Overview

Piano type ironing table is the one widely used for the ironing and repair ironing of various type cut pieces and finished dresses. The ironing tables of our company have stable and reliable quality, attractive appearance, excellent performance, easy operation, wide varieties of accessories, broad applicability and low price, which enable our products to win extensive welcome and recognition. The newly developed TDG-B1 type ironing table with boiler (see Figure 1 and 2) is the new energy saving ironing table basing on the original TDZ-B type ironing table. The frame is provided independent electrically heated boiler inside to allow the electric heating steam iron to perform ironing on this table directly, without relying on other steam sources. This boiler is highly easy to purchase, install and use, especially suitable for the configuration of required processes of the production line, as well as for the individual consumer.

This ironing table has the following structural features and function settings:

1. The base frame is equipped with mopboard at the lower front to control the run or stop of suction fan inside the frame through hold-to-run control to achieve the dehumidification of floor or die head. This mopboard is easy to operate and control and saves energy.

2. The table is equipped with air duct suction automatic switch device at the lower to automatic achieve the switch of floor/die head suction, reduce the unnecessary suction volume or power consumption.

3. The table have steam hose, buck (choose by customer) is equipped with electric heating device to allow temperature setting between room temperature and 120℃ and automatic control over the heating temperature through the temperature controller under floor / die head, Elimination condensate water and stagnant water and water vapor in the machine to ensuring the clothing ironing quality. (Users can independently choose whether the table / die head heating device)

4. The frame is equipped with dedicated electric heating steam boiler inside to achieve fully automatic control over the steam pressure and water level and guarantee the steam pressure and steam volume required by the iron. In case the steam pressure is too high, the safety valve will discharge the steam automatically to avoid accidents caused by too high steam pressure. The pressure gauge is provided at the right of the frame to allow frequent monitoring over the operation conditions of the boiler.

5. This ironing table is equipped with electric heating steam iron rest. The iron rest (stand) at the right side of floor is used to hold the iron and the spring

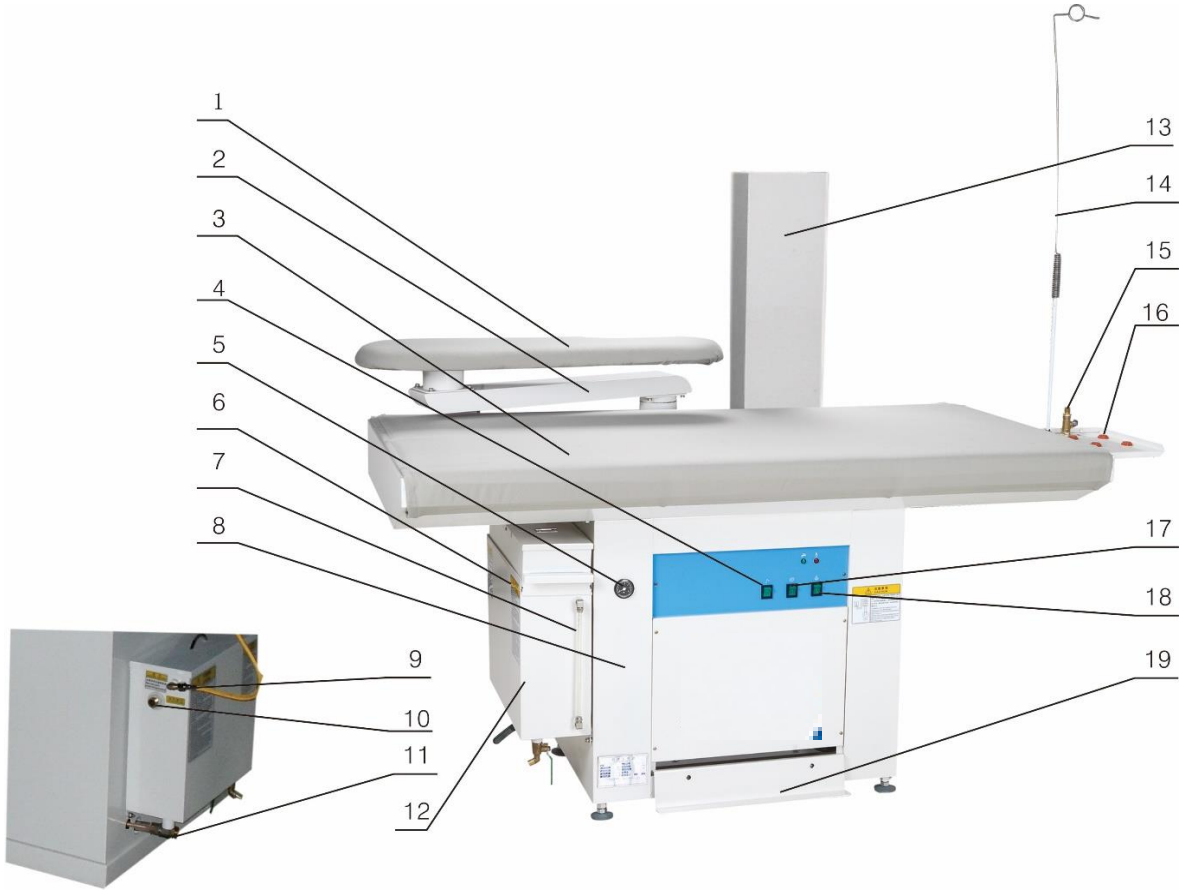
stay bar is used to support the steam hose and cable of iron. The steam supply valve is mounted at the back of frame. Through the hose supply steam to the steam iron to carried out ironing operation. Iron condensate water can

