2	TD1.06.02	Lower shaft of arm	1
3	TD1.06.03	Upper swivel of arm	1
4	TP6.06.05	arm gasket	2
5	GB/T5781-2000	Bolt [M8×25]	8
6	GB/T93-1987	elastic washer [8]	8
7	GB/T97.1-2002	washer[8]	8



Small size buck with heating element