returning water tank by hose which connect to connecting tube of water tank top left corner at the back of tank. It saves the boiler demineralized water consumption and energy expenditure to achieve the effect of energy saving. When use of electric steam iron, you should install additional power point and install solenoid valve after the steam supply,by using the inching switch on the iron handle, the user can control the solenoid valve to supply steam to the iron and then spray the steam to the clothing under ironing through the steam vent at the front part of the iron to facilitate the heating and shaping of clothing. It can fully satisfy and guarantee the post-finish process requirements of leveling, dehumidification, shaping, repair ironing and tidying of clothing, in particular, of suit-dresses.

6. This ironing table is also equipped with rotatable and retractile rocker arm and die head, Convenient sleeves, trouser legs etc. used during ironing.

Main Technical Parameters

Floor dimensions (mm): 820×1500 820X1200
Floor height (mm): 800
Buck electric heating tube power (W): 350(optional)
Boiler electric heating tube power (W): 4500
Boiler feed water pump power (W): 550
Suction motor power (W): 750
Suction pressure (Pa) : >150
Power voltage (V): 380V/220V
Rated pressure of boiler (MPa): 0.4
Boiler steam output (kg/h): 4.5
Excessive high water level capacity (L): 6
Overall dimensions (mm): 1417×1015×1500
Total weight (kg): ~ 112



1.Buck；2.Arm； 3. Working table； 4. switch； 5.Boiler pressure meter； 6.Water tank; 7.Tank water level; 8、Frame; 9.Tank backwater joint; 10.Tank floating ball; 11.Boiler blow valve; 12.Tank blow valve; 13.Upper air exit; 14.Spring stay bar； 15.Iron backwater joint; 16.Iron stand; 17.Suction fan power switch；18.Boiler heating switch；19.Suction fan inching control mopboard

Installation Instructions

1. After unpacking, the user should count the attached parts according to the packing list before installation.

2. After placing the ironing table in position, make the feet at the four corners of ironing table base frame level first, and adjust them to contact the ground if necessary. Secondly, mount the rest components in the following sequence (refer to Figure 1 and 2).

3. Insert the die head and rocker arm components into the rocker arm support and suction tube at the back of ironing table and make them rotate freely.If the die head have electric heating device, connect the die head heating power plug to the die head heating power outlet at the back.

4. Install iron frame on the right of the work table, tightened with bolt.Screw the thread end of round steel stay bar of spring stay bar components in the nut at the rear right corner of iron stand (refer to 10 of Figure 1), lock it with the nut to prevent the stay bar getting loose and then fit the spring stay bar over the round steel stay bar.

5. Finally, connect the power cable (refer to 14 of Figure 1) to the power,the capacity should be$\geqslant$15A.

6. Boiler water tank inlet port (refer to 6 of Figure 2) connected to soft water or water pipes, in order to ensure the supply water of the boiler.

Debugging and sequential normal use are allowed after the above installation finishes.

Use Method

The ironing table frame is equipped with operating panel (refer to 5 of Figure 1). On the top right corner of the panel are three indicator lamps which in turn are for: boiler feed water pump running and boiler heating. The switches at the lower of panel,the left is suction fan power switch, the right is boiler heating power switch.On the left of the panel is the master switch,the left of frame is boiler pressure gauge(refer to 6 of Figure 1). The following is the description of specific operating method and electrical schematic diagram (refer to Figure 3):

1. After mounting the ironing table, connect the power cable plug(refer to 14 of Figure 1) and outlet and supply the power. At the same time, connect the boiler water source (to the connecting pipe port at the feed tank of ironing table back, refer to 2&6 of Figure 2).It’s allowed to connect to tap water pipe ,you can aslo connect to dedicated pipeline softened water treatment.

2. Turn on the power switch AKI(refer to 13 of Figure 1).of the electrically

heated boiler and the indicator lamp inside will be on. Start the feed pump M2 to feed water to the boiler and then pump operation the indicator lamp HL1 will be on(refer to 11 of Figure 1) to indicate the pump is running and feeding water to the boiler. When the water reaches the normal water level, the level controller YK will switch on the heating circuit, the boiler heating indicator lamp will be on and the contactor KM2 will be powered on to make the electric heating tube EH to heat and the water inside the boiler will be heated until steam is generated. When the pressure reaches 0.4MPa, the pressure controller PK will cut off the heating circuit automatically and the steam pressure will not increase any more. At this point, the steam can be supplied to the steam iron to allow ironing operation.

When the steam pressure drops to a certain level, the pressure controller PK will switch on the heating circuit to reheat and maintain the steam pressure around 0.4MPa to guarantee the steam supply quality without intended care. In general, it's sufficient to monitor the pressure gauge at the left of frame frequently.

3. Where the clothing should be ironed on the floor or die head, close the suction fan power switch AK2 (refer to 12 of Figure 1)first, and then touch the suction fan inching mopboard (refer to 8 of Figure 1) on the base frame by foot slightly to start the suction fan (M1) and generate suction force to remove the wet vapor and discharge the vapor through the air exit (refer to 1 of Figure 2) at the back of frame. When the mopboard is not touched any more, the fan will be powered off and stop to save energy.

5. The electrically heated boiler inside this ironing table frame is under fully automatic operation, namely, a. The pressure controller PK will control the working pressure of boiler around 0.4MPa automatically (the pressure was set to 0.37 ~ 0.4MPa upon delivery). When the pressure increases to 0.4MPa, the heating power will be cut off to prevent over-pressure. When the pressure drops to 0.37 ~ 0.38MPa, the heating power will be connected to continue heating and generating steam. b. In addition, the boiler is equipped with safety valve, which will discharge the steam automatically to prevent over-pressure when the steam pressure reaches 0.43MPa due to unexpected reasons. c. It's sufficient to monitor the pressure gauge on the frame frequently during operation. d. The boiler water level will be maintained between the maximum and minimum safe water level for continuous normal operation without reaching full water level due to too high water level or water shortage due to too low water level. Besides, the water level controller YK will disable heating upon water supply and disable water supply upon heating. e. Pay attention to the water source or water supply tank for water break during boiler operation. The

water supplied to the boiler must be softened water subjected to treatment. Where the water supplied to the boiler is tap water with dosing treatment, it must meet the following criteria:

Turbidity / FTU	Hardness/(mmol/L)	pH (25℃)	Oil/(mg/L)
≤20.0	≤4.0	7.0~10.0	≤2.0

f. Each time after use, wait the steam pressure drops to be≤0.1MPa, stop monitoring the pressure and stop the boiler for the next use. Alternatively, discharge the water inside the boiler through the drainage valve (refer to 7 of Figure 2).

6. When die head operation,the flap inner floor can turned air course automatically.then the floor will stop suction,reducing the amount of wind suction to achieve the purpose of energy saving.

Maintenance and Precautions

1. The floor and die head are covered with sponge and floor cloth which cannot be knocked; do not place heavy goods on them; do not place objects with burr on them; do not place hot iron on them so as to prevent burning the floor cloth and sponge.

2. Never allow the electric heating tube under the floor and die head powered on and heating without starting the suction fan for ironing; otherwise, the ironing felt may be damaged and even result in other hazards.

3. After use, cut off the power and disconnect the main switch to prevent unexpected hazards and damage.

4. The dust, fiber flocculation, steam, high temperature and water accumulation which may get the internal chamber of ironing table polluted, corroded and aged should be removed periodically. The ironing felt and floor cloth should be replaced in time according to the aging degree.

5. The water supplied to the boiler must be softened water or distilled water subjected to treatment.When use tapping pipe as water supply directly, add dedicated softening agent to the water. For the specific dose and method, refer to the operating instructions of softening agent.

6. Clean the boiler internal chamber and water level probe with detergent and remove the scale periodically. According to the operation instructions of detergent, prepare solution in a bucket, feed the solution to the boiler through feed pump, heat it properly and then cut off the power and settle for 2h to allow the scale to dissolve and fall. Then open the drainage valve to discharge the sewage and clean the boiler with clean water for several times to restore the

original state.

7. The boiler water level probe is the sensitive element of water level control system. If the probe surface is covered with scale, it will result in malfunction of water level control. Therefore, it's necessary to clean the probe surface periodically. Do not mistake the position and wiring joints of probe during removal and installation.

8. The frame is equipped with boiler feed pump inside. There should be no air inside the water pump and supply pipe forming "air chamber" at any time. Discharge the air through opening the water pump .

Constant Faults and Solution

Fault Description	Fault Cause	Solution
Power switch is on while the indicator lamp is not on	The power is not connected No power supply after main switch is turned on Blown FUSE Damage of indicator lamp inside the switch Indicator lamp damage	Check the power and confirm it's switched on Operate the main switch repeatedly or check and repair Replace the fuse Replace the switch or indicator lamp Replace the indicator lamp
Suction fan not rotate	Poor contact of switch Poor contact of inching switch Motor malfunction	Replace the switch Adjust the position of mopboard and travel switch or replace the travel switch Repair or replace the motor
Weak suction force	Wrong position of switch flap Impeller malfunction	Use the flap correctly or repair it Clean or replace the impeller
Floor and die head electric heating tube not hot or adjustment malfunction	Temperature controller malfunction Electric heating tube damage	Check and repair the temperature controller or replace it Replace the electric heating tube
Boiler steam pressure not increase	Pressure controller malfunction Clogging of pressure controller connecting pipe Electric heating tube damage AC contactor malfunction	Service or replace Remove and clean it Replace it Repair or replace
Abnormal discharge of safety valve	Improper adjustment Foreign body attached to the valve flap Safety valve malfunction	Re-adjust Disassemble and clean it Service or replace
Drainage valve cannot operate	Clogging of pipeline by foreign body Handle looseness Sticky due to long time out of use Sealing element damage	Remove and clean it Service or replace Dismount, clean and service Replace the valve